TECHNICAL DATA SHEET

GSV – VINYLESTER TOOLING GELCOAT

This type of gelcoat is produced with vinylester resins which have a high resistance to chemical agents and excellent mechanical properties.
The use of vinylester tooling gelcoat is particularly recommended for making high-tech moulds and artifacts.
The mould must not be put into service before the gelcoat has reached a hardness index of at least 35 barcol. The minimum temperature during treatment and after treatment should be at least 18°C.
GV might appear thick, almost as a gel consistency, when the pail is opened.
By stirring, the thixotropy will reach the values corresponding to the product data sheet.

GENERAL INSTRUCTIONS FOR USE

The vinylester tooling gelcoat is pre-accelerated and thixotropic.
Available in the versions: H-BRUSH, S-SPRAY.
Colors: 10-green.
Packaging of 20 kg.
Recommended peroxide percentage (MEKP): 1,5 - 2%.
Film thickness: 0,7 – 0,9 mm.
Apply a test sample of the tooling gelcoat before the main operation, to ensure you get a good result.

STORAGE

→ To ensure maximum stability and maintain optimal resin properties, resins must be stored in closed containers at temperatures below 24°C, away from sources of heat and sunlight.
→ The product must be heated to at least 18°C prior to use, to ensure proper curing and handling.
→ All storage areas and containers must comply with local fire and building codes.
→ Copper or copper-containing alloys should be avoided as containers.
→ Store the product separated from oxidizing materials, peroxides and metal salts.
→ Keep containers closed when not in use. In its original packaging, the product can be used for **3 months**.

PHYSICAL DATA IN THE LIQUID STATE AT 23°C

Property	Spray	Brush	Unit	Method
Viscosity: (Brookfield RVT: sp.4/4 rpm)	10000 - 15000	17000 – 23000	mPa.s (cP)	I-MIA 10
Density	1,05 – 1,15	1,05 – 1,15	g/cm^3	I-MIA 02
Flash Point	32	32	°C	ASTM D 3278-95
Gel Time (1,5 % MEKP)	10 – 20	15 – 25	Minutes	I-MIA 15

MECHANICAL / PHYSICAL DATA OF THE CURED RESIN (*)

Property	Value	Unit	Method
Tensile strength	85	MPa	ISO 527 – 1/2
Tensile modulus	3400	MPa	ISO 527 – 1/2
Elongation at break	≥ 6	MPa	ISO 527 – 1/2
HDT	104	°C	ISO 75 – 1/2
BARCOL hardness 934 – 1	≥ 35	Unit	ASTM D 2583
(*) 2% MEKP 50% / 24h at 23°C + 3h at 100°C			

SAFETY

See product SDS before working it.

The information and data contained in this technical sheet are based on the measurements and experience gained; in good faith, they are made available to the customer who is responsible for the application verification and the definition of suitability for the intended use.
INTEC assumes no responsibility for the results obtained in the specific application made by the user.

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