

## SG 715 Epoxy Gel-coat

### Properties :

Can be applied with a brush or a spray gun  
Cures at ambient temperature  
Good thermal properties after curing: Tg1 max = 90°C (DSC)  
Good resistance to abrasion  
Recommended for building prototypes and scale models...

### Physical properties :

Reference	Definition	Appearance	Viscosity Cps at 20°C	Viscosity Cps at 25°C	Density g/ml at 20°C
SG 715	Resin	White or black gel	Thixotropic gel	Thixo.gel	1.16 ± 0.05
SD 802	Hardener	Colourless liquid	33 ± 5	29 ± 5	0.96 ± 0.01
EP 960	Thinner	Colourless liquid	2 ± 0.5	/	0.789

### Mixing proportions :

- For application with a roller/brush:
 

<b>White SG 715 / SD 802 / EP 960</b>	<b>100 g / 27 g / 0 to 6 g</b>
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- For application with a spray gun: the R/H mixture to be diluted to a maximum of 20% by weight of EP 960 thinner
 

<b>White SG 715 / SD 802 / EP 960</b>	<b>100 g / 27 g / 27 g maximum</b>
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### Reactivity of undiluted mix

Ambient temperature:	<b>at 20°C</b>	<b>at 25°C</b>
Pot-life measured on 150 g of mix/Exothermic temperature:	29' / 160°C	21' / 170° C
Time to reach 50°C for 150 g mix:	17'	12'
Time to be dry to touch in film:	2 h 20'	1 h 45'
Hard film after:	6 h	4 h

### Conditions for application

18 °C < Temperature of the substrate < 50 °C  
Hygrometry < 80%



## Release agent

Check compatibility with **SG 715** (resistance to or facility of removal from mould...) by making a preliminary test, specially if the gelcoat is used diluted.

Wax 103: for curing at below 50° C and undiluted gel coat

Cirex DE 68: for curing at above 50° C and diluted gel coat

## Processing

Brush/roller for lacquer

Thinning: 0 to 5% of weight of mix

Pneumatic spray gun: Carefully mix the **SG 715** and **SD 802** resin, and leave to develop for five minutes.

Thin with 20% maximum of EP 960: for 100 g of SG 715 / 802 mix, add 20 g of EP 960 thinner. Mix carefully.

Spray in thin coats 40 cm from the substrate. Wait 5' between each coat.

Allow the gel coat to gel before applying the second coat or laminating. The gel coat must be tacky (still sticky to the finger) to avoid any risk of delamination.

## Equipment

Brush/roller

## Lamination :

Lamination must begin as soon as the **SG 715** is no longer tacky.

## Post-curing :

If possible, carry out post-curing in the mould so as to limit marking of fibres.

12 hours @ 20°C + 24 hours @ 40°C

or 12 hours @ 20°C + 8 hours @ 60°C

## Thermal stability :

Tg1=90°C after 24 hours at ambient temperature + 8 hours at 60°C

## Cleaning :

EP 960 thinner, methyl ethyl ketone (MEK), solvent for epoxide paints.

**Toxicity / Labelling** (EEC Classification in accordance with Annex 1 of EEC Directive 67 / 548)

References	Symbols	Risk classification
SG 715		Xn: Harmful R 36/38: Irritant for eyes and skin R 51/53: Toxic for aquatic organisms, may have harmful effects, in the long term, on the aquatic environment R 43 May cause sensitisation through skin contact
SD 802		C: Corrosive R 21/22: Harmful if swallowed or if there is skin contact R 34: Causes burning R 43: May cause sensitisation through skin contact
EP 960		Flammable R 11, 23/25

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