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- Epoxy
- Resin
- Gel Coat
- Mat
- Woven Roving
- Cloth & Tape
- Biaxial
- Coring Material
- Polyurethane Foam
- Aerosil
- Talc
- Pigments
- Webbing Solution
- Styrene
- Acetone
- Brushes/Rollers
- Tools

DURATEC HI-GLOSS ADDITIVE

A superior product for gelcoat repair and for enhancing tooling gelcoat properties. Blend with gelcoats for gelcoat repairs; blend with tooling gelcoats to upgrade mold surfaces. You will get a superior finish, add quality and save time and labor with Duratec Clear Hi-Gloss Additive.

Why you should choose Duratec Polyester Clear Hi-Gloss Additive:

- ◇ Low Porosity-when used for repairs, blending the additive with gelcoat 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 gelcoat creates higher heat distortion temperature, improved gloss retention, increased impact resistance and reduced subsurface porosity.
- ◇ Superior Finish-when blended one-to-one with gelcoats, the additive creates an air-cure, enamel-like coating No air-dry additive is required. When used for repair, surfaces are restored to like-new condition.

APPLICATION GUIDE FOR DURATEC CLEAR HI-GLOSS ADDITIVE

GELCOAT REPAIR

The following procedure describes the use of the DURATEC CLEAR HI-GLOSS ADDITIVE in the repair of clear or pigmented gel coated FRP parts. Significant time and labor savings are generated; The end result is a smooth, high-gloss, hard surface repair that is similar in the appearance to the original gel coat surface. Ambient temperature should be in excess of 60°F to ensure a rapid and complete cure.

1) Thoroughly sand the area to be repaired to a 80-180 grit finish and remove all dirt, wax and grease from the surface.
2) Blend and mix completely equal parts of the DURATEC CLEAR HI-GLOSS ADDITVE and the desired gel coat required for the repair or entire overspray. Catalyze with a full 2% of mekP catalyst (20 cc per quart). Thin with a fast lacquer-thinner or mek solvent if desired.
3) 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 insure complete coverage.

Note: Spray pressures should be 35-50 psi. If a pressure pot is used, provide 10-15 psi pot pressure.

4) Do not inhibit the cure by adding wax surfacing agents as the combined gel coat and DURATEC CLEAR HI-GLOSS ADDITIVE will air cure to a hard, glossy finish in approximately 1-2 hours. (Apply forced-air-heat for a 20 minute cure time).
5) Lightly sand the repaired area with 220-600 grit sandpaper, either wet or dry, and buff to the desired finish, insuring that the newly gel coated area is blended with the surrounding gel coat surface.

TOOLING GELCOAT UPGRADE

The following procedure describes the addition of from five to fifteen percent (5-15%) of the DURATEC CLEAR HI-GLOSS ADDITIVE to tooling gelcoat to achieve the following property improvements; reduced subsurface porosity and orange-peel, increased impact resistance, improved gloss retention and higher heat distortion temperature.

1) Blend the DURATEC CLEAR HI-GLOSS ADDITIVE @ 5-15% to the tooling gelcoat; the viscosity and thix properties of the gelcoat will determine the quantity to be added.
2) After blending, catalyze at the rate suggested by the gelcoat manufacturer.
3) Spray as recommended by the gelcoat manufacturer.

NOTE: *Due to the lower viscosity, an extra wet-pass may be required to achieve total film thickness. Gel and tack times are comparable to the straight tooling gelcoat.*

PRODUCT PROPERTIES –All time calculations are based on temperatures of 77°F, 25°C
Viscosity-as measured on a Brookfield Viscometer Model RVF, spindle #2 at 20 rpm-**110 cps**
Thixotropic Index– **1**
Gel Time-Sample based on a 100 g mass, catalyzed at 2% with mekP– **16-20 minutes**
Weight per gallon– **8.0 lbs, 3.6 kg.**
Volatile Organic Compounds - **198 g/L**