



## General description

NM Gelcoat 230 is a white solvent free epoxy system designed for surface coats on moulds.

NM Gelcoat 230 is to be applied with brush to avoid encapsulation of air bubbles. On the primary release agent coated surface, apply approximately 0.2 kg/m<sup>2</sup>. Do not mix larger batches that could be applied within 10 minutes.

When cure has reached the stage when it is tacky but not attach to fingers, another coat of approximately 0.2 kg/m<sup>2</sup> NM Gelcoat 230 should be applied. The time between the layers are strongly affected by surrounding temperature.

When the second layer of gelcoat has reach the same stage as the first one earlier, it is time to begin laminating.

The surface-weave is applied and further more of the laminating epoxy are added. Continue working wet in wet until all weaves are in place.

## Typical applications:

- Surface resin for moulds.

## Typical properties

### **Resin:**

NM Gelcoat 230

### **Hardener:**

NM Härdare 233

### **Mixing ratio:**

Resin-Hardener 100-26 by weight

<i>Density:</i>	1290 kg/m <sup>3</sup>
<i>Viscosity at 25°C:</i>	Thixotropic
<i>Potlife 100g 20°C:</i>	15 minutes
<i>Compressive strength:</i>	72 MPa
<i>Flexural strength:</i>	85 MPa
<i>E-modulus:</i>	3.5 GPa
<i>HDT:</i>	50°C
<i>Setting-time:</i>	~2 hours
<i>Normal packing:</i>	5.0+1.3 = 6.3 kg

*Cleaning solvent:* Acetone

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