

1-DEFINITIONS

Gel coat **GC 206** is based on a vinyl ester resin. The gel coat is suitable for polyester laminate, mould making Formulated for brush application.

2- CHARACTERISTICS

- ◆ Thixotropic and pre-accelerated.
- ◆ Good handle ability.
- ◆ High quality with very good mechanical properties.
- ◆ High brightness. The brightness measured by our laboratory: 95 with a gloss meter with a 60 degrees angle.

3- PROPERTIES OF LIQUID GEL COAT

<u>Brookfield viscosity</u> (ISO2555 - 20°C – sp6)	5 rpm 30000mPa.s 50 rpm 7000 mPa.s
<u>Specific gravity</u> (ICON 012)	1.10 g/cm ³
<u>Non volatile content</u> (ICON 003)	60%
<u>Geltime</u> (ICON 002) (20°C – 2ml PMEC on 100g)	15 minutes

4- PROPERTIES OF CAST GEL COAT

<u>Flexural strength</u> (ISO 178)	155, 2 MPa
<u>Flexural modulus</u> (ISO 178)	3, 44 GP
<u>Tensile strength</u> (ISO 527)	38,58 MPa
<u>Elongation at break</u>	2.10%
<u>Barcol Hardness</u>	45
Mechanical tests carried out on 5 specimens of cast gel coat catalysed with 2% of MEKP M50, curing time at room temperature for 24 hours, then post cured for 3 hours at 80°C.	

5- GEL TIME ACCORDING TO THE TEMPERATURE

Geltime done on 100g

	1% MEKP M50	1.5% MEKP M50	2% MEKP M50	2.5% MEKP M50
20°C	50 min	31 min	14 min	10 min
25°C	30 min	18 min	10 min	7 min
30°C	23 min	14 min	7 min	6 min
35°C	14 min	7 min	6 min	4 min

6 - VERSIONS

Gel coat **GC 206** is available in the following colours: blue 5900, green 6900, black 9900 or clear 9901. Also available in spray version **GC 207**.

7 - APPLICATION ADVICES

Mix the peroxide well, never put under 1% or over 2.5%.

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We recommend to catalyse with 2% MEKP M50.

Never apply the **gc 206** at temperature under 18°C.

Apply 700 – 800 µm layers in 2 passes.

The first layer of **gc 206** must have a thickness of 400 – 500 µm.

When the first layer is cured, then apply 300µm of **gc 206**

Avoid excess thickness especially in angles. We recommend the application of several thin layers rather than a thick one in order to obtain a final thickness of 0.8 mm.

To obtain an optimal result, we recommend to apply after the **gc 206** the resin R 842 (see the technical data sheet NT R169Fof R842).When the R842 is cured, start to laminate with a moulding resin like R2000, R2000/50 or R2550

8 – POST CURING RECOMMENDATION

To obtain optimal resistance properties, the laminate with the **GC 206** should be post cured.

Keep the laminate at ambient temperature (18- 20°C) during 24 hours after the application of the last layer of moulding resin. Then post cure for 16 hours at 40°C.

9- PACKAGING

Gel coat **GC 206** is available in cans of 5 – 25 kg.

10- STORAGE CONDITIONS

Minimum storage life: 3 months

The gel coat is subject to the Highly Flammable Liquids Regulations. The product should be stored under cool conditions in closed opaque containers at a temperature not exceeding 25°C. Avoid exposure to heat sources such as direct sunlight.

11 – ADDITIONAL TESTS

Each **gc 206** batch will be delivered with a certificate of the trials done in laboratory prior to every delivery.

Before using the product and making the mould, the customer should test the **gc 206**, as NORD COMPOSITES cannot be responsible for the application process of the customer, nor for any damage or loss caused to mouldings by misuse of the gel coat.