



**POLYCRYL
CORPORATION**
EarthGuard Resins
and Gel Coats

Polycryl Tooling Gel Coat Application Data

POLYCRYL CORPORATION

260 Pierce Rd.
Oakland Tennessee 38060
Tel: (901) 465-3330
Fax: (901) 465-9992
Sales@polycrylcorp.com

1. Agitate slowly but thoroughly and bring the temperature of the Gel Coat to the recommended spray temperature of between 70 to 80°F.
2. Catalyze at 2.0% United Initiators 925H or Akzo Nobel L50a, no equivalent. No reduction or other additions are necessary.

NOTE – For extremely high ambient temperatures when the plug or parts to be sprayed and gel coat are at 80 – 90° F, 1.75% catalyst levels can be used. High heat can increase reactivity and shorten gel time.

3. For best results apply by pressure pot or air assisted airless equipment, never by conventional airless.

AIR ASSISTED AIRLESS:

- a) .1850-.1870 tip size for standard parts while maintaining 18 inches plus from parts. .2150-.2170 tip size when operator is spraying large parts such as boat hulls and keeping a distance of 2 ½ - 3 ft. plus.
- b) Fluid pressure approximately 45 lbs. and up to get correct start up pattern. Go to Polycryl's Pattern Guide for adjusting fluid pressure at spray gun. Most spray equipment companies furnish a similar pattern guide.
- c) Use the lowest air assist possible to obtain a uniform rectangular spray pattern without any tails at either end. High or excessive air assist can increase air entrapment in the gel coat film resulting in porosity.

PRESSURE POT:

- a) Atomizing air approximately 45 – 60 lbs.
- b) Fluid pressure approximately 20 – 30 lbs.
- c) Tip size approximately .070 for decks and close-in work, 18 inches plus distance from part. A .085 tip can be used for hard to reach parts keeping 2 ½ ft. plus from parts.

DISCLAIMER: The data on this sheet represents typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Polycryl assumes no obligation or liability for use of this information. UNLESS POLYCRYL AGREES OTHERWISE IN WRITING, POLYCRYL MAKES NOT WARRANTIES, EXPRESS OR IMPLIED, AND DISCLAIMS ALL IMPLIED WARRANTIES INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR FREEDOM FROM PATENT INFRINGEMENT. POLYCRYL WILL NOT BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES. Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option.

4. Apply 10-15 mil layers using 3 – 4 passes per layer until a total of 30-40 wet mils are achieved. DO NOT let the Tooling Gel Coat reach a gelled state between the 10-15 mil layers. Keeping a “wet line” is essential.
5. Adequate time is mandatory between each 10-15 mil layer to allow the material to “flash” or “breathe”. The amount of time will vary depending on the material, mold, and ambient temperatures. During colder conditions, “flash times” of up to 8 – 10 minutes may be required. Note: If these temperature (and time) parameters can not be reasonably met, Polycryl then highly recommends the installation of in-line heaters to maintain a constant temperature and achieve the best desired results possible.
6. The first skin should be applied 1 ½ - 3 hours after gel coating with ambient temperatures of 70-80° F.
7. A fabricator should make a test panel by their/these techniques to observe results before starting the actual tool. We also recommend spraying a glass panel and checking with a high intensity light to observe if there is any air entrapment (porosity) in the film and if so, make corrections to eliminate. Once this is achieved the gel coat can be properly sprayed.