

Gelcoat Repair Kit

For Industrial Components

Before You Begin

- Open the package carefully to avoid damaging the contents.
- Verify that no damage occurred during shipment.
- Make sure all items pictured are included in the kit before beginning the repair.

Considerations

- Working time is about 20 minutes after catalyzing the gelcoat resin at an ambient temperature of 70° F (21° C).
 - Working time decreases with increased temperature.
 - At 90° F (32° C), the working time is only about 10 minutes.
 - Working in direct sun will also decrease working time.
- After the repair, use acetone to clean the bristle brush before the gelcoat hardens. If not cleaned, the bristles will become hardened and the brush will be unusable.

Safety Precautions



IMPORTANT Follow these precautions:

- Use appropriate personal protective equipment (PPE) when handling gelcoat and catalyst, including gloves and eye protection.
- Read and follow all precautions described in the Safety Data Sheets supplied with this kit.
- Leftover catalyzed gelcoat in the mixing container will generate heat as it hardens and can get very hot. Place container in a safe place away from combustible materials, and make sure it has cooled down before disposal.

Step 1. Gather Other Items Needed for Repair

Gather the following items:

- Sandpaper (60 or 80 grit)
- Acetone
- Clean rag
- Painters' masking tape
- Paint roller

Contents of Kit



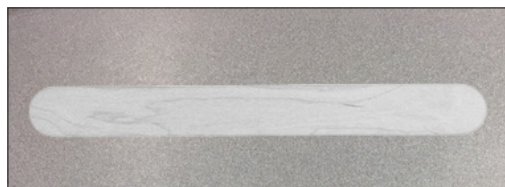
Gelcoat



Catalyst



Mixing Container



Tongue Depressor



Bristle Brush (natural bristles)



Roller Cover

Step 2. Prepare the Surface(s)

Step 2a. Abrade the damaged surface(s) with 60 or 80 grit sandpaper. If gelcoat is loose or peeling, scrape or grind it away until solidly bonded gelcoat is reached.

Step 2b. Taper the edges of the gelcoat surrounding the sanded area.

Step 2c. Wipe the area with a clean rag dampened with acetone to remove dust and contaminants.

Step 2d. Do one of the following:

- Tape off area to be gelcoated.
- Prepare to feather the new gelcoat into the existing gelcoat of the surrounding areas by sanding additional areas to achieve proper bonding.

Step 3. Prepare the Gelcoat

Note The kit is pre-measured at a gelcoat-to-catalyst ratio of 50:1 (2% catalyst). If less than the full kit is needed, add 2% catalyst by weight to the gelcoat, or simply proportion the kit. For example, use 50% of the supplied catalyst with 50% of the supplied gelcoat.

Step 3a. Pour the gelcoat into the mixing container.

Step 3b. Pour the catalyst into the mixing container.

Step 3c. Mix well with the tongue depressor for at least 60 seconds.

Step 4. Apply the Gelcoat

Step 4a. Use the supplied bristle brush to apply gelcoat to the repair surface. Do not apply the gelcoat thicker than 0.02 in. (0.5 mm) per coat.

Step 4b. Use a paint roller with the supplied roller cover as a dauber to create the desired texture.

Step 4c. If a second coat is needed, let the first coat dry, then sand it before applying a second coat. Do not exceed 0.03 in. (0.76 mm) in total thickness. A typical credit card is about 0.03 in. thick (0.76 mm).

Step 4d. Allow to dry until gelcoat is fully hardened.

Step 5. Clean Up

Step 5a. Place mixing container, tongue depressor, and roller cover in a safe place away from combustible materials while the gelcoat cools down.



IMPORTANT Leftover catalyzed gelcoat can get very hot.

Step 5b. To prepare the bristle brush for possible reuse, clean it with acetone before the gelcoat hardens. Otherwise, place it with the other items to cool down.

Step 5c. After the gelcoat has cooled and hardened, dispose of the used items.