



Duratec Clear Hi-Gloss Gel Coat Additive

Usage: Blended with gelcoats for gelcoat repairs; blended with tooling gelcoats to upgrade mold surfaces.

Features:

You'll get a superior finish, add quality and save time and labor with Duratec Hi-Gloss Additive. Here's why you should choose # 01040-B Hi-Gloss Additive-
Low Porosity - when used for repairs, blending the additive with gel coat produces a low porosity surface.

Reduced Orange Peel - the low viscosity of the blend results in a smooth finish that is easily sanded.

Improved Properties - for mold surfaces, the blending of the additive with tooling gelcoat creates a higher heat distortion temperature, improved gloss retention, increased impact resistance, and reduced subsurface porosity.

Superior Finish - when blended one-to-one with gelcoats, the additive creates an air cure, enamel-like coating. No air-dry additive is required. When used for gelcoat repair, surfaces are restored to like-new condition.

Product Properties:

Viscosity: As measured on a Brookfield Viscometer Model RVF, Spindle #2 at 20 rpm. 110 cps

Thixotropic Index: 1

Gel Time: Sample based on a 100 g mass, catalyzed at 2 percent with MEKP 16-20 min

Weight per Gallon: 8.0 lbs

Volatile Organic Compounds: 198 g/l

APPLICATION GUIDELINES

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 degrees F, or 16 degrees C to ensure a rapid and complete cure. Time calculations are based on temperatures of 77 degrees F.

SURFACE AND PRODUCT PREPARATION- GEL COAT REPAIR

Thoroughly sand the area to be repaired to a 80-180 grit finish.

Blend and mix completely equal parts of Duratec Polyester Clear Hi-Gloss Additive and the gelcoat required for the repair or overspray. Catalyze at 2% with MEKP catalyst. Thin 5-10 percent if necessary to a desired spray viscosity with mek solvent or a fast acrylic lacquer thinner.

APPLICATION PROCEDURES - GEL COAT REPAIR

Note: Spray pressures should be 35-50 psi. If a pressure pot is used, provide 10-15 psi pot pressure. 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.

Note: Do not inhibit the cure by adding wax surfacing agents. The combined gel-coat and Duratec Polyester Clear 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 repair 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 our #01102-A and #01103-A Polishing Compounds with a #01104-A Buffing Pad to achieve a glossy swirl mark-free finish.

SURFACE PRODUCT PREPARATION - TOOLING GEL COAT UPGRADE

Blend 5-15% of Duratec Polyester Clear Hi-Gloss Additive to the tooling gelcoat. The viscosity and thixotropic properties of the gelcoat will determine the quantity to be added. (The higher the viscosity and thixotropic properties, the more additive is required.) After blending, catalyze at the rate suggested by the tooling gelcoat manufacturer.

APPLICATION PROCEDURES - TOOLING GEL COAT UPGRADE

Spray as recommended by the tooling gelcoat manufacturer. Due to the lower viscosity, an extra wet pass may be required to achieve wet coat total film thickness. Gel and tack times are comparable to the straight tooling gelcoat. Laminate as usual when the additive/tooling gelcoat blend "tacks off" to the thumbprint stage.

FREQUENTLY ASKED QUESTIONS

Q: If I use this product, do I still need styrene wax to get a complete cure in top coating situations?

A: No. For added insurance, you could spray PVA over the gel coat to provide another way to seal out the air. Only add styrene wax if performing boat hull repairs below the waterline.

Q: What is the advantage of using the Hi-Gloss Additive vs. styrene or styrene wax?

A: This product both thins and helps increase the gloss of cured gelcoats. It allows a full cure without wax, which must be removed by sanding.

Q: Will the Hi-Gloss Additive cause clear gelcoat to become cloudy?

A: No.

SAFETY PRECAUTIONS

Duratec Polyester Clear Hi-Gloss Additive is extremely flammable. Do not spray near sparks, open flame, or heat. Keep area ventilated. Do not smoke. Avoid continuous breathing of vapor or spray mist. Do not take internally. See MSDS for more details.