CRYSTIC® TOPCOAT 69PAX

Iso - NPG Topcoat for Brush Application

Introduction
Crystic Topcoat 69PAX is a pre-accelerated, Iso - NPG topcoat. It has been formulated for brush application and is available in a restricted range of colours. The information contained in this technical datasheet also applies to these pigmented versions.

Applications
Crystic Topcoat 69PAX is designed for use where a smooth finish is required on the reverse side of a laminate.

Features and Benefits
Crystic Topcoat 69PAX has low styrene emission. It is not air inhibited, and produces a matt finish.

Formulation
Crystic Topcoat 69PAX should be allowed to attain workshop temperature (18ºC - 20ºC) before use. Stir well by hand, or with a low shear mixer to avoid aeration, and then allow to stand to regain thixotropy. Crystic Topcoat 69PAX requires only the addition of catalyst to start the curing reaction. The recommended catalyst is Butanox M50 (or other equivalent catalyst), which should be added at 2% into the topcoat. (Please consult our Technical Service Department if other catalysts are to be used). The catalyst should be thoroughly incorporated into the topcoat, with a low shear mechanical stirrer where possible.

Pot Life

Temperature	Pot Life in Minutes
15ºC	15
20ºC	11
25ºC	9

The topcoat, moulding and workshop should all be at, or above, 15oC before curing is carried out.

Application
For normal requirements, the application of Crystic Topcoat 69PAX should be controlled to 0.4 - 0.5mm (0.015 - 0.020 inches) wet film thickness. As a guide, approximately 450-600g/m² of topcoat mixture (depending on pigment) will give the required thickness when evenly applied.

Additives
Crystic Topcoat 69PAX is supplied in a restricted range of colours. This eliminates the potential for mixing errors with small quantities of pigment paste. The addition of fillers or pigments can adversely affect the properties of the cured topcoat.

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

Physical Data – Uncured
The following tables give typical properties of Crystic Topcoat 69PAX when tested in accordance with SB, BS, or BS EN ISO test methods.

Property	Unit	Liquid Topcoat
Appearance		Opaque
Viscosity at 25ºC		Thixotropic
Specific Gravity at 25ºC		1.1
Volatile Content	%	34
Stability at 20ºC	Months	3
Geltime at 25ºC Using 2% Butanox M50 (or Other Equivalent Catalyst)	Minutes	9

Physical Data – Cured

Property	Unit	Fully Cured *Topcoat (Unfilled Casting)
Barcol Hardness (Model GYZJ 934-1)		49
Water Absorption 24 hrs at 23ºC	mg	16
Deflection Temperature Under Load† (1.80 MPa)	ºC	96
Elongation at Break	%	1.6
Tensile Strength	MPa	57
Tensile Modulus	MPa	3884

* Curing Schedule - 24hrs at 20ºC, 3hrs at 80ºC.
† Curing Schedule - 24hrs at 20ºC, 5hrs at 80ºC, 3hrs at 120ºC.

Post-Curing
Curing at workshop temperature (20ºC) will be satisfactory for many applications. However, for optimum properties, laminates must be post-cured before being put into service. The moulding should be allowed to cure for 24 hours at 20ºC, and then be oven-cured for 3 hours at 80ºC.

Storage
Crystic Topcoat 69PAX should be stored in its original container and out of direct sunlight. It is recommended that the storage temperature should be less than 20ºC, where practical, but should not exceed 30ºC. Ideally, containers should only be opened immediately prior to use.

Packaging
Crystic Topcoat 69PAX is supplied in 25Kg and 225Kg containers.

Health and Safety
Please see separate Material Safety Data Sheet.

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