



GEL COAT REPAIR INSTRUCTIONS

A PERFECT MATCH EVERY TIME



VETERAN OWNED COMPANY

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A subsidiary of Multi-Tech Products



GEL COAT REPAIR

(There is no implied warranty of these materials and techniques. The success of the final repair lies with the experience and skill of the individual performing the repair.)

Safety Precautions:

Gel coat and fiberglass repair require personal contact with a variety of solvents, each having its own characteristics. Avoid contact with skin during mixing and spraying. Gloves are provided. Ventilation is required. Wear a vapor/particulate respirator (NIOSH/MSHA TC-23C). Eye protection is required when grinding, drilling, sanding, and mixing. Keep away from heat, sparks, and flames. Vapors may cause a flash fire. Close containers after use. Dispose of properly.

Wax Surfacing agent is either mixed in or included on Gel Coat without wax additive.

Wax Surfacing Agent or (PVA, Patch Aid, High Gloss Additive, Mylar or Wax Paper) must be used on the Final Coat of all Gel Coat repairs. It will not cure properly without one of these. If doing more than one coat, the initial coats are applied without wax and the final coat has the wax surfacing agent (included) mixed in at 1 oz per quart. If you don't use one of these additives, the Gel Coat will remain tacky.

It is the best practice to apply heat to the final coat to ensure a proper cure.

If applying multiple coats; You can apply the next coat approximately 10 minutes after the previous coat.

Repair Procedures:

1. Prepare Surface:
 - A. Prepare the cracked or damaged area by removing any loose edges of the Gel coat by using a razor knife, or by grinding with a router or Dremel® type tool.
 - B. Sand the routed area with 100 or 220 grit sandpaper to smooth any roughness around the area to be filled.
 - C. Clean the gap/crevice thoroughly with a white cloth saturated with acetone.

If Using Marine Coat One Filler or Fairing Compound.

1. Apply Filler:
 - A. Prepare the Poly Filler
 - Add 3% cream hardener to the Poly Filler already in the glass jar.
 - If a smaller amount of filler is desired:
 - Dispense some of the filler onto a mixing board and add cream hardener proportionately, 3% is recommended.
 - Mix thoroughly then transfer mix using a stir stick. Working time is limited, approximately 1 to 2 minutes depending on working temperature.
 - B. Using the stir stick or spreader, apply Poly Filler into the void working out any trapped air. Overfill the damaged area approximately 1/16 of an inch.



- C. Allow the filler to cure (dry) 3 to 10 minutes, accelerate with a heat gun or blow dryer if necessary.
- D. Sand the area to be filled with 100 or 220 grit sandpaper. If the area is under filled or imperfections exist, repeat filling procedure until satisfactory.
- E. Sand with 220 grit sandpaper to remove 100 grit scratches, followed by 320 grit and then 400 grit, in progression, until smooth.

2. Apply Gel coat.

If Brushing:

Make sure to add your wax surfacing agent to the final coat.

- A. Clean the surface around the repair thoroughly with acetone.
- B. Mix 2-3% of MEKP Hardener into the Gel Coat. Stir well. Working time is about 5 to 15 minutes, depending on the temperature.
- C. Apply the gelcoat by brush or roller in sections so that it doesn't start to cure while applying. Brush or roll smoothly.
- D. If doing more than one coat wait approximately 15 minutes before applying the next coat. Make sure you mix the surfacing agent to the FINAL coat for proper curing.

If Spraying:

- A. Spray the Gel coat mixture to the surface using the sprayer. It is recommended to test spray on a separate surface, such as paper or cardboard, to check the spray consistency. It may be necessary to thin with Acetone or Styrene. The Gel coat mixture may also be sprayed using an airbrush or a spot gun. It is important that the filled area is covered sufficiently and sprayed evenly with no runs. Once applied, allow it to cure 30 minutes. Accelerate with moderate heat if necessary.
 - B. Use a 2.0-2.5 spray tip.
 - D. PVA may be used as a sealer to prevent tackiness to the final cure. Spray PVA onto the sprayed Gel coat approximately 15 minutes after applying the coat.
3. Sand and Buff the Repair: (The Gel coat may still be a little tacky. It is acceptable to wipe off the tackiness with a cloth and acetone.)
- A. "Wet sand" the sprayed area with 320 grit sandpaper and water. Then sand in progression with 400 grit and 600 grit sandpaper until smooth. Important: Do not sand through the color exposing the filler. Wipe dry.
 - B. Apply the rubbing compound generously to the sanded area and polish by hand or using an electric buffer at 2500 rpm.



GLITTER FLAKE REPAIR

Make sure you have all the materials available (kit content, equipment, acetone, and clean rags) before you start your project

1. Prepare the damaged area by removing grease, wax, debris, etc.
2. Use acetone to clean up residual debris. DO NOT allow the acetone to touch any other areas. (Mask-off the area around the repair for better results).

NOTE: The Gel coat or resin polyester does not bind well to epoxy. DO NOT apply over epoxy.

3. Dispense a little more polyester resin gel than you think is needed to complete all repairs into the plastic mixing cup (to ensure you only need one color match).

If you need to fill in the repair with the color of the paint, mix the base color and MEKP in a mixing cup and put a small amount to fill in the repair with your base color. You can immediately sprinkle or blow a small amount of flake on the repair area.

NOTE: The flake should only be mixed with clear paste for the final coat. Make sure to cover with Mylar paper for proper curing and spread in nice and smooth.

If using the colored glitter metallic flake add the flake to the gel coat in the mixing cup to the desired consistency. Try to keep the added flake below 15% of the amount of gelcoat paste.

After approximately 10-15 minutes You can now add the final coat of clear paste and glitter flake over the color base (if applied color base).

4. For each teaspoon (1/6 oz) of blended gelcoat paste, add four drops of hardener. Thoroughly mix paste, pigments, and hardener. You have a work time of approximately 15 minutes.
5. Use the spreader to add the blend to the damaged area. Work mixture well into the damaged area. Be careful that the mixture does not come into contact with other areas.
6. Use the enclosed clear release paper (or a sheet of wax paper) to protect the repair area entirely. Make sure there are no air bubbles left between the paper release and repair area. Smooth out the repair patch with the spreader over the film. This will help even and smooth out the repair. The patch will heal in about an hour.
7. Remove after an hour—clean the area with a clean cloth with acetone.
8. Sand repaired area with wet 400, then 600-grit sandpaper for a good quality finish. Then, buff with a wax and a good polishing/rubbing compound (included)



GEL COAT REPAIR COLOR GUIDE BLENDING FORMULA

Desired Color to Match Finish	Base Color	Tinting Color
Red	Red	----
Maroon	Red	Black
Light Red	Red	White
Regal Red	Red	Blue
Blue	Blue	----
Navy Blue	Blue	Black
Royal Blue	Blue	White
French Navy	Blue	Red
Turquoise Blue	Blue	Yellow (very small amount)
Turquoise Green	Blue	Yellow
Black	Black	----
Charcoal	Black	White
Brown	Brown	----
Chocolate	Brown	Black (small amount)
Mid-Brown	Brown	Yellow
Medium Brown	Brown	Black and White
Dark Chocolate	Brown	Black
Reddish Brown	Brown	Red
Pink	White	Red
White	White	----
Cream	White	Yellow (small amount)
Almond	White	Yellow and Red to tone. Shade with Blue
Off-White	White	Black or Brown
Light Stone	White	Mid-Brown
Powder Blue	White	Blue
Harvest Gold	White	Yellow and Red to tone. Blue for Eye Appeal.
Dark Blue Gray	White	Black and Blue
Off-White Brown	White	Brown (1st) and Yellow
Wedgewood Blue	White	Blue plus small amount of Black
Charcoal or Light Gray	White	Black



Tan	Yellow	Red and White, darken with Black
Lime	Yellow	Blue (small amount)
Green	Yellow	Equal amount of Blue.
Yellow	Yellow	----
Canary	Yellow	White
Mustard	Yellow	Red and Black
Turquoise	Yellow	Blue and White
Light Yellow	Yellow	White
Orange or Gold	Yellow	Red
Pine or Olive Green	Yellow	Black
Lime or Bottle Green	Yellow	Blue
Beige	White (mix 1st)	Brown and Yellow (small amount)