

## DESCRIPTION

Poltix Resin M-EB-K is a pre-accelerated, filled unsaturated polyester resin based on vinylester resins. Poltix Resin M-EB-K is specifically designed as laminating resin for polyester moulds.

## PRINCIPAL CHARACTERISTICS

- Pre-accelerated and filled with inert fillers;
- Low shrinkage, minimal glass fibre print-through and surface defects;
- Rapid curing, reduces construction time of mould considerably;
- Rapid development of hardness, reduces release interval;
- Contains a colour indicator to control curing;
- Low styrene emission, results in a tack-free surface;
- Low shrinkage when used in combination with reinforcing materials;
- Excellent wetting of glass fibres.

## COLOURS AND GLOSS

Opaque – Eggshell

## BASIS PROPERTIES (AT 23 °C AND 50% R.H.)

Density	: approx. 1,4 g/cm <sup>3</sup>
Solid content	: approx. 100 % (volume)
Recommended d.f.t.	: depending on application
Gel time	: approx. 20 minutes
Full cure after	: approx. 2 hours
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Laminating after	: min. 2 hours max. 4 hours, without sanding
H.D.T. (ISO 75A)	: 90 °C
Shelf life	: separate components, stored cool and dry in original packaging minimum 6 months
Flash point (DIN53213)	: base component 32 °C hardener 52 °C

## SPREADING RATE

The practical spreading rate depends on the type of reinforcing materials applied. The following table gives an indication of the average resin consumption when combined with several materials:

Type	Resin each m <sup>2</sup>	D.f.t.
Glasmatt 225 gram/m <sup>2</sup>	750 gram	600 µm
Glasmatt 300 gram/m <sup>2</sup>	875 gram	700 µm
Glasmatt 450 gram/m <sup>2</sup>	1375 gram	1100 µm
Rovingweefsel 600 gram/m <sup>2</sup>	1125 gram	900 µm

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, climatologic conditions and skill of labour.

## SUBSTRATE CONDITION AND TEMPERATURE

Poltix Gelcoat M-EB : dry and free from oil, grease, contamination and loose particles;  
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 components thoroughly.

Mixing ratio : 100 base : 1 to 1½ hardener (parts by weight)  
Do not prepare more material than can be applied within the potlife of the mixture.

Induction time : none  
Pot life : 15 minutes at 25 °C  
20 minutes at 20 °C  
25 minutes at 15 °C

Application with :

	Brush
type thinner	none
% of thinner	
nozzle orifice	none
nozzle pressure	none
cleaning	Double Coat Brush thinner or Double Coat Degreaser

### ADDITIONAL INFORMATION

- Application of Poltix Resin M-EB-K
  - Poltix Resin M-EB-K is recommended for hand-layup.
  - For brush application use brushes with unpainted handles.
  - Apply a generous coat of Poltix Resin M-EB-K. Place a glass fibre in the wet layer of Poltix Resin M-EB-K and apply with a brush by pressing the brush onto the fibre at right angle. Remove air bubbles using a Teflon or aluminium deaeration roller.
- 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

*Although the information and recommendations are presented in good faith and believed to be correct at date of issue, De IJssel Coatings B.V. makes no representations as of the completeness or accuracy thereof. In no event De IJssel Coatings B.V. will be responsible for damages of any nature whatsoever resulting from the use of this information.*