



**POLYCRYL  
CORPORATION**  
EarthGuard Resins  
and Gel Coats

## Data Sheet

**POLYCRYL  
CORPORATION**

260 Pierce Rd.  
Oakland Tennessee 38060  
Tel: (901) 465-3330  
Fax: (901) 465-9992  
Sales@polycrylcorp.com

***EarthGuard DiamondBack***  
***High Temperature 602HT Series Vinyl Ester Hybrid***  
***Tooling Gel Coats***  
***(Orange, Green, Black)***

***EG-602 HT High Temperature Tooling Gel Coat is a vinyl ester, acrylic modified formulation.*** These gel coats are formulated specifically to meet the stringent high temperature specifications of the Marine and Transportation markets. Polycryl gel coats are formulated for spray with standard pressure pot equipment or air assisted airless equipment. Please refer to the “Polycryl Tooling Gel Coat Application Guide” before applying these products. Unacceptable results can occur when used improperly.

## Features

- High Temperature Phenolic Epoxy Enhancement
- Superior Gloss and Chemical Resistance.
- High Heat Distortion Temperature.
- Excellent Cure, High Barcol.
- Low VOC, MACT Compliant.

## Properties

Viscosity-CPS	
LVF #4 @ 6	12,000 - 16,000
LVF #4 @ 60	1,600 - 2,200
LVF #4 @ 30	2,700 - 3,500
Thix Index	6.0 - 8.0
Gel Time @ 2.0% United Initiators 925H	18 - 26 min.
Gel to Peak	7 - 12 min.
Peak Exotherm-F/100 gm	375 - 405°
% HAPS	35 - 38%
934 Barcol 30 gram qt.Lid, 1hour	35 - 40
Barcol, 24 hours	40 - 45
Wt./Gal	9.1 - 9.3 lbs.

DISCLAIMER: The data on this sheet represents typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Polycryl assumes no obligation or liability for use of this information. UNLESS POLYCRYL AGREES OTHERWISE IN WRITING, POLYCRYL MAKES NOT WARRANTIES, EXPRESS OR IMPLIED, AND DISCLAIMS ALL IMPLIED WARRANTIES INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR FREEDOM FROM PATENT INFRINGEMENT. POLYCRYL WILL NOT BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES. Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option.

## Application

1. Agitate slowly but thoroughly and bring temperature into 70-80° degree range.
2. Catalyze at 2.0% with United Initiators 925H or Akzo Nobel L50a, no equivalent. No reduction or other additions are necessary.
3. For best results apply with conventional air assisted airless equipment.

1840 – .1850 tip size.

Fluid pressure approximately 35 – 45 lbs.

For air assisted airless equipment, utilize approximately 25 – 35 lbs. of air assist.

Refer to the Polycryl Data Sheet---Typical Method to Pattern Air Assisted Airless Guns.

## Precautions

1. DO NOT apply excess or uneven film thicknesses as pre-release and or porosity may result.
2. Catalyzed masses will get extremely hot, volatilize and crack. Avoid catalyzed mass accumulations/waste as contact with skin or combustibles/flammables can result in injury or fire.
3. While these products do achieve a casting 934 Barcol hardness of 35 – 40, do not expect to read those figures if checking Barcol hardness of the tool itself. Barcol Impressors require 31 cured mils minimum to register the hardness of film. That thickness is not achieved from 30 or 40 wet mils with conditions of evaporation and shrinkage. A Barcol point/impressor may penetrate the Tool's gel coat and read higher if encountering glass or lower if resin.
4. Plugs, pumps, spray guns, and product containers should be properly grounded before use.
5. A good high quality high temperature paste wax or a liquid semi-permanent product is highly recommended.

## Stability-Shelf Life-Storage

These products are stable for 2 months if stored below 77 F and out of direct sunlight, in original **UNOPENED CONTAINERS**.

## Safety

1. This product contains styrene, acrylate and methacrylate monomers and all precautions required for those should be followed.
2. Refer to the appropriate MSDS and Technical Data Sheet for these products.
3. Refer to the product label precautions.
4. MEK Peroxide has its own hazards. The manufacturers MSDS / TDS should be consulted before use.