

Product Data



908 LENOIR ROAD • POST OFFICE BOX 1809
HICKORY, NORTH CAROLINA • 28603-1809
TELEPHONE (828) 328-1721
TOLL FREE (800) 334-5975
FAX (828) 328-4572

A-1984

GRANITE GEL COAT BASE

A-1984 Isophthalic Polyester based Gel Coat is formulated from a tough, resilient resin system that will resist direct impacts while maintaining a hard, durable surface desired for kitchen counters and work surfaces.

The A-1984 Isophthalic Polyester based Gel Coat is specifically designed as an in-mold Gel Coat. It can also be used in a post application process.

The A-1984 Isophthalic Polyester based Gel Coat is designed for use with ATH/Granule loadings of up to 50% by weight. The surface is normally “sanded” or abraded to maximize the “granite effect”. When properly prepared the surface will be indistinguishable from standard solid surface products.

The A-1984 Isophthalic Polyester based Gel Coat is designed with a low viscosity to allow the filler loading to be maximized and a superior “anti-sag” system to prevent sagging of the dense Gel Coat/Filler combination.

TYPICAL PROPERTIES @ 77° F (25°C)

UNCATALYZED

Weight/Gallon:	8.84 Pounds
Specific Gravity:	1.06 g/cc
Viscosity, Brookfield, 6 RPM	4,000 - 6,000 cps
60 RPM	1,000 - 1,300 cps
Shelf Life:	3 months minimum in sealed container maintained at less than 80°F.

CATALYZED (1% MEKP* @ 77°F.)

Gel time, 100 gram mass:	10 - 15 Minutes
Gel time, 20-mil film:	40 - 50 Minutes
Cure to Sand, 20-mil film:	< 60 Minutes

*Norac MEKP 9 or RCI 46-702

APPLICATION

HK Research Corporation's A-1984 Isophthalic Polyester based Gel Coat is designed for use with ATH/Granule loadings of up to 50% by weight. Pre-prepared ATH/Granule products such as those made by the RJ Marshall Company and others can be used. A custom blend can be prepared to personalize your product. A generic mixture suggested as a starting point follows.

A-1984	50 parts by weight
Granules	25 parts by weight
ATH	25 parts by weight
Color Paste*	0-1 parts by weight
MEKP	2 parts by weight

Blend carefully with a “Jiffy” type mixer or equivalent to minimize the incorporation of air into the mix. Carefully sift in the ATH and Granules. Add color paste if desired. Mix slowly for a minimum of ten minutes to “wet-out” the filler system.

The above Granite Gel Coat is formulated for standard conventional spray application. This high performance gel coat requires careful application in order to maximize the properties in the cured gel coat film. Poor application of the A-1984 Isophthalic Polyester based Gel Coat will cause a reduction in the properties of the cured gel coat film as well as the possibility of porosity which may interfere with post coating applications.

Color Pastes suitable for use in this system are as follows:

CORIAN COLORS*

Almond	HBN-8591
Bisque	HWE-2447
Bone	HBN-8566
Cameo White	HWE-2413
Champagne	HBN-8689
Dawn Beige	HBN-8584
Dune	HBN-8837
Dusty Rose	HRD-4496

CORIAN COLORS* (continued)

Glacier White	HWE-2372
Kiwi	HGN-5585
Mandarin	HOE-4012
Misty Green	HGN-5290
Peach	HRD-4488
Pearl Gray	HGY-9269
Satin Gray	HGY-9268
Sea Grass	HGN-5463
Taupe	HBN-8585
Vanilla	HWE-2518

*Solid Color Pastes are provided at opaque strength. If translucent strength version is required please consult an HK Research Laboratory Technician.

**COLOR PASTES FOR SOLID SURFACE
APPEARANCE WITH SPECIFIC FILLERS**

	<u>STONETEX 2100</u>	<u>DGE-210</u>	<u>SB-2</u>	<u>DF-40</u>
NEVAMAR- FOUNTAINHEAD COLORS				
Light Blue	HBE-6236	HBE-1062		
Teal	HGN-5216	HGN-1041		
Architectural White				HWE-2342
Classic White				HWE-2341
Sand Beige				HBN-8454
Shadow Blue			HBE-6242	
Gray Mist			HGY-9247	
Rose			HRD-4370	

**COLOR PASTES FOR SOLID SURFACE APPEARANCE
WITH SPECIFIC FILLERS
(CONTINUED)**

	<u>STONETEX 2100</u>	<u>DGE-210</u>	<u>SB-2</u>	<u>DF-40</u>
KOHLER COLORS				
Raspberry	HRD-4323	HRD-1082		
Wild Rose	HRD-4329	HRD-1109		
Heron Blue				HBE-6341
Mexican Sand				HBN-8386
Teal		HGN-1051		
Seafoam Green				HGN-5240
Innocent Blush				HRD-4304 (Onyxfil V)
WILSON ART COLORS				
Tyrol Green		HGN-5236		
Rosetta		HRD-4372		
Hollyberry		HRD-4379	HRD-4379	
Rose Mist		HRD-4401		
Hunter Green				HGN-5395

MISCELLANEOUS SOLID SURFACE COLOR PASTES

HBE-6230	Formica 973 Parakeet Blue	(DF-40/R-0217)
HBE-6233	EL Glacier Blue	(DF-40/R-0217)
HBE-6241	Pantone 320 Blue	(DF-40/R-0251)
HBE-6243	Brocom A-218 Navy Blue	(DF-40/R-0217)

MISCELLANEOUS SOLID SURFACE COLOR PASTES

(continued)

HBN-8478	Surrell Almondine	(DF-64/R-0251)
HGN-5234	Pantone 360 Green	(DF-40/R-0251)
HGN-5249	Solidex 601 Sloe Jade	(DF-40/R-0251)
HRD-4294	Formica 962 Pale Mauve	(DF-40/R-0217)
HRD-4360	Granatex Dusty Rose	(DGE-210/R-0251)
HRD-4363	Pantone 232 Hot Pink	(DF-40/R-0251)
HRD-4380	Pantone 267-C Purple	(DF-40/R-0251)

MIXING

Prior to removal from the shipping container and catalyzation, it is recommended that the materials be mixed thoroughly to reincorporate any "settled" or "stratified" material. It is further recommended that the material in the shipping container be mixed at least once a week during its use period. The mixing procedure would assure the most uniform properties during application of the gel coat. Mechanical mixing is recommended and should be sufficient to "turn" the material 10 times. Most common gel coat mixing equipment will accomplish an adequate blend in less than 1/2 hour.

It is suggested that the catalyst concentration used in the application of the A-1984 Isophthalic Polyester based Gel Coat not exceed 3.0% or fall below 1.5% to retain maximum properties. The recommended range for the catalyst concentration within the applied film is 1.8 to 2.2% at 77°F.

SAFETY CONSIDERATIONS

A-1984 Isophthalic Polyester based Gel Coat is based on a high grade Isophthalic resin that contains styrene monomer, a flammable liquid. Keep away from sparks, heat and open flame (including pilot lights). Electrical equipment should be vapor-proof and protected from breakage.

Styrene vapors are heavier than air and will tend to concentrate in the low areas of molds and in pockets immediately above the floor area. To keep vapors within a safe limit in all areas, adequate ventilation or suction fans should be used that will remove these styrene monomer vapors.

All equipment must be grounded - including spray guns and molds.

Both the polyester gel coat and catalyst may cause burns to eyes and skin. Do not get in the eyes! Avoid breathing vapors! Gel coat applicators should wear a NIOSH approved respirator effective for vapors, spray mist and dust. In case of accidental contact, remove contaminated clothing and wash affected skin areas with soap and copious quantities of water. Contact a physician if persistent skin irritation occurs. For eyes immediately flush with plenty of water for at least 15 minutes; call a physician immediately. Wash contaminated clothing before reusing.