GC 135

High-Temperature Resistant Mold Gel Coat

Introduction :

GC 135 is a brushable two-component epoxy gel coat used for the production of large high- temperature resistant moulds, such as mould surface gel coats for vacuum infusion, prepreg, RTM, SMC and thermoforming.

FEATURES :

• Long operation time • Surface high brightness and hardness

• Can be ground and polished • Resistant to chemical corrosion

PHYSICAL PROPERTIES:

Test item	Test method	GC135 Resin	GC135 Hardener
Mixing ratio by weight		100	16
Aspect	visual	Thixotropicliquid	liquid
Viscosity at 25°C(mPa.s)	ISO2555:2018	Thixotropy	Approximately200
Densitybeforemixing(g/cm^3)	ISO1675:1985	Approximately1.30	Approximately1.07
Densityaftercuring25°C(g/cm^3)	ISO2781:1996	Approximately1.25	
Gel time (500g) at 25°C (min)	Thermoelectric Thermometer	50-60	

MECHANICAL PROPERTIES :

Test item	Test method	GC135
Shore hardness	ISO868:1985	88D
Flexural modulus	ISO178:2001	4.1GPa
Flexural modulus	ISO178:2001	98MPa
Tg	ISO11357:2002(DSC)	130°C

Curingcondition:valuesaboveareobtainedonstandardspecimens:25 °C 60h+40 °C 2h+60 °C 2h+80 °C 2h+100 °C 2h+120 °C 3h

PROCESSING:

• First, apply a release agent on the mold without holes.

• The resin and the hardener agent should be mixed evenly in the prescribed ratio.

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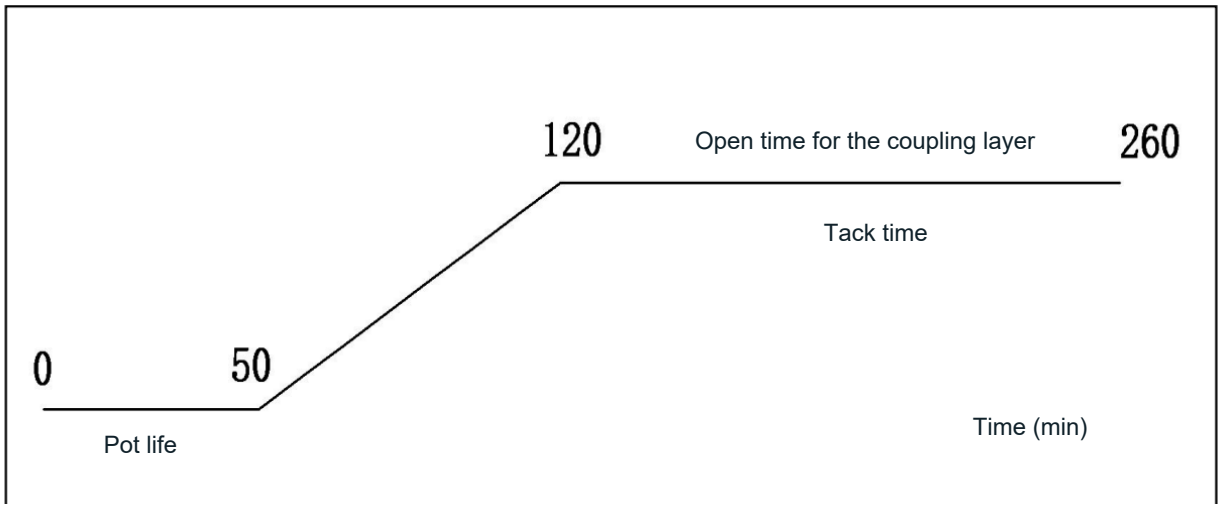
• Use a plastic or rubber spatula to apply only one layer of the gel coat. After the cooling time, you can proceed with the subsequent operations.

Application diagram of GC 135

(Application temperature : 25°C Mass 500 g)



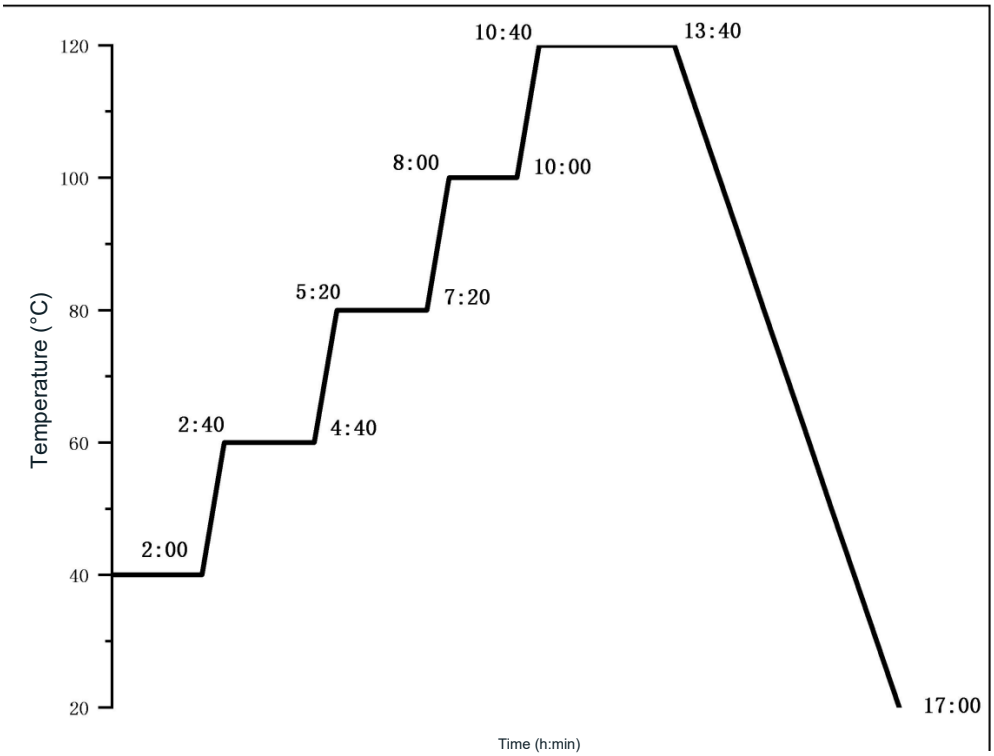
Pot life

Open time for the coupling layer

Tack time

Time (min)

After 24 hours of curing at 25 °C , further curing will be carried out.



Temperature (°C)

Time (h:min)

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USABLELIFE AND STORAGE:

While stored in dry place and in original unopened containers at temperature between 15°C and 25°C, the shelf life is 24 months .

HANDLING PRECAUTIONS:

Avoid contact with skin while in application, wear mask, gloves and protection close when necessary; used in well ventilated area.For further information, please consult product safety data sheet.

WARRANTY INFORMATION-PLEASE READ CAREFULLY :

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer’s tests to ensure that our products are safe, effective and fully satisfactory for the intended end use.

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