

Description

APG 1750 S is a blend of specially formulated high temperature resins, color pigments, and additives designed to produce high gloss mold surfaces. APG 1750 S allows for rapid build-up of gel coat and gives hard, durable, impact and chemical resistant tools and molds. Back-up reinforcement may be applied after a firm gel is obtained. This normally takes about 75 – 115 minutes after application. It is most commonly used in high temperature tools for epoxy infusion, cultured marble molds, thermoforming molds, FRP molds, and RTM mold repair. It contains no styrene and is low odor.

Properties

- High gloss
- Rapid build up
- High service temperature
- Styrene-free
- Impact and chemical resistant
- Excellent finishing and machinability
- Epoxy backing materials bond well

PHYSICAL PROPERTIES				
		APG 1750 S	MEKP Hardener	Mixed
Composition		Polyester Resin	MEKP	
Mix ratio – by weight		100	2	
Aspect		Liquid	Liquid	Liquid
Color		Orange or Black	Colorless	Orange or Black
Density at 77°F (25°C)	g/cc (lbs./gal)	1.30 (10.7)	1.20 (10.00)	1.30 (10.7)
Thixotropic index		7.2		
Pot life (102 g) at 77°F (25°C)	minutes			22

Processing Conditions

- Thoroughly blend 100 parts resin with 2 parts catalyst at indicated ratio for 1 to 1 ½ minutes in a clean dry container.
- Carefully scrape the surfaces while blending to ensure complete mixing and uniformity.

Surface Preparation and Application

- APG 1750 S should always be applied to properly prepared surfaces with mold release applied to surfaces as necessary.
- Product is designed to be applied by brush, flow coating or spray (has been successfully applied with an ES Manufacturing G860 HVLP spray gun at 40-60psi with a 2.5mm nozzle).
- For best performance, APG 1750 S should be sprayed in multiple passes of 0.003 – 0.006 inches (0.07 – 0.15 mm) film thickness each to a final film thickness of 0.025 inches (0.6 mm). Wait 2 – 3 minutes between passes. This technique minimizes air entrapment and pinholes in the gel coat.

MECHANICAL AND THERMAL PROPERTIES⁽¹⁾

Hardness at demold	ASTM D-2240	Shore D	87
Coefficient of thermal expansion	ASTM E-1545	ppm/°F (°C)	67 (120)
Service temperature		°F (°C)	400 (204)

⁽¹⁾ Average values on standard specimens cured 3 hours at 302°F (150°C)

Storage Conditions

This product has a shelf life of 6 months as indicated by the expiration date on the container when stored in original unopened containers between 59 – 77°F (15 – 25°C). Any opened can must be tightly closed.

Handling Precautions

Normal health and safety precautions should be observed when handling these products :

- *Ensure good ventilation*
- *Wear gloves, and safety glasses.*

For further information, please consult the material safety data sheet.

Guarantee

The information contained in this technical data sheet result from research and tests conducted in our Laboratories under precise conditions. It is the responsibility of the user to determine the suitability of AXSON products, under their own conditions before commencing with the proposed application. AXSON guarantee the conformity of their products with their specifications but cannot guarantee the compatibility of a product with any particular application. AXSON disclaim all responsibility for damage from any incident which results from the use of these products. The responsibility of AXSON is strictly limited to reimbursement or replacement of products which do not comply with the published specifications