



# ORCA GUARD

## Description:

ORCA Guard is an ISO NPG, thixotropic, polyester gel coat designed for cosmetic concealment of small to large FRP parts at an ambient temperature. Orca Guard is pre-promoted for curing at room temperature with the addition of methyl ethyl ketone peroxide (MEKP) initiator. Orca Guard is designed to be used with both the spray-up and hand lay application technique.

## Features:

- Good Weather Resistance
- Good Heat Resistance
- Good Water Resistance
- Good Workability
- High Gloss Finish

## Uses:

- Yacht/Boat Construction
- Manufactured parts
- Spray up process
- Hand Lay-up application
- Mold Construction

## TYPICAL PROPERTIES \*1

### Uncured Resin

Test	Value
Viscosity, 77" F	2200-3100cps
Specific Gravity, 77" F	
Curing Property, 77" F,	2% MEKP 9% active
Gel Time	14-16 minutes
Time to Peak	10 minutes
Peak Exothermic Temp.	350-390' F

\* 1. Values are representative.  
Specification limits are available upon request.

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## Orca Guard Gel Coat

### Handling & Storage

As with all polyester resin, rate and degree of cure are a function of initiator concentration and of temperature. Resin and work area should be between 70°F and 95°F to ensure satisfactory results. Initiator levels should be within a range of 1.0-3.0% based on weight of resin. The use of initiator levels outside of this range may result in an inadequate cure, with laminates exhibiting moderate to severe post cure after demolding.

Orca Guard is available in 55-Gallon metal drums.

To ensure maximum stability and maintain optimum resin properties, resins should be stored in closed containers at temperatures below 75°F and away from heat sources and sunlight. All storage areas and containers should conform to local fire and building codes. Drum stock should be stored away from all sources of flame or combustion. Inventory levels should be kept to a reasonable min with first-in, first-out stock rotation.

### Safety

Read and understand the Material Safety Data Sheet before working with this product

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Orca Composites - 22 S Idaho St Seattle WA, 98134 (800)942-0660