



BD7351X

DURELASTIC-Spray-Gelcoat

Product description

Product technology	Styrene-based gel coat
Stability	good
Resistance to light and weather	very good

General product properties

Binder-Base	Unsaturated polyester resin based on Iso-NPG
Colour	in accordance with RAL 840 HR other colours on request
Gloss value	Mould and separating agent-dependent
Viscosity	ca. 600 mPa*s
Density	1,3 g/ml theoretical
Resistance to storage	<p>approx. 3 month in original packagings at an ambient temperature of 5 to 25 °C. Open packages are to be used within a short time.</p> <p>The minimum storage stability of each batch is stated on the product label. The material does not necessarily become unusable if stored for longer than this period. However, for quality assurance purposes, an inspection of these materials is essential to ensure that they are still suitable for the intended application.</p> <p>As the time in storage increases, the gelling and curing times can change. The original gelling time can be adjusted by adding accelerators (e.g. BD7550).</p>

Application and processing

Tool/mould	GRP types (of glass fibre-reinforced plastic) Separating film Metal molds
Pretreatment	Treat moulds with suitable separating agents.
Laminate structure	<p>In order to achieve surfaces that look good, we recommend that you laminate a glass-fibre matting with very fine fibres for the first layer, e.g. 225g/m²</p> <p>In order to prevent the cover layer from being scratched, the pot life of the resin for the first layer should not exceed 20-25 min. at 18°C.</p> <p>The additional reinforcement layers can be applied using suitable, heavy materials such as 450g/m² glass-fibre matting.</p>
Mixin ratio	+ 2 % Durelastic curing agent (MEKP 50) HD0625
Thinning	EFD dilution 1-3 % 400900
Processing conditions	During processing, a room, material and mould temperature of [Variable] °C must be guaranteed in order to prevent hardening problems and cracking.



BD7351X DURELASTIC-Spray-Gelcoat

Processing time	max. 7-10 min. / 20 °C With the addition of 2 % HD0625	
Airless spraying	as delivered viscosity	
High pressure spraying	as delivered viscosity after adding curing agent nozzle 2,5-3 mm spray pressure 3-5 bar	
Material usage	500-600 g/m ² mean test layer thickness	theoretical
Cleaning of equipment	with EFD cleaning agent 400906 within the processing time.	

Further processing of coated pieces

Over-laminatable	after 90 min., at the latest after 12 hours at 20°C material and room temperature.
-------------------------	--

Mechanical tests

mechanical properties	Barcol hardness 934-1	44-48	DIN EN 59
	Elongation at break	3,6 %	DIN EN ISO 527-2
	HDT	76 °C	DIN EN ISO 75-2
	Tg	103 °C	DIN EN 61006
	This information refers to the cured, unreinforced pure resin.		

Comments

Work-and Healthprotection	The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health and Safety at Work and environmental protection can be found in the corresponding safety data sheet.
Test conditions	All information is based on a standard climate 23/50 DIN EN 23270. All information is based on our product knowledge an experience. We have no direct influence on the application itself. Please do not hesitate to contact us for further information. The information provided here contains reference values and does not constitute a specification.