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MARINE

COAT ONE



DURATEC®

INSTRUCTIONS

A PERFECT MATCH EVERY TIME



VETERAN OWNED COMPANY

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A subsidiary of Multi-Tech Products



DURATEC®

RECOMMENDED USE: GEL COAT REPAIR

1. A test blend is recommended, as every blend is unique, and the cure must be tested and assured. Every gel coat is different, so the cure time of the blend will vary. Note the cup-gel time.
2. Remove any cracked or damaged gel coat. Grind out cracks down to the laminate.
3. Repair laminate or assure the laminate is sound.
4. The temperature should be at least 60° F; low temperatures extend cure times.
5. Sand with 180 grit paper to within a few inches outside the repair area.
 - A. Bevel the edge of the existing gel coat.
 - B. Use a repair putty (Marine Coat One Poly Filler) to fill in any low areas.
6. Blend One: 1-part (25%) Duratec® and 3 parts (75%) gel coat.
 - A. Catalyze with 2% MEKP catalyst (about 20 milliliters per quart. Note: the 1:3 blend is recommended to maximize the hide (opacity)). If opacity is not an issue, use Blend Two for all the repairs.
 - B. Spray 3-4 passes over the repair, building up 12-15 mils. Allow at least two minutes between passes. Do not allow the Duratec®/gel coat blend to cure beyond the sticky/thumbprint stage between coats--usually about 30 minutes at 77° F when sprayed, faster in the cup.
7. Blend two:
 - A. 1-part Duratec® and one-part gel coat. Catalyze with 2% of a MEKP catalyst.
 - B. Spray at least 2 passes over the repair, building up an additional 8 mils or more. Be sure to get back onto the first passes while they are sticky. Cover all the previously coated areas. It is possible to feather the edge of the repaired area with the second blend.
8. Allow to cure completely.
9. Sand with the finest grit that is reasonable for the surface finish. With a good finish starting with 400 grit if possible.
 - A. The surface must be open for at least 8 hours between initial sanding and polishing. The open time allows for styrene release and full cure.
10. Sand with progressively finer grits like 400, 600, 800, 1000, Compound and polish with products formulated for gel coat like Aqua Buff 1000 and Aqua Buff 2000.