

# CRYSTIC MICROBAN GELCOAT 65PA

## Brush Isophthalic Gelcoat with Excellent Water and Weather Resistance

### Introduction

Crystic Microban Gelcoat 65PA is a pre-accelerated, isophthalic gelcoat with built-in antibacterial protection to provide protection against common bacteria, mould and mildew in composite parts manufactured using this product. It has been formulated for brush application, but spray versions are available. Crystic Microban Gelcoat 65PA is available in a wide range of colours and the information contained in this technical datasheet also applies to these pigmented versions.

### Applications

Crystic Microban Gelcoat 65PA is designed for use in all markets requiring a general purpose brush gelcoat with antibacterial protection. It is also suitable for general moulding requirements.

### Features and Benefits

Crystic Microban Gelcoat 65PA has excellent water and weather resistance.

### Formulation

Crystic Microban Gelcoat 65PA should be allowed to attain workshop temperature (18°C-20°C) before use. Stir well by hand, or with a low shear mixer to avoid aeration, and then allow to stand to regain thixotropy. Crystic Microban Gelcoat 65PA requires only the addition of catalyst to start the curing reaction. The recommended catalyst is Butanox M50 (or other equivalent catalyst) which should be added at 2% into the gelcoat. (Please consult our Technical Service Department if other catalysts are to be used). The catalyst should be thoroughly incorporated into the gelcoat, with a low shear mechanical stirrer where possible.

### Pot Life

Temperature	Pot Life in Minutes
15°C	24
20°C	15
25°C	9

The gelcoat, mould and workshop should all be at, or above, 15°C before curing is carried out.

### Application

For normal moulding, the application of Crystic Microban Gelcoat 65PA should be controlled to 0.4-0.5 mm (0.015-0.020 inch) wet film thickness. As a guide, approximately 450-600 g/m<sup>2</sup> of gelcoat mixture (depending on pigment) will give the required thickness when evenly applied.

### Additives

Crystic Microban Gelcoat 65PA is supplied in a wide range of colours. This eliminates the potential for mixing errors with small quantities of pigment paste. The addition of fillers or pigments can adversely affect the water and weather resistance of the cured gelcoat. Crystic Microban Gelcoat 65PA can be used as a flowcoat provided that 2% Crystic Solution MW is added to overcome the normal tackiness.

### 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.

## Typical Properties

The following tables give typical properties of Crystic Microban Gelcoat 65PA when tested in accordance with SB, BS, BS EN or BS EN ISO test methods.

Property		Liquid Gelcoat
Appearance		mauvis, cloudy
Viscosity at 25°C		thixotropic
Specific Gravity at 25°C		1.11
Volatile Content	%	34
Geltime at 25°C using 2% Butanox M50 (or other equivalent catalyst)	minutes	9
Stability at 20°C	months	3

Property		Fully cured* (unfilled casting)
Barcol Hardness (Model GYZJ 934-1)		42
Water Absorption 24hrs at 23°C	mg	18
Deflection Temperature under load (1.80MPa)†	°C	75
Elongation at Break	%	3.0
Tensile Strength	MPa	75
Tensile Modulus	MPa	3500

\* Curing schedule - 24 hrs at 20°C, 3 hrs at 80°C

† Curing schedule - 24 hrs at 20°C, 5 hrs at 80° C, 3 hrs at 120° C

## Post-Curing

Satisfactory laminates for many applications can be made with Crystic Microban Gelcoat 65PA by curing at workshop temperature (20°C). However, for optimum properties, laminates must be post-cured before being put into service. The moulding should be allowed to cure for 24 hours at 20°C, and then be oven-cured for 3 hours at 80°C.

## Storage

Crystic Microban Gelcoat 65PA 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 where practical, but should not exceed 30°C. Ideally, containers should be opened only immediately prior to use.

## Packaging

Crystic Microban Gelcoat 65PA is supplied in 25kg and 225kg containers.

## Health and Safety

See separate Material Safety Data Sheet.