BD9120X
DURELASTIC-System-Gelcoat

Product description

Product technology	Styrene-based gel coat
Application	spreadable
Stability	very good

General product properties

Binder-Base	Unsaturated polyester resin based on orthophthalic acid
Colour	in accordance with RAL 840 HR other colours on request
Gloss value	Mould and separating agent-dependent
Viscosity	3000 - 6500 mPa*s
Density	1,3 g/cm³ theoretical
Resistance to storage	approx. 6 month in original packagings at an ambient temperature of 5 to 25 °C. Open packages are to be used within a short time. 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. 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).

Application and processing

	GRP types (of glass fibre-reinforced plastic)
Tool/mould	Separating film
	Metal molds
Pretreatment	Treat moulds with suitable separating agents.
Note before use	Prior to use, stir slowly and well without letting air in or mix components homogeneously.
Mixin ratio	+ 2 % Durelastic curing agent (MEKP 50) HD0625
Thinning	EFD dilution 3-5 % 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.
Processing time	max. 12 - 15 min. / 20 °C With the addition of 2 % HD0625
painting	as delivered viscosity
Rolling	as delivered viscosity
Material usage	500-600 g/m² mean test layer thickness theoretical

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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	Bending strength	132 MPa	DIN EN ISO 178
	E-module	3150 MPa	DIN EN ISO 178
	Tensile strength	63 MPa	DIN EN ISO 527-2
	This information refers to the cured, unreinforced resin combination.		

Comments

System Coating	Can be integrated into the system coating concept as a horizontal system coating (different coatings with the same look) or vertical system coating (part of a multi-layer structure). For more information, see www.freilacke.de/systemlacke.
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.

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