TECHNICAL DATA SHEET

PRODUCT: EPOXY TOOLING GEL COAT

DESCRIPTION

Epoxy Tooling Gel Coat for use as a surface coat to either traditonal epoxy resin and glass reinforcement moulds or moulds made using our Epoxy Mould Making Putty to acheive a strong, durable epoxy based mould.

This epoxy mould making tooling gelcoat is designed to be used in combination with our Epoxy Mould Making Putty to provide a very quick, clean method of making problem free moulds for the laminationg of carbon fibre and fibreglass parts.

USES

Being an epoxy based mould making system this tooling gel coat is the ideal tool surface when making epoxy based end products (like carbon fibre parts or epoxy matrix GRP/FRP). Suitable for use making patterns, models, gauges, negatives and electro forming tools.

PROPERTIES

Viscosity @ 25^{o} C	Paste
Colour	Clear Thicksotropic Paste
Hardness	80-85 Shore D (BS 2782: Part 3: Method 365B)
Density	1.50 – 1.60 g/cm^{3} (BS 2782: Part3: Method 620)
Pot Life @20^{o} C	43.53mins
Cure Time (200g @ 25^{o}C)	12.-16hrs

MIXING RATIO

100 p.b.w. Epoxy Tooling Gel Coat
10 p.b.w. Epoxy Tooling Gel Coat Hardener

The gel coat should be mixed with its hardener should be mixed with its hardener according to the indicated mixing ratio. Both components should be thoroughly mixed, care should be taken to avoid air entrapment and make certain that material at bottom and sides of container is thoroughly stirred into centre.

APPLICATION

The mixed material should be evenly applied to the mould by brush, in 0.5mm thick layers. A minimum of two layers should be applied, with a combined thickness of less than 2.5mm. To ensure that each coat adheres, wait until the first coat has gelled to a tack free state before applying successive coats.
The gelcoat is tack free if when a finger is lightly drawn across the surface, no material sticks to it, but if firmly pressed, a mark will remain on the surface. The tack free stage is critical in the gelcoating process and will vary between different gelcoats and ambient temperatures. If the tack free stage is missed then it is likely that de-lamination between the gelcoat layers or the gelcoat and backing resin may result.

STORAGE

The resin and hardener should be stored in original, unopened containers between 15 and 25°C. KEEP THE PACKING TIGHTLY SEALED WHEN NOT IN USE.

SHELF LIFE If stored under the above conditions the resin and hardener will have a shelf life of 12 months, from the date of production.

This data is not to be used for specifications. Values listed are for typical properties and should not be considered minimum or maximum.

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