



1 CHARACTERISTICS

GC 165 is a gel coat based on NEOPENTHYL GLYCOL isophthalic polyester resin. It is recommended for the production of parts in RTM application. This gel coat remains tacky during 12 hours.

- Pre-accelerated and thixotroped.
- Formulated for Airless application.
- Freedom from drainage on inclined surfaces.
- Good hydrolysis and UV resistance.

2 PROPERTIES OF LIQUID GEL COAT

Brookfield viscosity (ISO 2555 - 20°C - sp5)	5 rpm : 140 - 180 Poise 50 rpm : 26 - 30 Poise
Geltime (ICON 002) (20°C - 2% MEKP on 100 g)	16 - 20 min
Specific gravity (ICON 012)	1.11 - 1.14 g/cm ³
Non volatile content (ICON 003)	63 - 67 %

3 VERSIONS

Gel coat **GC 165** is available in:

- Promoted version, **GR 165** with a gel time of 8 - 12 min (20°C – 2% MEKP on 100 g).
- Brush version, **GP 165** with a viscosity at 5 rpm: 400 - 800 Poise (20°C - sp6) and a gel time of 10 - 14 min (20°C - 2% MEKP on 100 g).

4 RECOMMENDATIONS BEFORE USE

- Mix the peroxide very well, never put less than 1% and more than 2.5% of peroxide.
- **GC 165** is ready to use, stir the gel coat each time before use to give a homogeneous product.
- This product is formulated to obtain the better characteristics in AIRLESS application and in pneumatic gravity gun (nozzle of 2.8 mm).
- Put 0.4 to 0.5 mm thickness of gel coat (about 500 g/m²)
- Avoid excess thickness especially in angles. We recommend the application of several thin layers rather than a thick one.

5 POST CURING

To obtain optimum properties of the **GC 165**, it is necessary to fully cure the laminate (GC and resin). The laminate must stay at ambient temperature (16 - 20°C) 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.

6 PACKAGING


Available in kegs of 25 kg or in drums of 225 kg.

IMPORTANT

*All of the results obtained according to trials in our laboratory. However, we don't be responsible of manufactured parts with the **GC 165**, if the application conditions specified are not respected.*

It is imperative that the user must also ensure that his application and his process are appropriate for this product to be used.

We hereby the conformity of our products with the above specifications. We cannot be responsible for any damage caused by misuse of this product or use of the product for an application not covered in the design.

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7 STORAGE CONDITIONS AND HANDLING

Storage life: Gel coat **GC 165** is stable for 3 months from date of production. The product must be stored in original closed packaging at a temperature between 15°C and 25°C, away from direct sunlight.

It is the responsibility of the customer to assure that the product is used in good conditions overall before the date limitation mentioned on the keg.

The gel coat is subject to the Highly Flammable Liquids Regulations.

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