

RELEST® Wind Gelcoat transparent



Polyaspartic

PRODUCT DESCRIPTION

Product Code: Base (RLA503, I372-0002) / Hardener (RLA602, I385-0013)

Viscoplastic, solvent-free polyaspartic coating with high tear propagation strength. Suitable for making transparent, bubble-free and fast drying intermediate coats.

RELEST Wind Gelcoat transparent only temporarily protects the laminating resin from UV radiation. The protective duration depends on the respective EP resin used and must be checked by the customer. This intermediate coat must be overcoated with at least one coloured, weathering resistant topcoat.

RELEST Wind Gelcoat transparent is characterised by its very good adhesion to EP laminate, its good flow and fast curing process. Thanks to its long workable life the product can be easily applied to large surfaces.

INTENDED USES

RELEST Wind Gelcoat transparent is designed as an intermediate coat, for use as part of a wind blade protection system.

PRACTICAL INFORMATION FOR RELEST WIND GELCOAT TRANSPARENT

Colour	Colourless
Gloss Level	Gloss
Volume Solids	>99%
Typical Thickness	450 microns (18 mils) dry
Theoretical Coverage	0.5 kg/m ² at 450 microns and stated volume solids; corresponds to approx. 1.96 m ² /kg
Practical Coverage	Allow appropriate loss factors
Density	1.12 g/cm ³ (Mixed)
Method of Application	Roller
Drying Time	

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
20°C (68°F)	60 minutes	180 minutes	60 minutes	72 hours
23°C (73°F)	25 minutes	95 minutes	60 minutes	72 hours
30°C (86°F)	20 minutes	65 minutes	60 minutes	72 hours

- Touch Dry and Hard Dry are equivalent to TG1 and TG7 respectively, according to ISO 9117-5
- Drying times will depend on the substrate temperature and ventilation.
- The figures quoted above have been determined at:
20°C / 30% RH 23°C / 65% RH 35°C / 85% RH
- Forced drying is possible up to 50°C. Consult your local representative for further information.

REGULATORY DATA

Flash Point (Typical)	Part A 145°C (293°F); Part B >99°C (210°F)		
Product Weight	1.12 kg/l (9.3 lb/gal)		
VOC	VOC (Base)	4.2 g/kg EU Solvent Emission Directive (Council Directive 2010/75/EU)	
	VOC (Hardener)	0 g/kg EU Solvent Emission Directive (Council Directive 2010/75/EU)	
	VOC (Mixed)	2.75 g/kg EU Solvent Emission Directive (Council Directive 2010/75/EU)	

See Product Characteristics section for further details

Protective Coatings

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SURFACE PREPARATION

The mould treated with suitable parting agents (carry out preliminary tests, if necessary) must be clean, dry and free of dust and other soiling.

The mould temperature should be between 10°C and 40°C (50°F - 104°F) prior to application of RELEST Wind Gelcoat transparent.

APPLICATION

Mixing

Thoroughly mix Part A and Part B with a mechanical stirrer, avoiding aeration as much as possible. Due to the short working pot life of this product, it is advised to mix small quantities to ensure maximum productivity.

Mix Ratio

Using Part B RELEST Hardener PUR 13 (I385-0013):
100 part(s) : 51 part(s) by volume
100 part(s) : 53 part(s) by weight

Working Pot Life

20°C (68°F)	23°C (73°F)	35°C (95°F)
20 minutes	15 minutes	8 minutes

- The figures quoted above have been determined at:
20°C / 30% RH 23°C / 65% RH 35°C / 85% RH
- The material must not be used once the specified working pot life has been exceeded. This may lead to inferior performance.

Roller

Recommended

Thinner

DO NOT THIN

Cleaner

RELEST Thinner PUR 132

Work Stoppages

Thoroughly clean all equipment with RELEST Thinner PUR 132. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.

Clean Up

Clean all equipment immediately after use with RELEST Thinner PUR 132.

All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

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PRODUCT CHARACTERISTICS

For recommendations regarding release agents and tested infusion resins please contact your local representative.

Apply the material by suitable rollers (e.g. SUPERFLOC rollers).

RELEST® Wind Gelcoat transparent is usually roller-applied undiluted and applied evenly to cold or heated moulds provided with parting agent by means of in-mould coating.

Due to the product's limited workable life it is recommended to mix several small quantities after each other depending on the respective mould size.

When applying the mixed material make sure that as little air as possible is rolled into the coating.

The material must no longer be used when the specified workable life has elapsed, i.e. when the gelling process has started. This may lead to air pockets, textural differences and crack formation.

Liquid epoxy resin which is reinforced with glass fibres is then applied. It is recommended to carry out an adhesion test beforehand.

The curing time of RELEST Wind Gelcoat transparent depends on the film thickness.

At the recommended dry film thickness of 450 µm, the product can be provided with glass fibre mats after approx. 70 min. at +20°C and after approx. 60 min. at +50°C.

Cured RELEST Wind Gelcoat transparent is sandable after removal from the mould.

Gelcoat surfaces must be sanded prior to reworking in order to reliably remove any adhering parting agent residues.

(*) Due to the heat of reaction released (exothermicity) the workable life strongly depends on the mixed/remaining material quantity.

Only mix small quantities at a time because of the product's relatively short workable life.

For optimum application and drying characteristics, the air and substrate temperature should be greater than 10°C (50°F) and relative humidity less than 85%. Good air flow and ventilation should be maintained to improve drying and recoat properties and speed up the application. Application at temperatures below 10°C (50°F) will retard drying and extend overcoatings intervals, as will higher humidities.

Surface temperature must always be a minimum of 3°C (5°F) above dew point.

This transparent coating must be overcoated with at least one coloured, weather-resistant topcoat.

Shore A hardness (24 h at +50°C) Approx. 75

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

SYSTEMS COMPATIBILITY

For suitable primers/intermediates, consult your local representative.

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ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult your local representative for further advice.

Warning: Contains isocyanate. Wear air-fed hood for spray application.

PACK SIZE

SHIPPING WEIGHT (TYPICAL)

STORAGE	Shelf Life	18 months minimum at 25°C (77°F) in original, unopened containers. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition. Opened containers must be tightly resealed and material used promptly.
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Important Note

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

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