

ORTHOPHTALIC GEL COAT

Orthophtalic gel coats for general purposes produced by **italbeit** are formulated in order to achieve a good level of performance in all those applications which don't require high chemical and mechanical resistance. Their formulation is based on a good orthophtalic resin, inorganic fillers and pigments. Main properties are:

- easy application
- high yield
- good mechanical properties

Given their properties, we suggest to use our orthophtalic gel coats in general purpose applications, industrial parts, transportation and interior parts in marine.

They can be also supplied in the self-releasing version, to facilitate the demoulding operations, or as topcoats, to improve the superficial curing when used directly on final pieces.

VERSIONS

spray up

roller

brush

self release

topcoat

colored

fast gel time

Application guide

For a proper application we strongly recommend to check that the temperature of the gel coat, of the mould and in the workshop is between 18°C and 25°C. All our gel coats are normally supplied pre-accelerated and simply need to be mixed with standard MEKP 50% peroxide. The amount of peroxide should be between 1,5% and 2%. The wet film thickness, depending on the shape of the mould and on the application method, should roughly be between 0,4 and 0,5 mm, which it's normally 600-800 g/m² of gel coat.

When applied with "airless" or similar equipment, we recommend the fine tuning of the machine (nozzle and pressure). If a further dilution is needed for the application, type and quantity of the diluent may vary according to specific needs. Please refer to our technical service for advice. We do not recommend the use of acetone, particularly in the brush version.

APPLICATIONS

general purposes

transportation

industrial parts

indoor application

Chemical and physical properties

	method	unit	107312P	107312	115092PU	115092U	
application			spray up	brush	spray	brush	PACKING pails Kg 25 drums Kg 250 IBC Kg 1000
appearance	A 01*	visual	white thixo	white thixo	clear thixo	clear thixo	
solid content	C 08*	%	70 ± 2	80 ± 2	63 ± 2	73 ± 2	
specific weight	DIN 63217	g/cm ³	1,3 ± 0,1	1,4 ± 0,1	1,3 ± 0,1	1,3 ± 0,1	COLORS unlimited color matching service available
Barcol	ASTM D 2583	unit	=> 40	=> 40	=> 40	=> 40	
gel time	P 04*	minutes	10 ± 2	10 ± 2	7 ± 2	7 ± 2	
peak	P 04*	°C	155 ± 10	155 ± 10	160 ± 10	150 ± 10	SHELF LIFE 3 months if properly stored in the original sealed pails, between 15° and 25°C, away from naked flames, heat sources and not exposed to direct sunlight
°C increase from 35°C	P 04*	°C/min	=> 10	=> 10	=> 12	=> 12	
viscosity	rpm 2 rpm 20 ASTM D 2196	mPa.s mPa.s	25.000/35.000 4.000/5.000	40.000/55.000 8.000/12.000	40.000/50.000 6.000/9.000	80.000/100.000 12.000/16.000	
thix index	ASTM D 2196	ratio	=> 7	5/5,5	=> 7,5	6/7	WARNINGS flammable product: keep it away from heat sources, sparkles and naked flames do not eat, drink or smoke during application avoid static charges keep the workshop properly ventilated

* *italbeit's internal method*

note:

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