TECHNICAL DATA SHEET

GELCOAT POLYESTER ISOPHTHALIC SPRAY LOW STYRENE WHITE

PRODUCT IDENTIFIER

Product Name:	**Gelcoat Polyester Isophthalic Spray Low Styrene White 1334501 Rev.1**
Revision Date:	03-OCT-2025

MAIN CHARACTERISTICS

Product Type

Preaccelerated Unsaturated Polyester Gel Coat in styrene, Isophthalic

Appearance

White

Key Features & Benefits

Fast curing
Good resistance to Gloss loss
Good resistance to Surface Yellowing
Good UV resistance
Good water resistance
High reactivity
High resistance to sagging
Low styrene content
Low styrene emission
Pigmented
Preaccelerated
Resilient Mechanical Properties
Thixotropic

Description

Gelcoat Polyester Isophthalic Spray Low Styrene White are a specific range of gel coats with lower styrene content

Gelcoat Polyester Isophthalic Spray Low Styrene White is a tailor made low styrene content spray gelcoat for general composite mouldings

PA Gel coats are ready to use, easy to spray, sag resistant, fast curing and require only the addition of the correct amount of an appropriate MEKP to cure

These are available in a limited range of colours but colour matching requests are possible

This product range is ready to use and exhibit good application characteristics

TECHNICAL DATA SHEET

Application

Application equipment should be maintained and regularly calibrated to maximise performance. Poorly maintained equipment or poor application will quickly negate the beneficial properties of the gel coat.

Do mix the Gel coat prior to use, preferably using a mechanical mixer with sufficient power for the appropriate container at low rpm. Mixing for 10 minutes every day is usually sufficient. Do NOT use air bubbling directly to mix.

Do not overmix the gel coat, it may break down viscosity, increasing tendency to sag and also result in styrene loss which could contribute to porosity.

Ensure Gel coat is used at minimum liquid temperature of 18°C including the mould used and workshop environment conditions

Film thickness above 600 micron may pre-release, trap porosity, crack and are more subject to weathering discolouration.

Film thickness below 300 micron may not cure properly, may be hard to patch, have more print through, and be more susceptible to water blisters

Follow best practice application techniques

Gelcoat film when sprayed should ideally be built up in multiple even passes of 125-200 micron maintaining a wet line during application process to achieve the total film thickness required

Ideal thickness is 500 micron with a range of 400-600 microns wet film

Spray grade materials are only designed for use with spray equipment and not for brush or roller application

Use only the recommended MEKP Peroxide dosage between 1.2 to 3.0% w/w

Shelf Life & Storage

Please ensure you rotate stock and use within shelf life

Please note the Shelf life for this product relates to unopened containers; Only open container prior to use

Read carefully the Safety Data Sheet before use

Store in the shade, out of direct sunlight. Keep storage temperature below 25°C. Shelf-life will be reduced at higher temperature.

CHARACTERISTICS(1)

PROPERTIES	TEST METHOD	UNIT	TYPICAL VALUES
Shelf life at 23°C in the dark		months	3
Solid content		%	61 - 71
RHEOLOGY			
Brookfield viscosity at 25°C, sp 4 rpm 4		mPa.s	12000 - 16000

Brookfield viscosity: 2 rpm / 20 rpm at 25°C			6.0-7.5
REACTIVITY			
Gel Time at 25°C + 1,8% MEKP50		minutes	**5 - 8**
Curing time at 25°C + 1,8% MEKP50		minutes	9 - 20
Peak exotherm at 25°C + 1,8% MEKP50		°C	160 - 220
FILM PROPERTIES			
Tack free Film cure : 500-700u at 25°C		min.	30 - 45
Complete Hide		microns wet	500 - 700

1) Thoroughly test the gelcoat in your applications before full-scale use. Geltimes may vary due to the reactive nature of these materials and due to different brands of curing additives. Always test on small scale before formulating large quantities.

PROPERTIES OF THE GELCOAT'S BASE RESIN IN CURED STATE (2)

PROPERTIES	TEST METHOD	UNIT	TYPICAL VALUES
Curing cycle	16h at 40°C		
HDT		°C	54
Tensile strength		MPa	59
Elongation at break		%	3.8

2) Properties are typical values, based on material tested in our laboratories, but varies from sample to sample. Typical values should not be construed as a guaranteed analysis of any specific lot or as specification items.

TECHNICAL DATA SHEET

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