

15.7.96 - GCMBen 30
Technical information

GELCOAT
SPRIGEL PX

PROPERTIES

SPRIGEL PX gelcoats are based on unsaturated polyester resin. Their specific formulation gives good adhesion with epoxy laminating resins.
These laminates have the properties of the both systems : polyester gelcoat/epoxy resin. They are used when very good mechanical resistance and nice surface are needed : gliders, cars, surfboards...

REMARKS

1. The different epoxy systems and working practices used by our customers are not under our control. We strongly recommend industrial trials to check if bonding between gelcoat and epoxy laminate is good and if properties of final are according to specifications.
2. SPRIGEL PX gelcoats are polyester gelcoats : they have classical properties of this type of material. They are not recommend for the building of parts where mechanical or chemical resistance are needed (molds building...)

APPLICATION

SPRIGEL PX gelcoat is supplied accelerated, either with a standard viscosity, either with airless viscosity. The gelcoat must be stirred gently before use.
Temperature of workshop, gelcoat and tools should be 18-25 °C and relative humidity below 85 %.
Quantity of MEKP 50 % catalyst used should be 1.5-2.5 %. Applied gelcoat thickness should be 300-500 microns depending of the final use.
Curing time before polymerisation is between 1 h 15 and 3 h.

HANDLING INSTRUCTIONS

Chemical composition : styrene solution of unsaturated polyester
Fire hazard : category II of flammable liquid
Transport classification : IMCO 3.3 Page 3153 UN n° 1866
Flash point : 23 °C
Fire fighting equipment : chemical fire extinguishers
Skin : wash with soap and water
Eyes : rinse immediately with plenty of water and seek medical advice
Waste disposal : soak up with sand, sawdust or similar absorbent material

STORAGE

It is highly recommended that the material is stored at stable temperatures under 25°C, and away from direct sunlight, for a maximum of 3 (three) months. Prolonged storage outside of recommended conditions sometimes influence liquid resin properties like viscosity and geltime. All facts and recommendations in this leaflet are presented in accordance with the best information available to us. They must not, however, be taken for a maker's guarantee, because conditions prevailing by the customer can effect the properties of the end product.

PROPERTIES

PROPERTIES OF SPRIGEL PX	VALUE	UNIT	METHOD
Viscosity at 23 °C - Brookfield RV4	1500-2000	mPas	ISO 2555
Spray grade, V6	7000-11000	mPas	ISO 2555
- 50 rpm	3500-4000	mPas	ASHLAND D006
- 5 rpm	10000-14000	mPas	
Brush grade, V3	7-11	min	
- 50 rpm	75	min	
- 5 rpm			
Curing at 23 °C 2 % P MEK			
- geltime			
- film curing 0,4 mm			

CONDITIONING

25 kg to 30 kg drums. Fully opening 220 kg barrels.

QUALITY STANDARDS

The production and sales of Ashland Polyester SAS products are subject to quality control and are certified to **ISO 9002 Standards** (1994)