

1- CHARACTERISTICS

Gel coat **GC 207** is based on a vinyl ester resin. He gel coat suitable for polyester laminate mould making.

- ◆ Gel coat **GC 207** is thixotropic and pre-accelerated. Formulated for spray application.
- ◆ 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.

2- PROPERTIES OF LIQUID GEL COAT

Brookfield viscosity (ISO2555 - 20°C – sp5)	5 rpm 12500 mPa.s 50 rpm 2300 mPa.s
Specific gravity (ICON 012)	1.05 g/cm ³
Non volatile content (ICON 003)	52%
Geltime (ICON 002) (20°C – 2ml PMEC on 100g)	15 minutes

3- PROPERTIES OF CAST GEL COAT

Flexural strength (ISO 178)	155,2 MPa
Flexural modulus (ISO 178)	3,44 GPa
Tensile strength (ISO 527)	38,58 MPa
Elongation at break (ISO 527)	2.10%
Barcol Hardness	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.	

4- 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	42	24	13	10
25°C	27	16	8	7
30°C	22	12	7	6
35°C	13	8	5	4

5 - VERSIONS

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

6 - APPLICATION ADVICES

Mix the peroxide well, never put under 1% or over 2.5%.
 We recommend to catalyse with 2% MEKP M50.
 Never apply the **gc 207** at temperature under 18°C.
 Apply 700 – 800 µm of gc 207 wet on wet in several thin passes.

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Avoid excess thickness especially in angles. We recommend the application of several thin layers rather than a thick one. And we recommend to wait a few minutes between each layer.

To obtain an optimal result, we recommend to apply after the **gc 207** 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

7 – POST CURING RECOMMENDATION

To obtain optimal resistance properties, the laminate with the **GC 207** 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.

8 - PACKAGING

Gel coat **GC 207** is available in cans of 5 – 25 kg.

9- 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.

10 – ADDITIONAL TESTS

Each gc 207 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 207, 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.