

SikaBiresin® GC155 EP-Gelcoat, rollable and easy applicable

Areas of Application

- Gelcoat for big laminating moulds

Product Benefits

- Rollable and easy applicable
- Good heat resistance
- Dense surface

Description

- Basis Two component epoxy system
- Component A **SikaBiresin® GC155**, epoxy resin, black, filled
- Component B **SikaBiresin® GC155**, amine, amber, unfilled

Processing Data		Component A	Component B
Individual components		SikaBiresin® GC155	SikaBiresin® GC155
Viscosity, 25° C	mPa.s	33,000	120
Density, 25° C	g/cm³	1.60	0.98
Mixing ratio A : B	in parts by weight	100	14
		Mixture	
Mixed viscosity, 25° C	mPa.s	8,500	
Potlife 500g	h	4	

Physical Data (approx. values after post curing 8h / 160° C)

SikaBiresin® GC155 with Component B			SikaBiresin® GC155
Colour			black
Density	ISO 1183/A	g/cm³	1.53
Shore hardness	ISO 868	-	D 89
Flexural E-Modulus	ISO 178	N/mm²	5,250
Flexural strength	ISO 178	N/mm²	95
Strain at the outer surface	ISO 178	%	2.7
Elongation at Fmax	ISO 527	%	1.7
Tensile E-Modulus	ISO 527	N/mm²	4,700
Tensile strength	ISO 527	N/mm²	50
Compressive strength	ISO 604	N/mm²	120
Impact resistance	ISO 179/1 Ue	kJ/m²	15
Heat deflection temperature	ISO R75 Af	°C	145
Glass transition temperature	ISO 11357	°C	150

Packaging

Individual components	SikaBiresin® GC155 (A)	5,0 kg net
	SikaBiresin® GC155 (B)	0,7 kg net

Processing

- The material, processing and mould temperature must be from +18° C to +25° C.
- Then the thoroughly mixed (with spatula or slow speed mixing equipment) SikaBiresin® GC155 mixture is applied directly out of the container using a flat, short-haired brush.
- The coating is applied in an uniform direction to ensure a homogeneous, even and void-free surface coat on the mould surface. The mould surface has to be pretreated with suitable release agents before.
- Within geltime a coupling layer can be applied to avoid adhesion problems.
- Better resistance of the surface compound to elevated temperatures, different solvents as well as exposition to water will be obtained after a post treatment of 4h at +120° C of demoulded parts. In this case a slow heating and slow decreasing of temperature after treatment are required.

Storage

- Minimum shelf life of SikaBiresin® GC155 (A) is 24 months and of SikaBiresin® GC155 (B) is 12 months under room conditions (+18° C - +25° C), when stored in original un-opened containers.
- After prolonged storage at low temperature, crystallisation of the A component may occur. This is easily removed by warming up for a sufficient time to +60° C to +80° C. Allow to cool to room temperature before use.
- Containers must be closed tightly immediately after use to prevent moisture ingress. The residual material needs to be used up as soon as possible.

Health and Safety Information

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety related data.

Disposal considerations

Product Recommendations: Must be disposed of in a special waste disposal unit in accordance with the corresponding regulations.

Packaging Recommendations: Completely emptied packagings can be given for recycling. Packaging that cannot be cleaned should be disposed of as product waste.

Value Bases

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

Legal Notice

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