

DURELASTIC

Spray-Gelcoat BD7160

- Accelerated with co.
- Gelcoat based on unsaturated polyester resin
- Thixotropic, stable attitude
- Sprayable

Technical / physical data	Colour	acc. to RAL 840 HR other colour shades on request
	Gloss value	depends on form and mould release agent
	Original viscosity	20 to 30 Poisen
	Mixing ratio (by weight)	+ 2 %
	Hardener	DURELASTIC-Hardener-MEKP-50 HD0625
	Potlife	10 to 12 Min. / 20 °C
	Thinner	DURELASTIC-Resin solution 400900 or DURELASTIC-Spraying thinner 400901 Addition: 3 to 5 %
	Density calculated	1,3 g / ml + / - 0,1
	Material usage after hardener addition	500 to 600 g / m ²

Storability Approx. 6 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.

- in original viscosity after hardener addition with cup pistol spraying.
nozzle: 2,5 bis 3 mm spraying pressure: 3 to 5 bar
- also Airless

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 thixotropied, etc.

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 16 °C, to avoid hardening disturbances and pulling up feature.

Cleaning of working equipment

Within the working time with EFD-EFD-Thinner 400500 or EFD-Cleaner 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

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.