

**General description**

NM Gelcoat 672 is a heat resistant epoxy gelcoat to be used in moulds. By the manufacturing of large moulds, it could be difficult to laminate within the tacky window of the gelcoat. If the laminating should be done with an infusion technique, it is impossible to work with a tacky gelcoat.

NM Gelcoat 672 is designed to guarantee an absolute adhesion between the cured and dry gelcoat surface and the laminate. This mean that two layers of gelcoat can be applied in one day, and the laminating can be done the next day. At a room temperature of 20-23°C, the second layer of gelcoat can be applied after approx. three hours. The consumption should be approx. 500g/m² and layer. (2 x 400µm).

The mixing procedure of the components is very important. A bad mixing will result in weak spots on the mould surface. After mixing, get a second vessel and pour the mixed contents from the first vessel and mix fully again. If a package should be divided, it must be done on a scale with a sufficient accuracy.

NM Gelcoat 672 cures at room temperature without brittleness. Tg will reach 60°C in seven days. Post curing at elevated temperature increases the Tg. See typical properties.

To minimize the risk of print through, the temperature should be raised by a ramp, normally 0.1-0.3°C/minute up to final curing temperature.

Typical properties

Resin:	<i>Potlife 100g 20°C:</i>	35 minutes
NM Gelcoat 672 A	<i>Open time:</i>	~ 3 hours
Hardener:	<i>Colour:</i>	Black
NM Härdare 672 B	<i>Normal packing:</i>	2.25 + 0.8=3.05 kg
Mixing ratio:	<i>Cleaning solvent:</i>	Acetone
Resin-Hardener 100-35 by weight		

<i>Density resin:</i>	1222 kg/m ³
<i>Density hardener:</i>	1000 kg/m ³
<i>Density mixture:</i>	1155 kg/m ³
<i>Viscosity at 25°C:</i>	Slight thixotropic

Glass Transition Temperature

Curing time	Flexural strenght MPa	E-modulus GPa	Tensile strenght MPa
7 days at 23°C	96	3,2	-
16 h at 50°C	115	3,0	47

Flex. and E-modulus acc. to ISO 178, Tensile acc. to ISO 527.

Curing time	Tg °C
7 days at 23°C	63
16 h at 50°C	83
16 h at 50°C+ 4 h at 100°C	124
16 h at 50°C+ 4 h at 100°C+ 4 h at 150°C	140

Additional

If the gel coat are to be applied in two layers, the relative humidity in the room should be less than 40 %

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