BERGOLIN GELCOAT 2D3800

Series 2D3800 · Solvent-borne 2K PU gelcoat (clearcoat) for the surface finishing of visible-carbon components (CFRP/GRP)

01 PRODUCT DESCRIPTION

Bergolin Gelcoat 2D3800, colorless is a high-quality, solvent-borne, styrene-free two-component polyurethane gelcoat (clearcoat) for the surface finishing of high-quality visible-carbon components made of CFRP and GRP. The material can be applied both as a gelcoat in the mould process (applied into the mould before laminating) and as a clearcoat directly onto the finished component, and is suitable for epoxy, polyester and vinyl ester resin systems. It creates a unique depth effect, brings out the fibre structure to full effect and forms a crystal-clear, high-gloss (or matt), low-yellowing surface with high UV stability and very good resistance to weather, water, chemicals, heat and cold. It also offers high bonding strength without an adhesion promoter and very good grindability and polishability. Typical fields of application are visible-carbon components (e.g. bodywork, spoilers, door sills, interior) as well as sports and leisure equipment (e.g. golf clubs, tennis and hockey rackets).

02 PRODUCT PROPERTIES

Binder system	Polyurethane
Hardener system	Aeroglide Hardener 7D3800
Cleaning thinner	Superdur Thinner 5D402
Characteristics	Transparent · Grindable & polishable · UV & weather resistant · Chemically resistant · Excellent adhesion
Color shade	Colorless
Gloss	High gloss or matt
Shelf life	Approx. 12 months in the unopened original container at +4 °C to +40 °C. Protect from frost and moisture.

Property	Comp. A	Comp. B	Mixture
Density · DIN EN ISO 2811-1 · +20 °C	Approx. 1.00–1.05 g/cm³	Approx. 1.02–1.08 g/cm³	Approx. 1.01–1.06 g/cm³
VOC content · IE Directive 2010/75/EU	Approx. 611 g/l	Approx. 357 g/l	Approx. 562 g/l
Solid content (wt.-%) · SDS	Approx. 40 %	Approx. 59 %	Approx. 42 %
Flow viscosity · DIN EN ISO 2431 · +20 °C	Approx. 25–35 s (4 mm)	Approx. 16–20 s (4 mm)	Approx. 20–25 s (4 mm)

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03 APPLICATION

The following information may vary depending on the application. Please contact your direct contact person for more detailed information.

Substrate	CFRP / GRP (further substrates on request)
Surface preparation	The surfaces to be coated must be clean, dry, load-bearing and free from contamination (e.g. oil, grease and dust). Release-agent residues must be removed completely. The substrate must be mechanically sanded. Use suitable abrasive paper with a grit of x–x. After sanding, remove all sanding residues completely.
Mixing ratio	100 : 15 by weight | 7 : 1 by volume
Mixing	Add the hardener component completely to the base component and mix intensively for approx. 1 min.
Theoretical consumption	Approx. 90 g/m² at 40 µm dry film thickness (substrate-dependent)
Application method	Gravity cup gun

SPRAY CONDITIONS

Parameter	Gravity cup gun
Recommended atomizing pressure	4–5 bar
Recommended spray nozzle	1.5–1.6 mm

Application conditions	**Application temperature** ≥ +15 °C (above +20 °C accelerated curing) **Relative humidity** 20–80 %
Pot life[*1]	Approx. 6–8 h
Lamination interval[*1]	Approx. 6–72 h

DRYING[*1]

Dust-dry	Approx. 1 h
Tack-free	Approx. 6 h
Overcoatable	Approx. 24 h
Fully cured	Approx. 10 days
Forced drying	Approx. 1 h at +80 °C or 30 min at +120 °C

[*1] *Values are based on laboratory measurements at +20 °C. Lower temperatures slow down drying; higher temperatures accelerate it. For optimum adhesion between gelcoat and resin we recommend tempering the component directly after resin infusion; please coordinate the tempering parameters with Bergolin Technical Service.*

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04 NOTE

This product data sheet supersedes all previously published product data sheets. The information contained herein is based on practical experience under standard conditions and assumes proper storage and processing. Substrates, materials and working conditions may vary. Therefore, no warranty or liability can be derived from the information contained in this document or from verbal consultation. It is the buyer's responsibility to verify the product's suitability for the intended use. Preliminary trials are recommended. The relevant legal regulations, the leaflets of the BG RCI and the accident prevention regulations of the responsible employers' liability insurance association must be observed. In all other respects, our General Terms and Conditions of Sale and Delivery apply.

MODIFIED BY
24.08.2026 – Martin Krull, Head of Laboratory

APPROVED BY
24.08.2026 – Stefan Eisenmenger, Product Management