

Product Data



908 LENOIR ROAD • POST OFFICE BOX 1809
HICKORY, NORTH CAROLINA • 28603-1809
TELEPHONE (828) 328-1721
TOLL FREE (800) 334-5975
FAX (828) 328-4572

B-7100

YELLOW, HIGHLY RESILIENT, LOW SHRINKAGE SOFT-SAND FILLER/SURFACER GEL COAT

B-7100 Yellow Filler/Surfacer Gel Coat is specifically formulated for use as the initial filler coat on a rough or porous pattern or plug surface. This product will fill these surface imperfections and, because of its low shrink feature, will sand down to a smooth surface without surface indentations or cavities. This smooth sanded surface is then ready for the application of a primer gel coat.

The highly resilient nature of the B-7100 does not permit it to cure hard enough to be used as the final primer gel coat from which a mold surface is duplicated. B-7100 is designed to be used in conjunction with a sanding primer gel coat such as HK Research's B-9043 or B-9046. The yellow oxide color of the B-7100 was chosen specifically to offer a good contrast to the medium gray color of these primer gel coats.

TYPICAL PROPERTIES @ 77°F (25°C)

UNCATALYZED

Weight/Gallon:	11.6 Pounds
Specific Gravity, g/cc:	1.39
Viscosity, Brookfield, 6 RPM	15,000 cps
60 RPM	2,500 cps
Shelf Life:	3 Months, minimum in sealed container maintained at less than 80°F.

CATALYZED (2% MEKP* @ 77°F)

Gel time, 100-gram mass:	16 - 20 Minutes
20 Mil Film Geltime:	30 - 40 Minutes
20 Mil Film, Cure to Laminate:	Approximately 60 minutes

*RCI Superox 46-702 or equivalent

page 1 of 3
HKR148-010798rev

APPLICATION

HK Research Corporation's B-7100 Yellow Soft-Sand Filler/Surfacer Gel Coat is formulated for standard conventional spray application as well as "air-less" application. This gel coat is suitable for use in standard "air-less equipment" or the currently available "low pressure-air assisted" air-less type equipment. This high performance gel coat requires careful application in order to maximize the properties in the cured gel coat film. Poor application of the B-7100 Gel Coat will cause a reduction in the properties of the cured gel coat film as well as the possibility of porosity which may interfere with post coating applications.

B-7100 is formulated with a surfacing agent making the product non-air inhibited which provides a tack-free surface for sanding, particularly when this product is used as a filler/surfacer. It is important to remember that this gel coat surface must be sanded and cleaned with a solvent such as mineral spirits to remove traces of surfacing agent that could interfere with bonding of a coating or laminate applied to this gel coat.

MIXING

Prior to removal from the shipping container and catalyzation, it is recommended that the materials be mixed thoroughly to reincorporate any "settled" or "stratified" material. It is further recommended that the material in the shipping container be mixed at least once a week during its use period. The mixing procedure would assure the most uniform properties during application of the gel coat. Mechanical mixing is recommended and should be sufficient to "turn" the material 10 times. Most common gel coat mixing equipment will accomplish an adequate blend in less than 1/2 hour.

It is suggested that the catalyst concentration used in the application of B-7100 Yellow Soft-Sand Isophthalic Filler/Surfacer Gel Coat not exceed 3.0% or fall below 1.5% to retain maximum properties. The recommended range for the catalyst concentration within the applied film is 1.8 to 2.2% at 77°F.

Under normal conditions the gel coat is ready to "lay up" in approximately 60 minutes. The "time to laminate" is dependent on the ambient temperature, humidity, and air movement, as well as the catalyst concentration and the film thickness. A wet film thickness of at least 18 to 20 mils is recommended for proper hiding, cure, and performance properties. This product should not be used when the temperature conditions, both mold and ambient, are less than 65°F as the curing of the gel coat may be adversely affected.

SAFETY CONSIDERATIONS

The B-7100 Yellow Soft-Sand Isophthalic Filler/Surfacer Gel Coat is based on a high grade Isophthalic resin that contains styrene monomer, 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 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 reusing.