



Your Formula for Success
RESINS | GEL COATS | COLORANTS

VIBRIN® G245MC POLYESTER GEL COAT



Product Information

POLYESTER GEL COAT FOR SPRAY APPLICATIONS

Typical Liquid Properties ¹		
Test	Unit of Measure	Nominal
Viscosity @ 77°F/25°C, RVF Brookfield Spindle #4 @ 20 RPM	cps	12,000-18,000
Thix Ratio	2:20 rpm	4.5-6.5
Gel Time @ 77°F/25°C, (1.5% of a 9% active oxygen MEKP)	minutes	6.5-12.5
Exotherm Time	minutes	5-15
Exotherm Temperature	°C	150-180
HAP Content	%	<30 White <33 Colors

Typical Cast Mechanical Properties ²			
Test	Unit of Measure	Nominal	Test Method
Tensile Strength	psi/Mpa	12,200/84	ASTM D 638
Tensile Modulus	psi/Gpa	520,000/3.6	ASTM D 638
Tensile Elongation	%	5.0	ASTM D 638
Flexural Strength	psi/Mpa	21,100/145	ASTM D 790
Flexural Modulus	psi/Gpa	550,000/3.8	ASTM D 790
Elongation	%	4.1(Y) 6.4(B)	ASTM D 638
Heat Distortion Temp.	°F/°C @ 264 psi	176/80	ASTM D 648

Typical properties are not to be construed as specifications.

DESCRIPTION

Vibrin G245MC is a fully promoted, thixotropic, isophthalic polyester gel-coat for spray applications.

Consult the Color Selector for examples of colors available.

APPLICATIONS

Fast cure and superior process characteristics make this product ideal for general purpose applications including tub/shower stall, transportation and outdoor parts.

BENEFITS

- Good UV stability
- Low HAP content allows product to meet Composites and Marine MACT standard
- Lower styrene emissions reduce occupational exposures
- Improved transfer efficiency with less overspray generates less waste
- Excellent high gloss finish with superior cosmetics
- Resistance to cracking

VIBRIN®

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PERFORMANCE GUIDELINES

A. All AOC thixotropic polyester gel coats should be mixed well prior to use.

B. MEKP levels should be kept between 1.0% and 2.5%

C. Gel coats should not be applied below 64°F/18°C.

D. G245MC may require higher ratio pressures to spray. 11:1 pumps may not be able to handle G245MC in some cases.

STORAGE STABILITY

This product is stable for three months from the date of manufacture when stored in the original containers, away from direct sunlight or other UV light sources and at or below 77°F/25°C.

Storage stability of two months or less should be anticipated if the storage temperature exceeds 86°F/30°C.

After extended storage, some drift may occur in the product viscosity and gel time.

SAFETY

See the appropriate Safety Data Sheet for guidelines.

ISO 9001:2008 CERTIFIED

The Quality Management Systems at every AOC manufacturing facility have been certified as meeting ISO 9001:2008 standards. This certification recognizes that each AOC facility has an internationally accepted model in place for managing and assuring quality. We follow the practices set forth in this model to add value to the resins we make for our customers.

FOOTNOTES

(1) The gel times shown are typical but may be affected by catalyst, promoter, inhibitor concentration, resin, mold, and shop temperature. Variations in gelling characteristics can be expected between different lots of catalysts and at extremely high humidities. Pigment and/or filler can retard or accelerate gelation. It is recommended that the fabricator check the gelling characteristics of a small quantity of resin under actual operating conditions prior to use.

(2) Based on tests at 77°F/25°C and 50% relative humidity. All tests performed on unreinforced castings. Thixotropic components are excluded from casting samples. Castings are post cured.



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