

GELCOATS

GELCOATS

The specially formulated gelcoat range offers high-quality products with easy application and necessary resistance to external influences such as mechanical, thermal or chemical stresses.

Biresin® S12:

- Grey gelcoat with good spreading properties
- Good abrasion resistance for foundry patterns
- Good chemical and heat resistance for diverse moulds (e.g. RTM, vacuumforming)

GC1 050:

- Proven standard gelcoat (white) for models and negatives
- GC13 hardener with longer potlife
- Good spreading and covering properties
- Easily workable

GC1 080:

- Blue gelcoat with good workability
- With GC10 hardener applicable on wet plaster (previously treated)
- With GC13 hardener better chemical and heat resistance for ceramic and RTM moulds (polyester)

GELCOATS OF EASY WORKABILITY

	A	GC1 050		GC1 080		Biresin® S8	APG 1750 S
	B	GC 10	GC 13	GC 10	GC 13	Biresin® S8	PMEK
Mixing ratio [g]	A	100	100	100	100	100	100
	B	10	10	10	10	20	2
Colour		white	white	blue	blue	black	light beige
Characteristics		good spreading and covering properties, easily workable		can be applied on wet plaster (previously treated), sandable and polishable	high resistance to chemicals, easy to apply	polishable to high gloss, heat resistant, good styrene resistance	styrene-free polyester gelcoat, compatible with EP system EPOLAM 2050
Applications		master models, negatives, gauges		ceramic moulds, applicable on plaster models (previously treated)	ceramic moulds, RTM moulds (polyester)	vacuumforming moulds, master models, moulds for composite production	sprayable gelcoat for composite moulds requiring high heat resistance and mirror glossy surface (not regularly in stock - available on request)
Processing data (approx. values)							
Potlife [min]		20 – 30	45	15	20	30	22
Geltime [min]		40	65	40	40	60	-
Demoulding time [h]		16	24	16	24	16 – 24	-
Physical data (approx. values)							
Density [g/cm³]		1.45	1.45	1.74	1,74	1.22	1.30
Shore hardness		D 83	D 88	D 90	D 89	D 86*	D 87
Flexural strength [MPa]		75	63	75	75	90*	-
HDT [°C]		-	-	-	-	136*	-
T _g [°C]		50	47	65*	85*	-	120

* after appropriate treatment



Tool for making reinforcements of bonnets made of GC1 080



Easy application of GC2 070

GELCOATS OF HIGH ABRASION OR HEAT RESISTANCE

	A	Biresin® S13	GC2 070	Biresin® S12	GC2 120	Biresin® S19
	B	S13	GC 10	S12	GC 12	S19
Mixing ratio [g]	A	100	100	100	100	100
	B	60	10	8	15	12
Colour		blue-grey	blue-green	grey	light green	grey
Characteristics		PUR elastomer with very high abrasion resistance, very impact and tear resistant	very good abrasion resistance	heat resistant, abrasion resistant, good solvent and styrene resistance	abrasion resistant, high heat resistance	high heat resistance
Applications		foundry patterns, core boxes	foundry patterns, match plates, diverse moulds	vacuumforming moulds, foundry patterns, moulds for composite production	foundry patterns, moulds for low pressure SMC and RTM (polyester, EP)	vacuumforming moulds, prototype / test injection moulds, moulds for composite production
Processing data (approx. values)						
Potlife [min]		20 - 25	20	30	18	45 - 60
Geltime [min]		45	60	45	30	150 - 180
Demoulding time [h]		16	16	16 - 24	-	24
Physical data (approx. values)						
Density [g/cm³]		1.23	1.59	2.1	1.48	1.65
Shore hardness		D 66	D 88	D 92	D 89	D 89*
Flexural strength [MPa]		-	-	78	115	85*
HDT [°C]		-	-	>100*	-	145*
T _c [°C]		-	70	-	120	158*

* after appropriate treatment