

# FREOPUR

## Gelcoat BD7342X

- Sprayable 2K-PU-Gelcoat System for high pressure machines
- Fast reactive
- Solvent-free
- Self releasing

Technical / physical data	Colour	accord. to RAL 840 HR other colour shades on request	
	Original viscosity	1000 - 2500 m.Pa.s , D = 500s-1	
	Mixing ratio by weight	100 : 55	
	Hardener	FREOPUR-Hardener HD0240	
	Potlife	approx. 60 sec. / 20 °C	
	Density 20°C Measured density of gelcoats on request	BD7342X HD0240	1,325 +/- 0,075 g / ml 1,165 g / ml
	Solid content after hardener addition calculated	approx 100%	
	Consumption calculated after hardener addition in original viscosity, without application loss	approx. 270 g / m <sup>2</sup> dry film thickness approx 200 µm depending on the desired layer thickness	
Storability	Approx. 3 month in original packings at an ambient temperature of 5 to 25 °C, in case the original packings are tightly closed. Opened packing must be used very shortly. The minimum storage stability of each batch is mentioned on the product label. A storage time beyond the mentioned date doesn't necessarily mean that the material is unusable. In this case a check of the qualities which are important for the respective use is necessary.		

## Processing and application

### Application

- sprayable by 2K high pressure machine with recirculation of A+B by pistol
- layer thickness min. 200 µm
- can be coated after >2 min. by fibre spraying with a suitable PUR-material
- avoid contact with water or polar solvent

### Substrates

metal moulds, e.g. aluminium, tempered to 40 degrees

### Pretreatment

Moulds must be treated before first use and after every cleaning by a suitable release agent e.g. Acmos 36-1659-129

### Application temperature

A: BD7342X: 75-85°C, dependent on the viscosity

B: HD0240: 85°C

### Cleaning of working equipment

Machines can be cleaned with compatible cleaning agents, such as MPA.

### Advise for safety protection and protection of health

The usual precautionary measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning health protection and environment protection can be read in the corresponding safety data sheet.

## Special remarks

### Stability

Good resistance against weak acids and bases.

### Test conditions

All information is based on a standard climate 20/65 DIN 50014.

All information are based on our product knowledge and experience. To the application we have no direct influence. For further information please don't hesitate to contact us.

The information mentioned herein are reference values and are not given as specification.