

1040 Duratec Clear Hi-Gloss Gel Coat Additive



Overview: #1040 can be mixed 1:1 with regular gel coat to reduce viscosity, porosity, and permit a complete open air cure. The reduction in viscosity allows gel coat to be sprayed controllably through siphon and HVLP equipment, reducing sanding and polishing time.

Below the waterline repairs still need the addition of #71 Styrene Wax for maximum hardness

Available in gallons and 4 gallon cases.

Features & Benefits:

- 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 gel coat creates a higher heat distortion temperature, improved gloss retention, increased impact resistance and reduced subsurface porosity.
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- Superior Finish - When blended one-to-one with gel coats, the additive created an air-cure, enamel-like coating. No air-dry additive is required. When used for gel coat repair, surfaces are restored to like-new condition.

Typical Product Properties:

	#1040
Viscosity	110 CPS
Thixotropic Index	1
Gel Time	16-20 Min*
Weight per Gallon	8.0 lb.

*Sample based on a 100 gram mass, catalyzed at 2 percent with MEKP
All time calculations are based on temperatures of 77°F, 25°C

Application Conditions:

- The surface should be clean, dry and free from oil, grease, 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 an 80-180 grit finish. Blend and mix completely equal parts of Duratec Polyester Clear Hi-Gloss Additive and the gel coat 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 Duratec Thinner.

Application Procedure - Gel Coat Repair:

- 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 gel coated area is blended with the surrounding gel coat surface.
- Use our #01102-A and #01103-A Polishing Compounds with an #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 gel coat.
- The viscosity and thixotropic properties of the gel coat 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 gel coat manufacturer.

Application Procedures - Tooling Gel Coat Upgrade:

- Spray as recommended by the tooling gel coat 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 gel coat.
- Laminate as usual when the additive/tooling gel coat 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 gel coats. It allows a full cure without wax, which must be removed by sanding.
- Q: Will the Hi-Gloss Additive cause Clear Gel Coat to become cloudy?
- A: No.

Safety and Handling: Duratec Clear Hi-Gloss Gel Coat Additive is extremely flammable. Do not apply near sparks, open flames or heat. Keep area ventilated. Do not smoke. Avoid continuous breathing of vapor.

Duratec Clear Hi-Gloss Gel Coat Additive contains ingredients which could be harmful if mishandled. Contact with skin and eyes should be avoided and necessary protective equipment and clothing should be worn. Individuals should wash with soap and water before eating or drinking. For more detailed instructions on handling please see the MSDS sheet.

All containers should be properly labeled to prevent accidental ingestion or improper disposal. Individuals should reseal any partly used material back in the container. Store under cool, dry conditions and away from open flames and high temperatures. For more detailed instructions on storage please see the MSDS sheet.