

PRODUCT DATA SHEET

SikaBiresin® GC108

Epoxy gelcoat with very good heat resistance and polishable properties

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	Component A SikaBiresin® GC108	Component B SikaBiresin® GC08
Chemical base	Epoxy resin, filled	Amine, unfilled
Color	Black	Amber
	mixed	Black
Density	1.21 kg/l	1.0 kg/l
	cured	1.22 kg/l
Mixing ratio	by weight	100 : 20
Viscosity (CQP029-4 / ISO 3219)	Pasty	130 mPa·s
	mixed	25 000 mPa·s
Pot life (CQP021-4)	200 g at 23 °C	30 minutes
Tack free time (CQP019-3)	at 23 °C	60 minutes
Demolding time	earliest after	16 hours
Shore D hardness (CQP023-1 / ISO 868)	86 ^A	
Flexural modulus (CQP027-2 / ISO 178)	3500 MPa ^A	
Flexural strength (CQP027-2 / ISO 178)	90 MPa ^A	
Impact resistance (CQP038-2 / ISO 179)	9 kJ/m ² ^A	
Compressive strength (CQP028-5 / ISO 604)	120 MPa ^A	
Heat deflection temperature (CQP030-1 / ISO 75B)	130 °C ^A	
Glass transition temperature (CQP301-5 / ISO 11357)	134 °C ^A	
Shelf life	24 months	12 months

CQP = Corporate Quality Procedure

^{A)} curing condition: 120 °C for 4 hours

DESCRIPTION

SikaBiresin® GC108 is a 2-component epoxy gelcoat with very good heat resistance and polishable properties.

PRODUCT BENEFITS

- Polishable to high gloss (up to gloss value 85)
- Good grindability
- Heat resistance up to 130 °C
- Dense surface and good edge stability
- Good styrene resistance

AREAS OF APPLICATION

SikaBiresin® GC108 is designed for manufacturing of master models, gauges and vacuum forming tools.

The Product is also well suited for production of negative molds in composites industry.

This product is suitable for experienced professional users only.

Tests under actual processing conditions and with additional materials such as coatings and release agents must be performed to proof material compatibility.

METHOD OF APPLICATION

Surface preparation

The material, processing and mold or master-model temperature shall be between 18 °C and 25 °C.
Make sure the mold or master model is clean, dry, dust and grease free.
If mold or master-model surface is porous, it must be sealed prior applying the release agent. It is recommended to use wax-based release agents. For further information regarding Sika release agent consult the corresponding Product Data Sheet.

Mixing process

Prior to use check the material for homogeneity and crystallization.
After prolonged storage at low temperature, crystallization of components may occur. This process can be easily reversed by heating the affected component to a maximum of 70 °C until the crystals have disappeared. Allow to cool down to requested processing temperature before use.
Component A must be stirred thoroughly before use.
Both components must be mixed homogeneously respecting the defined mixing ratio. The mixing can be performed with a spatula or a machine stirrer at ≤ 300 rpm.
Note: Both containers must be closed tightly immediately after use to prevent moisture ingress.
Once opened the Product shall be used as soon as possible.

Application

Apply the gelcoat to the mold in a uniform thickness using a flat, short-haired brush. The material must be applied in a uniform direction to produce a homogeneous, gap-free surface layer.

The product shall be processed immediately after mixing. Direct pouring of the mixed product onto the mold surface may cause surface imperfections and adversely affect the surface quality of the cured material.
A coupling layer or other backfill layer shall be applied as close as possible to the tacky phase to ensure proper adhesion and prevent bonding issues. Tack-free time depends on application thickness, room and mold temperature.
Post-curing of the finished part at 120 °C for 4 hours improves the resistance of the gelcoat in respect of temperature, solvents and water.
Note: The post-curing requires a slow temperature increase and decrease process.
Depending on the geometry and weight of the part, it is recommended to use a counter-part (conformer) during post-curing.

STORAGE CONDITIONS

Both components must be stored at temperature between 15 °C and 25 °C in original unopened containers.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.
Copies of the following publications are available on request:

- Safety Data Sheets

PACKAGING INFORMATION

SikaBiresin® GC108 (A)	
Pail	8 kg
SikaBiresin® GC08 (B)	
Canister	1.6 kg

BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

DISCLAIMER

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

