

# Gelcoat® 9091

## TYPE

Non-accelerated gelcoat based on orthophthalic acid thixotropic

## APPLICATION

can be applied by brush, roller or spray gun

## SPECIAL PROPERTIES

good weather resistance, good surface hardness with a great degree of toughness

## USE

gelcoat resin for the manufacture of containers, pipes, boats, sanitary and mould constructions

## PRODUCT DATA

Determined per batch:

Non-Volatile Matter DIN EN ISO 3251 non-volatile matter (1 h; 125 °C; 1 g)	[%]	66,5 - 70,5
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Gel Time (UP-Resins) DIN 16945 / 6.3.1.2 gel time 2,0 % MEKP + 1,0% Co1 (20 °C)	[min]	6 - 14
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Colour / Appearance VLN 250 colour appearance		colourless cloudy
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Diluting Properties (UP) VLN 237 dilutability range (STY)		>10:1
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Not continually determined:

Density (Liquids) DIN EN ISO 2811-2 density approx. (20 °C)	[g/cm³]	1,1
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Flash Point DIN EN ISO 1523 flash point approx.	[°C]	34
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## CURING

Curing is possible at room temperature by addition of keton peroxide, e.g. MethylEthylKetonPeroxide. Do not catalyze at levels below 1 % or above 3 % as this may cause curing problems. Two percent is recommended. Take care that the water content of the chosen peroxide is as low as possible. The water content of the peroxide should be below 3 %.

## PROCESSING

The Gelcoat has to be well homogenised in the original packing shortly before processing, either by stirring or by rolling the drums. The Gelcoat has to be applied with a flat brush with soft bristles and an unpainted handle. The Gelcoat should be applied only with an absolutely dry brush or roller (it must not contain solvent any more).

Recommended gelcoat-quantity: 500 - 850 g/m² for a film thickness of 0.4 - 0.7 mm. Two coats are recommended to ensure a homogenous thickness. The first coat must be allowed to cure before application of the second. Observe that the gelcoat as well as the mould should have a temperature of at least 20 °C.

As soon as the Gelcoat-layer is cured, laminate-build-up should be started. Sufficient curing is achieved when after dabbing with a finger no gelcoat sticks to the finger although the surface may be tacky (finger-test).

## PROCESSING TIME

The processing time may be varied with a suitable choice of accelerator and peroxide concentration.

## HUE

For optimal appearance it is recommended to use only one batch per moulded part. Please blend and homogenise several batches if the use of only one batch is not possible.

## STORAGE

At temperatures up to 25 °C storage stability packed in original containers amounts to at least 180 days.

The product should be stored under exclusion of direct sunlight in the original, undamaged and closed packaging in a dry and cool place. Gelttime and curing time can change during progressive storage. Shelf live is reduced at higher storage temperatures.

## PRECAUTIONS

Please notice the information in the material safety data sheet (MSDS).

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