CRYSTIC TOPCOAT 65PAX RAPIDE

Brush Topcoat (Available in a Wide Range of RAL Colours)

Introduction
Crystic Topcoat 65PAX Rapide is a pre-accelerated, isophthalic topcoat. It has been formulated for brush application. Crystic Topcoat 65PAX Rapide is available in a wide range of RAL colours and the information contained in this technical datasheet applies to all colours.

Applications
Crystic Topcoat 65PAX Rapide is designed for use where a smooth finish is required on the reverse side of a laminate.

Formulation
Crystic Topcoat 65PAX Rapide should be allowed to attain workshop temperature (18ºC-20°C) before use. Stir well by hand, or with a low shear mixer to avoid aeration, and then allow to stand to regain thixotropy. Crystic Topcoat 65PAX Rapide requires only the addition of catalyst to start the curing reaction. The recommended catalyst is Butanox M50 (or other equivalent catalyst), which should be added at 2% into the topcoat. (Please consult our Technical Service Department if other catalysts are to be used). The catalyst should be thoroughly incorporated into the Topcoat, with a low shear mechanical stirrer where possible.

Pot Life

Temperature	Pot Life in Minutes
15 ºC	24
20ºC	15
25ºC	10

The Topcoat, mould and workshop should all be at, or above, 15 ºC before curing is carried out.

Application
For normal moulding, the application of Crystic Topcoat 65PAX Rapide should be controlled to 0.4-0.5 mm (0.015-0.020 inch) wet film thickness. As a guide, approximately 450-600 g/m^2 of Topcoat mixture (depending on colour) will give the required thickness when evenly applied. Crystic Topcoat 65PAX Rapide is not suitable for use on parts which will be continually immersed in water, e.g boat hull.

Additives
Crystic Topcoat 65PAX Rapide is supplied in a wide range of RAL colours. The addition of fillers can adversely affect the quality of the surface achieved.

Recommended Testing
It is recommended that before using Crystic pigmented gelcoats, customers test all colours under their own conditions of application to ensure they attain the quality surface finish they require.

Typical Properties

The following tables give typical properties of Crystic Topcoat 65PAX Rapide when tested in accordance with SB, BS, BS EN or BS EN ISO test methods.

Property		Liquid Topcoat
Viscosity at 25ºC		thixotropic
Specific Gravity a 25ºC		1.1 – 1.2
Volatile Content	%	34
Geltime at 25ºC using 2% Butanox M50 (or other equivalent catalyst)	minutes	10
Stability at 20ºC	months	3

Property		Fully cured* (casting)
Barcol Hardness (Model GYZJ 934-1)		42
Water Absorption 24hrs at 23ºC	mg	18
Deflection Temperature under Load (1.80MPa)†	°C	75
Elongation at Break	%	3.0
Tensile Strength	MPa	75
Tensile Modulus	MPa	3500

* Curing schedule - 24 hrs at 20ºC, 3 hrs at 80ºC
† Curing schedule - 24 hrs at 20ºC, 5 hrs at 80º C, 3 hrs at 120º C

Post-Curing

Curing at workshop temperature (20ºC) will be satisfactory for many applications. However, for optimum properties, laminates should be post-cured before being put into service. The moulding should be allowed to cure for 24 hours at 20ºC, and then be oven-cured for 3 hours at 80ºC.

Storage

Crystic Topcoat 65PAX Rapide should be stored in its original container and out of direct sunlight. It is recommended that the storage temperature should be less than 20ºC where practical, and should not exceed 30ºC. Ideally, containers should be opened only immediately prior to use.

Packaging

Crystic Topcoat 65PAX Rapide is supplied in 25kg containers.

Health and Safety

See separate Material Safety Data Sheet.

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