

## NORPOL GM H

Generic Family: GMH

First Emission: 18/01/2022

Version: 1, 09/09/2022

### Product type

Preaccelerated Unsaturated polyester Gel Coat in styrene, Vinyl ester

### Appearance

Various Colours

### Description

NORPOL GM H gel coats are formulated to using specialty VE resins specifically for mould making. They are designed with properties to withstand the pressures of Moulding process with added heat, styrene and chemical resistance.

H Gel coats require the addition of appropriate amount of promoter before use. They will be then be ready to use, easy to brush, sag resistant, fast curing once the addition of the correct amount of an appropriate MEKP to cure

Please contact your Polynt representative for full details

This product range is ready to use and exhibit good application characteristics

This range of gel coats are available in a limited range of colours, Black , Green, Red and Neutral

### Key Features & Benefits

- Excellent resistance to Gloss loss
- High reactivity
- High thermal resistance
- High toughness
- Improved impact resistance
- Medium viscosity
- Pigmented
- Preaccelerated
- Thixotropic
- Very good chemical resistance

### Application

Brush grade materials are designed for hand application to the mould and carefully levelled with a brush for even thickness  
Brush grade materials are not designed for spraying or diluted with solvent to spray

Do mix the Gel coat prior to use, preferably using a mechanical mixer with sufficient power for the appropriate container at low rpm. Mixing for 10 minutes every day is usually sufficient. Do NOT use air bubbling directly to mix.

Do not overmix the gel coat, it may break down viscosity, increasing tendency to sag and also result in styrene loss which could contribute to porosity.

Ensure Gel coat is used at minimum liquid temperature of 18°C including the mould used and workshop environment conditions  
Follow best practice application techniques

Ideal thickness is 700 micron with a range of 550-850 microns wet film

Postcuring recommended

Use only the recommended MEKP Peroxide dosage between 1.2 to 2.0% w/w

### Shelf life and storage

Please ensure you rotate stock and use within shelf life

Please note the Shelf life for this product relates to unopened containers; Only open container prior to use

Read carefully the Safety Data Sheet before use

Store in the shade, out of direct sunlight. Keep storage temperature below 25°C. Shelf-life will be reduced at higher temperature.

### CHARACTERISTICS <sup>(1)</sup>

#### Properties

Storage stability at 23°C in the dark

Density - 23°C

#### Test Method

MT-CG 001O

#### Unit

months

g/cm<sup>3</sup>

#### Typical values

4

1.10 - 1.20

#### Rheology

Brookfield viscosity at 23°C, sp 4 rpm 4

Cone & Plate at 25°C

A050

MT-CG 025V

mPa.s

mPa.s

14000 - 24000

700 - 900

#### Reactivity

Gel Time at 23°C + 1,5% MEKP50

G020

minutes

10 - 25

#### Film Properties

Film Cure at 500-700 microns at 25°C

Complete Hide

MT-CG 901R

MT-CG 901Q

min

microns wet

70 - 80

Depends upon Colour

1) Thoroughly test the gelcoat in your applications before full-scale use. Geltimes may vary due to the reactive nature of these materials and due to different brands of curing additives. Always test on small scale before formulating large quantities.

### PROPERTIES OF THE GELCOAT'S BASE RESIN IN CURED STATE <sup>(2)</sup>

Curing cycle

24h at 23°C + 24h at 60°C

HDT

ISO 75-2A (2013)

°C

105

Tensile strength

ISO 527 (2012)

MPa

min 60

Elongation at break

ISO 527 (2012)

%

min 2.0

2) Properties are typical values, based on material tested in our laboratories, but varies from sample to sample. Typical values should not be construed as a guaranteed analysis of any specific lot or as specification items.

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