

100 SERIES GENERAL PURPOSE

DESCRIPTION

The 100 series is a pre-promoted, orthophthalic gel coat developed for the fiberglass industry.

FEATURES AND BENEFITS

- Good viscosity / thixotropy balance.
- Sagging resistance.
- 100-BA-001 is white and 100-GA-001 is grey.
- 100-NA-001 is black and 100-XB-002 is neutral base.

APPLICATIONS

- Manufacture of FRP Parts, General purpose.

TYPICAL LIQUID PROPERTIES

Property	Units	100-BA-001	100-GA-001	100-NA-001	100-XB-002	Test Method
Brookfield viscosity ²	Cps.	11000 - 13500	13000 - 16500	11000 - 13500	18000 - 20500	TARQ - 300
Thixotropic index ³	—	5 - 7.5		5 - 7	6 - 8	TARQ - 300
Gel time	Minutes	8 - 12 ¹		8 - 12 ⁴		TARQ - 400
Color DE	—	—	1 max.	—	—	TARQ - 590

¹ 1.8% Butanox M-50 @25°C; ² RVF, spindle # 4, 4 rpm @25°C; ³ RVF, spindle # 4, 2 / 20 rpm @25°C; ⁴ 1% Butanox M-50 @25°C

NOTE: Tests results compared with the reported in certificate can be affected due to: batch age, temperature, moisture, type and amount of catalyst, testing equipment and method.

RECOMMENDATIONS

- 1.- The catalyst level should not exceed 2.8% or fall below 1% for proper cure.
- 2.- These products should not be used when temperature conditions are below 16°C, as curing and handling may be adversely affected.
- 3.- Before use:
 - Mix once a day for 10 minutes, starting from the edges towards the center of the drum with the least possible turbulence.
 - Avoid air assistance, this is not effective and may cause water or oil contamination.
 - Avoid over-mixing, due to potential filler separation and increased tendencies to sag.

- 4.- Film should be sprayed in at least three passes, for a total film thickness of 18 to 22 mils (wet).
NOTE: Films less than 12 mils may not cure properly; films above 24 mils may pre-release, generate porosity or cracks.
- 5.- Brushing is not recommended, because it causes uneven thickness.
- 6.- Do not add any material different to the catalyst recommended for these products.
- 7.- Do not mix organic peroxides with metallic soaps, amines or any type of accelerators or promoters, because it can result on violent decomposition with fire or explosion.
- 8.- Any additional questions, please contact your Reacciones Químicas SA de CV sales representative.

STORAGE

Uncatalyzed 100 series gel coats have a usage life of 45 days from invoice date, when stored at 25°C or below, in closed, opaque, factory sealed containers, and out of direct sunlight, heat sources or moisture. If ordered in IBC totes, shelf life is only 30 days when stored at 25°C or below, in closed, factory sealed containers, and out of direct sunlight, heat sources or moisture. For every 7°C increase in storage temperature, the shelf life is reduced by one half.

SAFETY AND HANDLING

Detailed information for safe handling of 100 series gel coats, can be found on its SDS. For more information, please contact your Reacciones Químicas SA de CV sales representative.

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