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Product Information

Elan-tech®

ADD-UP2

**Compatibilizing additive for polyester-vinylester gelcoat
and Elan-tech® epoxy resins**

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- Application:** Compatibilizing additive for ISO; ISO-NPG and Vinilester gelcoats with epoxy resin.
- Processing:** ADD-UP2 must be added to the gelcoat/resin according to the instruction. In case a skin-coat is applied behind the gelcoat, ADD-UP2 is always introduced in the same %, only in the last layer of polyester resin or vinyl ester.
ADD-PU2 is also used in spray paint applications with polyester or vinyl ester gelcoat **(always paraffin free)** and for the finishing of printed composite articles without gelcoat. The surface of the gelcoat will look bright and tack-free, ready to be sanded or polished.
- Description:** The additive is a specific formulation that once introduced in the last polyester resin layer, increases the curing speed of gelcoat and blocks the emission of styrene, promoting a perfect adhesion of the epoxy resin applied immediately after or even after long time, according to the process (lamination, RTM, infusion, casting, etc.). ADD-UP2 does not interfere with the standard performance of the product (light resistance, water resistance, chemical resistance, hardness, sanding, self-extinguishing, etc.). It is also suitable for transparent and colored gelcoat and helps to maintain a higher gloss of the colour. The system is RoHS compliant (European directive 2002/95/EC) and the new RoHS Directive 2011/65/EU (RoHS 2) entered into force on 21 July 2011 and requires Member States to transpose the provisions into their respective national laws by 2 January 2013.
The polyester gelcoat/epoxy adhesion tests were conducted by “Centro Tecnologico Sperimentale” Laboratory of Ceparana (SP - Italy) and their test report n° 13916A is available on request.

TYPICAL PRODUCT CHARACTERISTICS

Aspect		Opalescent Liquid	
Viscosity at 25°C	IO-10-50 (ISO3219)	10 - 20	mPas
Density at 25°C	IO-10-51 (ASTM D 1475)	0,84 - 0,90	g/ml
Solids Content		26 - 28	%
Weight ratio on 100 g of gelcoat or ISO, ISO-NPG resin		1,8 - 2,2	g

Instructions

ADD-UP2 is an opalescent liquid that could separate in two phases and partially solidify with temperatures below 25°C. Prior to use the product has to be heated above 25-30°C and homogenised. The 0,450 Kg package is ready for use for standard 20-25 Kg tin of gelcoats or polyester resins. If the additive is used partially homogenize and the close the package immediately after sampling. Suggested amount is 1,8-2,2% (Wt/Wt) on gelcoats. **If used in polyester laminating resins the additive has to be introduced only in the last lamination layer.**

Pour ADD-UP2 in the gelcoat and mix thoroughly. The resulting gelcoat, could also be used after 2-3 weeks. **After a long storage of the products, homogenize carefully before use especially on low viscosity resins.**

ADD-UP2 slightly accelerates the product compared with standard. It is therefore possible to proceed with the lamination of the epoxy resin already after 1 hour after gel, or even up to 48 hours after. Avoid ambient and products temperatures below 20°C. The use of preheated moulds, optimizes the production cycles and improves the properties of the final composite.

Storage

Additive is solvent based. Store in the manner required by safety regulations.

ADD-UP2 can be stored for two years in the original sealed containers stored in a cool, dry place.

Handling precautions:

Do not use gelcoat containing paraffin or internal mould release.

ADD-UP2 provides excellent adhesion of the epoxy gelcoat on polyester or vinyl ester resins. Nevertheless, due to the large number of brands and products on the market and different methods of application, it is advisable to always carry out a test before using the product on a production cycle.

Consult the MSDS and follow the provisions relating to industrial hygiene and waste disposal.

Emission date: March 2016
Revision n.01

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