



# Guidelines for applying Crystic Gelcoat LS30PA

Post application to existing gelcoat surface





## SURFACE PREPARATION AND WORKSHOP CONDITIONS



Before starting it is important to make sure that the surface has been abraded and is clean and dry, with no oil or other surface contamination.



Ensure the gelcoat, the surface its being applied to and the workshop, are within a temperature range of 18 – 25°C. Do not apply if below 15°C.

## PREPARATION OF THE GELCOAT

Stir well until fully dispersed then add up to 5% of styrene to thin down to the desired viscosity, this amount will be influenced to some extent by the temperature of the gelcoat, the particular spray gun being used and the surface finish required. Do not thin with any other solvent or monomer other than styrene as there will be a danger of solvent entrapment within the cured gelcoat layer. The addition of styrene may reduce long term weathering properties of the gelcoat so it's best to keep this to a minimum.

For the final layer add 2% wax solution (Solution MW). This will ensure a tack free surface finish for compounding / polishing thereafter.

## APPLICATION

Add 2% medium reactivity MEKP catalyst (Butanox M50 or equivalent) and apply in a number of even passes of the spraygun until a wet film thickness of 400 - 600 microns has been achieved. Depending on the particular spray gun used, this may take 3 - 5 passes or more.

If a coating thickness of greater than 600 microns is required then application must be in two stages, allowing the first coat to cure to a firm but slightly tacky condition before proceeding.

**Important:** Do NOT add wax solution (Solution MW) to the first coat or adhesion between coats will be impaired.

## 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).

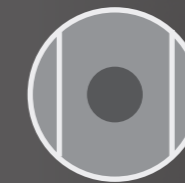
**In general:**



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.

## ABRASION AND POLISHING



The surface should be left until it has reached a good level of cure and hardness before abrasion and polishing, depending on ambient temperature this may take a minimum of 24 hours.