



**POLYCRYL  
CORPORATION**  
**EarthGuard Resins  
and Gel Coats**

## Data Sheet

**POLYCRYL  
CORPORATION**

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### *XPA – 100 PATCH ADDITIVE*

#### **Features:**

1. Reduces viscosity to spray through patching gun.
2. Speeds gel and cure without imparting color.
3. Provides tack-free cure in approximately one (1) hour.

#### **Usage:**

1. Two (2) parts Gel Coat
2. One (1) part Patch Additive
3. 2.0% United Initiators 925H catalyst (of total wt. GC + PA).

#### **Application:**

1. Apply catalyzed patching mix with Binks 115 gun, .070 orifice, or equivalent, at just enough pressure to apply a finely atomized fan of patching mix, 12-15 wet mils.
2. Allow film to cure to a dull, flat, non-tacky film. Can be accelerated with a heat gun at temperatures of 100-150°F, at 6-10 inches from the surface.
3. The cure should be such that you cannot dent the film by fingernail.
4. Proceed to sand the patch with 220 grit for a sanded finish, or, progressively with 320, 400, 600, 800, 1000, 1200, 1500 grit sandpaper. Commence using wet sandpaper at 600. Use 2000 grit Buffing Compound and a Final Finish Polish for a high gloss surface.
5. Polycryl recommends using United Initiators 925H or Akzo Nobel L50a catalyst with the XPA-100 Patch Additive.

#### **Safety:**

1. Gel Coat and Patch Additive contain styrene and acrylic monomers and should be handled with precautions prescribed for such materials.
2. United Initiators 925H catalyst contains Methyl Ethyl Ketone Peroxide and should be handled with precautions prescribed for such.
3. Patching Mixture will exotherm quite “HOT” and precautions should be taken to avoid fire and injury.

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