GELCOATS

Crystic® GC LS 30PA (AUS)

Low Styrene Emission IsoNPG Spray Gelcoat

Product Description
Crystic® GC LS 30PA (AUS) is a high performance IsoNPG gelcoat. It is pre-accelerated and formulated for spray application. Crystic® GC LS 30PA (AUS) has been developed to have exceptional water and UV resistance, and its viscosity profile ensures even coverage with minimal drainage and low film porosity. Crystic® GC LS 30PA (AUS) is recommended for use in the most demanding marine and land transport applications. It is also suitable for general moulding requirements.

The information contained in this technical data sheet applies to all colours.

Approvals
Crystic® Gelcoat LS 30PA is approved by Lloyd's Register of Shipping.

Features and Benefits

Features	Benefits
IsoNPG base resin	Outstanding water and weathering resistance
Easy to apply	Excellent surface finish
Low styrene emission	Less exposure to environment and operators

Spray Set Up

Application Temperature	18 – 25°C
Catalyst	1 – 2% Butanox M50 (or equivalent MEKP catalyst)
Airless Gun Nozzle Size	423 – 535
Pressure	3 – 4.5 bar
Distance to Mould	50 – 80cm
Recommended Wet Film Thickness	600 – 800 microns

Spray Application

Do	Don't
Ensure the gelcoat has attained workshop temperature of 18°C - 25°C before use.	Stir the gelcoat with high shear mixers as this will temporarily break down the thixotropy leading to drainage.
Add 1% - 2% medium reactivity MEKP 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.
Spray at the minimum practical spray pressure whilst maintaining an acceptable spray pattern and full fan width.	Apply backing laminate before the gelcoat has reached an appropriate degree of cure.
Apply a mist coat and then build up thickness in long even passes of 100-150 microns until the recommended wet film thickness of 600-800 microns is achieved.	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 8 hours of the gelcoat.	Allow vapour to be retained in deep mould sections as this can cause slow curing.

Additives and Variants
The information contained in this technical data sheet applies to all pigmented versions.
Incorporation of additional additives 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® GC LS 30PA (AUS) by curing at workshop temperature (18°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 gelcoats before use under their own conditions of application to ensure that the product meets requirements.

Typical Properties – Uncured

Property	Typical Value
Viscosity, ICI Cone & plate, 25°C	2.0 poise
Viscosity, Brookfield SP5 at 2.5RPM, 25°C	30,000 mPa.s
Viscosity, Brookfield SP5 at 20RPM, 25°C	5,800 mPa.s
Geltime, 2.0% Butanox M50, 25°C	10 minutes
Geltime, 1.0% Butanox M50, 25°C	17 minutes
Specific Gravity at 25°C	1.1
Styrene Content	27%
Stability from date of manufacture when stored in accordance with storage recommendations	5 Months

Typical Properties – Cured

Property*	Test Method	Typical Value
Barcol Hardness (Model GYZJ 934-1)	EN59	46
Water Absorption 24 hrs at 23°C	BS EN ISO 62 part 6.2	10 mg
Heat Deflection Temperature† (1.8MPa)	BS EN ISO 75-2 (1996)	62ºC
Elongation at Break	BS EN ISO 527-2	2.8%
Tensile Strength	BS EN ISO 527-2	52 MPa

* Curing Schedule – 24 hours at 20°C + 3 hours at 80°C.
† Curing Schedule – 24 hours at 20°C + 5 hours at 80°C + 3 hours at 120°C.

Packaging and Storage
Crystic® GC LS 30PA (AUS) is available in 25kg and 225kg containers.

Crystic® GC LS 30PA (AUS) should be stored between 5°C and 25°C in the original, unopened container in a dry, well-ventilated place. Protect from freezing and direct sunlight. Avoid contact with oxidising agents. If stored outside of these recommendations, shelf life will be significantly reduced.

Health and Safety
Read and understand separate Safety Data Sheet before using this product.

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