

### PRODUCT CODE: C460000 - C460004

ULTRATEC™ VE TOOLING GELCOAT is a high performance tooling gelcoat based on a vinyl ester resin, which also provides excellent heat resistance and maximum resistance to chemicals and solvents. ULTRATEC™ VE TOOLING GELCOAT provides a lasting high gloss finish which will stand up to a large number of lifts between each waxing and polishing operation provided the tooling gelcoat is properly cured. Minimum temperature during cure should be 18°C. SPECIAL NOTE: This Gelcoat requires the use of Norox CHM50 catalyst, which practically eliminates gassing/foaming often associated with MEKP cured vinyl ester systems. These Gelcoats have been formulated for spray application.

### FEATURES

- Excellent atomization and general spraying characteristics
- Excellent flow/levelling properties
- Good sag resistance
- Highly resistant to tripping/wrinkling
- High heat distortion temperature
- Low foaming formulation – designed for curing with CHM50 catalyst
- Minimal viscosity change on storage
- Formulation based on 100% Vinyl Ester

### BENEFITS

- Easy to apply with industry standard spray equipment
- Easy control of film thickness
- Provides a more consistent film thickness
- Increased tolerance to application variability
- Excellent heat resistance
- Reduced porosity in cured gelcoat film
- Maintains consistent sprayability and flow properties on storage
- Highly durable mould surfaces achievable with excellent gloss retention in service

### PRODUCT RANGE

C460000:	Ultratec™ VE Tooling Gelcoat – Neutral
C460001:	Ultratec™ VE Tooling Gelcoat – Red
C460004:	Ultratec™ VE Tooling Gelcoat – Black

### ADDITIONAL INFORMATION

Recommended peroxide dosage: 2.0 – 2.5% (v/w)\*  
Recommended film thickness: 0.55 -0.80 mm (wet film)

For optimum handling and application performance, this product is best used within 3 months from the date of manufacture. The product typically maintains satisfactory properties beyond this period.

\*Note: In summer months a minimum level of 1.5% Norox CHM-50 can be considered to minimise potential for pre-release under excessively warm workshop conditions.

Please consult with your local Allnex Composites representative for further details.

### TYPICAL LIQUID RESIN PROPERTIES @ 25°C

	Neutral Version	Pigmented Versions
Viscosity: Brookfield RVF sp 4/4 rpm	18000-21000cP	12000-17000cP
Cone & Plate (23°C)	280-330cP	280-330cP
Geltime (minutes) (2%-2.5% v/w Norox CHM50)	7-11 (winter) 12-16 (summer)	7-11 (winter) 12-16 (summer)

Typical values: Based on materials tested in our laboratories, but varies from sample to sample. Typical values should not be construed as a guaranteed analysis of any specific lot or as specification items.

### TYPICAL MECHANICAL PROPERTIES IN CURED STATE

(Fully Postcured Casting)

Property	Typical Value	Test Details
Hardness	40-45	Barcol (GYZ934-1) EN59
Heat Deflection	125°C (Neutral Spray Grade) 115°C (Fully Pigmented)	ISO 175

Cast resin was prepared as laid down in BS 3532 using 1% MEKP. Cured at room temperature for sixteen hours then post cured for two hours at 80°C followed by two hours at 100°C.

### STORAGE AND HANDLING

To ensure maximum stability and maintain optimum resin handling properties, gelcoat should be stored in closed containers, away from heat sources and sunlight. The product should be stored away from all sources of ignition. Stored quantities should be kept to a reasonable minimum and used on a first in/first out stock rotation basis. Prolonged storage, or unfavourable storing conditions, may cause separation, therefore agitation of the gelcoat before use is recommended.

### STANDARD PACKAGING

Mild steel drums (open top)  
Mild steel pails

Always refer to the MSDS before use.