

Product Name**368-LINE ACE GELCOATS****Product Description**

368-line ACE gelcoats are designed for general industrial use, to make items where a combination of an excellent gloss off the mould, weather resistance and toughness is required. They use a blend of iso- and ortho- phthalic polyester resins, to give very good application properties and reliable curing behaviour under normal conditions.

368-line ACE gelcoats are available in a comprehensive range of colours, in either brushing or spraying grades.

Product advantages include: easy application, good weathering properties, and good water resistance.

Physical Properties

These values are listed as a reference guide only and are not intended for use as specifications.

Test	Result	Test Method
Viscosity (Brookfield RVT, 5rpm), cps	10,000 – 20,000 (Spray) 20,000 – 30,000 (Brush)	TM18
Thixotropic Index	>5	TM18
Gel Time @ 25°C, 1% MEKP, mins	10-20	TM19
Density @ 25°C, kg/l	1.25-1.35	TM40

Cure Information**Catalyst Addition**

368-line gelcoats are formulated for application as received and are designed to be cured by the addition of 1.5 – 2.5% MEKP. Contact Technical service for information on recommended catalyst grades. Do not catalyse at levels below 1% or above 3% as this may result in curing problems or other physical defects.

Gelcoat Thickness

Correct gelcoat thickness is important to obtain satisfactory cure. Recommended thickness is as follows:

Wet: 0.6mm – 0.65mm (24 – 26 thou)

Dry: 0.5mm – 0.55mm (20 – 22 thou)

Temperature

Do not apply at temperatures less than 15°C or more than 35°C.

Humidity

Do not apply at relative humidity exceeding 80%.

Storage and Shelf Life

Uncatalysed gelcoats have a shelf life of 4 months from date of manufacture, when stored in original sealed containers in a cool, dry area away from sunlight and other sources of heat. Storage temperatures above 25°C can reduce the shelf life. Avoid contact with transition metals and their compounds e.g. zinc and copper, including brass and galvanised products.

Note that the material should be agitated before use.

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1

Disclaimer

The data presented in this leaflet are in accordance with the present state of our knowledge, and does not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this leaflet should be checked by preliminary trials because of conditions during processing over which we have no control, especially where other companies' raw materials are also being used. Recommendations for use do not constitute a warranty, either expressed or implied, of the fitness or suitability of the product for a particular purpose.