

COLGEL GC 215-02

Gel Coat

Description:

- » Colgel GC 215-02 iso/NPG gel coat is formulated to yield high performance against water and was primarily developed for quality marine applications but should be used in any FRP application where high performance characteristics are desired.
- » Colgel GC 215-02 has volatile content (VOC) of ca. 35 wt%.
- » Colgel GC 215-02 is ready to use, easy to spray, sag resistant and require only the addition of proper amount of an appropriate MEKP-50 to cure.

Specifications at 25 °C:

These values may or may not be manufacturing criteria; they are listed for a reference guide only. Particular batches may not conform exactly to the numbers listed because storage conditions, temperature changes, age, testing equipment (type and procedure) can each have a significant effect on the results. Gel coats with properties outside of these ranges can perform acceptably.

Property	Range	Method / According to standard
Viscosity; #4/10 rpm	7000 - 9000 mPa·s	MH1009 / ISO 3219
Thixotropic index (2.5/20)	5.0 - 7.0	MH1009 / ISO 3219
Gel time with 2% MEKP-50	6 - 12 minutes	MH3021
Monomer content (VOC)	34 - 36%	MH2034

Physical characteristics of cured nonreinforced base resin:

Property	Range	Method / According to standard
Density, 20 °C	1.15 - 1.20 kg/L	ISO 1183
Barcol hardness	35 - 45	EN 59
Tensile strength	80 - 90 MPa	ISO R 527
Elongation at break	3 - 4%	ISO 178
Flexural strength	120 - 140 MPa	ISO 178
E - modulus in tension	3400 - 3600 MPa	ISO R 527
Heat distortion temperature	85 - 95 °C	ISO 75 A

Application:

- » Colgel GC 215-02 gel coats are generally formulated for airless as well as conventional spray application.
- » Brushing or rolling is not recommended.
- » Do not add solvents such as acetone.
- » If required 1 - 3% of styrene may be added, to obtain optimum viscosity for special application purpose.

Cure:

- » It is recommended that gel time is checked in the customer's plant, because age, temperature, humidity and catalyst will produce varied gel times.

Note: The information contained herein is provided in good faith and is to the best of our knowledge accurate, but we assume no liability for its accuracy or completeness. Therefore, the buyer is advised to determine the suitability of this product for the intended use. We retain the right to make any changes according to technological progress or further developments. For safety information please refer to the current Material Safety Data Sheet.

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- » All data referencing gel or cure refers specifically to AKZO NOBEL Butanox M-50 catalyst.
- » The catalyst level should not exceed 3% or fall below 1.5% for proper cure. Recommended range is 1.8 - 2.2%.
- » This product should not be used when temperature conditions are below 18 °C.

Caution:

- » Do not over mix gel coats. Over-mixing breaks down gel coat viscosity, increasing tendencies to sag and causes styrene loss, which could contribute to porosity.
- » Gel coat should be mixed once a day for 10 minutes. Air bubbling should not be used for mixing.
- » Do not add any material other than a recommended MEKP-50.

Storage:

Uncatalyzed, standard cure gel coats have a usage life of 4 months from date of manufacture when stored at 25 °C or below in a closed container out of direct sunlight.

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