PRODUCT BULLETIN

February 2020

IMEDGE® 210 Series

High Performance Barrier Coats

DESCRIPTION

IMEDGE® products are high performance **I**n-**M**old cutting **EDGE** polymer technologies that offer unique and revolutionary alternatives to conventional FRP materials. The IMEDGE® technologies were developed to promote and drive innovation in the FRP industry. The IMEDGE® product line represents Polynt's commitment to be a leader in the industry through technology, sales, technical and customer support.

IMEDGE® 210 Series are high performance barrier coats formulated for use behind IMEDGE® in-mold coatings and conventional gel coats.

BENEFITS & FEATURES

- Enhanced impact resistance and toughness for reduced cracking
- Excellent water and blister resistance
- Improved surface quality through reduced fiber print and distortion
- Rapid cure for improved productivity
- Blue color provides a visual aid for thickness control and for air void elimination during lamination

PROPERTIES – LIQUID

Property(1)	Unit	210LK292	210LD137
Viscosity(2)	cps	15,000	15,500
Thix Index	-	6.5	6.0 (Min.)
Gel Time(3)	minutes	10	9.5
Total VOC	%	38	38
Lay-up Time	minutes	45	45
Sag Resistance	mils	50 (Max.)	50 (max)
Weight per Gallon	lbs/gal	9.3	9.45

1) All properties at 25°C/77°F unless otherwise noted
2) Brookfield Viscometer RVT Spindle #4 at 4 RPM
3) 2% United Initiators Norox® MEKP-925H

APPLICATION

For best cosmetic results, the exterior coating or gel coat should be allowed to cure until tack-free prior to IMEDGE® 210 application. The recommended application film thickness for IMEDGE® 210 is between 25 and 40 mils wet. Use of the maximum recommended film thickness will result in the most significant blister resistance, crack resistance and cosmetic benefits. Avoid wet films under 20 mils. Use multiple passes (typically 2-4) to build up the thickness. Some of the passes should be made perpendicular to ensure even coverage.

At a minimum, IMEDGE® 210 should be allowed to gel, exotherm, and cool down to ambient temperatures prior to lamination. This typically takes 45-60 minutes. For best cosmetic results, IMEDGE® 210 should be allowed to cure for a longer period of time prior to lamination. A cure time of 90 minutes is sufficient at 70-80°F. Cure times are dependent on material temperature, room temperature, humidity, air movement, and catalyst concentration. Longer cure times may be required if temperatures are cooler.

For best adhesion results, laminates should be applied to IMEDGE® 210 within 6 hours of application. However, acceptable adhesion may be achieved after longer IMEDGE® 210 open times. Each customer should test adhesion under their specific shop conditions and with their specific materials.

Refer to Polynt's Composites Applications Guide ("Cookbook") for equipment, application, and repair recommendations. Each user must determine the suitability of this product to his/her particular mode of operation and intended end-use application. A Polynt representative will be available to assist in the proper selection of all Polynt-Reichhold products available for commercial use.

SHELF LIFE & STORAGE

The shelf life of IMEDGE® 210 is 60 days from the date of manufacture from Polynt. To maximize usage life and maintain optimum properties, resins and gel coats should be stored in the original closed container at temperatures below 23°C/73°F and away from ignition sources and sunlight. Keep containers sealed to prevent moisture pick-up and monomer loss.

SAFETY & WARRANTY

To receive a copy of our safety and warranty information, please email safetyandwarranty@polynt.com.