

How to achieve optimal results with GelCoat



Processing with EpoxiPure Resin (12P80) and EpoxiPure Hardener (112P81)

Mixing ratio:

- 100 parts resin : 40 parts hardener + max. 14 parts (10 %) addition of GelCoat of the total quantity (resin + hardener) = 154 parts ready-to-use resin
- example: 100 g resin + 40 g hardener + 14 g GelCoat = 154 g ready-to-use resin

Advantages for colouring EpoxiPure with GelCoat

- no matrix impurities
- fully cured coloured epoxy-resin constructions
- high content of fine pigment creates exclusive, brilliant and scratch-resistant surfaces

How to achieve optimal results with GelCoat

Processing with Pre-preg (10C2) : GelCoat (95C10 – 16) and Hardener (95C9)

Mixing ratio: surface coat epoxy resin GelCoat (95C10 – 16) : hardener (95C9):

- surface coat epoxy resin : hardener = 100 parts resin : 12 parts hardener

The recommended mixing ratio should be kept as precisely as possible. Unbalanced curing times or faulty results could be caused already by differences of ± 2 %. The resin's toughness requires careful mixing with the hardener, up to the moment, when a homogenous, liquid mass is formed. The finished surface is easily polishable to high gloss.

Applying the GelCoat

The GelCoat is applied thinly onto the last layer of pre-preg by means of a spatula or brush.

Application tips and tricks

Applying a Nylon Stockinette, item-no. 95P2 prior to applying the GelCoat, eases vacuuming the upper foil and provides even distribution during the heating process. Select the upper foil one size larger in order not to pull off the GelCoat from the pre-preg surface during vacuuming. Creases can be pulled into areas which will be eliminated later by cutting off.

To achieve optimal opacity with GelCoat, we recommend the following temperature ramp

- 60 minutes at 40 °C
- + 30 minutes at 50 °C
- + 30 minutes at 80 °C
- + The remaining curing time depends on manufacturer's information about pre-pregs and materials used.

Advantages of GelCoat as surface layer for Pre-preg

- colourful composite construction
- bubble-free, high-gloss, impact- and scratch-resistant surface

