



HOW TO REPAIR GEL COAT

All Gel Coat repairs/touch-ups should be performed in dry and warm conditions. The part being repaired should be at least 65F, and the ambient air temperature should be at least 65F. The spot to be repaired/touched-up must be dry and free of dust and dirt, moisture will cause problems.

Included in the kits are the MSDS for the materials, please read and familiarize yourself with the materials to be used.

The repair kit includes:

- 1 Quart of Gel Coat
- 1 – 11ml tube of Liquid Hardener
- Stir Sticks
- Rubber Gloves
- 32oz White Paper Cup
- Sand Paper

IN ADDITION TO THE MATERIALS SENT IN THE REPAIR PACKAGE YOU WILL NEED ACETONE FOR CLEAN UP AND SOME COTTON WIPING RAGS.

MAKE SURE TO USE GLOVES AND OSHA APPROVED EYE PROTECTION WHEN DOING ANY REPAIRS

STEP 1: Clean area to be repaired/touched-up

If it is a small touch-up simply wipe the area down with a clean rag and some acetone. Larger areas require a light sanding with 80-Grit sand paper to properly prepare the surface so that the gel coat will bond properly.

Make sure to sand an area larger than the repair area to give you a good bonding surface for the gel coat.

You will need the following items to complete the next steps:

1. Gloves
2. Stir Stick
3. 32oz White Cup
4. Gel Coat
5. Liquid Hardener
6. Chip Brush



STEP 2: Mix the gel coat; you will not want to mix too much Gel Coat at one time, saving some in case you need to touch up later. Pour about 8oz into the White Cup (1/4 of the 32 oz cup) and mix in about ½ tube of liquid hardener. Stir thoroughly with stir stick.

STEP 3: Using the Chip Brush DAB, do not brush, on the Gel Coat to cover the area. The right amount of gel coat should fill in all small air pockets and imperfections in the fiberglass. Allow the gel coat to cure for 60 minutes before handling.

STEP 4: Inspect the repair for any small holes in the gel coat. If there are some areas that require more Gel Coat, sand the area again, mix, and reapply gel coat if necessary.

Once your repairs are complete, it will be necessary to harden off the unused portion of the gel coat. Simply mix the remaining liquid hardener into the can to harden off the material.

DO NOT DISPOSE OF THE MATERIALS IN THEIR LIQUID STATE, they are considered hazardous materials.

Once hardened they become inert and can be simply thrown in the trash.

Should you have any questions please call either John Miller or Tracy Switzer at 314-664-9300.