

SG 162 CS / SD 2625

High hardness surface Epoxy tooling gelcoat

Description

Epoxy tooling gel coat used for a small to medium production scale tool making for epoxy or polyester production parts. This gel coat is easy to brush, thixotropy is adapted for application on walls.

SG 162 CS is formulated with specific fillers giving high abrasion resistances, and it can works up to 80 ° C when post cured properly
It has a grey colour.

Properties

	Resin SG 162 CS	Hardener SD 2625
Aspect :	Gel	Liquid
Color	Grey	Yellow
Viscosity (mPa.s) @ 20 °C	Thixotropic gel	220 / 260
@ 25 °C	Thixotropic gel	190 / 220
Density (Kg/l) @ 20 °C	1.50 ± 0.05	1.04 ± 0.05

System SG 162 CS / SD 2625

Pot life on 500 g mix @ 20 °C	35 mn
@ 25 °C	30 mn
Time to overlay on a film of 400 microns	
Min / max @ 20 °C	2 h 30 to 4 h00
@ 25 °C	2 h 30 to 3 h30
Mixing ratio	100 g / 9,5 g

Advised post-cure cycle

If possible the post-cure will be done in the mould to limit the print of the fibbers

- 24 hours @ 20-25°C + 24 hours @ 40°C
- or 24 hours @ 20-25°C + 12 hours @ 60°C
- or 24 hours @ 20-25°C + 8 hours @ 80°C

Workshop conditions

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

Release agent

CAUTION ; SG 162 has been formulated with high abrasive fillers which could scratch the model

Use appropriate release agent. Apply the first layer of gel coat by brush

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