

 <b>NORD COMPOSITES</b>	<b>TECHNICAL DATA SHEET</b>	<b>GC 184/2</b> <b>Fire retardant gel coat</b> NTG 162 E – 19/09/17 Page : 1/2
---	-----------------------------	---

### 1. CHARACTERISTICS

Gel coat polyester, suitable for applications, with require fire-retardant classification. It is pre-accelerated.

- Gel coat **GC184/2** is thixotropic and pre-accelerated, meant to be used in spray applications.
- **Classification M1 with Norester 085/2: indicative test realised at Nord Composites. Q = 1.9.**

### 2. PROPERTIES OF THE LIQUID GEL COAT

Brookfield viscosity (ISO 2555 - 20°C - sp5)	5 rpm : 140 - 230 Poise 50 rpm : 20 - 36 Poise
Specific gravity (ICON 012)	1,60 g/cm <sup>3</sup>
Non volatile content (ICON 003)	70 - 74%
Drying time on film (20°C - 2% MEKP on 100 g)	50 - 70 minutes

### 3. MECHANICAL PROPERTIES OF CAST GEL COAT

Flexural strength* (ISO 178)	70.3 MPa
Flexural modulus* (ISO 178)	4.196 GPa
Tensile strength* (ISO 527)	40.69 MPa
Elongation at break* (ISO 527)	2.24%
Barcol hardness*	40

\*Mechanical tests realized on the cured gel coat with 2% MEKP. Post cure: 16 hours at 40°C.

### 4. VERSIONS

**GC 184/2** is available in light colours.  
For other colours, take contact with us.

This gel coat is available in non-pre-accelerated version: **GN184/2** with a gel time of 50 - 70 min (20°C - **0.12% Co12%** - 2% MEKP on 100 g).

### 5. RECOMMENDATIONS BEFORE USE

- Mix the peroxide very well, never put less than 1% and more than 3% of peroxide.
- **GC 184/2** is ready to use. Mix the gel coat each time before use to have a homogenate product.
- Before use, check that the temperature of the gel coat, of the mould and of the room is between 18°C and 25°C.
- Add 2% of MEKP peroxide and well mix the product.
- Put 0.4 to 0.5 mm thickness of gel coat (about 500 g/m<sup>2</sup>). Avoid thickness especially in angles. We recommend the application of several thin layers rather than a thick one.
- We retain the attention on the fact that this resin is classified according to the certificates mentioned here above and according to the application made in our laboratory. The customer is responsible to be sure that the moulding made by him is well classified.
- **For the non-pre-accelerated version (GN 184/2), take care not to mix the accelerator and the peroxide together, add them separately into the resin.**

#### **IMPORTANT**

*All of the results obtained according to trials in our laboratory. However, we don't be responsible of manufactured parts with the **GC 184/2**, 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.*



## **6. POST CURING**

To obtain optimum properties of the **GC 184/2**, it is necessary to cure the laminate (GC and resin). The laminate stay at ambient temperature 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**

Available in cans of 25 kg.

## **8. STORAGE CONDITIONS AND HANDLING**

Storage life: Gel coat **GC 184/2** 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.

### **IMPORTANT**

*All of the results obtained according to trials in our laboratory. However, we don't be responsible of manufactured parts with the **GC 184/2**, 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.*