

# 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

## G1516 100% NPG-ISOPHTHALIC, NON-AIR INHIBITED CLEAR MARINE GEL COAT

G-1516 100% NPG-Isophthalic, Non-Air Inhibited Clear Marine Gel Coat is formulated to meet the need for a high quality marine and general exterior grade clear polyester gel coat. Unique properties of this product include the following:

Light Stabilized to maximize long term gloss and color retention in outdoor applications.

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.

Non-air inhibited to permit tack-free cure of air exposed surfaces.

G-1516 is specifically formulated to offer the marine market the low-color, UV light-stabilized, weather-resistant clear gel coat necessary to maintain the beauty and appearance of marine FRP products required to compete in today's market.

G-1516 is also non-air inhibited, which means that it contains a surfacing agent that will enhance the cure of the air-exposed surface. This will permit the air exposed gel coat surface to cure so that the product can be used for re-surfacing or patching applications. The tack-free gel coat surface can then be sanded, buffed and polished to obtain a hard glossy gel coat surface.

page 1 of 3  
HKR154-031896

## **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

Gel time, 100 Grams @ 77°F,  
2% MEKP: 14 - 17 minutes

Shelf Life - Uncatalyzed @ 77°F 3 months minimum

---

## **APPLICATION OF G-1516**

G-1516 may be applied, as is, after catalyzation to provide a clear, durable finish utilizing normal gel coat equipment.

G-1516 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.

G-1516 contains a wax surfacing agent to enhance the cure of the air-exposed surface. This permits the gel coat to cure in resurfacing or patching applications so that it can then be sanded and polished. However, this same surfacing agent can interfere with adhesion of subsequent gel coat applications so that this non-air inhibited gel coat surface must be sanded and all traces of surfacing agent removed before spraying of another gel coat film or laminating resin.

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**

G-1516 is designed for use with 2% Lupersol DDM-9, 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.

## **SAFETY CONSIDERATIONS**

"G" 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.