

FREOPUR

Gelcoat BD7330X

- Sprayable 2K-PU-Gelcoat System for sanitary applications
- Medium reactive
- Good chemical resistance
- Solvent-free
- Self releasing

Technical / physical data	Colour	colour shades on request
	Original viscosity	1000 - 3000 m.Pa.s rotational viscometer, shear rate 500s-1
	Mixing ratio / hardener by weight	100 : 60 FREOPUR-Hardener HD0240
	Potlife	4,5 – 6,5 min. / 20 °C
	Density after hardener addition calculated	1,20 g / ml + / - 0,05
	Solid content after hardener addition calculated	approx 100%
	Consumption calculated after hardener addition in original viscosity, without application loss	approx. 720 g / m ² dry film thickness approx 600 µm dependent on the desired layer thickness

Storability Approx. 4 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

Processing and application**Application**

- process with 2K-low pressure machine
- spraying min. 500 - 700 µm
- after 10 min. reinforcing by a suitable PUR-resin
- demoulding after 30 minutes
- avoid contact with water or polar solvent

Substrates

epoxy moulds, heated to 50°C

Pretreatment

Moulds must be cleaned, free of dust, oil and fat.
Preatreat with Acmos 36-1659-206.

Application temperature

BD7330X: 70°C
HD0240: 80°C

Cleaning of working equipment

At once with MPA, hardened residues can only removed mechanically.

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**Stability**

Good resistance against weak acids, bases and alcohols, colorants and oxidising agents.

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.