

## APPLICATIONS

*Production of moulds for prepreg, RTM, SMC, thermoforming die...*

MECHANICAL & THERMAL PROPERTIES (1)			
Hardness	ISO 868-85	Shore D1	90
Flexural strength	ISO 178-93	MPa	90
Flexural modulus of elasticity	ISO 178-93	MPa	4 500
Glass transition temperature	T.M.A.-Mettler	°C (°F)	185 (365)

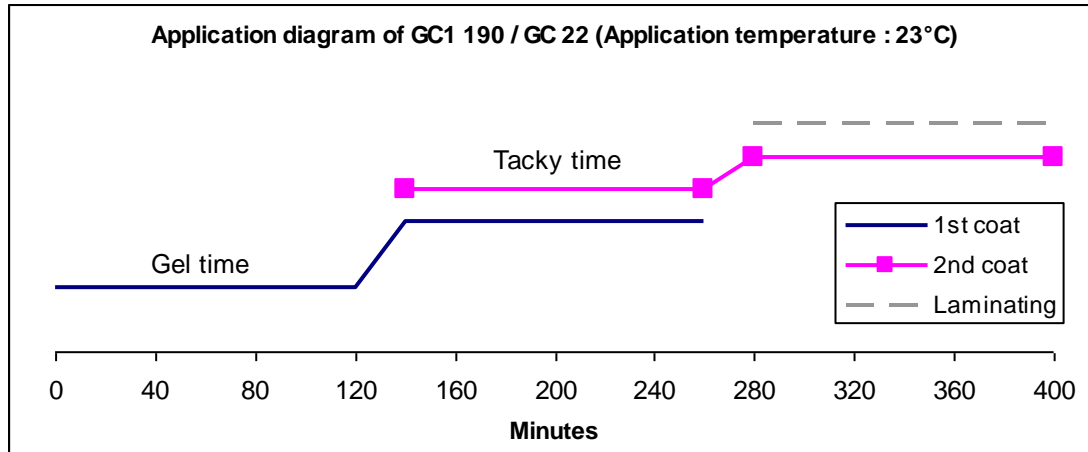
**(1)** : Average values obtained on standardized specimens, on neat resin.  
 Hardening : according to the curing cycle indicated on the next page.

PHYSICAL PROPERTIES				
		RESIN GC1 190	HARDENER GC 22	MIXING
Mixing ratio by weight		100	13	
Aspect		thick liquid	liquid	thick liquid
Color		black	amber	black
Brookfield LVT viscosity at 25°C (mPa.s)		thixotropic	4300	thixotropic
Pot life on 500 g at 25°C (min)				65
Density of uncured product	ISO 1675-85	1,66	1,04	-
Density of polymerised product	ISO 2781-88	-	-	1,59

## PROCESSING CONDITIONS

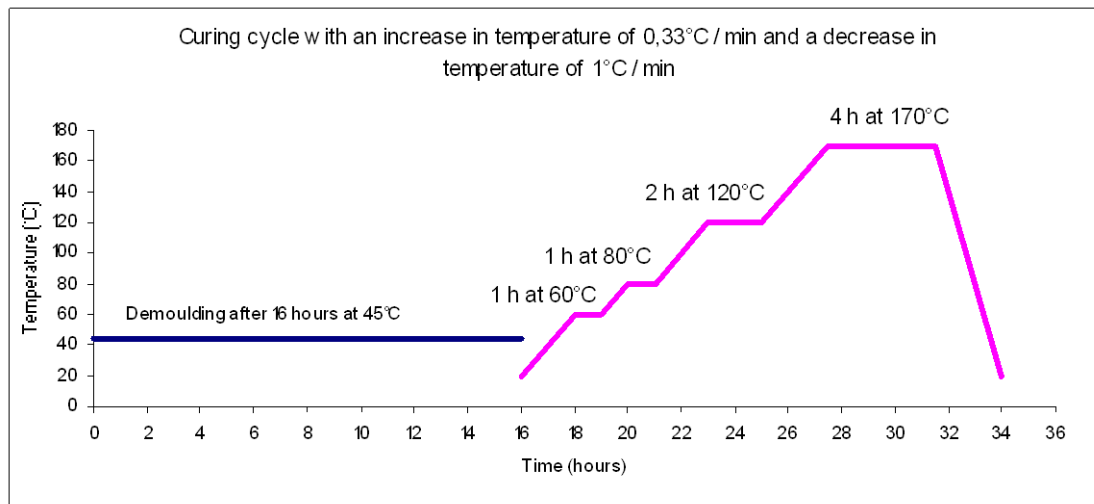
- Apply **DEMOLDING AGENT 841** or **WAX 827** on a non porous pattern, following relevant TDS.
- Back-up :
  - Wet lay-up : **EPOLAM 2080**
  - Infusion : **EPOLAM 2090-2026**
  - Resin concrete : **EPO 752/2080**

*The application of this Gel Coat at low temperature and with a high hygroscopy is not recommended.*



## CURING

The pretreatment at 45°C must be started **within 48 hrs maximum** after the beginning of the application.



## STORAGE CONDITIONS

Shelf life of the resin is 9 months in a dry place and in its original unopened container at a temperature below 20°C and shelf life of the hardener is 24 months in the same conditions.

Any open can must be tightly closed under dry inert gas (dry air, nitrogen, etc.).

A storage at temperature higher than 25°C can involve an increase in the resin viscosity, which will not modify the final characteristics of the product.

## HANDLING PRECAUTIONS

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

- ensure good ventilation,
- wear gloves, safety glasses and clothes.

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

## PACKAGING

GC1 190 RESIN	GC 22 HARDENER
5 kg	2 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.