

500-J-001

DESCRIPTION

The 500-J-001 is a pre-promoted, isophthalic tooling gel coat developed for the manufacture of molds where excellent performance and very good rigidity are required.

FEATURES AND BENEFITS

- Excellent gloss development.
- Good viscosity / thixotropy balance
- Fast curing cycles.
- Quick development of barcol hardness.
- the color is orange

APPLICATIONS

- Manufacture of molds.

TYPICAL LIQUID PROPERTIES

Property	Units	Min.	Max.	Test Method
Brookfield viscosity ²	Cps.	15000	20000	TARQ – 300
Thixotropic index ³	-----	6	8	TARQ – 300
Gel time ¹	Minutes	18	23	TARQ – 400
Cure time	Minutes	24	38	TARQ – 400
Exotherm temp.	°C	170	220	TARQ – 400
Film defects	-----	Free		TARQ – 510

¹ 1.8% Butanox M-50 @25°C; ² RVF spindle # 4, 4 rpm @25°C; ³ RVF, spindle # 4, 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 sprayed in at least three passes, 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.- Brushing is not recommended, because it causes uneven thickness.
- 6.- Do not add any material different to the catalyst recommended for this product.
- 7.- 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.
- 8.- Any additional questions, please contact your Reacciones Químicas SA de CV sales representative.

STORAGE

Uncatalyzed 500-J-001 gel coat, have 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 500-J-001 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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