

## DESCRIPTION

Poltix Lamineerhars is a pre-accelerated unsaturated isophthalic polyester resin for general applications.

## PRINCIPAL CHARACTERISTICS

- Thixotropic;
- Pre-accelerated;
- Rapid curing;
- Contains a colour indicator to control curing;
- Low styrene emission, results in a tack-free surface;
- Low shrinkage when used in combination with reinforcing materials;
- May be used in combination with reinforcing materials for the repair of polyester products such as boats, tanks, autoparts, etc.

## COLOURS AND GLOSS

Transparent – Silk gloss

## BASIS PROPERTIES (AT 23 °C AND 50% R.H.)

Density	: approx. 1,1 g/cm <sup>3</sup>
Solid content	: approx. 100 % (volume)
Dust dry after	: approx. 25 minutes
Full cure after	: approx. 2 hours
Recoating interval	: min. 24 hours, see additional information max. unlimited, provided free from contamination
H.D.T. (ISO 75A)	: 70 °C
Shelf life	: separate components, stored cool and dry in original packaging minimum 6 months
Flash point (DIN53213)	: base component 31 °C hardener 52 °C

## SPREADING RATE

The practical spreading rate depends on the type of reinforcing materials applied. The following table gives an indication of the average resin consumption when combined with several materials:

Type	Resins each m <sup>2</sup>	D.f.t.
Glasmat 225 gram/m <sup>2</sup>	600 gram	600 µm
Glasmat 300 gram/m <sup>2</sup>	700 gram	700 µm
Glasmat 450 gram/m <sup>2</sup>	1100 gram	1100 µm
Rovingweefsel 600 gram/m <sup>2</sup>	900 gram	900 µm

The practical spreading rate depends on a number of variables, such as: shape and size of object to be painted, the condition and profile of the substrate, the method of application, climatologic conditions and skill of labour.

## SUBSTRATE CONDITION AND TEMPERATURE

Polyester : dry and free from oil, grease, contamination, old paint layers and loose particles, sanded with grit paper P120 and degreased with Double Coat Degreaser;

During application and curing a minimum temperature of 15 °C is allowed. The temperature of the substrate should be minimum 3 °C above dew point.

**INSTRUCTIONS FOR USE**

Before use, mix base and hardener components thoroughly.

Mixing ratio : 100 base : 2 hardener (parts by weight)  
Do not prepare more material than can be applied within the potlife of the mixture.

Induction time : none  
Pot life : 10 minutes at 25 °C  
15 minutes at 20 °C  
20 minutes at 15 °C

Application with :

	Brush
type thinner	none
% of thinner	
nozzle orifice	none
nozzle pressure	none
cleaning	Double Coat Brush thinner or Double Coat Degreaser

**ADDITIONAL INFORMATION**

- Recoating of surfaces repaired with Poltix Lamineerhars

	15 °C	20 °C	25 °C
Minimum, with IJmopox, Variopox or Double Coat	24 hours	24 hours	24 hours
Minimum, wit Poly Lak	4 hours	4 hours	4 hours
Maximum, after degreasing and sanding with P120 – 180	unlimited	unlimited	unlimited

- Application of Poltix Lamineerhars
  - Poltix Lamineerhars is recommended for hand-layup. It is possible to apply Poltix Lamineerhars with conventional air or airless spray equipment but the relatively short potlife should be considered. Special 2-component spray equipment is more suitable.
  - For brush application use brushes with unpainted handles.
  - Apply a generous coat of Poltix Lamineerhars. Place a glasfiber in the wet layer of Poltix Lamineerhars and apply with a brush by pressing the brush onto the fiber at right angle. Remove airbubbles using a Teflon or aluminium deaeration roller.
- Hardener  
As hardener/catalyst we recommend Butanox M50 (Akzo Nobel) or Peroxan ME50L (Pergan). After mixing the base component with the harder the temperature of the mixture will increase rapidly due to an exothermic reaction. Do not prepare more material than can be applied within the pot life of the mixture.

### SAFETY INFORMATION

This product contains solvents. Take all necessary safety measurements when using this product and arrange proper ventilation and safety equipment for all personnel. For details on safety and health see our material safety data sheet.

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#### *Disclaimer*

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