

DESCRIPTION

Poltix Gelcoat Metallic is a gelcoat based on a pre-accelerated isophthalic unsaturated polyester resin, pigmented with lightfast pigments, metallic effect pigments and UV filters.

PRINCIPAL CHARACTERISTICS

- Thixotropic, reduces sagging on vertical surfaces;
- Pre-accelerated;
- Rapid curing;
- Semi-flexible but with excellent scratch and impact resistance;
- Protective coating for reinforced polyester laminates such as boats, auto parts, decorative sheeting, sanitary units, etc.;
- Excellent hiding power;
- Contains specially selected UV filters;
- Resistant to a wide range of chemicals, high resistance to osmosis;
- Only suitable for airless application.

COLOURS

16 colours, see additional information

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

Density	:	approx. 1,1 to 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. 2,4 m ² /kg
At 400 µm (dry film)	:	approx. 2,1 m ² /kg
At 450 µm (dry film)	:	approx. 1,9 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 : airless version:
5 minutes at 25 °C
10 minutes at 20 °C
15 minutes at 15 °C
The pot life depends also on colour.

Application with :

	Only airless version	
	Airless spray, external mixing	Airless spray, internal mixing
Type of thinner	n.a.	n.a.
% of thinner	n.a.	n.a.
Nozzle orifice	0,016 inch	0,023 inch
Nozzle pressure		
Cleaning with	Double Coat Degreaser, Ethyl acetate or Acetone	

Application by brush or roller is not possible due to the metallic effect pigments.

ADDITIONAL INFORMATION

- Available colours

The following colours are available:

Code	Omschrijving	Code	Omschrijving
±RAL 3001	Red	±RAL 7038	Agate grey
±RAL 5004	Black blue	±RAL 8019	Grey brown
±RAL 5011	Steel blue	±RAL 8023	Orange brown
±RAL 6001	Emerald green	±RAL 8025	Pale brown
±RAL 6009	Fir green	±RAL 9005	Jet black
±RAL 7012	Basalt grey	±RAL 9006	Aluminium
±RAL 7016	Anthracite grey	±RAL 9011	Graphite black
±RAL 7026	Granite grey	YT 8869	Gold metallic

- Recoating Poltix Gelcoat Iso

	15 °C	20 °C	25 °C
Minimum, with Poltix Gelcoat Iso	4 hours	3 hours	2 hours
Minimum, with laminate	4 hours	3 hours	2 hours
Maximum, with Poltix Gelcoat Iso	24 hours	24 hours	18 hours
Maximum, with laminate	24 hours	24 hours	18 hours

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

- Application of Poltix Gelcoat Metallic
 - Apply Poltix Gelcoat Metallic evenly, without runs or sags, preferably in two coats. Runs and sags and areas with too low thickness might be visible in the product after release from mould. Areas with too low thickness may yellow excessively when exposed to direct sunlight.
 - Following systems are recommended:
 - Standard system:
One coat Poltix Gelcoat Metallic of 450 – 550 gram/m² followed by the laminate;

2. Premium system:

One coat Poltix Gelcoat Metallic of 450 – 550 gram/m² followed by one coat of Poltix Gelcoat Iso in a similar solid colour and then the laminate;

3. Superior system:

One coat Poltix Gelcoat Iso UV transparent of 450 – 550 gram/m² followed by one coat Poltix Gelcoat Metallic of 450 – 550 gram/m² and next one coat of Poltix Gelcoat Iso in a similar solid colour and then the laminate;

Combinations of the above systems are possible. Also, the laminate can be pigmented with a suitable solid colour.

- A too low temperature 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 Gelcoat Metallic is pre-accelerated with a combination of special accelerators and promoters.
- 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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