

CRYSTIC[®] Flowcoat 408PA White

White Pigmented Orthophthalic Polyester Flowcoat

Introduction

Crystic Flowcoat 408PA White is a pre-accelerated Flowcoat with excellent scuff resistance, designed for use in general purpose GRP mouldings. It is based on a high quality orthophthalic unsaturated polyester resin. It is suitable for all general moulding requirements. It is pigmented using a highly UV resistant grade of titanium dioxide. It has been formulated for application using spray equipment, but may be applied by brush where a lower viscosity is preferred. A version designed specifically for use with a brush, Crystic Flowcoat 407PA White, is available.

Applications

Crystic Flowcoat 408PA White is designed for application on the back of GRP mouldings, as a decorative, protective coating for the laminate. It will resist mild chemical attack from cleaning agents, etc, but it is not designed for use on the inner surfaces of vessels holding water. For such an application, Crystic Topcoat 506PA White is recommended.

Formulation

Crystic Flowcoat 408PA White should be allowed to attain workshop temperature (18°C-20°C) before use. Stir well by hand, or with a low shear mixer to avoid aeration, and then allow to stand to regain thixotropy. Crystic Flowcoat 408PA White requires only the addition of catalyst to start the curing reaction. The recommended catalyst is Norox[®] KP9, and this should be added at 1-3% into the Flowcoat. In hot weather, the pot life can be so short even with 1% Norox KP9 catalyst, it is difficult to avoid the material gelling in the pot. Do not use less than 1% Norox KP9 catalyst. Rather use Norox MEKP-925H catalyst. The catalyst should be thoroughly incorporated into the Flowcoat, with a low shear mechanical stirrer where possible.

Pot Life

The temperature, and the amount of Norox KP9 catalyst or Norox[®] MEKP-925H catalyst affect the geltime, and hence the pot life of Crystic Flowcoat 408PA White. Table 1 shows this relationship.

Table 1: Geltime in minutes of Crystic Flowcoat 408PA White at varying temperatures.

■ = Combination not recommended.

Catalyst type		Norox KP9			Norox MEKP-925H		
		1%	2%	3%	1%	2%	3%
Catalyst addition		Geltime in minutes					
Temperature	15°C	■	17'	14'	■	■	■
	25°C	14'	11'	■	■	32'	13'
	35°C	7'	5'	■	■	15'	7'

The Flowcoat, moulding and workshop should all be at or above, 15°C before curing 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.

Application

Crystic Flowcoat 408PA White is designed for application by spraygun to the back of GRP laminates in order to protect the fibres from water attack and to provide an attractive finish. Coverage and the evenness of finish is affected greatly by the evenness of the laminate. Measures taken to achieve a smooth finish, such as sanding or the use of surface tissue, will result in a smoother flowcoated surface. It will also reduce the amount of Crystic Flowcoat 408PA White required to cover the surface. In normal use, the application of should be controlled to 0.4-0.5 mm wet film thickness. As a guide, approximately 500-700 g/m² of Flowcoat mixture will give the required thickness when evenly applied.

Additives

The addition of fillers to Crystic Flowcoat 408PA White can adversely affect the water and scuff resistance of the cured Flowcoat. Should coloured Flowcoat be required, Crystic Flowcoat 408PA can be supplied in a range of colours, or may be pigmented using Crystic Pigment Pastes.

Typical Properties

Table 2: Typical properties of liquid Crystic Flowcoat 408PA White.

Property	Units	Nominal value
Appearance		Viscous white liquid
Viscosity @ 25°C, Brookfield RVT @100 rpm	centipoise	2500
Thixotropic index	ratio	2.8
Geltime at 25°C using 2% Catalyst M	minutes	11 minutes
Film geltime @ 500 microns at 25°C using 2% Norox KP9 catalyst	minutes	16 minutes
Stability in the dark @ 20°C	months	3

Storage

Crystic Flowcoat 408PA White 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 Flowcoat 408PA White is supplied in 25kg and 225kg containers.

Health and Safety

Please see the applicable Material Safety Data Sheets, depending on the curing system used.

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Before you use this information, kindly verify that this data sheet is the latest version.

All information is given in good faith but without warranty. We cannot accept responsibility or liability for any damage, loss or patent infringement resulting from the use of this information.

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