

industrial gel coat

Industrial gel coats are formulated with ortophtalic polyester resins in styrene and inorganic fillers. Due to their composition, they are particularly suited for application as topcoats or where the pieces will be coated after demoulding. They are used in all those applications where chemical resistance is not required. Main features of this line of gel coats are:

- very easy to sand paper
- high resilience
- application easiness
- surfaces with no porosity
- no shrinkage

They can be also supplied in the self-releasing version, to facilitate the demoulding operations, or as topcoats, to improve superficial curing when used directly on final pieces.

application

For the application we strongly recommend to check the temperature of the product, moulds and workshop, that has to be between 18°C and 25°C. Our gel coats are already accelerated and have to be catalyzed with standard MEKP between 1,5% - 2%. Wet film thickness, depending on moulds and application methods, has to be roughly 0,4 - 0,5 mm, equivalent to 600-800 gr/m² of gel coat.

When applied with "airless" or similar equipment, we recommend the fine tuning of the machine (nozzle and pressure). If for the application a further dilution is needed, type and quantity of diluent may vary according to specific needs: always ask our technical service before. We do not recommend the use of acetone, particularly in the brush versions.

versions

spray up	yes
roller	yes
brush	yes
self-release	yes
topcoat	yes
coloured	yes
transparent	no
fast gel time	yes

applications

car body
isothermic trucks
marine
transportation
industrial parts
repairing

chemical-physical properties

	method	unit	107314P	107314AV	107314	107314C	
applicaton			spray up	roller/veil	brush	brush topcoat	<p>packaging</p> <p>Kg. 30 / 200 / 1.000 plastic liner on demand</p> <p>colours</p> <p>italbeit colour card</p> <p>Ral colour card</p> <p>colour matching service</p> <p>stability</p> <p>3 months if stored in its original closed pails, between 16°C and 22°C, away from naked flames, heat sources and not in direct sun light.</p> <p>warnings</p> <ul style="list-style-type: none"> • flammable product, keep away from naked flames, sparkles and heat sources. • do not smoke, drink or eat when using it. • avoid static charges. • keep the workshop properly ventilated
appearance	A 01*	visual	white thixo	white thixo	white thixo	white thixo	
solid content	C 08*	%	74 ± 2	74 ± 2	79 ± 2	79 ± 2	
specific weight	DIN 63217	g/cm ³	1,4 ± 0,1	1,4 ± 0,1	1,4 ± 0,1	1,4 ± 0,1	
Barcol	ASTM D 2583	unit	=> 40	=> 40	=> 40	=> 40	
gel time	P 04*	minutes	7 ± 2	6 ± 2	6 ± 2	9 ± 2	
peak	P 04*	°C	150 ± 15	150 ± 15	135 ± 15	130 ± 15	
°C increase from 35°C	P 04*	°C/min	=> 10	=> 10	=> 10	=> 10	
viscosity rpm 2 rpm 20	ASTM D 2196	mPa.s mPa.s	20.000/30.000 4.500/6.500	13.000/18.000 2.500/3.500	120.000/160.000 18.000/28.000	95.000/120.000 16.000/20.000	
thix index	ASTM D 2196	ratio	=> 5	4/5	=> 5	=> 5	
<p>* italbeit's method</p> <p style="text-align: center;">italbeit srl via Diaz, 9/11 Nerviano (Mi) - Italy info@italbeit.it</p>							
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