



DURA-KOTE GEL COATS

GENERAL USAGE AND SAFETY GUIDELINES

SAFETY

Before applying Dura-kote gel coats please review the safety requirements and ensure that the material is used in a safe and responsible manner. Ensure that you have read and understood the MSDS for both Dura-kote and any other materials and equipment used with Dura-kote - they may have their own hazards and safety constraints and these should be reviewed prior to use.

Any spilled material should be soaked up with absorbents, these should be disposed of safely, and the area washed clean

HOUSEKEEPING

- Dura-kote gel coat should be stored in the original sealed container in a cool dry area away from direct sunlight. Dura-kote should ideally be used within three months and no later than six months of manufacture.
- All equipment and tools used in the application process should be clean and free of contamination.
- The work area should be clean and free of debris. A clean operation is safer and more efficient.
- Check all filters for blockage, inspect all air compressors, drain all water traps, and inspect all worker safety equipment prior to production.

EQUIPMENT

- The best possible material flow rate should be determined for the target mold. This flow rate should be controlled by selecting the correct tip size. The lowest possible pump pressure will normally yield better results and fewer quality control problems.
- The catalyst flow should then be adjusted according to the manufacturer's recommendations for that equipment. The catalyst should be added to the gel coat at 2% by weight.
- Adjust the fan pattern prior to application; the pattern should be a uniform oval.
- Calibrate the equipment to insure that the catalyst and gel coat are mixing adequately.

MOLD PREPARATION

- The mold surface should be prepared according to the instructions for the mold release in use.
- The mold should be inspected for contamination, lack of gloss, or physical defects prior to application.

APPLICATION

- Gel coats should be thoroughly mixed prior to use.
- For best results, apply a mist coat to the surface. Allow this to dry for approximately five minutes before apply the rest of the material. Apply three passes of six wet mils each to a total of eighteen wet film mils. A wet film gauge should be used on coating pass to ensure accurate film thickness.
- The ambient temperature, the mold temperature, and the product temperature should be above 60°F

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Last updated 26 June 2003

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