 NORD COMPOSITES	TECHNICAL DATA SHEET	GC 206 Vinylester tooling Gel Coat NTG 053 M – 04/11/14 Page : 1/2
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1 CHARACTERISTICS

Gel coat **GC 206** is based on a vinyl ester resin. The gel coat is suitable for polyester laminate, mould making. The product is developed for brush application.

- Thixotropic and pre-accelerated.
- Good handle ability.
- High quality with very good mechanical properties.
- High brightness. The brightness measured by our laboratory : 95 with a gloss meter with a 60 degrees angle.
- The **GC 206** is a good tools gel coat due to the high temperature resistance and the chemical resistance, especially for the short circle application (RTM for example) or molding of concrete polyester.

2 PROPERTIES OF LIQUID GEL COAT

Brookfield viscosity (ISO 2555 - 20°C – sp6)	5 rpm : 250 - 350 Poise 50 rpm : 60 - 80 Poise
Specific gravity (ICON 012)	1 - 1.10 g/cm ³
Gelttime (ICON 002) (20°C – 2% MEKP on 100 g)	10 - 14 minutes
Non volatile content (ICON 003)	66 - 68%

3 MECHANICAL PROPERTIES OF CAST GEL COAT

Flexural strength* (ISO 178)	155.2 MPa
Flexural modulus* (ISO 178)	3.44 GPa
Tensile strength* (ISO 527)	38.58 MPa
Elongation at break* (ISO 527)	2.10%
Temperature of deflection under load (HDT)* (ISO 75-3)	100°C
Barcol hardness*	45

* Mechanical tests carried out on 5 specimens of cast gel coat **GC 206** catalysed with 2% of MEKP M50, curing time at room temperature for 24 hours, then post cured for 3 hours at 80°C.

4 GEL TIME ACCORDING TO THE TEMPERATURE


Gel time done on 100 g

Temperature	1% MEKP M50	1.5% MEKP M50	2% MEKP M50	2.5% MEKP M50
20°C	50 min	31 min	14 min	10 min
25°C	30 min	18 min	10 min	7 min
30°C	23 min	14 min	7 min	6 min
35°C	14 min	7 min	6 min	4 min

IMPORTANT

All of the results obtained according to trials in our laboratory. However, we don't be responsible of manufactured parts with the **GC 206**, 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.

 NORD COMPOSITES	TECHNICAL DATA SHEET	GC 206 Vinylester tooling Gel Coat NTG 053 M – 04/11/14 Page : 2/2
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5 VERSIONS

Gel coat **GC 206** is available in the following colours: blue 5900, green 6900, black 9900, orange 2900 or clear 9901. Also available in spray version **GC 207**.

6 RECOMMENDATIONS BEFORE USE

- Mix the peroxide well, never put under 1% or over 2.5%.
- We recommend to catalyse with 2% MEKP M50.
- Never apply the **GC 206** at temperature under 18°C.
- Apply 700 – 800 µm layers in 2 passes :
 - The first layer of **GC 206** must have a thickness of 400 – 500 µm.
 - When the first layer is cured, then apply 300µm of **GC 206**
- Avoid excess thickness especially in angles. We recommend the application of several thin layers rather than a thick one in order to obtain a final thickness of 0.8 mm.
- To obtain an optimal result, we recommend to apply after the **GC 206** the resin **R 842**. When the **R 842** is cured, start to laminate with a moulding resin like **R 2000**, **R 2000/50** or **R 2550**.

7 POST CURING

To obtain optimal resistance properties, the laminate with the **GC 206** should be post cured.
Keep the laminate at ambient temperature (18- 20°C) during 24 hours after the application of the last layer of moulding resin. Then post cure for 16 hours at 40°C.

8 PACKAGING

Gel coat **GC 206** is available in cans of 5 to 25 kg and drums of 225 kg.

9 STORAGE CONDITIONS AND HANDLING

Storage life : Gel coat **GC 206** 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

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