



Getting Your Boat Ready For Repairs

Once you have determined what areas of the boat you will be repairing, take steps to cover and protect the rest of the boat from the gunwale up, or when working on the deck or cabin, tarp off the adjacent areas.

1. Remove rails, cleats, louvers, snaps, striping tape, etc.
2. Duct tape off adjacent gunwale molding, and deck fittings you are unable to remove.

NOTE: Duct tape is recommended over masking tape because it provides better protection.

3. Remove seals from the edges of parts or fittings when doing a repair around that part or fitting.

Sanding:

Use fast-cut grits sandpaper (40, 80, 100) wet & dry to feather sand and ground out a routed area prior to filling, or for the first sanding of gouges, dock dings, scratches, and blisters.

COLOR MATCH:

Take a mixing cup & add the tints a drop at a time. In some instances a drop can be too much. Use a pin head or sharp tipped tool for finer tinting and slight adjustments. Keep track of the number of drops each tint. When the color looks close, touch a drop of the mix onto the hull. Make needed adjustments until you are satisfied with the match (don't expect perfection) then write down the formula so you can duplicate it for the rest of the paste. See color chart included in our Multi Color Kit # 100.

Preparing the Scratch: Never try to repair a scratch by simply painting or spraying over it with Gelcote®. Liquid Gelcote® is too thin to fill a scratch. Instead Use **Gelcote #110P Filling Pastes** or **Gelcote #100 Six color Tint Matching Kits**

TO GET A PERMANENT REPAIR:

Rough and/or sand area to be repaired using course sandpaper, sharp instrument or small grinding tool such as a drill. The object is to get enough "tooth" to the repair area to assure a good bond. Use a rag to remove dust. Take care not to damage surrounding areas. Masking tape around repair are will minimize this possibility. **Note: THIS IS THE TIME TO WIPE THE OPEN SCRATCH WITH STYRENE TO REACTIVATE THE OLD GELCOTE®.**



Spraying GelcoteTM

Gelcote® may be thinned for use in a siphon pot gun or sprayer with Acetone or Styrene Monomer. Do not use more than 20% by volume of thinner, and always add thinner first then add the Catalyst or Hardener and mix thoroughly. Over thinning will result in an inadequate curing.

Initially spray a cover coat as smooth and evenly as you can to cover your repair. This coat should be mostly in the repair area, and may be repeated. Sanding between coats is not necessary. Once your repair is covered, feather a 'flow' or sanding coat on the masked off area making layered passes to avoid a buildup of **Gelcote** in any one area.

Each of these coats may involve several passes. Be even and consistent in your gun movement, overlapping each previous pass slightly and not hesitating on the ends. When spraying to a radius, flow the **gelcote** to the tape.

As soon as you are done spraying, clean your sprayer fully with acetone.

Most re-sprayed **Gelcote**® will cure in **2-4** hours, although overnight cures are ideal. Begin wet sanding with the finest grit that will remove orange peel in the re-sprayed area. This will avoid unnecessary sanding scratches. Usually 320 or 400 grit wet/dry is sufficient for the initial sanding. Sand to a 600 finish and buff with Gelcote® Buffing Compound.



Troubleshooting Tips When Working With Gelcote™

- Clean repair area and all tools with acetone prior to application.
- Do not over catalyze or add more than 20% by volume of thinner.
- Gelcote will not fully cure without adding a surfacing agent or over spraying with PVA.
- Do not work in direct sunlight.
- Check color thoroughly before applying.
- Store Gelcote® in a cool dry place.
- Gelcote should be applied in temperatures of 60°F to 80°F.
- Always use eye and hand protection.
- Read all warnings on Gelcote® label.
- Keep out of the reach of Children.
- Take your time and enjoy the experience.

Brushing Gelcote™

The major disadvantage of polyester coatings is that they cannot be applied in a perfect “self leveling coat”. It must be mechanically finished by wet/dry sanding and polishing. If a Factory mold finish is to be expected.

Sand the entire surface to be coated with 220 grit sandpaper. If cracks or gouges are present, they should be repaired first using **Gelcote # 100P Filling Paste**. When sanding is completed, the surface should be free of flaws and perfectly smooth. Choose a good pure (natural) bristle brush with tapered ends. Avoid brushes that are either too stiff or too soft. For most work, a **3” or 4”** wide brush will suffice. If there is a trim color, you should have a narrow trim brush on hand.

Avoid Direct Sunlight

Choose a shady location or an overcast day. You should catalyze your material so that it cures as quickly as possible within your working time. **Generally mix one-pint batches**. A good practice is to pour the mixed **Gelcote®** from the mixing container into another container used for application. This further assures that no un-catalyzed material is clinging to the sides of the pot.

“Lay on” the **Gelcote** in a heavy thickness (about 10 mils) using horizontal strokes, working from top to bottom. Avoid re-brushing as this could cause blistering. Remember to always lap wet.

Generally, one heavy coat is sufficient. However, if you have opacity problems two coats may be necessary with a light sanding between coats. Once the coating (**Gelcote®**) has cured, it should be block sanded using a **250** grit paper to remove all brush marks and high spots. Following this, it should be wet sanded with **400 and 600** grit paper, buffed, polished and waxed.