

BÜFA® -ISO-Gelcoat 3000-H nature

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BÜFA®-ISO 3000 Gelcoats are thixotropic and based on an unsaturated isophthalic acid resin. BÜFA®-ISO 3000 products are characterised by their very good processing and weathering properties.

Profile

Product family	BÜFA®-ISO 3000
Product type	Gelcoat
Processing method	Hand quality
Pre-accelerated product	Yes
Resin base	Isophthalic acid (IP)
Production method	Batch manufacturing
Colour	transparent
Odour	like styrene

Application Range

BÜFA®-ISO-Gelcoat 3000 Gelcoats are suitable for moulded parts that are exposed to heavy weathering or normal hydrolysis load. In addition, they offer a very effective combination of flexibility, good mechanical properties, simple processing, normal resistance to osmosis and high UV-resistance, low yellowing and a high degree of gloss.

Specification / Technical Data

Density (BM D01) approx.	1,13 g/mL
Flashpoint (BPV FP 02) approx.	47°C
Styrene content approx.	30,30 %
Viscosity (BM V01)	45,000 - 60,000 mPas

Technical Data Sheet //

Viscosity at 20°C with spindle 6 and 5 rpm	
Viscosity (BM V01)	9,000 - 11,000 mPas
Viscosity at 20°C with spindle 6 and 50 rpm	

The BÜFA testing standards define the testing scenario after the values are determined in our facilities. They relate to generally accepted standards and are available under request.

Curing

Reactivity	BM R01
Sample size	100g sample
Peroxide addition	Curox M-303 2,0 vol%
Geltime (Reactivity 20-30°C)	8 - 13 min
Curing time (Reactivity 20°C-Tmax)	16 - 22 min
T-Max (Reactivity Tmax at 20°C)	160 - 190 °C

ATTENTION! The above data refer exclusively to the use of the reactants mentioned here in the specified dosage. When using other products and also with deviating dosage, the results may be different.

The inspection and assurance of the product quality (goods which meet the specifications) take place within the framework of quality control immediately after the product has been manufactured.

If circumstances permit, we recommend post-curing (tempering) the component for several hours at 80°C to optimise the moulding material properties. This achieves the optimal gelcoat properties.

In all circumstances, it must be taken into account that the viscosity, reactivity and chemical resistance of the tinted gelcoat may be negatively affected by the pigmentation!

Processing

So far, the BÜFA release agent system BF 500 / BF 700 has been tested and used successfully for this gelcoat. Other release agents should first be tested for their usability under practical conditions.

Optimal results are achieved by observing the following instructions: The wet film thickness of the product in liquid state should ideally range between 600 - 800 µm and should not be less than 600 µm when wet.

In order to guarantee a perfect bond, the laminating work must be carried out after no more than 8 hours. If the gelcoat is applied after a waiting time >8 h, the user bears full responsibility and should test this in advance.

This gelcoat can only be processed manually as a result of the product composition.

For processing and curing, the instructions in our "Working with BÜFA® -Gelcoats" technical information leaflet must also be observed.

Colouring

The density of the product depends on the pigmentation.

This is a non-pigmented product.

Other information

The gelcoat should be stirred gently before processing.

Maritime approval: Lloyds Register**

Lloyds Register** - BÜFA® -ISO-GELCOAT 3000-H --> MATS/4551/2

Storage and handling

As a result of the wide range of factors which may influence the operating conditions and the application of the product, the user must still carry out their own tests and trials.

The product must be stored closed, in a cool, dry place and protected from sunlight.

In unopened, original containers, the product can be processed for at least 3 months if properly stored at up to 20 °C.

Higher temperatures reduce storage life.

The setting and curing times as well as the viscosities may vary with longer storage periods.

The above details have been compiled to the best of our knowledge and are based on our current knowledge and experience. These details only constitute product descriptions. Under no circumstances do they constitute guarantees relating to quality or durability. The processor is obliged to carry out their own tests and investigations in order to take responsibility for any processing and application of our products in the processor's application area. The latest version of the corresponding EU safety data sheet must also be observed.