



# Guidelines for Gelcoat application

Spraying onto mould surface



## MOULD PREPARATION

- 1 Clean mould thoroughly and ensure it is free of dust, debris and contaminants.
- 2 Apply an appropriate release again as per manufacturer recommendations.
- 3 If the mould is new, a sealing system may also be required prior to the release agent.

## GELCOAT PREPARATION

- 1 Check the containers are damage free before opening.
- 2 Mix the gelcoat using a low shear mixer and allow to stand for at least 10 minutes to regain thixotropy.
- 3 Gelcoat and workshop conditions should be between 18°C and 25°C before use.

## CATALYST / PEROXIDE



High quality medium reactivity MEKP such as Butanox M50 (or equivalent) is recommended.



Catalyst level should be kept between 1-3% and should remain constant for an entire moulding.

## NOZZLE / SPRAY TIP SELECTION

Spray tip advice is dependant on the type of part to spray and also the access achievable to the mould (platforms, scaffolding, length of hose from spray gun etc).

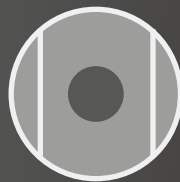
In general:



For smaller parts, tip 521 or 518 are recommended.



For larger parts and smaller hulls, tip 521 or 523 are recommended.



For larger hulls, tip 526 is recommended.

Always use minimum pressure required to achieve a uniform 'finger-free' spray pattern.



# SPRAY EQUIPMENT PREPARATION

✓ Make sure filters are clear and clean.

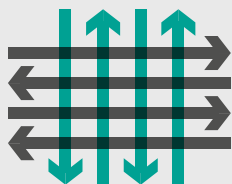
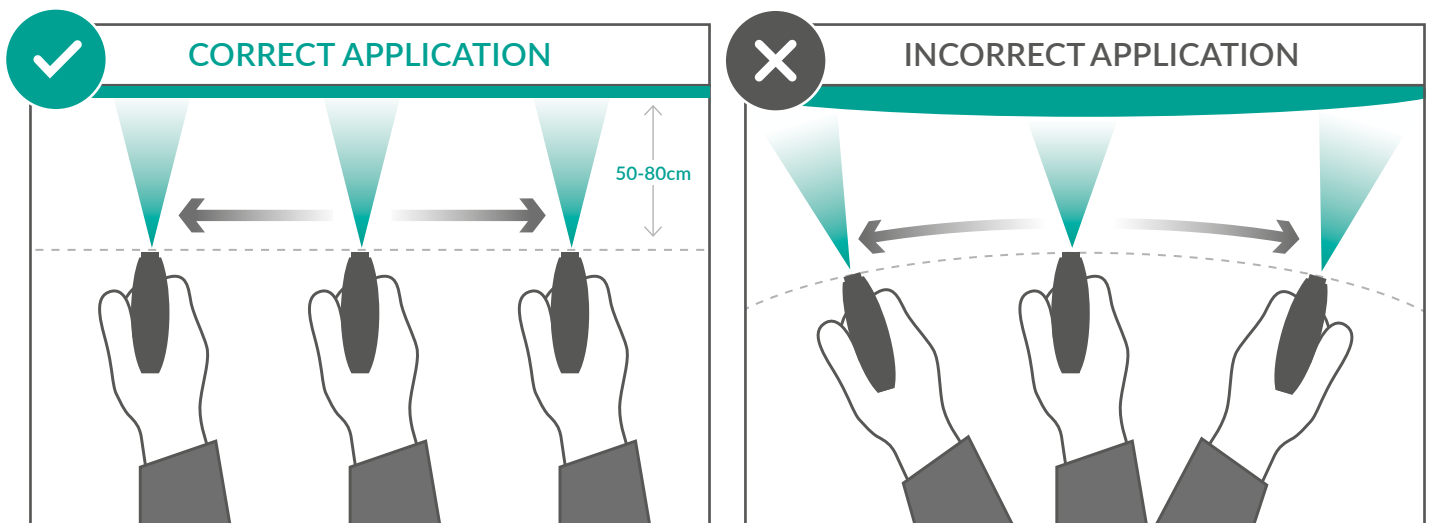
✓ Check and adjust the spray pattern ensuring pressure is at the minimum to achieve desired spray pattern.

## SPRAY APPLICATION

Spraying should be carried out in a properly ventilated spray booth, in a separate part of the workshop. The mould to be sprayed should be positioned in the most practical position ergonomically, to allow for an even coverage and to reduce fatigue of the operator. Keeping the wrist flexible, start by spraying away from the mould and bring the gun towards it maintaining an even left to right spraying pattern at a consistent distance of approximately 50 – 80cm. The gun should always be perpendicular to the mould.

An arched spraying motion as per the illustration below will result in an uneven coverage, as will tilting the gun vertically.

**Note:** Test the Gelcoat when coat is still wet. The wet film thickness target should be 500 – 600.



Spraying with continuous parallel strokes, left to right then up and down to lay down a mist coat, this is best practice to avoid colour faults (grey arrows first pass, green arrows second pass).

**Note:** Please refer to individual product technical data sheets for specific application details or contact our technical services department for further advice and assistance.



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