



Mould Making Gelcoat

Code M55G4--

PRODUCT FEATURES

Marinline-branded mould making gelcoats allow manufacturing articles having a homogeneous surface. They show a high styrene resistance and a good flexibility, in order to avoid cracking during production cycles. They can be easily polished. These gelcoats are ideal for fiberglass mould making, both for hand lay-up and low pressure injection molding technology.

APPLICATION

Pre-accelerated gelcoat. It requires 1,5 to 2% MEKP catalyst to harden, with a thickness range between 0,6 and 0,8 mm (650 - 850 gr/m²).

Avoid using at a temperature lower than 15°C. Do not dilute with acetone.

PACKAGE

Tins 25 Kg (L)

VERSIONS

Brush or spray application. Available in the following colours: black, orange, green.

PROPERTIES OF THE NON-CURED PRODUCT

PROPERTY	METHOD	UNIT OF MEASUREMENT	VALUE
Appearance	/	/	Thixotropic fluid
Brush viscosity at 25°C	UM 3	cps	12.000 – 16.000
Spray viscosity at 25°C	UM 3	cps	6.000 – 8.500
Film Gel time at 25°C ¹	UM 2	minutes	20 – 40
Mass Gel time at 25°C ²	UM 2	minutes	5 – 11
Specific weight	UM 7	g/ml	1,15 – 1,25
Stability	UM7	months	max 4

PROPERTIES OF THE CURED PRODUCT

PROPERTY	METHOD	UNIT OF MEASUREMENT	VALUE
Water absorbing	/	%	< 0,2
Barcol hardness ³	ASTM D 2583 - 75	/	> 40
Elongation at break	ISO/D 527 – 1966	%	2-3
HDT	ISO 75 – 1974	°C	> 100

Remarks

¹ Catalysis 2% MEKP 50% thickness 0,5 mm² Catalysis 2% MEKP 50% mass 100 g³ After 3 hours at 60°C



IMPORTANT NOTE

The information given in this technical sheet is not intended to be exhaustive and any person, using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us of the suitability of the product for the intended purpose, does so at his own risk.

While we endeavour to ensure that all advice we give about the product is correct, we have no control over either the quality or condition of the substrate or the many factors affecting the use and application of the product.

Therefore, unless we specifically agree in writing to do so, we do not accept any liability whatsoever or howsoever arising for the performance of the product or for any loss or damage arising out of the use of the product.

The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.