

# CRYSTIC<sup>®</sup> STONECAST GELCOAT 95PA

## Spray Viscosity Granite-Effect Gelcoat

### Introduction

Crystic Stonecast Gelcoat 95PA is a pre-accelerated Gelcoat based on a high clarity, low colour isophthalic/neopentyl glycol resin. It has been specially formulated to accept Poly Stone coloured chips and be able to be spray applied by the different dry and wet spray methods available.

### Applications

Crystic Stonecast Gelcoat 95PA combined with the Poly Stone coloured chips is recommended for use as a Spray Granite effect on vanity units, worktops/seating in kitchens, bathrooms and commercial premises including fast food restaurants, pubs, offices and airports.

### Features and Benefits

Crystic Stonecast Gelcoat 95PA combined with the Poly Stone coloured chips, produces films which have the same aesthetic appeal of Solid Surface, i.e., numerous and varied granite/marble finishes, which are now fashionable.

### Formulation

Crystic Stonecast Gelcoat 95PA should be allowed to attain workshop temperature 15°C - 20°C before use. The recommended starting formulation for the combination with the Poly Stone chip is:

75% Crystic Stonecast Gelcoat 95PA  
25% Poly Stone coloured chips

This combination requires only the addition of catalyst to start the curing process. The recommended catalyst is Andonox<sup>®</sup> KP9 which should be added at 2%, the addition level calculated on the weight of the Crystic Stonecast Gelcoat 95PA present in the combination with the Poly Stone chips.

### Pot Life

The temperature, and the amount of Catalyst M affect the geltime, and hence the pot life of Crystic Stonecast Gelcoat 95PA. The table below shows the geltime in minutes of Crystic Stonecast Gelcoat 95PA at varying temperatures, with 2% Andonox<sup>®</sup> KP9 catalyst.

Temperature	Pot Life In Minutes
15°C	22
20°C	14
25°C	9

The gelcoat mould and workshop should all be at or above 15°C before curing or spraying is carried out. Scott Bader (Pty) Ltd. will not be liable for problems caused by use at lower temperatures than recommended.

**N.B.** Peroxide catalysts are highly reactive and may decompose with explosive violence, or cause fires, if they come into contact with flammable materials, metals or accelerators. For this reason they must never be stored in metal containers or be mixed directly with accelerators.

### Spray Application of Crystic Stonecast Spray Granite Gelcoat 95PA / Poly Stone Combination

There are two basic methods plus variations for spraying of the Crystic Stonecast Spray Granite Gelcoat / Poly Stone combinations - dry and wet spraying. For full details of all the methods available to spray the Crystic Stonecast Spray Granite Gelcoat please refer to the following Application Guides:

The Methods of Spraying Crystic Stonecast Spray Granite Gelcoat;

- Cup Gun Dry Spraying Method
- Particle Pump/Dry Spray Applicator (DSA) Method
- Wet Spray Method

#### Physical Data - Uncured

The following tables give typical properties of the Crystic Stonecast Gelcoat 95PA when tested in accordance with BS2782.

Property	Unit	Liquid Gelcoat
Appearance		Pale Pink
Viscosity at 25°C (ICI Cone and Plate)	Centipoise	210
Geltime at 25°C using 2% Andonox <sup>®</sup> KP9 Catalyst	Minutes	9
Stability In The Dark at 20°C	Months	3

#### Physical Data - Uncured

Property	Unit	Fully Cured Gelcoat
Barcol Hardness (Model GYZJ 934-1)		44
Water Absorption 24 hrs at 23°C	mg	24
Deflection Temperature Under Load † (1.80 MPa)	°C	100
Elongation at Break	%	2.2
Tensile Strength	MPa	60
Tensile Modulus	MPa	3000

† Curing Schedule - 24hrs at 20°C, 5hrs at 80°C, 3hrs at 120°C.

#### Post-Curing

Satisfactory laminates can be made with the Crystic Stonecast Gelcoat 95PA by curing at Workshop temperature (20°C). However where optimum properties of the Crystic Stonecast Gelcoat 95PA are required, such as in contact with hot and cold water, the laminates must be post cured before being put into service. The moulding should be allowed to cure for 24 hours at 20°C and then oven cured for 3 hours at 80°C.

#### Storage

Crystic Stonecast Gelcoat 95PA should be stored in the dark in suitable closed containers. It is recommended that the storage temperature should be less than 20°C where practical, but should not exceed 30°C. Ideally, containers should be opened only immediately prior to use. Where they have to be stored outside, it is recommended that drums be kept in a horizontal position to avoid the possible ingress of water. Wherever possible, containers should be stored under cover.

#### Packaging

Crystic Stonecast Gelcoat 95PA is supplied in 25Kg containers and 225Kg drums.

#### Health and Safety

Please see separate Material Safety Data Sheet.

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Crystic Gelcoat 95PA - TDS