

1. CHARACTERISTICS

Gel coat GC 207 is based on a vinyl ester resin. The gel coat is suitable for polyester laminate mould making and for spray applications.

- Thixotropic and pre-accelerated.
- Good handle ability.
- High quality with very good mechanical properties.
- Application airless machine. Nozzle 40/21 or 50/21. Pressure 3 4 bars.
- High brightness. The brightness measured by our laboratory: 95 with a gloss meter with a 60 degres angle.
- The GC 207 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 - sp5)	5 rpm : 100 - 150 Poise 50 rpm : 21 - 25 Poise		
Specific gravity (ICON 012)	1 - 1.10 g/cm ³		
Gel time (ICON 002) (20°C - 2% MEKP M50 on 100 g)	13 - 17 minutes		
Non volatile content (ICON 003)	52%		

3. PROPERTIES OF CAST GEL COAT

Flexural strength* (ISO 178)	78.4 MPa		
Flexural modulus* (ISO 178)	4.48 GPa		
Tensile strength* (ISO 527)	57.7 MPa		
Elongation at break* (ISO 527)	3.4%		
Temperature of deflection under load (HDT)* (ISO 75-3)	102°C		
Barcol hardness*	45		

* Mechanical tests carried out on 5 specimens of cast gel coat GC 207 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 TEMPERATUIRE

Gel time done on 100g

Temperature	1% MEKP M50	1.5% MEKP M50	2% MEKP M50	2.5% MEKP M50
20°C	42 min	24 min	13 min	10 min
25°C	27 min	16 min	8 min	7 min
30°C	22 min	12 min	7 min	6 min
35°C	13 min	8 min	5 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 207, 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.



5. VERSIONS

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

Gel coat GC 207 is available in low viscosity version: GC207BV with a viscosity at 5 rpm: 75 - 125 Poise and at 50 rpm: 18 - 22 Poise (20°C - sp5).

Available with high abrasion resistance with corindon GO 207.

6. APPLICATION ADVICES

- Mix the peroxide well, never put under 1% or over 2.5%.
- Mix the product before use.
- We recommend to catalyze with 2% MEKP M50.
- Never apply the GC 207 at temperature under 18°C.
- Apply 700 800 µm of GC 207 wet on wet in several thin passes (approximately 800 g/m²).
- Avoid excess thickness especially in angles. We recommend the application of several thin layers rather than a thick one. And we recommend to wait a few minutes between each layer.
- For mould production, we recommend to apply after the GC 207 the resin R 842 catalysed with 2% of MEKP M50. 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 optimum resistance properties, the laminate with the gel coat **GC 207** must be post-curing. In order to accelerate the hardening, the laminate stays at ambient temperature (16 to 20 °C) during 24 hours followed a post-curing of 16 hours at 40°C. We advise to do a post-curing immediately after ripening period to obtain optimums results.

8. PACKAGING

Gel coat GC 207 is available in cans 5 kg, 25 kg and drums 200 kg.

9. STORAGE CONDITIONS AND HANDLING

Storage life: Gel coat GC 207 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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