

SANCO, INCORPORATED

Specializing in Non-Ferrous Minerals



235018-515

GRAY SAND ABLE GEL COAT TECHNICAL DATA SHEET

Product Type: The **235018-515 Gray Sandable Gel Coat** is based on a semi-flexible orthophthalic polyester gel coat for use in the manufacture of cultured marble. This product sprays easily, sands easily, and has very low porosity.

Performance Properties:

Total HAPs: Viscosity: 32±5% (26±2% Styrene, 6±2% MMA)

Thix Index: Gel @ 77°F 4500-5500 cps (LVF spindle #3 @ 6 rpm) @
77°F 600-1000 (LVF spindle #3 @ 60 rpm)

Time: @ 77°F 6.5

Film Cure: Barcol @ 77°F 5-8 minutes (1.5% Cadox L-50 MEKP in 100 grams mass)*
* Values refer to 9% active oxygen MEKP

Hardness: @ 77°F 50 minutes maximum

6 hours: 20-25 Overnight: 35-40

Heat Deflection Temperature: Measured by ASTM D 235°F
648

Crack Test: Developed by Bob Dougherty, Chief Design Engineer for Boston Whaler for 30 years. This test involves a thermal shock cycle with 3/16 of an inch steel bar immersed in gel coat. 235018-515 passes this most demanding test.

Sag Resistance: **235018-515** has excellent sag resistance on vertical surfaces.

Resistance to Porosity and Pinholes: Outstanding. Depends somewhat on type of spray gun, technique, and weather conditions that are prevalent at the time of application. A gel coat that is applied too thin will not cure satisfactorily and will be more permeable.

Many gel coat blisters can be avoided during gel coat application, being very careful not to entrap air behind the gel coat film between the interface of the gel coat and the polyester backup resin. Blisters may appear in these spots caused by the absorption of moisture through the gel coat film.

Specifications on all products may be subject to slight adjustment during the initial period of manufacture. SANCO, Inc. reserves the right to change specifications at any time. The general description, recommended uses, application data, and statements in the product literature are guidelines only. Users should test this product in advance to verify suitability for particular uses. Because this product may be used for a variety of applications over which SANCO, Inc. has no control, SANCO, Inc. neither makes nor authorizes to be made any express or implied representation or warranty with regard to this product concerning the performance, use, fitness for particular purpose, suitability for use on any surface or merchantability of this product, whether used alone or in combination with other products. SANCO, Inc. assumes no liability for incidental, consequential, or direct damage of any kind regardless of cause or negligence.

April, 2002

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