

CRYSTIC[®] GELCOAT 0209SMK

General Purpose Isophthalic Spray Gelcoat

Introduction

Crystic Gelcoat 0209SMK is a pre-accelerated, robust, isophthalic and thixotropic polyester gelcoat specially designed for spray application.

Applications

Crystic Gelcoat 0209SMK has been developed for the production of high quality industrial parts. We recommend stirring the gelcoat with a low shear mixer before use. The gelcoat is pre-accelerated and only requires the addition of the catalyst to start its curing reaction.

Features and Benefits

Pure isophthalic base resin
Robust high reactivity
Levelling additives
Low styrene content

Excellent weathering resistance
Rapid curing, fast mould turn round
Excellent self levelling, no wave effect
Better comfort for the workers and for the environment

Variants

This gelcoat is also available with a faster curing time under the reference Crystic Gelcoat 0209SMKW.

Formulation

Crystic Gelcoat 0209SMK must be allowed to attain workshop temperature before use. Stir well by hand or with a low shear mixer to avoid aeration, and then allow to stand to regain thixotropy. The recommended catalyst is Butanox M50 (or other equivalent catalyst) which should be added at 2% in the gelcoat.

Geltime

Catalyst level and temperature will influence the gel time. Gelcoat must not be used at temperatures under 15°C.

	Butanox M50	Geltime In Minutes at 25°C	Back Up Time at 20°C
Crystic 0209SMK	2%	8 - 10	50 - 60
Crystic 0209SMKW	2%	6.5 - 8.5	30 - 40

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.

Application

Application Temperature	18 - 20°C
Dilution	Ready for use
Catalyst	2% Butanox M50
Gun	Nozzle 20/10 to 30/10 mm or 421
Pressure	3 to 4.5 bars
Distance to mould	50cm minimum
Wet Film Thickness	500 - 800 Microns

Physical Data - Uncured

Property	Unit	Liquid Gelcoat
Viscosity at 25°C (Brookfield RVT Sp n ⁴ , 3 rpm)	dPas	280 - 420
Specific Gravity at 25°C		1.25
Stability at 20°C	Months	3

Physical Data - Cured

Property	Unit	Fully Cured* Gelcoat
Barcol Hardness (Model GYZJ 934-1)		35
HDT (1.80 MPa)	°C	75
Elongation at Break	%	2.8
Tensile Strength	MPa	68
Tensile Modulus	MPa	4050

*Curing Schedule - Test According to BS 2782:1976
1MPa = 1MN/m² = 1N/mm² = 10.2 kgf/cm

Packaging

Crystic Gelcoat 0209SMK is supplied in 25Kg kegs and 200Kg drums.

Storage

Crystic Gelcoat 0209SMK 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 where practical, but should not exceed 30°C. Ideally, containers should be opened only immediately prior to use.

Health and Safety

Please refer to Material Safety Data Sheet.

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