



### 1. CHARACTERISTICS

The gel coat **GC 511** is a polyester gel coat developed for the production of parts which have to be sanded and repainted.

- Pre-accelerated and thixotroped.
- Brush application.
- Curing at ambient temperature by addition of MEKP catalyst (i.e. BUTANOX M50).
- Easy to sand.
- Fast drying.
- No porosities.

### 2. PROPERTIES OF LIQUID GEL COAT

Brookfield viscosity (ISO 2555 - 20°C - sp6)	5 rpm : 375 - 525 Poise 50 rpm : 70 - 90 Poise
Specific gravity (ICON 012)	1.20 g/cm <sup>3</sup>
Non volatile content (ICON 003)	65 - 67%
Geltime (ICON 002) (20°C – 2% MEKP on 100 g)	6 - 10 min

### 3. MECHANICAL PROPERTIES OF CAST BASE RESIN

Flexural strength* (ISO 178)	159,2 MPa
Tensile strength* (ISO 527)	58,43 MPa
Elongation at break* (ISO 527)	2,67%
Temperature of deflection under load* (HDT) (ISO 75-3)	81,9°C

\*Mechanical tests realised on the cured base resin of gel coat **GC 511** with 2% MEKP.  
Post cure: 16 hours at 40°C.

### 4. RECOMMENDATIONS BEFORE USE

- The Gel Coat **GC 511** needs to be well homogenated before use.
- To obtain an optimal curing, the MEKP catalyst rate (i.e. Butanox M50) must be from 1% to 2% according to the size of the part that has to be made and at ambient temperature (recommended temperature is nearly 20°C).
- Lay down nearly 0.4 to 0.5 mm of Gel Coat that is to say nearly 500 g/m<sup>2</sup>.
- It is recommended to apply several thin layers rather than a thick one (wet on wet).


### 5. PACKAGING

The gel coat **GC 511** is available in kegs of 25 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 511**, 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.*

 <b>NORD COMPOSITES</b>	<b>TECHNICAL DATA SHEET</b>	<b>GC 511</b> <b>Sanding Gel Coat</b> NTG 156 C - 29/05/17 Page : 2/2
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#### 6. STORAGE CONDITIONS AND HANDLING

Storage life: The gel coat **GC 511** is stable during 3 months from date of production. The product must be stored in original 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 time limitation mentioned on the keg.

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

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