
Mini-Craft of Florida, Inc.

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**McKote
Professional
Grade
Gelcoats**

ISO/NPG

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FEATURES:

- * Crack Resistance
- * Weather Resistance
- * Water Resistance
- * Shelf Stability
- * Color Stability
- * Excellent Application Properties
- * High Level of Neopentyl Glycol

McKote Professional Grade Gelcoats combine all of the best physical and application properties that have made Mini-Craft products so well accepted over the years.

Rather than a new chemistry, McKote Professional Grade Gelcoats represent a refinement in material selection, manufacturing techniques and quality assurance programs that make this gelcoat line truly a high performance coating.

Each feature has been optimized to the highest practical level. When proper application techniques are employed, application problems, such as porosity, resin tearing, color separation, etc. are minimized.

McKote Professional Grade Gelcoats, when used on a properly designed laminate, will produce a truly superior gelcoated part.

Coverage: Approximately 80 sq/ft. per gallon sprayed at 20 mils.

LIQUID GELCOAT PROPERTIES

1. Gel Time @ 77°F... *To customer specification**
1.5% MEKP
2. Gel to Peak (minutes).....15-20
3. Viscosity @77 °F.....2300 to 2900 CPS
LVF #4 @ 60 RPM
4. Thin index (6/60).....5.0-6.0
5. Weight Per Gallon (lbs).....9.8 to 10.8
6. 150°F Stability.....5 days minimum
7. Hegman Grind.....5+

* *Within parameters Mini-Craft deems necessary to maintain product integrity.*

APPLICATION PROPERTIES

1. Film Cure @ 77 °F (min.)40-60
2. Patchability.....Good*
3. Hide @ 20Mils (Wet).....Complete
*Use Mini-Craft Booster for best results

CURED GELCOAT PROPERTIES

1. Tensile Test (ASTM D638 IV)
Elongation %2.8 to 3.5
Tensile Strength (psi).....6,000 to 8,500
Modules of Elasticity (psi) 0.25 to 0.33x10⁶
2. Coefficient of linear Expansion
5.1x10⁻⁵ in/in °C
(Measured by DuPont Thermomechanical Analyzer)
3. Linear Polymerization Shrinkage (ASTM 2566)
0.0165 to 0.0180 in/in °C
4. Barcol Hardness (Barber Coleman impressor)
38 to 45 in gel coat casting

CURED COMPOSITE PROPERTIES (GELCOAT WITH LAMINATE)

1. Three point bend test (ASTM D790)

	% Elongation	Tensile Strength	Modulus of Elasticity
McKote Gelcoat		12,000 to	0.80 to 1.0
G.P. 1 resin laminate.....	1.7 to 2.2	16,000 psi	x10 ⁶ psi
McKote Gelcoat		10,000 to	0.80 to 1.0
D.C.P.D.2 resin laminate.....	1.2 to 1.7	13,000 psi	x10 ⁶ psi

2. Blister Resistance (boiling water exposure test)

100 Hours
excellent

200 Hours
fair to good