

DURELASTIC

Spray-Gelcoat BD7351X

- Fine layer (gelcoat) based on ISO-NPG
- Thixotropic, stable attitude
- Sprayable
- light-stabilised

Technical / Physical data	Colour	acc. to RAL 840 HR other colour shades on request
	Gloss	depends on form and mould release agent
	Original viscosity	approx 600 mPas at 500 1/sec.
	Mixing ratio	+ 2 % DURELASTIC-hardener MEKP-50 HD0625
	Potlife and temperature	8 to 10 Min. / 20 °C
	Thinner	DURELASTIC-Resin solution 400900 Addition: 1 to 3 %
	Density calculated	1,3 g / ml + / - 0,1
	Material usage after adding hardener	500-600 g / m ²

Storability

Approx. 3 month in original packings at an ambient temperature of 5 to 25 °C, in case the original packings are tightly closed. Opened packing must be used very shortly. The minimum storage stability of each batch is mentioned on the product label. A storage time beyond the mentioned date doesn't necessarily mean that the material is unusable. In this case a check of the qualities which are important for the respective

Due to a prolonged storage time the gelation and curing times can be changed. By adding an accelerator (e.g. BD7550) the original gelation time can be adjusted.

Processing and application

Application

Components are to be mixed homogeneously.

Spraying: as delivered viscosity

Laminate structure

In order to receive optically good surfaces, we recommend to up-laminate a spindivided glass fiber mat for the first situation, e.g. 225 g / m².

In order to avoid a pulling up of the surface layer, the pot life of the resin mixture for the first situation should not amount to any more than 20 to 25 minutes with 18 °C. The further reinforcing plies can with suitable heavier materials, e.g. glass fiber mat 450 g/m².

We recommend you DURELASTIC-Laminating resins in different attitudes, e.g. accelerates, accelerator-free, additionally thixotroped, etc.

Relaminate

After approx. 90 min., at the latest after 12 h. / 20 °C area -, material- and formtemperature.

Substrates

GFP-Forms, Metal-Forms, Releasefoil

Pretreatment

Forms treat with suitable release agent.

To application see DURELASTIC-Info. NR. 108.

Application temperature

During the processing area -, material - and form temperature are to be kept above 18 °C,

to avoid hardening disturbances and pulling up feature.

Cleaning of working equipment

EFD-cleaning agent 400906.

Advise for safety protection and protection of health

The usual precautionary measures for ventilation as well as for personal protection are to

be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning health protection and environment protection can be read in the corresponding safety data sheet.

Special remarks

Characteristics

(in hardened state)

	Testing method	unit	declared value
Barcol hardness:	DIN EN 59		44-48
Elongation at break	DIN EN ISO 527-2	%	3,6
Heat distortion temperature:	DIN EN ISO 75-2	°C	76
Glass transition temperature:	DIN EN 61006	°C	103

These data refer to the used resin combinations.

Test conditions

All information is based on a standard climate 20/65 DIN 50014.

All information are based on our product knowledge and experience. To the application we have no direct influence. For further information please don't hesitate to contact us.

The information mentioned herein are reference values and are not given as specification.