CRYSTIC® GELCOAT 80PA WHITE

Isophthalic Industrial Grade Brush Gelcoat

Introduction
Crystic Gelcoat 80PA White is an isophthalic, industrial grade, white pigmented, pre-accelerated gelcoat designed for hand lay-up.

Applications
Crystic Gelcoat 80PA White is most suitable for all general moulding requirements. It has been designed for application by brush yielding good coverage and flow and levelling properties. For normal mouldings, the gelcoat thickness should be controlled to about 0.5 - 0.6mm.

Crystic Gelcoat 80PA White is not recommended for use in the marine application or corrosion resistance application.

Formulation
The following formulations are recommended for laminating.

Parts by Weight	Formulation I
Crystic Gelcoat 80PA White	100
Catalyst M or MEKP M-50	1 - 2

Curing should not be carried out at temperature below 15 ºC and the gelcoat must be allowed to attain workshop temperature before being formulated for use. This gelcoat only requires the addition of catalyst to start the curing reaction. Shortly before use, the correct amount of catalyst should be added and thoroughly stirred into the gel coat.

Physical Data - Uncured
The following tables give typical properties of Crystic Gelcoat 80PA White when tested in accordance with BS 2782

Property	Unit	Liquid Gelcoat
Appearance		White, Bit Free
Viscosity at 25ºC, B/F SP2 rpm 20	Poise	40 - 50
C & P Viscosity at 25ºC	Poise	12 - 20
Specific Gravity at 25ºC		1.1 - 1.3
Stability at 20ºC	Months	3
Geltime at 25ºC Using 2% Butanox M50 (or Other Equivalent Catalyst)	Minutes	18 - 22

Physical Data - Cured

Property	Unit	Fully Cured* Base Resin (Unfilled Casting)
Barcol Hardness (Model GYZJ 934-1)		40
Deflection Temperature Under Load† (1.80 MPa)	ºC	75
Elongation at Break	%	2.0
Tensile Strength	MPa	65
Tensile Modulus	MPa	3500

* Curing Schedule - 24hrs at 20ºC, 3hrs at 80ºC.
† Curing Schedule - 24hrs at 20ºC, 5hrs at 80ºC, 3hrs at 120ºC.

Post-Curing
Satisfactory laminates for many applications can be made with Crystic Gelcoat 80PA White 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 Gelcoat 80PA White should be stored in the dark in suitable, closed containers. 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 Gelcoat 80PA White is supplied in 20Kg and 225Kg containers.

Health and Safety
Please see separate Material Safety Data Sheet.

Version 2 : February 2013

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