



GC1 150

EPOXY GEL COAT
CAN BE POLISHED – GLOSS RECOVERING
GOOD THERMAL RESISTANCE
GOOD CHEMICAL RESISTANCE

USE

Polyester RTM molds, polyurethane molds.

PHYSICAL PROPERTIES				
		RESIN GC1 150	HARDENER GC 20	MIXING
Mixing ratio by weight		100	23	
Aspect		paste	liquid	thick liquid
Color		dark blue	light amber	dark blue
Brookfield LVT viscosity at 25°C (mPa.s)		thixotropic	480	thixotropic
Density of uncured product	ISO 1675-85	1.25 - 1.31	0.92 - 0.98	-
Density of cured product	ISO 2781-88	-	-	1.25 – 1.31
Pot life at 25°C on 500g (min.)	-			55

MECHANICAL AND THERMAL PROPERTIES (1)			
Hardness	ISO 868-85	Shore D1	86
Flexural strength	ISO 178-93	MPa	107
Flexural modulus of elasticity	ISO 178-93	MPa	4,100
Glass transition temperature (Hardening 8 hrs at 100°C)	T.M.A.-Mettler	°C	130
Glass transition temperature (Hardening 8 hrs at 130°C)	T.M.A.-Mettler	°C	150

(1) Average values obtained on standardized specimens / Hardening 8 hrs at 100°C

PROCESSING CONDITIONS

Apply the mix with a clean brush on the pattern previously waxed with DEMOLDING AGENT 841 or WAX 827. Resin and hardener must be mixed at a temperature greater than 18°C according to the mix ratio indicated on this technical data sheet.

To obtain a 1 m² surface of 0.5 mm thickness requires approximately 0.65 kg gel coat.

*Advised reinforcement : EPOLAM 2050 laminating resin
EPO 4030 casting resin*

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SPECIFIC PROPERTIES (2)

Gel time	-	min.	85
Time between application of 2 coats of gel coat	-	min.	<60
Demolding time	-	hour	24

(2) Average values obtained on standardized specimens at 23°C

STORAGE CONDITIONS

Shelf life of both parts is 12 months in a dry place and in their original unopened containers at a temperature below 20°C.

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

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 150 RESIN

8.69 kg
Pack of 12 x 0.326 kg

GC 20 HARDENER

2.0 kg
Pack of 12 x 0.075 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.