



1 CHARACTERISTICS

Gel coat **GC 181** is based on an isophthalic resin. This gel coat is recommended for brush quality applications.

- Pre-accelerated and thixotroped.
- High coverage.
- Freedom from drainage on inclined surfaces.
- Good mechanical and impact resistance.
- Good weathering and hydrolysis resistance.
- Alimentary agreement delivered by IANESCO center of Poitiers.

2 PROPERTIES OF LIQUID GEL COAT

Brookfield viscosity (ISO 2555 - 20°C - sp5)	5 rpm : 375 - 525 Poise 50 rpm : 70 - 90 Poise
Specific gravity (ICON 012)	1.15 - 1.22g/cm ³
Temps de gel (ICON 002) (20°C - 2% P MEC sur 100 g)	6 - 10 minutes
Non volatile content (ICON 003)	66 - 70%

3 PROPERTIES OF CAST GEL COAT

Flexural strength (ISO 178)	77.1 MPa
Flexural modulus (ISO 178)	3.25 GPa
Tensile strength (ISO 527)	48.35 MPa
Strength modulus (ISO 527)	2.29 GPa
Elongation at break (ISO 527)	2.83%
Barcol hardness	45

4 VERSIONS

GC 181 is available in all colors.

GC 181 is available in pre-release version **GD 181**, finition version **GF 181**, UV version **GL 181**, HRA version **GH 181**.

GC 181 is available in long gel time version **GC 180** with a gel time of 12 - 16 minutes (2% MEKP at 20°C on 100g).

5 APPLICATION ADVICES

- Mix well before use.
- To obtain optimum polymerization, the level of catalyst MEKP (Butanox M50 type) should be between 1% and 2% according to the size of the part to be made and the room temperature (we recommend 20°C).
- Put 0.4 to 0.5 mm thickness of gel coat (about 500 g/m²)
- Avoid thickness especially in angles. We recommend the application of several thin layer rather than a thick one.

IMPORTANT

*All of the results obtained according to trials in our laboratory. However, we don't be responsible of manufactured parts with the gel coat **GC 181**, if the application conditions specified are not respected.*

The user must also ensure that his application is 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.



6 POST CURING

To obtain optimum properties of the **GC 181**, it is necessary to cure the laminate (GC and resin). The laminate stay at ambient temperature (16 - 20°C) during 24 hours, then, we advise to do a post-curing of 16 hours at 40°C. This post-curing must be done immediately after the 24 hours.

7 PACKAGING

Gel coat **GC 181** is available in cans 25 kg.

8 STORAGE CONDITIONS AND HANDLING

Storage life : Gel coat **GC 181** 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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