

## 1- CHARACTERISTICS

Gel coat based on ISO-NPG resin to use for quality applications.

- ◆ Pre-accelerated and thixotroped : for brush application.
- ◆ A Fast drying
- ◆ No porosity.
- ◆ Good handle ability and coverage.

## 2- PROPERTIES OF LIQUID GEL COAT

|   |  |
|---|--|
| <u>Brookfield viscosity</u><br>(ISO2555 - 20°C – sp6)     | 5 rpm 30000 mPa.s<br>50 rpm 7000 mPa.s |
| <u>Specific gravity</u><br>(ICON 012)                     | 1.20 – 1.30 g/cm <sup>3</sup>          |
| <u>No volatile content</u><br>(ICON 003)                  | 65 - 70%                               |
| <u>Geltime</u><br>(ICON 002)<br>(20°C – 2% MEKP on 100gr) | 12 minutes                             |

## 3-PROPERTIES OF CAST GEL COAT

|   |                |
|---|----------------|
| <u>Flexural strength</u><br>(ISO 178 )                    | 80 to 100 MPa  |
| <u>Flexural modulus</u><br>(ISO 178 )                     | 3.6 to 3.8 GPa |
| <u>Tensile strength</u><br>(ISO 527 )                     | 38 to 50 MPa   |
| <u>Elongation at break</u><br>(ISO 527 )                  | 2.3 to 2.8 %   |
| <u>Temperature of deflection under load</u><br>(ISO 75-3) | 72 °C          |
| <u>Barcol hardness</u>                                    | 50             |

## 4- VERSIONS

Gel coat **GC 161** is available in all colours. Exists in spray version: **GC 168**.  
 Exists in top coat version: **GF161**.

## 5- PACKAGING

Available in cans of 25 kg.

## 6- APPLICATION ADVICES

- ◆ Mix the peroxide well, never put under 1% or over 3%.
- ◆ **GC 161** is ready to use; stir the gel coat each time before use to give a homogeneous product.
- ◆ Put 0.4 to 0.5 mm thickness of gel coat (about 500 g/m<sup>2</sup>)
- ◆ Avoid excess thickness especially in angles. We recommend the application of several thin layers rather than a thick one.

## 7- POST-CURING

To obtain optimum properties of the **GC 161**, it is necessary to fully cure the laminate (GC and resin). The laminate must stay at ambient temperature for 24 hours, then, we advise to post-cure for 16 hours at 40°C. This post-curing must be done immediately after the initial cure.

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**8- STORAGE CONDITIONS AND HANDLING**

Maximum storage life: 3 months.

The gel coat is subject to the Highly Flammable Liquids Regulations. The product should be stored under cool conditions in closed opaque containers at a temperature not exceeding 25°C. Avoid exposure to heat sources such as direct sunlight.

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