



## BD9351X

## DURELASTIC-System-Gelcoat

### Product description

<b>Product technology</b>	Styrene-based gel coat
<b>Stability</b>	good
<b>Resistance to light and weather</b>	very good

### General product properties

<b>Binder-Base</b>	Unsaturated polyester resin based on Iso-NPG
<b>Colour</b>	in accordance with RAL 840 HR other colours on request
<b>Gloss value</b>	Mould and separating agent-dependent
<b>Viscosity</b>	ca. 600 mPa*s
<b>Density</b>	1,3 g/ml <span style="float: right;">theoretical</span>
<b>Resistance to storage</b>	<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

<b>Tool/mould</b>	GRP types (of glass fibre-reinforced plastic) Separating film Metal molds
<b>Pretreatment</b>	Treat moulds with suitable separating agents.
<b>Laminate structure</b>	<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/m<sup>2</sup></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/m<sup>2</sup> glass-fibre matting.</p>
<b>Mixin ratio</b>	+ 2 % Durelastic curing agent (MEKP 50) HD0625
<b>Thinning</b>	EFD dilution 1-3 % 400900
<b>Processing conditions</b>	During processing, a room, material and mould temperature of [Variable] °C must be guaranteed in order to prevent hardening problems and cracking.



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

### Further processing of coated pieces

<b>Over-laminatable</b>	after 90 min., at the latest after 12 hours at 20°C material and room temperature.
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### Mechanical tests

<b>mechanical properties</b>	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

<b>System Coating</b>	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 <a href="http://www.freilacke.de/systemlacke">www.freilacke.de/systemlacke</a> .
<b>Work-and Healthprotection</b>	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.
<b>Test conditions</b>	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.