



Technical Data Sheet

NM Gelcoat 672

Utg: 2004-12-01

Ers: 2024-01-25

Rev: 2025-09-02

General Description

NM Gelcoat 672 is a heat-resistant epoxy gelcoat for moulds.

NM Gelcoat 672 has a short open time and it is therefore possible to apply two layers of gelcoat and start lamination on the same day.

At normal room temperature (20–23 °C), the second gelcoat layer can be applied approximately 1.5–2 hours after the first. Lamination can be carried out after the same interval following the second layer. Ensure that the gelcoat layer is tacky to the touch and capable of holding the next layer without displacement.

The consumption should be calculated at approx. 500g/m² and layer. It corresponds to about 400µm (0.4mm).

Application

The mixture of components is very important. A poor mixing results in soft spots in the cured system.

Mix thoroughly in a vessel, transfer the mixture into a clean vessel and mix further. Dosage should always be done on a scale with sufficient accuracy.

NM Gelcoat 672 is best applied with a brush to eliminate air bubbles.

Release agents

We recommend film forming release agents such as Marbocote 220.

Wax-based release agents are generally not recommended. For this, trials must be done first.

Curing

NM Gelcoat 672 hardens without brittleness at room temperature. The heat resistance (T_G) then becomes approx. 60°C.

Post-curing at an elevated temperature increases heat and styrene resistance. See technical data.

To minimize the risk of print through, the temperature must be increased by ramping.

Normally 0.1–0.3°C/minute up to the curing temperature.

Post work

Before starting lamination, the RH in the room must be checked again. RH must now not exceed 50%. The layer of gelcoat closest to the fabric should not have cured longer than 36 hours at room temperature.

Typical Properties

Resin NM Gelcoat 672 A
Hardener NM Härdare 672 B

Mixing ratio

Resin – Hardener 100 – 35 by weight

Density, 20°C: 1155 kg/m³
Viscosity, 25°C: Slightly thixotropic
Dry content: 100%
Pot life 100g 20°C: 25 minutes
Open time, 20°C: approx. 2 hours

Compressive strength: 70 MPa

Flexural strength, 7d RT: 96 MPa
E-modulus [Flexural]: 3.2 GPa

Flexural strength, 16h 50°C: 114 MPa
E-modulus [Flexural]: 4.5 GPa

Tensile strength, 16h, 50°C: 45 MPa

*Adhesion between layers,
16h, 50°C:* > 8MPa

T_G, 7 days at 23°C: 63°C / 145°F
T_G, 16 h at 50°C 80°C / 176°F
*T_G, 16 h at 50°C +
4 h at 100°C:* 124°C / 255°F
*T_G, 16 h at 50°C +
4 h at 100°C +
4 h at 150°C:* 140°C / 284°F

Colour: Black

Normal packing: 3.05 kg

Cleaning solvent: Acetone

*Flexural strength and E-modulus measured according to ISO 178
Tensile strength, E-modulus and Elongation at break measured
according to ISO 527
T_G measured according with DSC 20K/min*

Disclaimer

This product's technical specifications are developed by experience in field and laboratory by us. Fully cured will take place at seven days at +23°C and 50 % RF.

We reserve the right to change products as well as data. Current data sheets are available at our website and with us. We cannot assume responsibility for use in areas that we do not know. The user shall always evaluate products for their intended use and we guarantee only the material properties. For every product we offer reference objects separately.

Note: If the material has not been used before, or if it has been a long time since it was last used, the supplier must be contacted prior to use to ensure that the latest information and handling instructions are followed.

NILS MALMGREN AB

P.O Box 2039
S-442 02 YTTERBY

Phone: +46 303-936 10

Quality certified since 1990

E-mail: info@nilsmalmgren.se
Home site: www.nilsmalmgren.se