



### Release agent

Check compatibility with **SG 715** (resistance to or facility of removal from mould...) by making a preliminary test, specially if the gelcoat is used diluted.

Wax 103: for curing at below 50° C and undiluted gel coat

Cirex DE 68: for curing at above 50° C and diluted gel coat

### Processing

Brush/roller for lacquer

Thinning: 0 to 5% of weight of mix

Pneumatic spray gun: Carefully mix the **SG 715** and **SD 802** resin, and leave to develop for five minutes.

Thin with 20% maximum of EP 960: for 100 g of SG 715 / 802 mix, add 20 g of EP 960 thinner.

Mix carefully.

Spray in thin coats 40 cm from the substrate. Wait 5' between each coat.

Allow the gel coat to gel before applying the second coat or laminating. The gel coat must be tacky (still sticky to the finger) to avoid any risk of delamination.

### Equipment

Brush/roller

### Lamination

Lamination must begin as soon as the **SG 715** is no longer tacky.

### Post-curing

If possible, carry out post-curing in the mould so as to limit marking of fibres.

12 hours @ 20°C + 24 hours @ 40°C

or 12 hours @ 20°C + 8 hours @ 60°C




### Thermal stability

Tg1=90° C after 24 hours at ambient temperature + 8 hours at 60° C

### Cleaning

EP 960 thinner, methyl ethyl ketone (MEK), solvent for epoxide paints.

## Toxicity / Labelling

| Products | Labels  |              | Risk Classification   |
|----------|---|--------------|---|
| SG 715   |  | Xn: Harmful  | R 36/38: Irritant for eyes and skin<br>R 51/53: Toxic for aquatic organisms, may have harmful effects, in the long term, on the aquatic environment<br>R 43: May cause sensitisation through skin |
| SD 802   |  | C: Corrosive | R 21/22: Harmful if swallowed or if there is skin contact<br>R 34: Causes burning<br>R 43: May cause sensitisation through skin contact   |
| EP 960   |  | Flammable    | R 11, 23/25   |

(EEC Classification in accordance with Annex 1 of EEC Directive 67 / 548)

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