

POLYCOR®

9EXCK119

Clear, Vinyl Ester In-Mold Coating

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Description

POLYCOR® 9EXCK119 is a clear, vinyl ester based gel coat formulated for use as an in-mold coating. POLYCOR® 9EXCK119 is specifically formulated for use in manufacturing processes where visual inspection of molded parts is *required such as during epoxy wind blade manufacture*.

POLYCOR® 9EXCK119 meets the EPA National Emission Standards for Hazardous Air Pollutants (NESHAP) for Boat Manufacturing and Reinforced Plastic Composites Production.

POLYCOR® 9EXCK119 can be used for room temperature and heated molding applications. POLYCOR® 9EXCK119 is recommended for use in applications where parts will be post coated or painted. POLYCOR® 9EXCK119 can withstand epoxy cure and post cure cycles as well as paint cure cycles.

POLYCOR® 9EXCK119 should not be used as an exterior coating in outdoor applications where weathering resistance is required.

While offering these benefits, these POLYCOR® 9EXCK119 has retained the important construction and application qualities expected from CCP gel coats, such as resistance to porosity, sag resistance, consistent liquid properties, and more. These all add up to higher quality appeal composite parts made with POLYCOR® 9EXCK119.

Features and Benefits

- User friendly for both spray or roll application
- Clear film allows for two sided part inspection
- Heat resistant to withstand epoxy cure and post cure cycles as well as paint cure cycles
- Chemical and water resistant
- Flexible and cracking resistance
- Excellent adhesion to polyesters, vinyl esters or epoxies

Liquid Properties (at 77°F (25°C))

Typical properties of POLYCOR® 9EXCK119 are shown below. These values may or may not be manufacturing control criteria; they are listed for a reference guide only. Particular batches will not conform exactly to the numbers listed because storage conditions, temperature changes, age, testing equipment (type and procedure) can each have a significant effect on the test results. Gel coats with properties outside of these ranges can perform acceptably.



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Test	POLYCOR® 9XCK119
Flash Point	88°F
Hazardous Air Pollutants	Refer to MSDS
Volatile Organic Compounds	41.1%
Weight per Gallon	8.68 lbs.
Viscosity ¹	7500 cps
Thixotropic Index (2/20)	3.7
Gel Time ²	14 minutes
Lay-up Time	50-60 minutes
Sag Resistance	Good @ 25 mils

¹Brookfield RV, spindle #4, 5 rpm

²100 gm mass, 1.8% Arkema Luperox® DDM-9

Refer to the MSDS for handling precautions. MSDS's will be supplied automatically with the first order for material, and are available by product code upon request from CCP's Regulatory Department and at www.ccpcompositesus.com.

Application

POLYCOR® 9EXCK119 must be mixed prior to use. This includes prior to production spray application and when obtaining material for patching or any material that has been set aside for patching. Several suitable types of mixing equipment and styles of agitators are available for both pails and drums. Regardless of the specific type used, the equipment must have sufficient horsepower (relative to container size) to achieve thorough circulation from top to bottom and out to the sides of the container. The agitator must be properly sized for the container and must allow for uniform mixing regardless of the liquid level in the container.

Do not over mix POLYCOR® 9EXCK119. Over mixing can break down the coating viscosity increasing the tendency to sag. Over mixing can also result in styrene loss which could contribute to porosity. Air bubbling should not be used for mixing. It is not effective and only serves as a potential source of water or oil contamination.

POLYCOR® 9EXCK119 is formulated for spray or roll application. Brushing is not recommended due to poor flow and leveling.

Spray equipment must be well maintained and regularly calibrated. Application procedure recommendations should be followed carefully. Poorly maintained equipment or poor application will quickly negate the beneficial properties of POLYCOR® 9EXCK119. Refer to CCP's Composites Application Guide, for equipment and application recommendations.

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When establishing the fan pattern for the spray equipment, use the lowest pump pressure needed to achieve a good fan pattern (no fingers or tails, uniform particle size of about 1/16"). Use of higher pressures can lead to a porosity or excessive overspray.

Overspray can result in a leathery or chicken skin texture if it falls on the part surface. To minimize overspray that falls onto the mold, plan the spray pattern so that the beginning is closest to the vapor/air exhaust and progresses to the opposite mold end. The spray pattern should also allow for a wet line to be maintained.

A spray distance of 18 to 36 inches is recommended. Closer spray distances can result in blowing of the film or air entrapment. Spraying at distances greater than 4 feet will increase orange peel and porosity. For deep channels, recessed, and hard-to-spray areas, an extension nozzle is highly recommended.

CCP does not recommend fluid lines longer than 50 feet, or pumps smaller than 20:1 ratio. CCP recommends a gel coat delivery rate of no more than 2.5 pounds per minute with conventional air atomized equipment, and no more than 4 pounds per minute with airless equipment.

For optimum results, uniform catalyst mix must be achieved. Even with the equipment properly calibrated, potential problems can occur due to poorly atomized catalyst; surging problems (gel coat or catalyst); poor tip alignment (catalyst to gel coat mix); contamination; and poor application procedures, which will quickly negate all benefits of calibration. The equipment (and application procedures) must be monitored on a routine basis to ensure proper application and cure of the gel coat. Inquire about and adhere to all equipment manufacturers' recommendations.

Avoid overspray settling on mold surfaces by beginning the spray pattern closest to the vapor/air exhaust and progressing to the opposite mold end. Maintain recommended spray distances from the mold surface.

Delamination can occur if the gel coat is left in the mold overnight without being laminated. It is essential that a laminate be applied behind the gel coat within 8 hours of being sprayed.

Cure

It is recommended that gel time be checked in the customer's plant because age, temperature, humidity and catalyst will produce varied gel times. All data referencing gel or cure refers specifically to Arkema Luperox[®] DDM-9 catalyst. Syrgis NOROX[®] MEKP-9 and NOROX[®] MEKP-9H, Akzo Nobel CADOX L-50a and CADOX D-50 are expected to yield similar performance. Arkema Luperox[®] DHD-9, NOROX[®] MEKP-925 and NOROX[®] MEKP-925H, and Chemtura HP-90 can also be used, but gel and cure times will vary.

The recommended catalyst range is 1.2% to 3.0% with 1.8% at 77°F being ideal. Normally, the gel coat film is ready for lamination in 50 to 60 minutes. This time element is dependent on material temperature, room temperature, humidity, air movement, and catalyst concentration. If lay-up time is checked by the finger method, slight pressure and rubbing should be used.

These products should not be used when temperature conditions are below 60°F, as curing may be adversely affected.

Caution

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Spray and pumping equipment must be completely clean other gel coat and resin products before using POLYCOR® 9EXCK119.

Do not add any material, other than recommended methyl ethyl ketone peroxide, to this product without the advice of a representative of CCP Composites US.

Storage limitations

POLYCOR® 9EXCK119 has a usage life of 90 days from date of shipment from CCP when stored at 73°F or below in a closed, factory-sealed, opaque container and out of direct sunlight. The usage life is cut in half for every 20°F over 73°F.

Data Sheets/MSDS

CCP data sheets and MSDS's are available in printable format at www.ccpcompositesus.com.

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Seller warrants that: (i) Buyer shall obtain good title to the product sold hereunder, (ii) at Shipment such product shall conform to Seller's specifications; and (iii) the sale or use of such product will not infringe the claims of any U.S. patent covering the product itself, but Seller does not warrant against infringement which might arise by the use of said product in any combination with other products or arising in the operation of any process. **SELLER MAKES NO OTHER WARRANTY OF ANY KIND, EXPRESS OR IMPLIED, INCLUDING WITHOUT LIMITATION ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE, EVEN IF THAT PURPOSE IS KNOWN TO SELLER. ANY APPLICATION INFORMATION OR ASSISTANCE WHICH SELLER MAY FURNISH TO BUYER IS GRATUITOUS AND SHALL IN NO WAY BE DEEMED PART OF THE SALE OF PRODUCT HEREUNDER OR A WARRANTY OF THE RESULTS OBTAINED THROUGH THE USE OF SUCH PRODUCT.**

Without limiting the generality of the foregoing, if any product fails to meet warranties mentioned above, Seller shall at Seller's option either replace the nonconforming product at no cost to Buyer or refund the Buyer the purchase price thereof. The foregoing is Buyer's sole and exclusive remedy for failure of Seller to deliver or supply product that meets the foregoing warranties. Seller's liability with respect to this contract and the product purchased under it shall not exceed the purchase price of the portion of such product as to which such liability arises. Seller shall not be liable for any injury, loss or damage, resulting from the handling or use of the product shipped hereunder whether in the manufacturing process or otherwise. In no event shall Seller be liable for special, incidental or consequential damages, including without limitations loss of profits, capital or business opportunity, downtime costs, or claims of customers or employees of Buyer. Failure to give Seller notice of any claim within thirty (30) days of shipment of the product concerned shall constitute a waiver of such claim by Buyer. Any product credit received by Buyer hereunder, if not used, shall automatically expire one (1) year from the date the credit was granted. Notwithstanding any applicable statute of limitations to the contrary, any action by Buyer relation to a claim hereunder must be instituted no later than two (2) years after the occurrence of the event upon which the claim is based. All the foregoing limitations shall apply irrespective of whether Buyer's claim is based upon breach of contract, breach of warranty, negligence, strict liability, or any other legal theory.

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COMPOSITES SAFETY INFORMATION (October 2011)

All sales of products manufactured by CCP Composites US (CCP), and described herein, are made solely on condition that CCP's customers comply with applicable health and safety laws, regulations and orders relating to the handling of our products in the workplace. Before using, read the following information, and both the product label, and Material Safety Data Sheet pertaining to each product.

Most products contain styrene. Styrene can cause eye, skin and respiratory tract irritation. Avoid contact with eyes, skin and clothing. Impermeable gloves, safety eyewear and protective clothing should be worn during use to avoid skin and eye contact. Wash thoroughly after use.

Styrene is a solvent and may be harmful if inhaled. Reports have associated repeated and prolonged occupational overexposure to solvents with permanent brain and nervous system damage. Extended exposure to styrene at concentrations above the recommended exposure limits may cause central nervous system depression causing dizziness, headaches or nausea and, if overexposure is continued indefinitely, loss of consciousness, liver and kidney damage.

Do not ingest or breathe vapor, spray mists or dusts caused by applying, sanding, grinding and sawing products. Wear an appropriate NIOSH/MSHA approved and properly fitted respirator during application and use of these products until vapors, mists and dusts are exhausted, unless air monitoring demonstrates vapors, mists and dusts are below applicable exposure limits. Follow respirator manufacturer's directions for respirator use.

The International Agency for Research on Cancer (IARC) reclassified styrene as Group 2B, "possibly carcinogenic to humans." This revised classification was not based on new health data relating to either humans or animals, but on a change in the IARC classification system. The Styrene Information and Research Center does not agree with the reclassification and published the following statement: Recently published studies tracing 50,000 workers exposed to high occupational levels of styrene over a period of 45 years showed no association between styrene and cancer, no increase in cancer among styrene workers (as opposed to the average among all workers), and no increase in mortality related to styrene.

Styrene is classified by OSHA and the Department of Transportation as a flammable liquid. Flammable products should be kept away from heat, sparks, and flame. Lighting and other electrical systems in the work place should be vapor-proof and protected from breakage.

Vapors from styrene may cause flash fire. Styrene vapors are heavier than air and may concentrate in the lower levels of molds and the work area. General clean air dilution or local exhaust ventilation should be provided in volume and pattern to keep vapors well below the lower explosion limit and all air contaminants (vapor, mists and dusts) below the current permissible exposure limits in the mixing, application, curing and repair areas.

Some products may contain additional hazardous ingredients. To determine the hazardous ingredients present, their applicable exposure limits and other safety information, read the Material Safety Data Sheet for each product (identified by product number) before using. If unavailable, these can be obtained, free of charge, from your CCP representative or from: CCP Composites US, P.O. Box 419389, Kansas City, MO 64141-6389; 816-391-6053.

FIRST AID: In case of eye contact, flush immediately with plenty of water for at least 15 minutes and get medical attention; for skin, wash thoroughly with soap and water. If affected by inhalation of vapors or spray mist, remove to fresh air. If swallowed, get medical attention.

Those products have at least two components that must be mixed before use. Any mixture of components will have hazards of all components. Before opening the packages read all warning labels. Observe all precautions.

Keep containers closed when not in use. In case of spillage, absorb with inert material and dispose of in accordance with applicable regulations. Emptied containers may retain hazardous residue. Do not cut, puncture or weld on or near these containers. Follow container label warnings until containers are thoroughly cleaned or destroyed.

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