

Mini-Craft of Florida, Inc.

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(ADV)MC386



**McKote
Professional
Grade
Gelcoats**

**TOOLING
GEL KOTE**

Mini-Craft of Florida, Inc.

FEATURES

- * Ease of application.
- * Color Coded.
- * Minimum distortion.
- * High gloss
- * Excellent abrasion resistance.
- * Superior hardness.

APPLICATION

Mini-Craft Tooling Gelkotes can be applied directly to the part to be duplicated. Care must be exercised in preparing the plug with wax to permit positive release. Air atomizing spray equipment should be used.

CAUTION

Do not use varnish as a sealer or finish coating when preparing a plug for mold making. Even if the varnish is well waxed and coated with a parting film, sufficient styrene monomer from the gel kote can pass through the barriers to soften the varnish. The softened varnish will act as an adhesive between the mold and the plug.

LAMINATING RESIN

It is recommended that a high heat distortion resin be used for laminating: such as tooling resin or equivalent. Resin manufacturer's recommendations for laminating procedures should be followed exactly for best results.

VISCOSITY

Brookfield-Model LVF, Spindle #4, @ 23°C.

1. 6 rpm.....11,000 cps to 14,000 cps.
2. Thix @ 6/60 ...5.0 to 6.5.

CATALYZATION

9% active oxygen MEK-Peroxide @ 23°C.

1. Do not catalyze with less than 1% catalyst (by total weight of gelcoat).

2. Do not catalyze with more than 2% catalyst (by total weight of gelcoat).

CURE DATA

1. Gel time: 8-15 minutes with 1.5% - 9% active oxygen MEKP at 23°C.
2. Volumetric Shrinkage under 10%.
3. Sag Resistance 25-30 mils.

CURED GELCOAT

1. Barcol Hardness 1/8" Casting Model 934-1, after 48hours45 minimum.
2. Craze Resistance Excellent.

STANDARD MINI-CRAFT TOOLING GELKOTES

- | | |
|---------|-------------|
| * Red | * Black |
| * Green | * Tangerine |

SHELF LIFE

90 DAYS.

Price quotations available on request.
F.O.B. Shipping Point.

PRECAUTION MINI-CRAFT TOOLING GELCOATS

1. Agitate well before using.
2. The gel time of this product may change upon aging. Check it to your specifications. If it is not within specifications or over 90 days old, contact your Mini-Craft sales representative.
3. Do not use less than 1% or more than 2% of MEKP catalyst.
4. Use only clean and properly adjusted spray equipment.
5. Prepare a one quarter inch thick casting with sprayed material at the time the gelcoat is sprayed into the mold. The Barcol Hardness of this casting should reach 40 within two days. Retain this casting, identified as to mold and date.
6. Spray catalyzed gelcoat on two small (2feet x 2feet approximately) test panels at the same time that the tooling gelcoat is sprayed into the mold. Carefully use the same spray procedures as used on the mold. When the test panels have gelled, strip one and inspect it for porosity before proceeding further with the construction of the mold. Laminate the second panel using the same procedure used on the production mold. Retain this panel for possible future evaluation, identified as to mold and date.
7. In the event of any problem, refer to the appropriate Mini-Craft literature and contact you Mini-Craft Sales Representative immediately.

Refer to product material safety data sheet for safety and handling precautions.
AN ENLARGED VERSION OF THIS LABEL APPEARS ON
THE TOOLING GELCOAT CONTAINER.