Crystic® Gelcoat GT-600

Isophthalic Gelcoat for Brush Application

Product Description and Approvals

Crystic® Gelcoat GT-600 is a high performance isophthalic gelcoat. It is pre-accelerated and formulated for brush application.
Crystic® Gelcoat GT-600 has been developed to have excellent intrinsic water and weather resistance. The viscosity profile ensures even coverage with minimal drainage and low film porosity.
Crystic® Gelcoat GT-600 is recommended for use in the marine, building and transport industries. It is also suitable for general moulding requirements. Crystic® Gelcoat GT-600 is approved by Lloyd's Register of Shipping.
GelTint offers the latest in pigment and gelcoat technology producing a high quality product for ease of use, finish and longevity. There is a vast range of colours available. Custom colour matching is also available if required once you contact a Scott Bader representative.
The biggest benefit of GelTint is the speed of service. We have a maximum lead time of 5 working days (excluding delivery) with a priority service of 48 hours from when the order is placed.

Features and Benefits

Features	Benefits
Isophthalic base resin	Excellent water / blistering resistance
High elongation	Good impact resistance
Easy to apply	Excellent surface finish

Brush Application

Do	Don't
Ensure the gelcoat has attained workshop temperature of 15°C - 25°C before use.	Stir the gelcoat with high shear mixers as this will temporarily break down the thixotropy leading to drainage.
Add 2% Butanox® M-50 or equivalent catalyst.	Exceed a wet film thickness of 800 microns as thick films encourage air retention.
Gently stir the gelcoat by hand or low shear stirrer.	Apply excessive thickness in corner areas as this can cause pre-release.
Use long brush strokes and even pressure to apply the gelcoat in an even film across the mould surface	Apply backing laminate before the gelcoat has reached an appropriate degree of cure.
Brush through the gelcoat until the recommended wet film thickness of 600-800 microns is reached.	Catalyse more gelcoat than can be applied before it starts to gel as this will lead to wastage and possible exothermic reaction.
Apply the first layer of laminate within 24 hours of the gelcoat.	Allow vapour to be retained in deep mould sections as this can cause slow curing.

Additives and Variants

Crystic® Gelcoat GT-600 should only be used with specified GelTint pigments. The information contained in this technical data sheet applies to all pigmented versions.
A topcoat version of this material is available called GT-600 PAX.
Incorporation of additional material may affect the working, weathering or cured properties of the gelcoat. Please check with Scott Bader's Technical Service department before using the gelcoat outside of specified parameters.

Post-Curing

Satisfactory laminates for many applications can be made with Crystic® Gelcoat GT-600 by curing at workshop temperature (15°C - 25°C). However, for optimum properties, laminates must be post-cured before being put into service. The moulding should be allowed to cure for 24 hours at workshop temperature and then oven-cured for 16 hours at 40°C.

Recommended Testing

It is recommended that customers test all pigmented gelcoats before use under their own conditions of application to ensure the required surface finish is achieved. We recommend that Customers new to GelTint or customers using new GelTint colours test the product before use in full scale production. Due to the nature and fast service of the GelTint process, retain samples of the final product are not taken.

Typical Properties – Uncured

Property	Typical Value
Viscosity, 25°C $0.6s^{-1}$	400 poise
Viscosity, 25°C $4500s^{-1}$	15 poise
Specific Gravity at 25°C	1.1
Styrene Content	34%

Typical Properties – Cured

Property	Test Method	Typical Value
Barcol Hardness (Model GYZJ 934-1)*	EN59	42
Water Absorption 24 hrs at 23°C*	BS EN ISO 62 part 6.2	18 mg
Heat Deflection Temperature† (1.8MPa)	BS EN ISO 75-2 (1996)	75°C
Elongation at Break*	BS EN ISO 527-2	3%
Tensile Strength*	BS EN ISO 527-2	75 MPa
Tensile Modulus*	BS EN ISO 527-2	3500 MPa
Flexural Strength*	BS EN ISO 178	126 MPa
Flexural Modulus*	BS EN ISO 178	4300 MPa

* Curing Schedule - 24hrs at 20°C, 3hrs at 80°C.
† Curing Schedule - 24hrs at 20°C, 5hrs at 80°C, 3hrs at 120°C.

Gel time & Backup time

Catalyst level and temperature will influence the gel time. The product only requires the addition of catalyst to start curing. We recommend the use of a 50% MEKP (type Butanox® M-50) which should be added at 2% in the gelcoat.

Temperature	Gel time (2% Butanox® M-50)**	Backup time (2% Butanox® M-50)**
15°C	19 minutes	90 minutes
20°C	12 minutes	45 minutes
25°C	8 minutes	30 minutes
30°C	6 minutes	25 minutes

**Measured under laboratory conditions. Information should be used as a guide only.

Packaging and Storage

Crystic® Gelcoat GT-600 is available in 20kg containers.

Crystic® Gelcoat GT-600 should be stored in its original container, under cover, and out of direct sunlight. These must be kept closed and airtight. It is recommended that the storage temperature should be less than 25°C and the product should not be frozen. Storing the product outside of these conditions may affect the properties of the product and reduce its shelf life. Ideally, containers should be opened only immediately prior to use. Material should be used within 5 months from date of production.

Health and Safety

Read and understand separate Material Safety Data Sheet before using this product. Unsaturated polyester products release heat when they cure in bulk.

Eng - GT-600 - June 2017

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