



## SG 520 Blue / SD 5202 Epoxy tooling gelcoat

### Description

Epoxy tooling gelcoat **SG 520 Blue** is used for a small to medium production scale tool making. This gel coat is easy to brush, with an ideal thixotropy, it dries off quickly and it is not very sensitive to workshop conditions. **SG 520 blue** allows mechanical key with a surface veil or a carded (verrane) type fabric. It has a dark color and is sandable.

### Properties

		<b>Resin SG 520 Blue</b>	<b>Hardener SD 5202</b>
Aspect :		Gel	Liquid
Color		Blue	Yellow
Viscosity (mPa.s)	@ 20 °C @ 25 °C	Thixotropic gel Thixotropic gel	2000 ± 300 1650 ± 300
Density (Kg/l)	@ 20 °C	1.14 ± 0.05	1.09 ± 0.05

### System SG 520 / SD 5202

Gel time on 150 g mix	@ 20 °C @ 25 °C	19 mn 15 mn
Time to dry off on film of 400 microns	@ 20 °C @ 25 °C	1 h 15 50'
Time to overlay on a film of 400 microns	@ 20 °C @ 25 °C	2 h 1 h 30
Mixing ratio		<b>100 g / 32 g</b>

Others : **520 Black / 5202** : 100 g / 29 g

### Advised post-cure cycle

If possible the post-cure will be done in the mould to limit the print of the fiber  
24 hours @ 20-25°C + 24 hours @ 40°C ( Tg 1 = 63°C )  
or 24 hours @ 20-25°C + 8 hours @ 50°C ( Tg 1= 71°C , Tg 1 max. = 75°C)

### Workshop conditions

18 °C < Temperature of the substrate < 50°C  
Hygrometry < 80%

### Release agent

Verify by a preliminary trial the compatibility with **SG 520** (Fish eyes, releasing capacity...)  
**Wax 103** : for post-cure or exotherm of 50 °C maximum and undiluted gelcoat.  
**Cirex** : for post-cure or exotherm over 50°C and diluted gelcoat.



## Application

Brush / Roller for lacquer  
Let the gelcoat get thicker before applying the second coat or laminating.

## Consumption

brush / roller: 100 to 300 g /m<sup>2</sup>

## Laminating

The laminating must start when the SG 520 gets thicker.




## Cleaning

Diluent **EP 960**, Methylene ketone (MEK), solvent for epoxy paints.

## Packaging (by Kg)

Kits	Resin <b>SG 520 Blue</b>	Hardener <b>SD 5202</b>
1.32	1	0.32
4.13	3.13	1
	Resin <b>SG 520 Black</b>	Hardener <b>SD 5202</b>
1.29	1	0.29
4.13	3.13	1

## Safety data

Products	Labels	Risk Phrases	
<b>SG 520</b>	 	Xi Irritating N Dangerous for The environment	36/38 - 51/53 - 43
<b>SD 5202</b>		T Toxic	20 - 24/25 - 35

**Classification CEE in accordance with the Annexe I of the Directive 67 / 548 / CEE**  
**For more informations, check safety data sheet.**

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