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Havelgelcoat 65

polyester gelcoat clear or white

Technical data sheet

Charakteristic:	Preaccelerated gelcoat for marine, building and common use Clear or coloured
Aplication:	Layers 0,4 – 0,6 mm Topcoat or gelcoat Hand lay up by brush or spray
Processing temperature:	+15 °C - +80 °C
Processing:	Brushing or spraying
Special properties:	Excelent water and climatic resistance Styrene content~34 % Geltime(100g+ 2 % Butanox M50) 9 min HDT 120°C

Úvod

Havelgelcoat 65 is standard preaccelerated isophthalic gelcoat mainly for brush painting application.

It is formulated for use in marine, building and transport industry. also it is suitable for common use. Provide excellent resistance to water.

Atest

It has Lloyd's Register of Shipping for use to build marine structures under supplier overlook.

Aplication

Gelcoat use to be tempered to workshop (18-20°C) before using. Mixe it properly by hand mixing device with low spin to avoid making bubbles. After let it watt to become thixotropic. For start of curing reaction it is necessary to add catalyst Butanox M50 or another type of MEKP peroxide in addition of cca 2% by volume. Catalyst should be mixed properly into gelcoat carefully to avoid creation of bubbles.

Pot life

Temperature	Pot life in min
15°C	24
20°C	15
25°C	9

Usually is applied into 0,4-0,5 mm layer by uniform application of cca. 450-600 g/m². When gelcoat is coloured local test is suitable to avoid bad fitting of colours. Cure schedule 24 hod at 20°C, postcuring 3 hod at 80°C, or 5 hod at 80°C and 3 hod at 120°C.

Aditives

Addition of pigments or fillers could have negative effect to water and climate resistance. Addition of 2% wax solution to avoid sticky surface could be created topcoat.

Physical properties

Tested SB, BS, EN or BS EN ISO metod.

Property	Unit	Liquid gelcoat
Look		Clear or coloured
Viskozity at 25°C		Thixotropic
Density at 25°C	kg/dm ³	1,11
VOC content	%	34
Stability in darkness at 20°C	Months	3
Gel time at 25°C (2% butanox M50)	min	9

Property	Unit	Cured Gecoat *
Hardness (Barcol GYZJ 934-1)		42
Water absorbtion 24 hod. at 23°C	mg	18
Bending temperature when dragged **	°C	75
Extension in rupture	%	3,0
Tensile strength	MPa	75
Strength Module	MPa	3500

*Cured 24 hod at 20°C, 3 hod at 80°C

** Cured 24 hod at 20°C, 5 hod at 80°C, 3hod at 10°C

Storage

In a sealed container, dark at 15-25 ° C, the shelf life is 6 months.

Health and safety

Please read the separate Material Safety Data Sheet.

Note for the reader

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