

## SG 162 CS / SD 280x

### Epoxy tooling gelcoat High hardness surface

#### Description

Epoxy tooling gel coat used for a small to medium production scale tool making for epoxy or polyester production parts. This gel coat is easy to brush, thixotropy is adapted for application on walls.

SG 162 CS is formulated with specific fillers giving high abrasion resistances, and it can works up to 60 ° C when post cured properly  
It has a grey colour.

#### SG 162 CS physical properties

Aspect :		Gel
Color RAL		Grey 7031
Viscosity (mPa.s)	@ 20 °C	19 000 ± 3600
	@ 25 °C	14 000 ± 2800
Density	@ 20 °C	1.50 ± 0.05

#### SD 280x hardeners physical properties

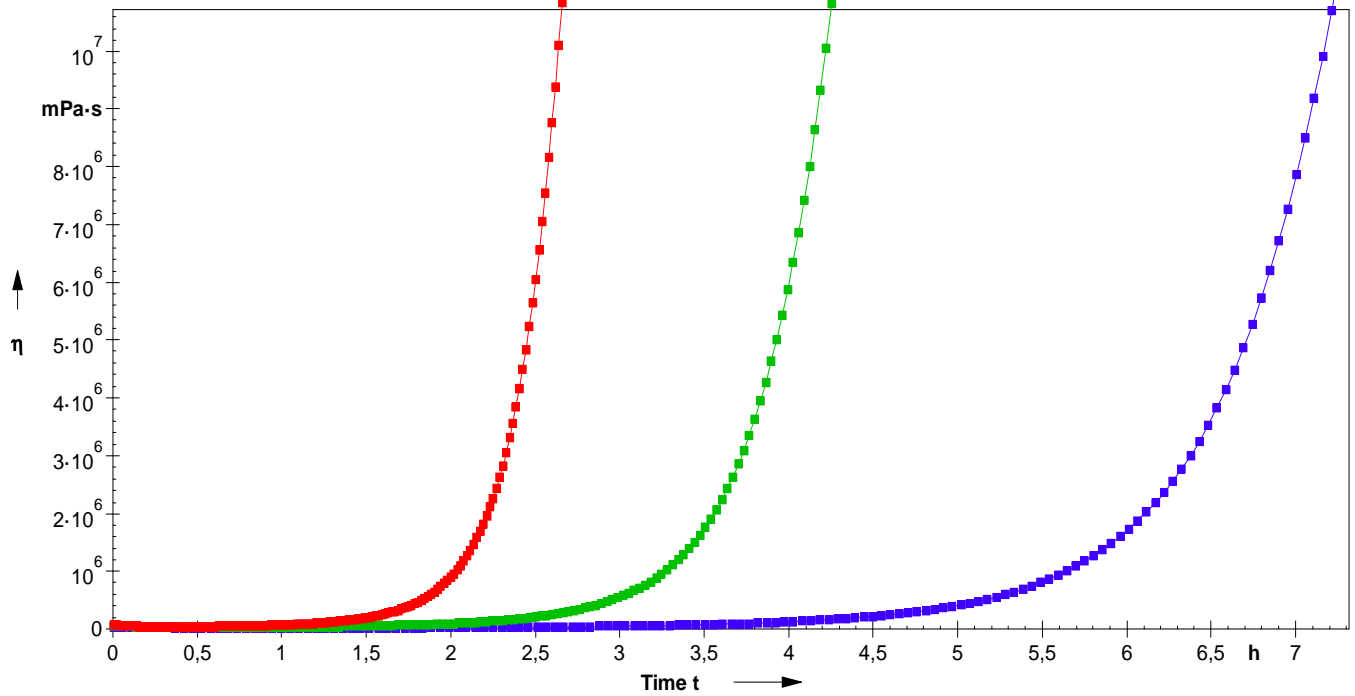
		SD 2806	SD 2805	SD 2803
Reactivity		Very fast	Fast	Standard
Aspect / colour		Yellow liquid	Yellow liquid	Yellow liquid
Viscosity (mPa.s)	@ 15 °C	450 ± 100	300 ± 50	200 ± 40
	@ 20 °C	300 ± 60	200 ± 40	140 ± 30
	@ 25 °C	200 ± 40	140 ± 25	100 ± 20
	@ 30 °C	140 ± 30	100 ± 20	80 ± 15
Density	@ 20 °C	1.07 ± 0.01	1.04 ± 0.01	1.00 ± 0.01

#### System SG 162 CS / SD 280x

	SG 162 CS / SD 2806	SG 162 CS / SD 2805	SG 162 CS / SD 2803
Mixing ratio by weight	100 / 17		
Tg onset by DSC AT + 6 h 60 °C	73 / 75 °C	71 / 72 °C	69 / 70 °C

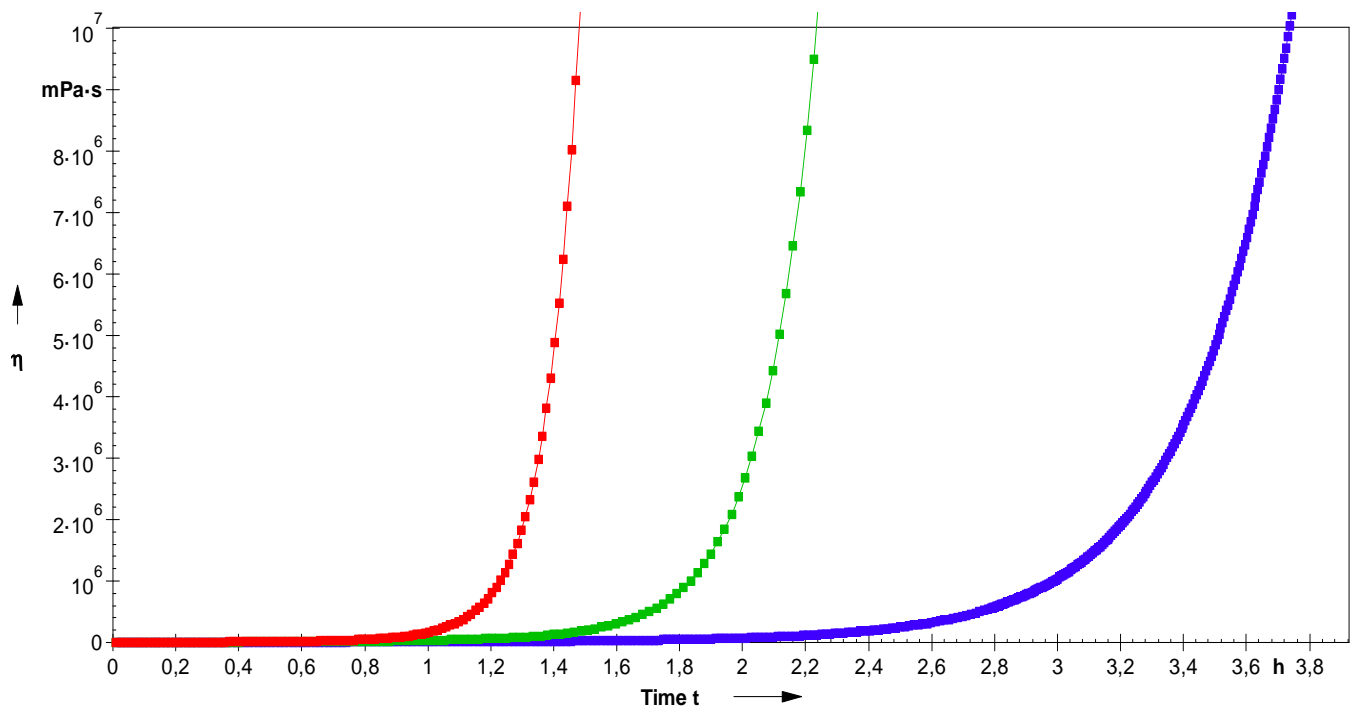
## Increase of viscosity on 1 mm film

@ 20 °C



■ SG 162 CS / SD 2803 @ 20 °C    
 ■ SG 162 CS / SD 2805 @ 20 °C    
 ■ SG 162 CS / SD 2806 @ 20 °C

@ 30 °C



■ SG 162 CS / SD 2803 @ 30 °C    
 ■ SG 162 CS / SD 2805 @ 30 °C    
 ■ SG 162 CS / SD 2806 @ 30 °C

### **Advised post-cure cycle**

If possible the post-cure will be done in the mould to limit the print of the fibers  
24 hours @ ambient + 24 hours @ 40°C  
or 24 hours @ ambient + 12 hours @ 60°C

### **Workshop conditions**

18 °C < Temperature of the substrate < 50°C  
Hygrometry < 80%

### **Release agent**

SG 162 CS has been formulated with high abrasive fillers which could scratch the model  
Use appropriate release agent. Apply the first layer of gel coat by brush