Technical Data Sheet

Gelcoat Plus

BÜFA®-STANDARD-GELCOAT-S

Standard UP Gelcoat, spraying quality Prod. No. 764-9999

Product description

BÜFA®-Standard-Gelcoat-S is a pre-accelerated gelcoat in a spraying consistence based on a special mixture of unsaturated polyester resins modified with isophthalic acid and dissolved in styrene.

Applications

BÜFA®-Standard-Gelcoat-S can be used for moulded parts subjected to normal loads (e.g. machine parts, furniture, industrial moulded parts, canoes, etc.) that are used indoors and outdoors. BÜFA®-Standard Gelcoat S is distinguished by outstanding working properties and a remarkably low styrene content.

Specifications / technical data

Property	Test method	Value	Unit
Density at 20 °C		approx. 1,1 - 1,3	g/ml
Viscosity at 20 °C Brookfield RV/DV-II Spl 4 rpm 4	ISO 2555	14 000 - 17 000	mPas
Styrene content		29 - 32	%
Flash point	DIN 53 213	+ 34	° C

Curing

Reactivity:
BÜFA method in accordance with DIN 16 945 6.2.2.1
(100 g gelcoat + 2.0 ml Butanox M-50)

20 - 30 °C	8 - 13 min
20 °C - Tmax	18 - 23 min
Tmax	140 - 170 °C

Gel time at 20 °C in a 100 g cup with 2.0 ml Butanox M-50: 8 - 13 min

Attention!
The information given above refers exclusively to the use of the catalyst named and the quantity specified. The use of different products or differing quantities may yield different results. Density depends on pigmentation.

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Colouring

BÜFA®-Standard-Gelcoat-S can be supplied in most RAL colours and a number of other shades of colour. It is also available under Art. No. 764-0001 as an unpigmented base gelcoat with higher viscosity and reactivity. Colour matching is also possible if there is sufficient order volume. Always remember that the viscosity and reactivity of tinted gelcoats may change through pigmentation!

Properties of the cured base resin

Property*	Test method	Value
Tensile strength	ISO 527-2	45 - 52 MPa
Tensile E-modulus	ISO 527-2	2,800 - 3,200 MPa
Elongation at break	ISO 527-2	6 - 7 %
Heat distortion temperature (HDT)	ISO 75-A	approx. + 80 °C

* Measured in a standard laboratory atmosphere on cast test specimens made of pure resin conditioned for 8 hours at +80 °C.

Directions for use

Our release agent system BF 500 /BF 700 has been tested and successfully used with this gelcoat. Before using other release agents, they should be tested for suitability under practical conditions. If circumstances permit, we recommend post-curing the moulded part for several hours at + 80 °C to achieve optimal gelcoat properties.
For more information on working and curing, see the notes in our Technical Information leaflet, "Working with OLDOPAL Gelcoats".

Storage/Handling

This product must be stored cool in closed containers, protected from sunlight. Shelf-life is at least 3 months in unopened, original containers stored up to a temperature of 20 °C. Gel and curing times may change with increasing duration of storage.

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A company of BÜFA and DSM Composite Resins