



Lilly-Ram Chemical Company, LLC  
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Ram's Gelcoat technology significantly reduces styrene emissions, shrinkage, and costly overspray.

In addition to lower emissions and shrinkage, Ram gelcoat yields improved weatherability and osmotic blister resistance when compared to similar conventional gelcoats.

**Advantages:**

- 50% Less Styrene Emissions
- 30-60% Less Shrinkage
- Reduced Overspray
- Ease of Application
- Enhanced Weather ability
- Crack resistance
- Osmotic Blister Resistance
- Long term durability
- UV light stability

**UNCURED GELCOAT PROPERTIES**  
 (All properties based on 2.0% MEKP)

- Gel time @ 77°F .....10-12 min.
- Gel to peak.....8 - 10 min.
- Film cure @ 77°F .....45 max.
  
- Visc. @ 77°F  
 (LVF #4 @ 60rpm-cps).....3000 - 3500
- Thix index (6/60).....5.0 -6.25
- Sag resistance.....20 - 25 mils
  
- Hegman grind .....4 minimum
- Weight per gallon.....10.0 – 12.0 lbs
- Stability @ 77°F  
 Closed Container.....2 months
- Hide @ 15 mils (wet).....complete

**CURED GELCOAT PROPERTIES**

- 'Y Flex elongation  
 ASTM D790.....1.5 – 1.7%
- 'Y HDT ASTM D648.....175 - 190°F

**TYPICAL APPLICATIONS** Marine, sanitary ware, wind blades recreational vehicles, and other open mold hand lay-up applications.

**COLORS**

A range of colors as well as custom colors are available on short notice. Using computer spectrophotometry, Ram can match your color sample.

Ram gelcoats are intended for use under controlled industrial conditions and are not recommended to be used below 70°F.

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