

CRYSTIC GELCOAT MOULE S

Spray Iso - NPG Gelcoat for Mould Making

Introduction

Crystic Gelcoat Moule S is an Iso - NPG polyester gelcoat, thixotropic and pre-accelerated, specially designed to be spray applied.

Application

Crystic Gelcoat Moule S has been specially formulated for mould making. It is pre-accelerated and only requires the addition of the catalyst to start its curing reaction.

Features & Benefits

Features

High heat resistance

High surface hardness

Benefits

High dimensional stability

Excellent mechanical properties

Excellent surface aspect and gloss

Excellent gloss retention

Variation

Crystic Gelcoat Moule S is available in a brush version under the reference Crystic Gelcoat Moule H.

Formulation

Crystic Gelcoat Moule S must be allowed to attain workshop temperature before use. Stir well by hand or with a low hear mixer to avoid aeration, and then allow to stand to regain thixotropy.

The recommended catalyst is Butanox M50 (or other equivalent catalyst) which should be added at 2% to the gelcoat.

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.

Gel Time

Catalyst level and temperature will influence the gel time. Typical gel time at 20°C of Crystic Gelcoat Moule S with 2% Butanox M50 is 9 to 11 minutes.

Typical Properties

Property		Liquid Gelcoat
Viscosity at 20°C Brookfield HBT, Sp n°2, 5rpm	dPas	9280 - 10240
Specific Gravity at 25 °C	-	1.15 – 1.35
Stability at 20°C	months	3

Property		Cured Base Resin
Barcol Hardness (Model GYZJ 934 – 1)	-	40
Heat Deflection Temperature (1.8 MPa)	°C	98
Elongation at Break	%	2.2
Tensile Strength	MPa	50
Tensile Modulus	MPa	2100
Specific Gravity at 25°C	-	1.14
Volumetric Shrinkage	%	8
Refractive Index n 20/D	-	1.557

(Curing schedule - Test According to BS 2782:1976)

$$1\text{MPa} = 1\text{MN/m}^2 = 1\text{N/mm}^2 = 10.2 \text{ kgf/cm}^2$$

Packaging

Crylic Gelcoat Moule S is supplied in 25kg kegs and 200 kg drums.

Storage

Moule (S) should be stored in its original container 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

Health & Safety

Please refer to Material Safety Data Sheet.

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