Spray YOUR GEL COAT LIKE paint



HI-GLOSS ADDITIVE

904-001 · THE PROVEN LEADER FOR GEL COAT REPAIR

& SAND TIL IT SHINES

5 Fast facts ABOUT DURATEC HI-GLOSS ADDITIVE

AIR CURE

Additive eliminates the need for air inhibitors like wax & PVA, creating a superior finish.

ELIMINATES LOW-GLOSS

Especially areas on the edges of repairs, like the low-gloss "donut" often seen in gel coat repairs.

BETTER PROFILE

Flat & smooth profile compared to un-modified gel coat or gel coat with wax & styrene.

FASTER & EASIER REPAIR

The air-cure blend created with gelcoat cures fast and hard, creating a shiny smooth surface that is easy to sand.

REDUCED POROSITY

Improves air release, thus preventing porosity in tooling gelcoat.

904-001 application guide

PREPARE

NOTE: A test blend is recommended, as every blend is unique and the cure must be tested and assured. The cure time of the blend will vary, as every gelcoat is different. Note the cup-gel time.

- Temperature should be at least 64°F. Low temperatures extend cure time.
- If repairing, remove or fix any cracked or damaged gelcoat. Grind out cracks down to the laminate. Repair laminate or assure the laminate is sound. We recommend Duratec Vinyl Ester Mold Repair Putty for laminate repair. Sand with 180 grit to a few inches outside the repair area. Bevel the edge of the existing gelcoat.
- Duratec High Gloss Additive will thin the gel coat, depending the gel coat and your blend ratio. Thinner material will flow and resist orange peel with a smaller tip (1.8 mm or less), where thicker material will clog and not disperse and a larger tip is better (2.0mm or higher).

BLEND INSTRUCTIONS

- Option One - 50/50 Blend: 1 part (50%) 904-001, 1 part (50%) gelcoat. Recommended for all repairs where opacity is not an issue.
- Option Two - 25/75 Blend: 1 part (25%) 904-001, 3 parts (75%) gelcoat. Recommended to maximize the hide (opacity).
- See our Technical Data Sheet online for other blend options, and troubleshooting support.

SPRAY

- Catalyze blend with full strength MEKP catalyst, like Norox 925 at a 2% mix ratio. Both the gel coat and Duratec require catalyst to gel and fully cure. Only catalyze the amount of blended material you will use before material gels (about 15 minutes) to avoid clogging gun.
- Spray 3-4 passes over the repair or surface area, building up 12-15 mils. Allow at least two minutes between passes. Do not allow the blend to cure beyond the sticky/thumbprint stage between coats.

SAND

- Sand when the surface has cured enough not to clog your paper. Start with the finest grit that is reasonable for the surface finish. With a good finish starting with 400 grit is possible.
- The surface must be open for at least 8 hours between initial sanding and start of polishing. The open time allows for styrene release and full cure.
- Sand with progressively finer grits like 400, 600, 800, 1000. Compound and polish with products formulated for gelcoat like Aqua Buff 1000 and Aqua Buff 2000.

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