

MAXGUARD® GT // S Premium Tooling Gelcoat

MAXGUARD GT // S premium tooling gelcoat is based on epoxy modified vinyl ester. The base resin in combination with the gelcoat formula give final tooling a hard and glossy surface with good mechanical properties and toughness. MAXGUARD GT // S tooling gelcoat is available in black (75200) and green (75400) colours.

Typical liquid gelcoat properties at 23 °C

| Property | Value | Unit | Method |
|-----------------------------------|-------|------|--------|
| Viscosity, Brookfield RV4, 10 rpm | 7000 | mPas | L 002 |
| Viscosity, cone&plate | 230 | mPas | L 004 |
| Geltime, 2% MEKP-50 | 7 | min | L 005 |

Typical cured gelcoat properties

| Property | Value | Unit | Method |
|-----------------------------|-------|--------|------------|
| Heat deflection temperature | 110 | °C | ISO 75 (A) |
| Hardness | 35-40 | Barcol | ASTM D2583 |

Application and use

MAXGUARD GT // S is a premium tooling gelcoat for spray application. It is suitable for manufacturing of tooling used in the marine, transportation and building and construction industries.

To achieve best results, temperature of all equipment, materials and work shop must be 20-26°C. If the temperature is too low the tooling gelcoat may be undercured (which can also occur if gelcoat layer is too thin or peroxide dosing is incorrect) and a hard glossy surface cannot be achieved.

Some guidelines;

- Stir the tooling gelcoat gently in the original pail.
- Take the needed quantity of gelcoat into a large enough pail to be able to add 2% of peroxide and mix peroxide thoroughly into the gelcoat.
- The spray grade (S) has to be applied by spraying several thin layers wet to wet (appr. 0,2 mm each) with smallest possible nozzle and with lowest possible pressure. A brake of 2-4 minutes should be kept after each layer to allow proper air release. Final wet layer thickness should be minimum 0,8 - 1,0 mm.
- The final thickness of the cured tooling gelcoat should be 0,8 mm.



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Certificates and approvals

The manufacturing, quality control and distribution of products, by Ashland Composite Polymers, are complying with one or more of the following programs or standards: Responsible Care, ISO 9001, ISO 14001 and OHSAS 18001 by BVQI.

Handling and storage

For good working practices, see Ashland's "Gelcoat Handling Guide". Maximum storage of gelcoat is 3 months at temperature under 25°C away from direct sunlight. The gelcoat must be gently stirred before use. Temperature of workshop, raw materials and tools should be 20 - 26°C and relative humidity below 70%.

Notice

All information presented herein is believed to be accurate and reliable, and is solely for the user's consideration, investigation and verification. The information is not to be taken as an express or implied representation or warranty for which Ashland assumes legal responsibility. Any warranties, including warranties of merchantability or non-infringement of intellectual property rights of third parties, are herewith expressly excluded.

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Ashland requests that the user reads, understands and complies with the information contained herein and the current Material Safety Data Sheet.

More information

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