

## **Application Instructions for Resin & Gelcoat Additives**

**Wax Solution Description:** Surfacing Agent is a clear liquid added to produce a less tacky finish and improve sanding properties. Will migrate or “bloom” to the exposed surface of the laminate or casting. Creates a thin film that prevents air contact with the resin. Allows cure to take place.

- **Application:** Add 2% - 4% by weight of Surfacing Agent to any standard gelcoat. Due to varying application methods and environmental conditions, each finished surface should be tested using solvent wipe to check for color removal. When laying up more than 1 ply, add surfacing agent to the final coat only.

**Hi-Gloss Additive Description:** Symtec Hi-gloss is an additive which significantly improves the application and appearance of gelcoat patches. It helps the gelcoat to flow out and produce a smoother finish.

- **Application:** Blend three parts gelcoat with two parts Hi-gloss. Use more or less high-gloss additive depending on the color. In some cases additional surfacing agent may be needed or apply a thin coat of PVA over the patched area. Mix well and be sure to scrape sides of container. To avoid gelling of the solution in the application equipment, be ready to spray before catalyzing material.

**Applications (for Wax Solution & Hi-gloss):** The products are formulated for spray application as supplied. Thinning is not recommended. Apply in several thin overlapping coats rather than a single thick coat. This will help avoid sagging, porosity, solvent entrapments and other defects. Make sure the air pressure is adjusted properly, and that the spray gun lines are free of solvent, water, and oil. Apply to a thickness of 18 – 25 mils wet. Brush application is not recommended.

**Webbing Solution Description:** Webbing Solution is a clear liquid added to gelcoat to obtain “splatter” or “cobweb” effect. It is mixed with gelcoat of one color, and sprayed onto a contrasting colored surface. Decorative effects produced by the webbing mixture will vary, and relate directly to techniques or gun adjustments. A fine hairline spider web pattern results from plenty of air and scanty material flow. Coarse and splotchy patterns are created by fuller material flow and decreased air volume. Experimentation will help determine the desired effect.

- **Application:** Stir well before use. The proper mixing ratio is one part webbing solution to two parts gelcoat by weight. It is then catalyzed and sprayed over a contrasting colored surface. Alternatively, it can be sprayed into a mold and then oversprayed with a contrasting colored gelcoat.

**Cure (for Surfacing Agent & Patch Reducer & Webbing Solution):** For catalyzation, use Methyl Ethyl Ketone Peroxide (MEKP) @ 1.0% to 3.0%. Do not catalyze at levels below 1.0% or above 3%. It is recommended that the gel time be checked at the customer’s plant because temperature, age, humidity and catalyst will produce varied gel times. The above listed products should be used when the ambient and mold conditions are below 60° F, as curing could be adversely affected. Material temperature should be at least 70° F.

**Mixing (for gelcoats and all associated products):** The material should be mixed once a day for 10-20 minutes at low agitation. Do not overmix. Overmixing will lead to a breakdown of the viscosity and thixotropic properties. This can increase the tendency to sag and it will cause styrene loss, which will increase the likelihood of porosity.

**Storage Recommendations (for gelcoats and all associated products):** Uncatalyzed gelcoats and associated products have a shelf life as stated from the date of manufacture when stored at 75° F or below, in a closed, factory-sealed container and out of direct sunlight. The shelf life is cut in half for every 20° F over 75° F. Products outside of this shelf life range can perform acceptably.

**WARNING: All materials listed are hazardous materials and are toxic. Vapors may cause flash fire. Use only with adequate ventilation. Keep away from heat, sparks, or open flames. Prevent build-up of vapors. Avoid prolonged contact with skin and breathing of vapors or spray mist. Close container after each use. Refer to the MSDS sheet of each product being used for more information. MSDS sheets are available upon request.**

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