



GEL COAT REPAIR INSTRUCTIONS

Repair Kit Items Needed:

Utility Knife
Mixing Board
Sandpaper
(wet/dry-150 grit, 220 grit,400
grit, and 500 grit)
Clean Cloths (for buffing)
Acetone
Heavy Grit Rubbing Compound
Marine Finish Wax

Repair Kit Includes:

Gel Coat (1 pint)
MEKP (11ml)
Cabosil Powder (1 pint)
Bondo Spreader
Preval
(Auto sprayer / use with cup)
Stir Sticks
Cups
Particle Mask
Rubber Gloves

Safety Notes:

- Use a Dust Particle Mask when sanding and be sure to dispose of all unused materials in a environmentally safe manner.
- MEKP (Catalyst) can be a volatile chemical. Keep away from all other chemicals and keep in a cool dry place.
- When using MEKP Avoid Skin and Eye Contact.

Instructions:

1. Cut out loose gel coat chips with utility knife. Gouge hairline cracks into "V" shape (1/8" wide/1/16" deep). See Figure 1

Note: It's best to use some sort of Router for above water cracks

2. Sand repair area with 150 wet grit sandpaper 1" beyond all spots being repaired. Clean above water repairs with acetone. See Safety Note
3. Mix Gel Coat with Cabosil Powder until it reaches the consistency of smooth peanut butter. This will take some time to work the lumps out.
4. When Cabosil/Gel Coat Putty is at desired consistency, add 2% MEKP hardener (about 10 drops per ounce of putty). See Safety Note
5. Mix Thoroughly.
6. Apply with Bondo Spreader to repair spot, leave slightly higher than surrounding area to allow for shrinkage and sanding. See Figure 2
7. Allow to harden 30 to 60 minutes (underwater repairs will take longer usually 24 hours).
8. When completely dry, begin sanding with 220 grit sandpaper, and work to 500 grit (Use 150 grit sandpaper only if necessary to smooth very rough repair areas). See Safety Note
9. If Gel does not match well enough (usually too dark) then use a Preval to spray on Gel.
10. To spray gel - 2oz. Gel, 1/2 oz. Acetone, 2ml. (milliliters) MEKP. See Figure 3 and Safety Note
11. Sprayed Gel should be smooth enough to start sanding with 400 wet grit and finish with 500 wet grit. Buff with heavy grit white rubbing compound. See Safety Note

Note: Do Not Over Catalyze. Too much MEKP will impede the process and change the color - 3% is the absolute maximum.

GEL COAT REPAIR

Figure 1

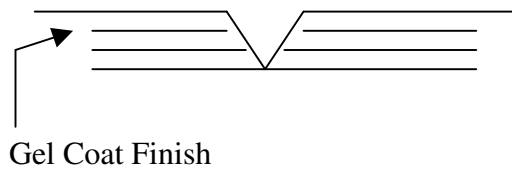


Figure 2

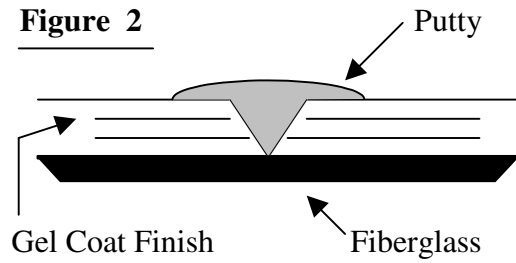


Figure 3

