

# Product Data



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## GEL COAT PATCHING PROCEDURE SPRAY APPLIED - MARINE

### I. Identification

- A. Minor gel coat scratches and/or dull areas may require only a buffing and polishing to restore their original appearance.
- B. Deeper scratches and imperfections in the gel coat can be sanded out and patched with a gel coat patching material, followed by sanding and polishing to restore their appearance
- C. Very deep gouges that extend through the gel coat may require a patch of the laminate, followed by a gel coat patch, prior to sanding and polishing.

### II. Tools & Equipment

- 1. Cup or beaker calibrated in cc's (cubic centimeters)
- 2. Standard eye-dropper
- 3. Acetone
- 4. I0550 Patching Additive
- 5. Sand paper & buffing materials
- 6. Siphon spray gun

### III. Preparation

Proper preparation of the area to be patched is a vital part of the restoration process.

Sand the area to be repaired with 400 grit paper with a Dual Action (DA) sander (hand sanding can be used in radii or small areas). Sand an area at least two times larger than the area to be repaired. Clean the sanded area with acetone until a dust free surface is achieved. Tape off surrounding areas to prevent overspray contamination. The exposed area should be at least three times larger than area to be repaired.

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## **IV. Application**

To obtain best results, all patches should be made with the same batch of gel coat used in the original manufacturing of the part. If this can be done, it will help assure a good color match to the original gel coat surface and aid in achieving a nearly "invisible" patch.

To 70 cc of gel coat stir in 30 cc I0550 patching additive. Less I0550 can be added if you wish to obtain a higher viscosity (thicker) material. The total must equal 100 cc's (i.e. If you use 10 cc of I0550, use 90 cc of gel coat). Do not use less than 10 cc nor more than 35 cc of I0550. Catalyze this material with 2.5 cc of MEKP-9 or RCI 46-702 organic peroxide.

Using a siphon gun, adjust the air pressure just above the point where it is "spitting". You want as low air pressure as possible to minimize "orange peel" and overspray. Using an "air brush" technique spray gel coat to area to be repaired. The gel coat should be applied the thickest directly over the area needing to be repaired. "Feather" the gel coat until you reach the edges of the sanded area. DO NOT spray all the way to the tape edges.

If time does not allow you to wait four hours to sand, heat patch with a heat gun after a waxy surface appears. Keep your hand to either side of the patch. Heat the patch and your hand. If you burn your hand, you are burning the patch. This could result in discoloration, of your hand and the patch. Allow the patch to cool before proceeding.

## **V. Sanding**

The cured patch is now ready to sand. Remove the tape. Wipe the patch with an acetone soaked rag to remove some of the wax. Wet sand the entire area with 400 grit paper. You can use a DA, but be careful not to sand too much. Sand from the center of the patch out. This ensures that the edges will not "roll up" and cause a "halo". Sand the entire area that you had taped off. When all overspray and "orange

peel" are removed, wipe area with acetone to remove all sanding dust. Wet-sand a slightly larger area with 600 grit sand paper to remove all 400 paper scratches. Wipe area with acetone to remove all sanding dust. Continue this (in 200 grit increments) until you have achieved your desired smoothness. The higher you go in paper size the more gloss the finished patch will have.

Buff the area with a high speed buffer and buffing compound that has grit larger than your last sand paper (i.e. buff with 2000 grit compound if your last paper was 1000 grit). Do not overheat the patch. Polish the patch with an appropriate polishing compound until desired gloss is achieved. Wax the patch to seal the surface.