

# DURELASTIC

## Spray-Gelcoat BD7161

- Gelcoat based on orthophthal acid
- Accelerated with co.
- Thixotropic, stable attitude
- Sprayable

<b>Technical / physical data</b>	<b>Colour</b>	acc. to RAL 840 HR other colour shades on request
	<b>Gloss value</b>	depends on form and mould release agent
	<b>Original viscosity</b>	approx. 600 mPas bei 500 / Sek. <sup>-1</sup>
	<b>Mixing ratio (by weight)</b>	+ 2 % DURELASTIC-Hardener-MEKP-50 HD0603
	<b>Potlife</b>	8 to 10 min. / 20 °C
	<b>Thinner</b>	DURELASTIC-Resin solution 400900 Addition: 3 %
	<b>Density</b> calculated	1,1 g / ml +/- 0,1
	<b>Material usage</b> after hardener addition	500 to 600 g / m <sup>2</sup>

### Storability

Approx. 4 month in original packings at an ambient temperature of 5 to 25 °C, in case the original packings are tightly closed. Opened packing must be used very shortly. The minimum storage stability of each batch is mentioned on the product label. A storage time beyond the mentioned date doesn't necessarily mean that the material is unusable. In this case a check of the qualities which are important for the respective

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Due to a prolonged storage time the gelation and curing times can be changed. By adding an accelerator (e.g. BD7550) the original gelation time can be adjusted.

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## Processing and application

### Application

Components are to be mixed homogeneously.

- in original viscosity after hardener addition with cup pistol spraying.  
nozzle: 2,5 bis 3 mm spraying pressure: 3 to 5 bar
- also Airless

### Laminate structure

In order to receive optically good surfaces, we recommend to up-laminate a spindivided glass fiber mat for the first situation, e.g. 225 g / m<sup>2</sup>. In order to avoid a pulling up of the surface layer, the pot life of the resin mixture for the first situation should not amount to any more than 20 to 25 minutes with 18 °C. The further reinforcing plies can with suitable

heavier materials, e.g. glass fiber mat 450 g/m<sup>2</sup>. We recommend you DURELASTIC-Laminating resins in different attitudes, e.g. accelerates, accelerator-free, additionally thixotropied, etc.

### Relaminate

After approx. 90 min., at the latest after 12 h. / 20 °C area -, material- and formtemperature.

### Substrates

GFP-Forms, Metal-Forms, Releasefoil

### Pretreatment

Forms treat with suitable release agent  
To application see DURELASTIC-Info. NR. 108

### Application temperature

During the processing area -, material - and form temperature are to be kept above 16 °C, to avoid hardening disturbances and pulling up feature.

### Cleaning of working equipment

Within the working time with EFD-Thinner 400500 or  
EFD-Cleaner 400906.

### Advise for safety protection and protection of health

The usual precautionary measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning health protection and environment protection can be read in the corresponding safety data sheet.

## Special remarks

### Test conditions

All information is based on a standard climate 20/65 DIN 50014.

All information are based on our product knowledge and experience. To the application we have no direct influence. For further information please don't hesitate to contact us.

The information mentioned herein are reference values and are not given as specification.