

1 CHARACTERISTICS

Gel coat **GC 610** is based on an isophatlic resin. This gel coat is recommended for brush quality applications.

- Pre-accelerated and thixotroped.
- Good coverage.
- No flowing in vertical or bent side.
- Good mechanical and impact resistance.
- Good weathering and hydrolysis resistance.
- **Gel coat approved LLOYD'S, certificate N° MATS/3957/2. Report dated September 2015.**

2 PROPERTIES OF LIQUID GEL COAT

Brookfield viscosity (ISO 2555 - 20°C – sp6)	5 rpm : 270 - 430 Poise 50 rpm : 65 - 85 Poise
Specific gravity (ICON 012)	1.15 - 1.22 g/cm ³
Geltime (ICON 002) (20°C - 2% MEKP M50 on 100 g)	10 - 14 minutes
No volatile content (ICON 003)	60 - 68 %

3 MECHANICALS PROPERTIES OF CAST GEL COAT

Flexural strength (ISO 178)	111 MPa
Flexural modulus (ISO 178)	3 GPa
Tensile strength (ISO 527-2)	61 MPa
Elongation at break (ISO 527-2)	4.1%
Heat distortion temperature HDT (ISO 75-3)	75°C
Barcol hardness	50
Water absorption after 7 days (ISO 62)	29.9 mg

4 VERSIONS

GC 610 is available in several colours. Please contact our technical service to know the feasibility of the coloured wished.

GC 610 is available in:

- Top coat version: **GF610**.
- Low viscosity version: **GC610BV** with a viscosity at 5 rpm: 195 - 245 Poise, at 50 rpm: 55 - 65 Poise (20°C - sp6) and a gel time of 11 - 15 min (20°C - 2% MEKP M50 on 100 g).

IMPORTANT

*All of the results obtained according to trials in our laboratory. However, we don't be responsible of manufactured parts with the **GC 610**, 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 APPLICATION ADVICES

- Mix well the product 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.

6 POST CURING

To obtain optimum properties of the **GC 610**, 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 610** is available in kegs of 25 kg or in drums of 225 kg.

8 STORAGE CONDITIONS AND HANDLING

Storage life: Gel coat **GC 610** 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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