Orca Composites

Orca Shield
Polyester Gel Coat

DESCRIPTION
Orca Shield Gel Coat is a fully promoted, thixotropic, neopentyl glycol-isophthalic polyester gel coat for spray applications. This product is designed for pigmented, medium to highly chromatic colors.

BENEFITS
- Superior UV and water resistance make this an ideal product for Marine, Transportation and architechtural applications where resistance to the environment is essential.
- High gloss with superior cosmetics
- Excellent physical properties
- Superior processing characteristics
- Easy to repair

APPLICATION GUIDELINES
A. All ORCA thixotropic polyester gel coats should be mixed well prior to use.
B. MEKP levels should be kept between1.0% and 2.5%
C. Gel coat should not be applied at temperatures below 64°F/18°C.
D. Recommend spraying 3 passes at 5-8mils allowing a short flash time between passes.

MINIMUM STORAGE STABILITY
The Orca Shield gel coat is stable for three months from date of production when stored away from sunlight at no more than 77°F/25°C. Storage at elevated temperatures will reduce shelf life. After extended storage, some drift may occur in gel time or viscosity.

SAFETY
See appropriate Material Safety Data Sheet for guidelines.

Typical Cast Liquid Properties *

	Typical Range
Viscosity @ 77°F/25°C, RVF Brookfield Spindle #4 @ 20 RPM, cps.	4000-4800
Thix ratio (2:20 RPM)	7.5-8.5
Gel Time @ 77°F/25°C (1.8% of a 9% active oxygen MEKP), minutes	14-16
Exotherm Time, minutes	10-18
Exotherm Temperature, °C	170-200
HAP Content, %	Less than 35

*Typical properties are not to be construed as specifications.

ISO 9001:2000 CERTIFIED
The Quality Management Systems at every manufacturing facility have been certified as meeting ISO 9001:2000 standards. This certification recognizes that each facility has an internationally accepted model in place for managing and assuring quality. We follow the practices set forth in this model to add value to the resins we make for our customers.

FOOTNOTES
(1) Gel times shown are typical but may be affected by catalyst type and level, and by gel coat, mold and shop temperature. Variations in curing characteristics can be expected between different lots of catalysts and at extremely high humidities. It is recommended that the fabricator check the curing characteristics of a small quantity of gel coat under actual operating conditions prior to use.

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