

USE

Polyurethane foaming mold, polyurethane and polyester low pressure injection, contact mold, thermoforming die.

MECHANICAL AND THERMAL PROPERTIES AT 23 °C⁽¹⁾

Hardness	ISO 868-85	Shore D1 / D15	87 / 86
Compressive modulus	ISO 604	MPa	6000
Compressive yield strength	ISO 604	MPa	123
Flexural modulus	ISO 178-93	MPa	5300
Flexural strength	ISO 178-93	MPa	92
Glass transition temperature after curing	T.M.A.-Mettler	°C	130
Glass transition temperature without curing (24hrs at room temperature)	T.M.A.-Mettler	°C	66

(1) : Average values obtained on standardized specimens / Hardening 16hrs at 25 °C + curing described in processing conditions

STORAGE CONDITIONS

Use before 24 months according to the manufacturing date. Expiration date indicated on the packaging.

HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products :

- ensure good ventilation
- wear gloves and safety glasses

For further information, please consult the product safety data sheet.

PACKAGING

Resin

1 x 13.33 kg

12 x 0.5 kg

Hardener

1 x 1.740 kg

Pack of 12 x 0.065 kg

GUARANTEE

The information of our technical data sheet are based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of AXSON products, under their own conditions before commencing with the proposed application. AXSON refuse any guarantee about the compatibility of a product with any particular application. AXSON disclaim all responsibility for damage from any incident which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.

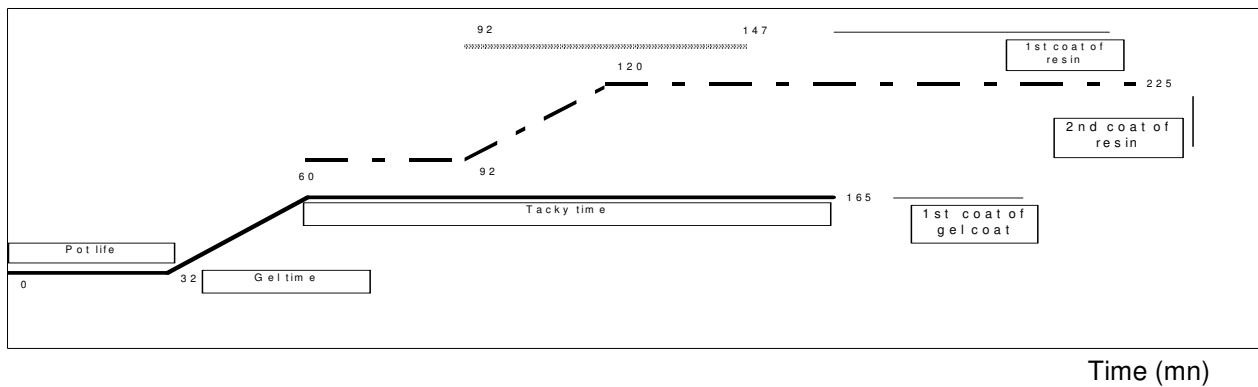
The technical data sheet and the safety data sheet are also available on our website : www.axson.com

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TECHNICAL DATA SHEET

PHYSICAL PROPERTIES				
		RESIN GC1 125	HARDENER GC 15	MIXING
Mixing ratio by weight		100	13	
Aspect		paste	liquid	thick liquid
Color		grey	light amber	grey
Brookfield LVT viscosity at 25°C (mPa.s)	-	thixotropic	850	thixotropic
Density at 25°C	ISO 1675-85	1.57 – 1.63	1.05 – 1.09	1.47 – 1.52

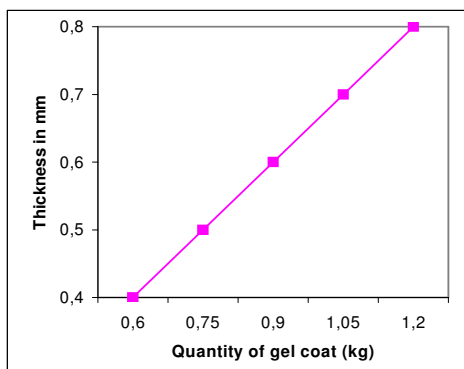
Application diagram of GC1 125/GC 15
(Application temperature : 23°C Mass 560 g)



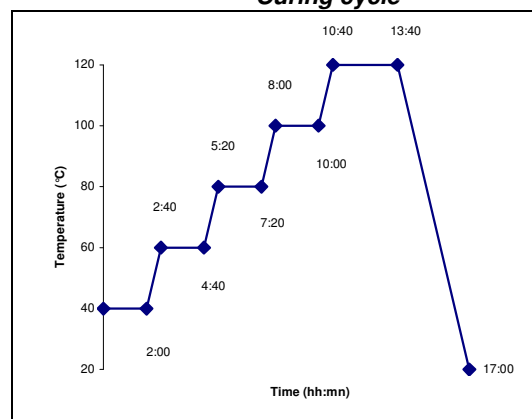
PROCESSING CONDITIONS

- Apply DEMOLDING AGENT 841 or WAX 827 on a non porous pattern.
- Back-up : EPOLAM 2050 and reinforcements EPO 4030

Quantity of gel coat for production of a 1 m² surface
(for information only)



Curing cycle



Initial stabilization 16 hrs at room temperature.