



Orange Tooling Gelcoat

Description

The Orange Gel Coat is a polyester-based compound designed for use in the creation of fiberglass molds. Due to the unique formulation of its base resin, this material cures to a durable, high gloss finish and offers excellent resistance to mold distortion from repeated use. Formulated for spray applications, this material is catalyzed with Methyl Ethyl Ketone Peroxide (MEKP) at a suggested rate of 1.8% by weight.

Physical Properties

Color	Orange
Mix Ratio (by wt)	1.8% recommended
Viscosity (cps)	4,500-5,500
Gel Time (minutes)	20-30
Demold Time (hours)	24
Glass Transition Tg (before post cure)	291F
Glass Transition Tg (after post cure)	303.8F
Post Cure 4 hours @ 149F after (24) hour room temperature cure	

Best results are achieved by spraying. Apply (2) coats at 18 mil wet each and allow the gel coat to gel and cure between coats. Apply each coat with a minimum of (2) passes; (3) passes are preferred. For best results, allow the gel coat to “breathe” for (2) minutes between each pass. Do not allow longer than 5 minutes between thin coats without covering with a fresh pass. Thin films will exhibit print-through and distortion. Do not overspray nor apply more than 20 mils per coat to mitigate cracking/crazing after use. It is essential that no more than 40 mils (wet) total be applied with any of the tooling gel coats.

Conventional Air Atomized:

Binks Equipment – More than 13 C.F.M. Required

Fluid Nozzle	66-67
Air Nozzle	63 PB or 67 PB
Needle	65 or 67

DeVilbiss Equipment – More than 17 C.F.M. Required

Gun	P-JGA-502
Nozzle Combination	704-E

Do not spray more than 2.5 pounds per minute of tooling gel coat. A minimum of 60 PSI atomizing pressure (measured with fan fully open) should be used to properly atomize the gel coat.

The user shall determine the suitability of this product for their application and assumes all risks and liabilities associated with the use of this product. The exclusive remedy for all proven claims is replacement of our materials only and in no event shall Freeman Mfg. & Supply Co. be liable for special, incidental, or consequential claims.

READ SAFETY DATA SHEETS AND PRODUCT LABELS BEFORE USING PRODUCT