

GELCOAT CRYSTIC 967FR

Fire Retardant Iso -NPG Spray Gelcoat

Introduction

Crystic Gelcoat 967FR is a pre-accelerated, thixotropic Iso -NPG polyester gelcoat. It has been formulated for spray application by an airless machine.

Application

Crystic Gelcoat 967FR has been specially designed for the production of parts in the building and transportation industry where fire retardancy is a key property. It is pre accelerated and only requires the addition of the catalyst to start its curing reaction.

Features & Benefits

Features	Benefits
Base resin Iso-NPG	Excellent chemical & mechanical resistance and flexibility
Special additives	Improved fire resistance
Fast curing	Fast mould turn round – time saving

Approvals

Crystic Gelcoat 967FR meets M1/F2 fire approval with Crystic 5046 and M2/F2 fire approval with Crystic 26026.

Formulation

Crystic Gelcoat 967FR must be allowed to attain workshop temperature (18-20°C) before use. Stir well by hand or with a low shear mixer and leave for rest. The gelcoat only requires the adding of catalyst to start curing. The recommended catalyst is Butanox M50 (or other equivalent catalyst) which should be added at 2% in the gelcoat.

Gel time

Catalyst level and temperature will influence the gel time. Typical gel time at 25°C of Crystic Gelcoat 967FR for 100 parts gelcoat catalysed with 2 % Butanox M50 is 14-16 minutes.

Recommended Testing

It is recommended that customers test all pigmented gelcoats before use under their own conditions of application to ensure the required surface finish is achieved.

Application

Application Temperature	18 - 20°C
Catalyst	2% Butanox M50
Airless Gun Nozzle	421
Gravity Gun Nozzle	20/10 to 30/10mm
Pressure	3 to 4.5 bars
Distance to the Mould	50cm min
Thickness	400 – 600 microns

Typical Properties

Property		Liquid gelcoat
Viscosity at 25°C	dPas	350 – 400
Index of Thixotropy		6 – 6.5
Density at 25°C		1.38
Stability at 25°C	minutes	3

Property		Cured Base Resin
Barcol Hardness (model GY2J 934 – 1)		45
HDT	°C	90
Elongation at Break	%	2.5
Tensile Strength	MPa	70
Tensile Modulus	MPa	3400

Test according to BS 2782 :1976

1MPa = 1MN/m² = 1N/mm² = 10,2 kgf/cm²

Packaging

Crystic Gelcoat 967FR is supplied in 25 kg kegs and in 200kg drums.

Storage

Liquid Crystic Gelcoat 967FR should be kept away from heat or flames. It should be stored in its original container and out of direct sunlight. It is recommended that the storage temperature should be less than 20°C. Ideally, containers should be opened immediately prior to use.

Health and Safety

Please see separate Material Safety Data Sheet

January 2010
Version 2