CRYSTIC GELCOAT 11PA

Spray Iso - NPG Gelcoat for Mould Making

Introduction
Crystic Gelcoat 11PA is an Iso - NPG polyester gelcoat, thixotropic and pre-accelerated, specially designed to be spray applied.

Application
Crystic Gelcoat 11PA has been specially formulated for mould making. It is pre-accelerated and only requires the addition of the catalyst to start its curing reaction.

Features and benefits

Features	Benefits
High heat resistance	High dimensional stability Excellent mechanical properties
High surface hardness	Excellent surface aspect and gloss Excellent gloss retention

Variants
Crystic Gelcoat 11PA is available in a brush version under the reference Crystic Gelcoat Moule H.

Formulation
Crystic Gelcoat 11PA must be allowed to attain workshop temperature before use. Stir well by hand or with a low hear mixer to avoid aeration, and then allow to stand to regain thixotropy.

The recommended catalyst is Butanox M50 (or other equivalent catalyst) which should be added at 2% to the gelcoat.

Recommended Testing
It is recommended that customers test all pigmented gelcoats before use under their own conditions of application to ensure the required surface finish is achieved.
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Gel Time
Catalyst level and temperature will influence the gel time. Typical gel time at 20°C of Crystic Gelcoat 11PA with 2% Butanox M50 is 9 to 11 minutes.

Property		Liquid Gelcoat
Viscosity at 25ºC (Brookfield HBT, Sp n°2, 5rpm)	dPas	9280 - 10240
Specific Gravity at 25ºC		1.15 – 1.35
Stability at 20ºC	months	3
Property		**Fully cured Base Resin**
Barcol Hardness (model GYZJ 934-1)		40
Heat Deflection Temperature (1.80 MPa)	ºC	98
Elongation at Break	%	2.2
Tensile Strength	MPa	50
Tensile Modulus	MPa	2100
Specific Gravity at 25°C		1.14
Volumetric Shrinkage	%	8
Refractive Index n 20/D		1.557

(Curing schedule - Test According to BS 2782:1976)
1MPa = 1MN/m^2 = 1N/mm^2 = 10.2 kgf/cm^2

Packaging
Crystic Gelcoat 11PA is supplied in 25kg kegs and 200kg drums.

Storage
Crystic Gelcoat 11PA should be stored in its original container out of direct sunlight. It is recommended that the storage temperature should be less than 20°C where practical, but should not exceed 30°C. Ideally, containers should be opened only immediately prior to use

Health & Safety
Please refer to Material Safety Data Sheet.

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