

DESCRIPTION

Poltix Schuurgelcoat is a sandinggelcoat based on a pre-accelerated isophthalic unsaturated polyester resin and special fillers to facilitate sanding.

PRINCIPAL CHARACTERISTICS

- Specially developed for products which will be coated immediately after release from mould;
- Excellent sanding properties;
- Thixotropic, reduces sagging on vertical surfaces;
- Pre-accelerated;
- Rapid curing;
- Semi-flexible but with excellent scratch and impact resistance;
- Resistant to a wide range of chemicals;

COLOURS AND GLOSS

Lightgrey, other colours on request

BASIS PROPERTIES (AT 20 °C AND 50% R.H.)

Density	:	approx. 1,4 tot 1,3 g/cm ³ , depending on colour and type
Solid content	:	approx. 100 % (volume)
Recommended d.f.t.	:	350 - 450 µm (dry), depending on application
Full cure after	:	2 hours
Application second layer gelcoat after	:	min. 3 hours, see additional information max. 24 hours, provided free from any contamination
Laminate to be applied after	:	min. 3 hours, see additional information max. 24 hours, provided free from any contamination
H.D.T. (DIN53458)	:	approx. 75 °C
Shelf life	:	separate components, stored cool and dry in original packaging, at least 3 months
Flashpoint (DIN53213)	:	base component 34 °C hardener component 52 °C (MEK peroxide)

SPREADING RATE

At 350 µm (dry film)	:	approx. 2,0 m ² /kg
At 400 µm (dry film)	:	approx. 1,8 m ² /kg
At 450 µm (dry film)	:	approx. 1,6 m ² /kg

The practical spreading rate depends on a number of variables, such as: shape and size of object to be painted, the condition and profile of the substrate, the method of application, environmental conditions and skill of labour.

SUBSTRATE CONDITION AND TEMPERATURE

Mould : in good condition, clean and dry, free from any contamination, loose particles and other foreign matter; pre-treated with a suitable mould release agent;

During application and curing a minimum temperature of 15 °C is allowed. The temperature of the substrate should be minimum 3 °C above dew point.

INSTRUCTIONS FOR USE

Before use mix base and hardener thoroughly.

Mixing ratio : 100 base : 2 hardener (parts by weight)
Do not prepare more material than can be applied within the pot life of the mixture.

Induction time : None
Pot life : 5 minutes at 25 °C
10 minutes at 20 °C
15 minutes at 15 °C
The pot life depends also on colour.

Application with :

	Brush
Type of thinner	n.a.
% of thinner	n.a.
Nozzle orifice	n.a.
Nozzle pressure	n.a.
Cleaning with	Double Coat Degreaser, Ethyl acetate or Acetone

Application by airless is only possible with the special airless version of Poltix Schuurgelcoat. Please contact us for more detailed information on this product.

ADDITIONAL INFORMATION

- Recoating Poltix Schuurgelcoat

	15 °C	20 °C	25 °C
Minimum, with Poltix Schuurgelcoat	4 hours	3 hours	2 hours
Minimum, with laminate	4 hours	3 hours	2 hours
Maximum, with Poltix Schuurgelcoat	24 hours	24 hours	18 hours
Maximum, with laminate	24 hours	24 hours	18 hours
Maximum, with coating systems after degreasing and grit sanding P120-P180	unlimited	unlimited	unlimited

The actual minimum and maximum interval depends also on the colour.

- Application of Poltix Schuurgelcoat
 - Poltix Schuurgelcoat is only recommended for brush application.
 - Use for brush application brushes with unpainted handles.
 - Apply Poltix Schuurgelcoat evenly, without runs or sags, preferably in two coats. This will prevent holidays and areas with too low film thickness. Brush marks, runs and sags and areas with too low thickness might be visible in the product after release from mould.
 - Avoid areas with low filmthickness, , apply sufficient material to achieve a film thickness of at least 300 µm. Areas with a too low film thickness will not give full polymerisation and will lead to surface defects in the product. These defects will be visible as dents, spots with low gloss or other irregularities and will cause further defects when subsequent coatings are applied.
 - A too low temperate will give a long gel time. The polymerisation will be incomplete. A too high temperature will shorten gel time. A too high application temperature will give a too rapid curing and will cause air entrapment.
- Pre-accelerated
Poltix Schuurgelcoat is pre-accelerated with a combination of special accelerators and promoters.

- Release from mould
Special additives are added to Poltix Schuurgelcoat to improve the sanding properties. These additives could influence the release of the product from the mould. Special attention should be given to the type of release agent used and its application.
- Recoating of Poltix Schuurgelcoat
Poltix Schuurgelcoat may be recoated with Double Coat or similar paint materials. Remove all residue of mould release agent using degreasers or cleaners such as Double Coat Degreaser. Sand the surface with gritpaper P220 and clean the surface again with Double Coat Degreaser. Repair small damaged areas with Poltix Superplamuur or IJmofix. Apply two to three coats of Double Coat by brush, roller or spray.
- Hardener
As hardener/catalyst we recommend Butanox M50 (Akzo Nobel) or Peroxan ME50L (Pergan). After mixing the base component with the harder the temperature of the mixture will increase rapidly due to an exothermic reaction. Do not prepare more material than can be applied within the pot life of the mixture.

SAFETY INFORMATION

This product contains solvents. Take all necessary safety measurements when using this product and arrange proper ventilation and safety equipment for all personnel. For details on safety and health see our material safety data sheet.

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Disclaimer

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