

GELCOAT EP 4060

*Two Part Epoxy Gelcoat System
85 – 90 Shore D Hardness*

GELCOAT EP 4060 is a two component, aluminium filled, brushable, room temperature curing surface coat. GELCOAT EP 4060 is designed for use in RTM tools, RIM tools, PU moulding tools, vacuum forming moulds, negatives, applications requiring high heat and chemical resistance and negatives where very fine surface finishes are required.

Special Features

- Excellent chemical resistance (styrene, methyl methacrylate)
- High heat distortion temperature
- Easy application on vertical surfaces
- Aluminium like polishable finish

Mix Ratio

EP 4060 : H4060
By Weight 100 : 15

Product Data

Property	Units	EP 4060	H4060	Mix
Material	-	Epoxy resin	Formulated amine	Epoxy
Appearance	-	Grey thixotropic paste	Amber liquid	Grey thixotropic paste
Viscosity (25°C)	mPa.s	100,000 – 200,000	10 – 20	20,000 – 25,000
Density (25°C)	g/cm ³	1.40 – 1.50	0.95 – 1.00	1.45 – 1.55
Pot Life (200g, 25°C)	Minutes	-	-	60 – 80
Tack Free Time (1mm, 25°C)	Minutes	-	-	60
Demould Time (200g, 25°C)	Hours	-	-	24 may be longer in cold conditions

Cured Properties

Properties	Standard	Units	Result (Full Cure)
Hardness	BS 2782: Part 3: Method 365B	Shore D	85 – 90
Tensile Strength	BS 2782: Part 3: Method 320A	MPa	15.0 – 20.0
Elongation at Break	BS 2782: Part 3: Method 320A	%	3.0 – 4.0
Flexural Strength	BS 2782: Part 3: Method 335A	MPa	50.0 – 60.0
Flexural Modulus	BS 2782: Part 3: Method 335A	MPa	2700 – 3200
Heat Distortion Temperature (HDT)	TMA	°C	155 – 165

Method of Use

Mould Preparation

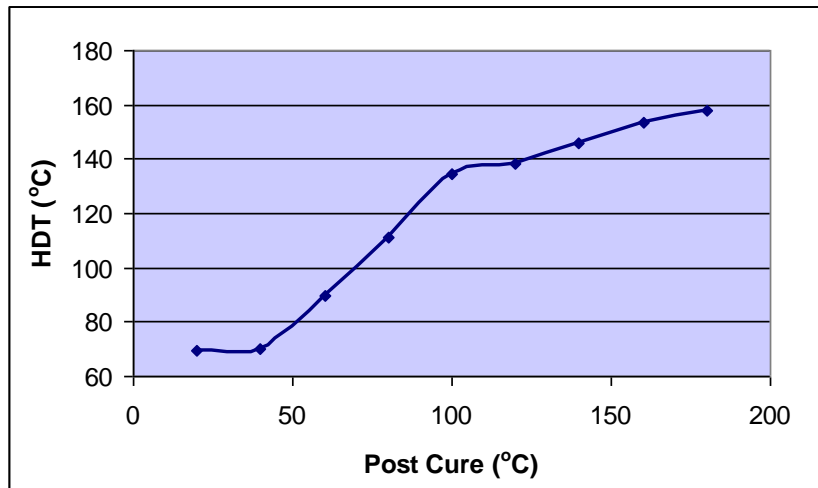
Mould surfaces should be treated with ALCHEMIX R7 or suitable release agent. Porous materials should be well sealed.

Mixing and Application

GELCOAT EP 4060 should be mixed with HARDENER H4060 according to the indicated mixing ratio. Both components should be thoroughly mixed, care should be taken to avoid air entrapment and make certain that material at bottom and sides of container is thoroughly stirred into centre. The mixed material should be evenly applied to the mould by brush, in 0.5mm thick layers. A minimum of two layers should be applied, with a combined thickness of less than 2.5mm. To ensure that each coat adheres, wait until the first coat has gelled to a tack free state before applying successive coats. The gelcoat is tack free if when a finger is lightly drawn across the surface no material sticks to it, but if firmly pressed, a mark will remain on the surface. The laminating resin or coupling coat can be applied when the final layer of gelcoat has reached a tack free state. The tack free stage is critical in the gelcoating process and will vary between different gelcoats. If the tack free stage is missed then it is likely that de-lamination between the gelcoat layers or the gelcoat and backing resin may result. See separate data sheet for details on the use of these products.

Cure and Post Cure

To achieve full high temperature properties, a step wise post cure treatment is recommended. Allow the product to cure at room temperature for at least 24 hours, and then heat from 40°C to 160°C at a rate of 20°C per hour, allow the product to slowly return to room temperature. The product can be used without post cure or with partial post cure, but will not achieve full high temperature properties.



Laminating

ALCHEMIX EP 575 high HDT epoxy laminating system is recommended for use with GELCOAT EP 4060. ALCHEMIX EP 4350 high HDT laminating paste, in combination with ALCHEMIX EP 4050C coupling coat, can also be used with GELCOAT EP 4060. Full technical data is available for these products.

Storage

GELCOAT EP 4060 and HARDENER H4060 should be stored in original, unopened containers between 15 and 25°C. KEEP THE PACKING TIGHTLY SEALED WHEN NOT IN USE.

If stored under the above conditions, GELCOAT EP 4060 / H4060 will have a shelf life of 12 months, from the date of production.

Packaging

GELCOAT EP 4060 is supplied in 1kg, 5kg and 10kg containers.
HARDENER H4060 is supplied in 150g, 750g and 1.5kg containers.

(Please contact Alchemie Ltd for bulk supply)

Further Information

This data is not to be used for specifications. Values listed are for typical properties and should not be considered minimum or maximum.

Our technical advice, whether verbal, or in writing is given in good faith, but without warranty – this also applies where proprietary rights of third parties are involved. It does not release you from the obligation to test the products supplied by us as to their suitability for the intended process and use.

Before using any of our products, users should familiarise themselves with the relevant Technical and MSDS provided by Alchemie Ltd.

Alchemie Limited

Alchemie Ltd develop, formulate and distribute Epoxy Resins, Polyurethane Resins, Silicones, Model Boards and Sheet Wax for use in the following applications:

- Electrical encapsulation
- Rapid Prototyping
- Prototypes
- Casting
- Gel Coating
- Laminating
- Model Making
- Master Models
- Flexible and rigid mould making

We offer fast service, technical support, development expertise, innovative products, diverse knowledge and experience.

We are a well-established company, with a high level of investment and experience. We implement BS EN ISO 9001.

Alchemie® and Alchemix® are registered Trademarks of Alchemie Ltd, Warwick Road, Kineton, Warwick, England, CV35 0HU, England, United Kingdom. Ph: +44 (0)1926 641600; FAX: +44 (0)1926 641698