

## 220-B-117

### DESCRIPTION

The 220-B-117 is a pre-promoted, white isophthalic gel coat developed for the fiberglass industry.

### FEATURES AND BENEFITS

- Good viscosity / thixotropy balance.
- High viscosity.

### APPLICATIONS

- Specially designed to be used with a brush for manufacture of FRP parts.

### TYPICAL LIQUID PROPERTIES

Property	Units	Min.	Max.	Test Method
Non volatile matter	%	65	75	TARQ – 500
Brookfield viscosity <sup>2</sup>	Cps.	50000	55000	TARQ – 300
Thixotropic index <sup>3</sup>	-----	5	7	TARQ – 300
Gel time <sup>1</sup>	Minutes	8	12	TARQ – 400
Gel time to peak	Minutes	7	10	TARQ – 400
Exotherm temp.	°C	140	180	TARQ – 400

<sup>1</sup> 1.8% Butanox M-50 @25°C; <sup>2</sup> RVF, spindle # 5, 4 rpm @25°C; <sup>3</sup> RVF, spindle # 5, 2 / 20 rpm @25°C

NOTE: Tests results compared with the reported in certificate can be affected due to: batch age, temperature, moisture, type and amount of catalyst, testing equipment and method.

## RECOMMENDATIONS

- 1.- The catalyst level should not exceed 2.8% or fall below 1% for proper cure.
- 2.- This product should not be used when temperature conditions are below 16°C, as curing and handling may be adversely affected.
- 3.- Before use:
  - Mix once a day for 10 minutes, starting from the edges towards the center of the drum with the least possible turbulence.
  - Avoid air assistance, this is not effective and may cause water or oil contamination.
  - Avoid over-mixing, due to potential filler separation and increased tendencies to sag.
- 4.- Film should be applied for a total film thickness of 18 to 22 mils (wet).  
NOTE: Films less than 12 mils may not cure properly; films above 24 mils may pre-release, generate porosity or cracks.
- 5.- Do not add any material different to the catalyst recommended for this product.
- 6.- Do not mix organic peroxides with metallic soaps, amines or any type of accelerators or promoters, because it can result on violent decomposition with fire or explosion.
- 7.- Any additional questions, please contact your Reacciones Químicas SA de CV sales representative.

## STORAGE

Uncatalyzed 220-B-117 gel coat has a usage life of 45 days from invoice date, when stored at 25°C or below, in closed, opaque, factory sealed containers, and out of direct sunlight, heat sources or moisture. If ordered in IBC totes, shelf life is only 30 days when stored at 25°C or below, in closed, factory sealed containers, and out of direct sunlight, heat sources or moisture. For every 7°C increase in storage temperature, the shelf life is reduced by one half.

## SAFETY AND HANDLING

Detailed information for safe handling of 220-B-117 gel coat, can be found on its SDS. For more information, please contact your Reacciones Químicas SA de CV sales representative.

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