



## 1- CHARACTERISTICS

Gel coat based on ISO-NPG resin to use for quality applications.

- ◆ Pre-accelerated and thixotropic : for brush application.
- ◆ A Fast drying
- ◆ No porosity.
- ◆ Good handle ability and coverage.

## 2- PROPERTIES OF LIQUID GEL COAT

<u>Brookfield viscosity</u> (ISO2555 - 20°C – sp6)	5 rpm 30000 mPa.s 50 rpm 7000 mPa.s
<u>Specific gravity</u> (ICON 012)	1.20 – 1.30 g/cm <sup>3</sup>
<u>Non volatile content</u> (ICON 003)	65 - 70%
<u>Geltime</u> (ICON 002) (20°C – 2% MEKP on 100gr)	12 minutes

## 3-PROPERTIES OF CAST GEL COAT

<u>Flexural strength</u> (ISO 178 )	80 to 100 MPa
<u>Flexural modulus</u> (ISO 178 )	3.6 to 3.8 GPa
<u>Tensile strength</u> (ISO 527 )	38 to 50 MPa
<u>Elongation at break</u> (ISO 527 )	2.3 to 2.8 %
<u>Heat distortion temperature (HDT)</u> (ISO 75-3)	72 °C
<u>Barcol hardness</u>	50

## 4- VERSIONS

Gel coat **GC 161** is available in all colours. Exists in spray version: **GC 168**.  
Exists in top coat version: **GF 161**.

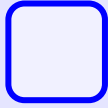
## 5- PACKAGING

Available in cans of 25 kg.

## 6- APPLICATION ADVICES

- ◆ Mix the peroxide well, never put under 1% or over 3%.
- ◆ **GC 161** is ready to use; stir the gel coat each time before use to give a homogeneous product.
- ◆ Put 0.4 to 0.5 mm thickness of gel coat (about 500 g/m<sup>2</sup>)
- ◆ Avoid excess thickness especially in angles. We recommend the application of several thin layers rather than a thick one.

*Information contained in this publication is given in good faith and is without warranty or guarantee. No liability can be accepted for claims, losses or demands arising out of the contents of this publication.*



**NORD  
COMPOSITES  
UK LTD**

## **TECHNICAL DATA SHEET**

**GC 161**  
NTG 098 D – 06/06/2008

### **7- POST-CURING**

To obtain optimum properties of the **GC 161**, it is necessary to fully cure the laminate (GC and resin). The laminate must stay at ambient temperature for 24 hours, then, we advise to post-cure for 16 hours at 40°C. This post-curing must be done immediately after the initial cure.

### **8- STORAGE CONDITIONS AND HANDLING**

Maximum storage life: 3 months.

The gel coat is subject to the Highly Flammable Liquids Regulations. The product should be stored under cool conditions in closed opaque containers at a temperature not exceeding 25°C. Avoid exposure to heat sources such as direct sunlight.

---

*Information contained in this publication are given in good faith without warranty or guarantee. No liability can be accepted for claims, losses or demands arising out of the contents of this publication.*

Unit 1 Moor Lane Ind Est. – BIRMINGHAM B6 7AT – ENGLAND – Tel: 0121 356 9144 – Fax: 0121 356 5244