



Technical Data

GatorHyde GelSpar

Aliphatic, In-Mold Applied Coating

NB2012

Revised: 011510

MANUFACTURER

GatorHyde Protective Coatings, Inc.
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PRODUCT DESCRIPTION:

GelSpar is a 100% solids*, aliphatic in-mold applied coating that has been designed as a replacement for polyester gel coat. **GelSpar** contains zero VOC's and displays excellent UV weathering characteristics. **GelSpar** greatly improves crack, impact and chip resistance when compared with polyester gelcoats. **GelSpar** has been designed to be applied using heated high-pressure plural component application equipment manufactured by GlasCraft® or Graco®.

*Depending on pigmentation choice, **GelSpar** may have a small amount of solvent present to assist in leveling and flow properties over certain mold releases.

APPLICATION TECHNIQUES:

GelSpar B-Side (the pigmented component) should be thoroughly mixed before mixing with the A-side. The material should be sprayed to a 15-25 mil dry film thickness. GatorHyde recommends a Graco Fusion® or a GlasCraft Probler 2® spray gun. Contact the manufacturer for further information. The plural component spray equipment must be able to maintain constant pressures of 2500 psi and temperatures of 160°F on the primary heaters and hose heat. Immediately following application of the **GelSpar**, depending on the application, a barrier coat may be recommended to eliminate glass shadowing and "press-thru" to the **GelSpar**. It is not required to pre-heat the molds prior to application of **GelSpar**.

AVAILABLE COLORS:

Several colors available, contact GatorHyde for details.

PHYSICAL PROPERTIES:

Tensile Strength	ASTM D-412	Failure, psi	3850
Elongation	ASTM D-412	%	22
Tear Strength Die C	ASTM D-624	pli	750
Hardness	ASTM-D2240	Shore D	65
Flash Point	Pensky/Martin	°F	>200
Taber® Abrasion (1KG, 1000 revs)	ASTM-D4060	mg loss, CS-17	20.6

% Solids (weight)	Calculated	%	100
VOC Content	Calculated	lbs./gal	0.00
Gloss	ASTM D-523	60° spec. Gloss	90+
Impact	ASTM D-2794	direct, reverse	160,160
Viscosity A-Side			1500 cps
Viscosity B-Side			1000 cps

Processing Properties (15 mils) (75°F) (54%RH)

Gel time (200 gram mass)	15 Seconds
Tack Free Time	30 seconds
Volume Ratio (A:B)	2A:3B

MIXING INSTRUCTIONS:

Thoroughly mix B-Side prior to mixing with A-side using a "drum or tote mixer" for three minute or until consistent color is attained.

Mold Release Agents:

► Several silicone, water-based, and wax-based primers have been tested. GatorHyde can recommend several mold releases on polyester and fiberglass molds. Each applicator should test mold release products to their own satisfaction. Baking of some mold releases may be required.

CLEAN-UP/DISPOSAL:

Cured product may be disposed of without restriction. The un-cured isocyanate and resin portions should be mixed together and disposed of in a normal manner. "Drip free" containers should be disposed of according to local, state, and federal laws.

SAFETY & HANDLING:

MSDS will be mailed immediately upon receipt of a purchase order or upon request. All personnel should read and understand the safety recommendations. All body parts should be covered and respirators are required for safe application of this product. Keep uncured product away from children at all times.

REPAIR:

GelSpar can be repaired using a specified repair technique prepared by GatorHyde. Contact GatorHyde for specific recommendations

SHELF LIFE & STORAGE:

Six months to one year in factory delivered, unopened containers. Keep away from extreme heat, freezing and moisture.

PACKAGING:

GelSpar is available in 5 gallon pails (25 gal kit), 55 gallon drums (275 gallon kit), 275 gallon totes are also available.

SHIPPING INFORMATION:

GelSpar can be shipped via most commercial truck lines. The shipping class is "55". The "A" side (isocyanate) is unregulated. The B-Side is also unregulated.

CHEMICAL RESISTANCE:

ASTM D3912 Mod. 24 Hour Immersion

<u>Chemical</u>	<u>Result (25°C)</u>
Acetic Acid (100%)	NR
Acetone	RC, Dis
Ammonium Hydroxide (20%)	R
Anti-freeze/Water (50:50)	RC
Battery Acid (Sulfuric Acid)	C
Benzene	RC
Brake Fluid (DOT3)	RC, Dis
Brine-Saturated (310g/l)	R
Citric Acid	RC
Clorox® (10%)/Water	R, Dis
Copper Chromate Arsenic (4%)	R
Diesel Fuel	R
Gasoline	R
Gasoline/5% MTBE	RC
Gasoline/5% Methanol	R
Hydrochloric Acid (100%)	C
Hydraulic Fluid (oil)	RC, Dis
Isopropyl Alcohol	RC
Lactic Acid	RC
MEK	NR
Methanol	C, Dis
Methylene Chloride	NR
Mineral Spirits	R
Motor Oil	R, Dis
MTBE	C
Muriatic Acid (10%)	R
NaCl/Water (10%)	R
Nitric Acid (50%)	R
Phosphoric Acid (10%)	R
Phosphoric Acid (50%)	NR
Potassium Hydroxide (10%)	R
Potassium Hydroxide (20%)	R, Dis
Propylene Carbonate	R
Skydrol®	RC
Sodium Hydroxide (50%)	R
Sodium Hypochlorite (10%)	RC
Sodium Bicarbonate	R
Sugar/Water (10%)	R
Sulfuric Acid (50%)	R, Dis
Toluene	R
1,1,1-Trichlorethylene	R, Dis
Vinegar (5%)/Water	R
Water	R
Water(82°C)14Day	R
Xylene	R

R= Recommend = Little or no Visible Damage

RC or C= Recommend Conditional = Some Effect-Swelling, Discoloration, Cracking,-Wash Down Within One Hour of Spillage to Avoid Effects

NR= Not Recommended

Dis= Discoloration Only

WARRANTY:

The technical data and any other printed information furnished by GatorHyde are true and accurate to the best of our knowledge. **GelSpar** conforms to in-house quality control procedures and should be considered free of defects. Due to the wide range of applications of this product, it is impossible to assume responsibility for any errors in regard to application, coverage, workmanship, over-spray, or injuries resulting from the use of this product. Liability, if any, for this product will be in the form of replacement materials. The possibility exists to warrant this product on a specific application basis under specific written application instructions from GatorHyde.