



Most re-sprayed gel coat will cure in 2-4 hours, although overnight cures are ideal. Begin wet sanding with the finest grit that will remove orange peel in the re-sprayed area. This will avoid unnecessary sanding scratches. Usually 320 or 400 grit wet paper is sufficient for the initial sanding. Wet sand to a 600 finish and buff with SM20 Buffing Compound and SM30 Polishing Compound.

Brushing

The major disadvantage of polyester coatings is that they cannot be applied in a perfect "self leveling" coat. It must be mechanically finished by wet/dry sanding and polishing if a factory mold finish is to be expected. Sand the entire surface to be coated with 150 grit sandpaper. If cracks or gouges are present, they should be repaired first. When sanding is completed, the surface should be free of flaws and perfectly smooth. Choose a good pure (natural) bristle brush with tapered ends. Avoid brushes that are either too stiff or too soft. For most work, a 3" or 4" wide brush will suffice. If there is a trim color, you should have a narrow trim brush on hand. Spectrum Color has many sizes of brushes available.

DO NOT WORK IN DIRECT SUNLIGHT

Choose a shady location or an overcast day. You should catalyze your material so that it cures as quickly as possible within your working time. Generally, mix one-pint batches. A good practice is to pour the mixed gel coat from the mixing container into another container used for application. This further assures that no uncatalyzed material is clinging to the sides of the pot.

"Lay on" the gel coat in a heavy thickness (about 10 mils) using horizontal strokes and working from top to bottom. Avoid re-brushing as this could remove the waxy surface additive. Remember to always lap wet. Generally, one heavy coat is sufficient. However, if you have opacity problems two coats may be necessary with a light sanding between coats. Once the coating (gel coat) has cured, it should be block sanded using a 250 wet grit paper to remove all brush marks and high spots. Following this, it should be wet sanded with 320, 400 and 600 wet grit paper, buffed, polished and waxed.

Important Troubleshooting Tips

1. Clean repair area and all tools with acetone prior to application
2. Pot life (amount of time for application of the product) shortens dramatically as you mix larger batch sizes. Keep in mind that you have a limited time to apply what you have mixed (usually between 5-15 minutes).
3. Measure catalyst accurately. Under- or over-catalyzed gel coat will cure slower and look faded or chalky.
4. Gel coat will not fully cure without adding a surfacing agent or over spraying with PVA
5. Do not work in direct sunlight
6. Check color thoroughly before applying
7. Store gel coat in a cool, dry place
8. Gel coat should be applied in temperatures of 60°F to 80°F
9. Always use eye and hand protection
10. Read all warnings on product labels

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Prepping the Boat

After deciding on what areas of the boat you will be repairing, take steps to cover and protect the rest of the boat from the gunwale up. When working on the deck or cabin, tarp off the adjacent areas. 3M and UV tapes are available from Spectrum Color.

1. Remove rails, cleats, louvers, snaps, striping tape, etc.
2. Using Blue UV tape, tape off adjacent gunwale molding, and deck fittings you are unable to remove. 3m fine line tape can be used
3. Remove seals from the edges of parts or fittings when doing a repair around that part or fitting.

Sanding

The heavier fast-cut grits (**40/80/100**) are used to feather sand and ground out a routed area prior to filling. Also, they are used for the first sanding of gouges, dock dings, scratches, and blisters. When sanding areas that have been filled with putty we suggest using 40 or 80 grit sandpaper, depending on how large the repair is. Once the fill area is level or contoured to the desired shape, sand with 220 grit paper to remove the course scratches from 40 or 80 grit. At this point, the repair is ready to prep and spray with gel coat. When sanding flat areas use a rubber block. Spectrum Color offers Spectrum LOOPS abrasives for best results.

Spraying

Gel coat may be thinned for use with Patch Aid only! Styrene Monomer & **Acetone are NOT recommended**. Do not use more than 5%-30%, by volume, of the patch aid (see chart) depending on type of gel coat and patch aid. Always add Patch Aid first then add the Catalyst (MEKP) and mix thoroughly. Over thinning will result in an inadequate thickness for full curing.

Please note: Gel coat requires the addition of **catalyst (MEKP)** at 2% by volume (77°F)

Measure catalyst accurately. Under- or over-catalyzation retards curing and causes fading and chalking.

Gel Coat will not fully cure without adding a surfacing agent. Polynt, HK & Inios Patch-Aid's® are recommended. Other options are Over-spraying with PVA before gel coat reaches its gel stage (5-10 min.) or adding 1oz per quart of surface seal.

Initially spray a cover coat as smooth and evenly as you can to cover your repair. This coat should be mostly in the repair area and may be repeated. Sanding between coats is not necessary unless a surfacing agent has been added to your gel coat. Once your repair is covered, feather a 'flow' or sanding coat on the masked-off area making layered passes to avoid a buildup of gel coat in any one area. Each of these coats may involve several passes. Be even and consistent in your gun movement, overlapping each previous pass slightly and not hesitating on the ends. When spraying to a radius, flow the gel coat to the tape. In open flat areas, layer passes. Final thickness should be 12-15 mils minimum or the gel coat may not fully cure.

As soon as you are done spraying, clean your sprayer fully with acetone.

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