

CRYSTIC[®] GELCOAT 3.7020PA

General Purpose Spray Sandable Gelcoat

Introduction

Crystic Gelcoat 3.7020PA is an orthophthalic, pre-accelerated spray sandable gelcoat.

Application

Crystic Gelcoat 3.7020PA is a sandable gelcoat designed for use in parts that are to be post painted. It is available in cream or grey and is formulated for spray application, using a gravity gun or an airless system. Crystic Gelcoat 3.7020PA is formulated using extremely fine, soft fillers which permit easy and precise sanding. The rheology is carefully adjusted in order to avoid any presence of air bubbles in the applied gelcoat film. Following removal of any dust or moisture, paint may be applied directly to the sanded gelcoat.

Features and Benefits

Features

Pre-accelerated
Special Rheology
Very fine fillers

Benefits

Offering a rapid cure, enabling fast mould turnaround
No air inclusion or porosity
Easy, precise sanding

Formulation

Crystic Gelcoat 3.7020PA should be allowed to attain workshop temperature (18 – 20°C) before application. Stir well by hand or with a low shear mixer and leave to stand for a short time. This product only requires the addition of catalyst to start the curing process. We recommend the use of Butanox M50 (or other equivalent catalyst) at 2%, mixed thoroughly with the gelcoat before application.

Variants

Crystic Gelcoat 3.7020PA is also available in a promoted, pre-accelerated version with a faster curing time under reference Crystic Gelcoat 3.7020KPA.

Application

Crystic Gelcoat 3.7020PA is a spray gelcoat. It is recommended to stir the gelcoat before application.

Dilution	Ready for use
Catalyst	2% Butanox M50
Spray Application	Gravity Gun Airless
	Spray Tip 2 - 3mm Spray Tip 417 - 421
Pressure	2 to 25 bars
Distance to Mould	50cm (Minimum)
Wet Film Thickness	400 - 600 Microns
Film Cure Time at 20°C	3.7020 PA 3.7020 KPA
	40 Minutes 20 Minutes

Geltime

Catalyst level and temperature will influence gel time. Do not use the gelcoat at temperatures of 15°C or less. At 25°C, the gel time for 100 parts Crystic Gelcoat 3.7020PA and 2 parts of Catalyst Butanox M50 is 15 to 18 minutes. The promoted version, Crystic Gelcoat 3.7020KPA, has a gel time of 6 to 9 minutes under the same conditions and has in addition a more rapid hardening rate.

Recommended Testing

It is recommended that customers test all pigmented gelcoats before use under their own conditions of application to ensure the required surface finish is achieved.

Physical Data - Uncured

Property	Unit	Liquid Gelcoat
Viscosity at 25°C (Brookfield HBT Sp n°2, 5 rpm)	dPas	Thixotropic
Specific Gravity at 25°C	-	1.40
Stability in The Dark at 20°C	Month	3
Styrene Content	%	34 - 36

Physical Data - Cured

Property	Unit	Cured Base Resin
Barcol Hardness (Model GYZJ 934-1)		40 - 45
Heat Deflection Temperature (1.8 MPa)	°C	67
Elongation at Break	%	3.2
Tensile Strength	MPa	45
Tensile Modulus	MPa	1500

Curing Schedule - Test According to BS 2782:1976
 $1\text{MPa} = 1\text{MN/m}^2 = 1\text{N/mm}^2 = 10.2\text{ kgf/cm}$

Packaging

Crystic Gelcoat Gelcoat 3.7020PA is supplied in 25Kg kegs and 225Kg drums.

Storage

Crystic Gelcoat 3.7020PA should be stored in its original container and out of direct sunlight. It is recommended that the storage temperature should be less than 20°C.

Health and Safety

Please refer to Material Safety Data Sheet.

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