

Product Data



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MG-1615 SERIES 100% NPG-ISOPHTHALIC, CLEAR, LIGHT- STABILIZED MARINE GEL COAT

The MG-1615 Clear 100% NPG-Isophthalic Marine Gel Coat series is formulated to meet the need for high quality marine and general exterior gel-coated FRP applications. Unique properties of this product series are as follows:

Improved clarity “Black Flake is Blacker!”

Recommended for Polycryl Polyflake* application.

Light Stabilized to maximize long term gloss and color retention for recreational products.

Superior quality 100% NPG-Isophthalic base to provide the best possible long term weathering properties and water resistance.

Acrylic modified to further enhance long term weatherability.

Enhanced air release to improve film clarity.

Available in several gel time ranges to fit most production schedules.

MG-1615 is specifically formulated to offer the marine market the low-color, UV light-stabilized, weather-resistant clear gel necessary to maintain the beauty and appearance of marine FRP products required to compete in today's market. This type of clear gel coat is especially important to those manufacturers using the "glitter" flake such as Polycryl Polyflake*, where clarity and depth of appearance are critical features. The low color and clarity of MG-1615 offers the marine manufacturer those very features so important to the user of polyflake materials.

* Polycryl Polyflake available from Polycryl Corporation,
Memphis, TN.

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TYPICAL PROPERTIES OF LIQUID GEL COAT

Weight/Gallon @ 77°F:	8.7 Pounds
Specific Gravity @ 77°F:	1.05
Viscosity, Brookfield @ 77°F	
@ 6 rpm :	10,000 - 12,000 cps
@ 60 rpm :	1,600 - 2,000 cps
Geltime, 100 Grams @ 77°F, 2% MEKP:	14 - 16 minutes**
Shelf Life - Uncatalyzed @ 77°F	3 months minimum

** Other gel times available. See Appendix I

APPLICATION OF MG-1615

MG-1615 may be applied, as is, after catalyzation to provide a clear, durable finish utilizing normal gel coat equipment.

MG-1615 100% NPG-Isophthalic Clear Gel Coat is modified with acrylic monomer and carefully UV light-stabilized to maximize the long-term resistance to loss of gloss and change in color due to prolonged outdoor exposure. This product is designed to maintain the appearance and durability of the FRP products made using this gel coat.

MG-1615 may be used in combination with Polycryl Polyflake to obtain a bright, handsome glitter finish on FRP parts. The MG-1615 provides a clear, deep-appearing finish with only one coat.

The particular flake used should be mixed with the MG-1615 in the following proportion:

MG-1615	100 pbw
Polycryl Polyflake	10 - 20 pbw

Care must be taken to insure that the flake is well dispersed. If the flake is not well dispersed, lumps resulting in nozzle clogging will be evident.

A Binks #18 gun with a 68PB air nozzle and 68 needle and a Devilbiss JGA or MBC gun with a 64D nozzle are known to work well in this application.

CATALYZATION CAUTION

MG-1615 is designed for use with 2% Superox 46-702 or equivalent catalyst. It may be desirable to reduce the catalyst content during extremely warm ambient conditions. If this is the case, we recommend that the level not be decreased below 1 1/2% minimum to insure adequate cure and maintain maximum properties. If a longer or shorter working time is required, we recommend choosing another version of this product with the desired gel time. (See Appendix I)

SAFETY CONSIDERATIONS

"MG" Series NPG/Isophthalic gel coats are based on a resin which contains styrene monomer, which is a flammable liquid. Keep away from sparks, heat and open flame (including pilot lights). Electrical equipment should be vapor-proof and protected from breakage.

Styrene vapors are heavier than air and will tend to concentrate in the low areas of molds and in pockets immediately above the floor area. To keep vapors within a safe limit in all areas, adequate ventilation or suction fans should be used that will remove these styrene monomer vapors.

All equipment must be grounded - including spray guns and molds.

Both the polyester gel coat and the catalyst may cause burns to eyes and skin. Do not get in the eyes! Avoid breathing vapors! Gel coat applicators should wear a NIOSH approved respirator effective for vapors, spray mist and dust. In case of accidental contact, remove contaminated clothing and wash affected skin areas with soap and copious quantities of water. Contact a physician if persistent skin irritation occurs. For eyes, immediately flush with plenty of water for at least 15 minutes; call a physician immediately. Wash contaminated clothing before using.

APPENDIX I

This 100% NPG-Isophthalic Clear Gel Coat is available in a wide range of gel times to fit the needs of various FRP fabricators. The following table lists these products and their corresponding gel times.

<u>PRODUCT</u>	<u>CUP GEL TIME (2% MEKP @ 77°F)¹</u>
MG-1610	9-11 minutes
MG-1612	11-14 minutes
MG-1615	14-16 minutes
MG-1617	16-18 minutes
MG-1619	18-20 minutes
MG-1621	20-22 minutes
MG-1624	23-25 minutes

Each of these clear gel coat products will exhibit the same viscosity and handling characteristics as well as offer maximum durability. They differ only in the gel time and total cure time before further lamination can proceed.

¹ RCI 46-702