Iso-Flo Brushing Flowcoat Tech Data

Introduction

Iso-Flo Flowcoat is a pre-accelerated isophthalic flowcoat. It has been formulated for brush or roller application.

Iso-Flo Flowcoat is available in a restricted range of colours and the information contained in this leaflet applies to these versions.

Applications

Iso-Flo Flowcoat is recommended for use as a finish coat on glass laminate moulded composite articles which provides a cosmetically attractive finish.
Approximate coverage is 600gms per M2
It is always recommended to undertake a test panel to confirm colour and quality of finish before applying flowcoat to the job.

Features

Excellent flow/levelling properties · Rapid air release · Excellent water resistance · Good sag resistance · Excellent weathering resistance · High gloss retention · High degree of flexibility and general toughness

Benefits

Easy to control film thickness · Minimal air entrapment · Improved part quality · Reduced potential for blisters/osmosis · Increased tolerance to application variability · Improved article longevity · Superior appearance of article during its service life ·

Pot Life

The temperature, and the amount of catalyst affect the geltime, and hence the pot life of Iso-Flo. The table below shows the geltime of this relationship using 2% MEKP @ 25 degrees.

Season	Geltime In Minutes
Winter	14 - 18 mins
Summer	18 – 22 mins

It is not recommended to exceed a catalyst level of 3.0%

Curing should not be carried out at temperatures below 16°C. The flowcoat, article surface and workshop should all be at, or above, this temperature. H S Composites will not be liable for problems caused by use at lower temperatures than recommended.

Application: Do's

• Gently stir the flowcoat before use by hand or low shear mixer.
• Ensure the flowcoat has attained workshop temperature of 16°C-25°C before use.
• Recommended wet film thickness of 18 – 28 thou. This will minimise porosity and colour defects.

Application: Don't

• Stir the flowcoat with high shear mixers as this will temporarily break down the thixotropy leading to drainage.
• Exceed a wet film thickness of 18 – 28 thou as thick films encourage air retention.
• Apply excessive thickness in corner areas.

Properties Uncured Iso-Flo Flowcoat

Appearance	Varies Colours
Viscosity at 25°C	Thixotropic
Specific Gravity at 25°C	1.1
Volatile Content	46%
Geltime at 25°C Using 2% MEKP	14 - 18 mins
Flash Point	31

Note: Over time, with increased exposure to climatic/chemical conditions, some lightening of colour and reduction in reflective properties of the cured flowcoat – may occur.

Storage

Iso-Flo Flowcoat should be stored in the dark in suitable closed containers. It is recommended that the storage temperature should be less than 20°C where practical, but should not exceed 30°C. Ideally, containers should be opened only immediately prior to use. Where they must be stored outside, it is recommended that drums be kept in a horizontal position to avoid the possible ingress of water. Wherever possible, containers should be stored under cover.

Hazards:

Personal Protection:

For further information check the full SDS for this product.