

5.1 Tech Data

Features and Benefits of Marble Clear Gel Coats

Background:

The superior transparency and consistency of Interplastic Silmar® clear gel coats brings out the best in cultured marble and onyx vanity, bathtubs and wall panels. Our extremely durable and MACT-compliant (lower styrene/better emissions) Silmar clear gel coats are top performers in clarity and color.

Silmar marble clear products (SIL08LH-70 and SIL08LH-80) are a low VOC NPG® gel coat resin system, specifically designed for the cast polymer industry. These products meets MACT Standard, EPA 40 CFR Part 63 requirements of the National Emissions Standards for Hazardous Air Pollutants: Reinforced Plastic Composite Production, maximum of 44% HAP for clear gel coat.

Key performance properties of Interplastic marble clear gel coats include:

- Rapid film cure time
- Excellent backside leveling
- Crack resistance / flexibility
- Repair/Patching
- Glass like color

Coating performance in these areas is heavily influenced by processing variables:

- Film thickness
- Environment –
 - Spray pressures, temperature, humidity, cycle time, mold prep
- MEKP type and content
- Matrix exotherm,
- Oil and water contamination

Standard Products Comparison

	Formulation:	SIL08LH-70	SIL08LH-80	SIL08LH-99	SIL08LH-101
<u>Test</u>	<u>Test Method</u>				
Cup Gel Time	CRSTP-340	5:00 – 7:00	4:00 – 6:00	3:00 – 5:30	5:00 – 7:00
Film Cure Time (77°F)	CRSTP-346	50 minutes	50 minutes	30 minutes	50 minutes
Brookfield Viscosity (RV4 @ 4 RPM)	CRSTP-301	11,000 – 15,000 cps	11,000 – 15,000 cps	11,000 – 15,000 cps	11,000 – 14,500 cps
Thix Index	CRSTP-301	6.3 – 8.0	6.0 – 8.0	6.0 – 8.0	5.0 – 7.0
HAPs Content	CRSTP-329	≤44%	<44%	≤44%	<44%
Flexibility (Flex Strip)	CRSTP-348	1.33 %	1.15 %	1.22 %	1.36 %
MACT Compliant	EPA 40 CFR	Yes	Yes	Yes	Yes

Test values listed above are representative of product performance tested in accordance with the method listed and are believed to be correct upon the writing of this document. Specifications and properties of materials delivered may vary slightly from those listed above.

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