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SURFACE COAT/GELCOAT

E-108 GC

Product Data Sheet

E-108 GC provides a durable, dimensionally stable, surface coat for laminated tools with excellent chemical and temperature resistance. This material has a work time of approximately 15 minutes. Use this system in conjunction with **E-108 SP** laminating epoxy resin. This two-component system has several Hardeners (H) available that are selected based on part's thickness and service temperature—*See Hardener Selection Below*.

Available Sizes: Quart Kit Gallon Kit 5 Gallon Kit

Properties:

Shore Hardness: 90 D
Color: Black
Viscosity, cps: 170,000 cp, Unmixed
Mixed: Flowable, High Viscosity Liquid
Shrinkage: Nil

Mix Ratio:

(By Weight)

100% E-108 GC

H-2072 @ 16.5% Heat Resistance—250F

Pot Life: 15 Minutes @ 75F, 3/8—250F

Tack Free Time: 15 Hours @ 75F or Post Cure 1 Hour @ 125-150F

H-82R @ 7.5% **For High Temperature Resistance 300F+

MIXING INSTRUCTIONS:

Weigh epoxy base and hardener at specified mix ratio--(Check mix ratio of Hardener). Mix well by hand or mechanical mixer. Be sure to scrape sides and bottom or transfer to another container for a more thorough mix.

Apply gelcoat to a properly sealed and released plug/master. After gelcoat has gelled, subsequent reinforcing layers of fiberglass cloth and **E-108 SP** laminating resin are applied until desired tool thickness is achieved—allowing laminating resin to gel before applying next coat. Allow part to cure—16 hours @ 75F--before using.

STORAGE:

Store and use material at room temperature or below 90F. For cold materials, warm-up material by a hot water bath (place unmixed containers in a plastic bag first and allow 15 minutes for material to absorb heat) prior to mixing.

THE INFORMATION AND DATA CONTAINED HEREIN ARE BASED ON INFORMATION WE BELIEVE RELIABLE. EACH USER OF THE MATERIAL SHOULD THOROUGHLY TEST APPLICATION AND INDEPENDENTLY CONCLUDE SATISFACTORY PERFORMANCE BEFORE COMMERCIALIZING. SUGGESTIONS OF USES SHOULD NOT BE TAKEN AS INDUCEMENTS TO INFRINGE ON ANY PARTICULAR PATENT.