CRYSTIC® TOPCOAT LS 96PAX

Low Styrene Content Topcoat for Spray Application

Introduction
Crystic Topcoat LS 96PAX is a filled, pre-accelerated topcoat, formulated for spray application. A wide range of colours is available, and the information contained in this leaflet also applies to these pigmented versions.

Applications
Crystic Topcoat LS 96PAX is recommended for use in land transport and building applications. It is also suitable for general moulding requirements.

Features and Benefits
Crystic Topcoat LS 96PAX typically contains 28%-30% styrene when formulated as a pigmented topcoat. It has good weather resistance and is low in viscosity, with excellent air release properties. Crystic Topcoat LS 96PAX achieves good coverage in thin film, and does not drain on the mould.

Formulation
Crystic Topcoat LS 96PAX should be allowed to attain workshop temperature (18°C – 20°C) before use. It should be stirred well using a low shear mixer to avoid aeration, then allowed to stand to regain thixotropy. Crystic Topcoat LS 96PAX requires only the addition of a catalyst to start the curing reaction. The recommended catalyst is Catalyst M (or Butanox M50), which should be added at 2% into the topcoat. Please consult our Technical Service Department if other catalysts are to be used.

Spray Application : Do

- Gently stir the topcoat before use, by hand or with a low shear mixer.
- Ensure the topcoat has attained workshop temperature (18°C – 20°C) before use. Temperatures below 18°C will require a higher pressure to achieve an acceptable spray pattern and this will encourage porosity.
- Spray at the minimum practical pressure whilst maintaining an acceptable spray pattern and full fan width.
- Build up thickness in long, even passes until the recommended thickness is achieved.

Don't

- Stir the topcoat with high shear mixers as this will temporarily break down the thixotropy, leading to drainage.
- Exceed a wet film thickness of 0.625mm (0.025inch), as thick films encourage air retention.
- Apply excessive thickness in corner areas as this can cause pre-release.

Additives
The addition of pigment pastes, or other additives, can adversely affect the spraying characteristics of Crystic Topcoat LS 96PAX. To avoid this, it is supplied in a wide range of colours, which eliminates the potential for mixing errors. The inclusion of additives can also adversely affect the weather resistance of the cured topcoat.

Post-Curing
Satisfactory laminates for many applications can be made with Crystic Topcoat LS 96PAX by curing at workshop temperature (20°C). 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 20°C, and then be oven cured for 3 hours at 80°C.

Physical Data - Uncured
The following tables give typical properties of Crystic Topcoat LS 96PAX when tested in accordance with SB, BS, BS EN or BS EN ISO test methods.

Property	Unit	Liquid Topcoat
Appearance		Bit Free, Coloured
Viscosity at 25ºC		Thixotropic
Specific Gravity at 25ºC		1.2
Stability at 20ºC	Months	3
Geltime at 25ºC Using 2% Butanox M50 (or Other Equivalent Catalyst)	Minutes	7

Physical Data - Cured

Property	Unit	Fully Cured *Topcoat (Unfilled Casting)
Barcol Hardness (model GYZJ 934-1)		45
Water Absorption 24 hrs at 23ºC	mg	16
Deflection Temperature Under Load† (1.80 MPa)	ºC	70
Elongation at Break at 20ºC	%	2.1
Tensile Strength	MPa	59
Tensile Modulus	MPa	5000

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

Storage
Crystic Topcoat LS 96PAX should be stored in the dark in suitable, closed containers. It is recommended that the storage temperature be less than 20°C where practical, but should not exceed 30°C. Ideally, containers should be opened only immediately prior to use.

Packaging
Crystic Topcoat LS 96PAX is supplied in 25Kg and 225Kg containers.

Health & Safety
Please see separate Material Safety Data Sheet.

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