

# RELEST® Wind Gelcoat ca. RAL 7038, RA

Art.-Nr. I3727238

## Properties:

<b>Type of binder</b>	Polyurethane
<b>Mixing ratio</b>	according to weight: 100 : 33 according to volume: 100 : 43
<b>Hardener</b>	RELEST® Hardener PUR 13
<b>Viscosity (base) Rotational measurement</b>	Approx. 4300 mPas
<b>Density (ISO 2811-1, base)</b>	Approx. 1.47 g/cm <sup>3</sup>
<b>Solid content (base)</b>	Weight: approx. 100%
<b>Gloss level</b>	Gloss
<b>Shore D hardness (24 h at +50°C)</b>	Approx. 70
<b>VOC content</b>	Approx. 35 g/l
<b>Spreading rate</b>	At a recommended dry film thickness of 200 µm on even surfaces, in delivery form without application loss theoretical: approx. 280 g/m <sup>2</sup> corresponds to: approx. 3.6 m <sup>2</sup> /kg  <small>Non-binding reference value since surfaces and their consumption rates vary. Carry out a test application according to DIN 53220 to assess the exact spreading rate.</small>

The technical data refer to +20°C and 65% relative air humidity.

## Characteristics and resistance:

Viscoplastic polyurethane coating with excellent abrasion resistance. Suitable for making coatings with good light- and weather-resistance.

RELEST® Wind Gelcoat RA is characterised by its very good adhesion to EP laminate.

## Substrate preparation:

### General:

The surface preparation is decisive for the durability of all coating systems. Substrates must be clean, dry, solid and free of dust, parting agents and all soiling. Surfaces must usually be sanded before use.

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## Instructions for use:

Empty the contents of the hardener container completely into the base component container. Make sure that the hardener container is completely empty and mix thoroughly with a low-speed stirrer equipped with a double paddle mixer. Small quantities can also be mixed manually. Then transfer the mixture to a larger, clean container. Remove all residues adhering to the mixing vessel by means of a spatula and add to the mixture, and mix again.

Apply the gel coat by suitable rollers (e.g. SUPERFLOC rollers).  
Make sure that as little air/foam as possible is generated during the mixing and application process.  
The material must be applied swiftly and evenly at the specified wet film thickness without adding thinner.

## Application:

(The data are exemplary data only.)

<b>Application conditions</b>	+15°C min. to +35°C max. air and object temperature at 85% rel. humidity max. Observe dew point. The lower the ambient and the object temperature and the higher the air humidity, the longer the drying time. High air humidity accelerates the drying process, air humidity below 35% considerably slows down the drying process.		
<b>Workable life</b>	Climate	Workable life (*)	
	+20°C / 30% rel. humidity	approx. 40 min	
	+23°C / 65% rel. humidity	approx. 30 min	
	+35°C / 85% rel. humidity	approx. 10 min	
<b>Overcoating times</b>	Climate	Sandable after	Overcoating times (**)
	+20°C / 30% rel. humidity	approx. 120 min	approx. 60 – 80 min
	+23°C / 65% rel. humidity	approx. 70 min	approx. 30 – 40 min
	+35°C / 85% rel. humidity	approx. 35 min	approx. 15 – 30 min

(\*) Due to the heat of reaction (exothermicity) the workable life strongly depends on the actually mixed/remaining material quantity.

Only mix small quantities at a time because of the product's relatively short workable life!

(\*\*) If the surfaces coated with RELEST® Wind Gelcoat RA are older than 8 hours, they must be sanded before reworking.

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## Application method:

(All data are approximate values; the viscosity depends on the respective temperature.)

Spraying	Compressed air	Airless	Airmix	Roller application
Spray pressure [bar]: Atomised air [bar]: Nozzle size [mm]: Spray applications [cross coats]: Application viscosity: Thinner [%]:	not suitable	not suitable	not suitable	undiluted in delivery form

## Drying times:

Drying times (ISO 9117) at 200 µm	Drying stage (TG) 1 (dust dry)	Drying stage (TG) 7 (resistant to mechanical stress)
<b>+20°C/30% rel. humidity</b>	approx. 90 min	approx. 270 min
<b>+23°C/65% rel. humidity</b>	approx. 30 min	approx. 100 min
<b>+30°C/85% rel. humidity</b>	approx. 20 min	approx. 60 min

## Storage/Transport conditions:

The material is storable for approx. 12 months from date of manufacture in firmly closed original containers. Seal open containers airtight and use up soon. Protect from frost, heat and humidity.

## Standard coating system:

The respective coating system can be individually adapted to the local manufacturing processes and the desired quality standard. Please contact the responsible field staff!

## Safety measures:

The information and safety advice on the containers as well as the respective accident prevention regulations of the responsible trade associations are to be observed at all times when working with this product. For further information, please see the Safety Data Sheets.