

# Product Data



908 LENOIR ROAD • POST OFFICE BOX 1809  
HICKORY, NORTH CAROLINA • 28603-1809  
TELEPHONE (828) 328-1721  
TOLL FREE (800) 334-5975  
FAX (828) 328-4572

## I-0530 GEL COAT PATCHING ADDITIVE

I-0530 is especially formulated for use as an additive to polyester gel coats to permit easy application of the gel coat as a patching material. This additive reduces the viscosity/thixotropy of the gel coat thus permitting easier spray application to small areas with a touch-up or siphon spray gun. The I-0530 additive also helps to provide a relatively fast-curing, tack-free cure of the gel coat patch to facilitate ease of sanding without affecting the color of the gel coat patch. This additive permits a fabricator to use the same batch of gel coat for patching that was used to spray the initial part, thereby providing the best possible color match of the patch to the original part.

The suggested level of usage of I-0530 Gel Coat Patching Additive is 2-3% of the weight of the gel coat. Thus we recommend the following formula:

Gel Coat	100 Grams
I-0530 Additive	2-3 Grams
MEKP Hardener	2 Grams

Ideally we would like to see a patched area be allowed to cure overnight before sanding and buffing. This time period permits maximum cure and virtually eliminates any chance of discoloration of the patch due to sanding or buffing. This discoloration is sometimes seen as a "halo" effect around the patched area. If an overnight cure is not practical, it is up to the applicator to make sure that the patch has cured to a hard, tack-free surface. This should usually take 2-4 hours under normal ambient temperature conditions.

The use of the I-0530 Gel Coat Patching Additive will provide excellent leveling of the patched surface along with a hard, tack-free surface that will facilitate ease of sanding of the patched area.

I-0530 is a clear, amber liquid that should stay in solution but we do recommend shaking or stirring of the I-0530 prior to use to insure complete solution of the several ingredients in the additive. In some instances prolonged cold temperatures can cause the I-0530 product to become cloudy due to a cold temperature incompatibility of the ingredients in the additive. If this should occur, we recommend carefully heating the I-0530 liquid to a temperature of 90-100°F under agitation until a clear liquid is obtained. Storage at normal room temperatures of 65°F or above should be sufficient to maintain I-0530 as a clear liquid.

As stated before, the recommended level of I-0530 is 2-3% of the gel coat weight. We have determined, however, that one can use up to 5% of the additive in a gel coat, if needed, to provide a smoother, drier surface for sanding. Levels in excess of 5% of the gel coat weight should not be used as they could have an adverse effect on the color and cure of the gel coat patch.

I-0530 contains everything that is required to accomplish a good patching gel coat. We do not recommend the use of any other solvents, such as acetone, to accomplish a lower viscosity. If a lower viscosity patching material is necessary, we suggest above that one can increase the I-0530 level to 4 or 5% of the gel coat weight to accomplish this and still maintain a good balance of additives needed for a good patching surface.

We strongly suggest that a fabricator should try to patch a gel coat surface with the same batch of gel coat originally sprayed on that part. This helps to insure a good color match of patch to the original surface. If different batches of gel coat are used one can expect to occasionally see some slight color difference.