

Application Guide



Repair Application: *Gelcoat*

Use these Duratec® products to repair clear or pigmented gelcoated FRP parts:

Duratec Polyester Hi-Gloss Additive (904-001 Clear)

Duratec Thinner (39LAC-1)

The end result is a low porosity, smooth, high-gloss, hard surface that is similar in appearance to the original gelcoat surface. Duratec Polyester Hi-Gloss Additive will reduce subsurface porosity and orange peel, increase impact resistance, improve gloss retention and elevate heat distortion temperatures.

Application Conditions

The surface should be clean, dry and free from oil, grease, wax or other contaminants. Ambient temperature should be in excess of 60°F, 16°C to ensure a rapid and complete cure. Time calculations are based on temperatures of 77°F, 25°C.

Surface and Product Preparation

Thoroughly sand the area to be repaired to a 120 or 180 grit finish.

Blend and mix completely equal parts of Duratec Polyester Hi-Gloss Additive and the gelcoat required for the repair or overspray. Catalyze at 2 percent with mekP catalyst (20 cc per quart). Thin 5-10 percent if necessary to a desired spray viscosity with Duratec Thinner or mek solvent.

Application Procedures

Spray the entire surface to be repaired with a fine mist coat and wait 2 minutes for the solvents to flash off. Follow with wet coats, overlapping the surrounding area to ensure complete coverage. When re-spraying large areas, keep a wet edge as with gelcoat spray techniques.



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Notes:

- ❑ Spray pressures should be 35-50 psi. If a pressure pot is used, provide 10-15 psi pot pressure.
- ❑ Do not inhibit the cure by adding wax surfacing agents. The combined gelcoat and Duratec Polyester Hi-Gloss Additive will air cure to a hard, glossy finish in approximately 1-2 hours. (Apply forced-air heat for a 30-minute cure time.)

Lightly sand the repaired area with 320-800 grit sandpaper, either wet or dry, and buff to the desired finish, ensuring that the newly gelcoated area is blended with the surrounding gelcoat surface.

Use Aqua-Buff 1000-F Fast Cut Compound and Aqua-Buff 2000 Compound/Polish to achieve swirl mark-free finish.

SAFETY PRECAUTIONS: Duratec Polyester Hi-Gloss Additive and Duratec Thinner are extremely flammable. Do not apply near sparks, open flame or heat. Keep area ventilated. Do not smoke. Avoid continuous breathing of vapor. Do not take internally.



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