

SG 530 GM

Epoxy tooling gelcoat 60°C

Description

SG 530 GM is an epoxy gelcoat designed for mould making, moulds with a service temperature of 60-70°C.

SG 530 GM is applied with brush or lacquer roller, cure at ambient temperature and must be post-cured to obtain its thermal resistance.

With an adapted viscosity, **SG 530 GM** becomes smooth as you apply it, permit to coat vertical areas and sharp angles without sagging.

SD 544.4 is a slow hardener, it allows coating of large surfaces, mass exotherm is low. This gelcoat cure slowly without surface pollution.

SG 530 GM can be overlaid with a surface veil or a carded (verrane) type fabric, this will create a mechanical key between **SG 530 GM** and laminate. By this process, you can overlay an epoxy gelcoat the day after its application.

Properties

Reference	description	Aspect/Colour	Viscosity @ 20°C (Cps)	Viscosity @ 25°C (Cps)	Density @ 20°C (g/ml)
SG 530 GM	Gelcoat	Black gel	Thixotropic gel	Thixotropic gel	1.25 ± 0.1
SD 544.4	Hardener	Brown liquid	320 ± 50	250 ± 50	1.02
SG 530 / SD 544.4	Mix	Black gel	Thixotropic gel	Thixotropic gel	1.20

Mixing ratio

Mixing ratio by weight of **SG 530 / SD 544.4** :

100g / 27g

Mixing ratio by volume of **SG 530 / SD 544.4** :

cannot be used.

Reactivity

	@ 20°C	@ 30°C
Pot-life on 150g mix	60 min	30 min
Time « set to touch » on film 500g/m ²	5 h 00 min	2 h 30 min
Time « dry to touch » on film 500g/m ²	8 h 00 min	5 h 00 min
Time for applying mechanical key mini – maxi @ 40% HR	3 h to 4 h	1 h 30 min to 2 h 30 min

Other possible system

SD 530 GM / SD 8205

Type : Tooling gelcoat

Tg 1 max : 97°C

Mixing ratio by weight : 100 g / 24 g

@ 30°C :

-Set to touch : 1 h

-Mechanical key after : 35 min to 50 min

Workshop conditions

- 18°C < Substrate temperature < 50°C

- Hygrometry < 70°C

Release agent

Verify by preliminary tests demoulding capacity of the release agent.
Select a release agent with a service temperature of 60°C minimum.

Application

Use a mechanical way with high shearing to mix **SG 530 GM** and **SD 544.4**.
Respect precisely mixing ratio by weight. Mix the two components, mind the sides and the bottom of the recipient.
Prepare quantity applicable within 30 min.
By brush or lacquer roller, **SG 530 GM** is self-leveling, do not dilute.

Laminating

Laminating can start when **SG 530 GM** is set to touch, or later when a mechanical key has been applied.

Mechanical key

A mechanical key is a surface veil or a carded type fabric, applied onto gelcoat when it is still wet but starting to set. The principal is to have half of the fabric wet by **SG 530 GM**, the other half is wet by the resin system. Use a clean, dry lacquer roller to apply gently the fabric on **SG 530 GM**

Avantages :

- Late overlay of gelcoat.
- Less print of fibers
- Very good adhesion between gelcoat and laminate.

Cure cycle

Same as resin used for laminating.
Maximum post cure temperature : 90°C
A minimum of 12 h @ 40°C is necessary before release.



Thermal stability

Tg 1 max : 105°C

Storage

@ 25°C, shelf-life is at least 1 year, in original container, for **SG 530 GM** and **SD 544.4**.

Safety data

Products	Labels	Risk Phrases
SG 530 GM	 Xi Irritating	R 36/38 – R 51/53 – R 43
SD 544.4	 T Toxic	R 20/21/22–R 48/43/45

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

The informations that we give by writing or verbally, in the context of our technical assistance and our trials, do not engage our responsibility. We advice the users of SICOMIN's epoxy system, to verify by some practical trials if our products are suitable for the envisaged processes and applications. The use, the implementation and the transformation of the supplied products, are not under our control and your responsibility only will respond for it.
If our responsibility should nevertheless be involved, it would be, for all the damages, limited to the value of the goods supplied by us and implement by you. We guaranty the non-reproachable quality of our products, in the general context of sales and delivery.