



## Working with Gelcoats

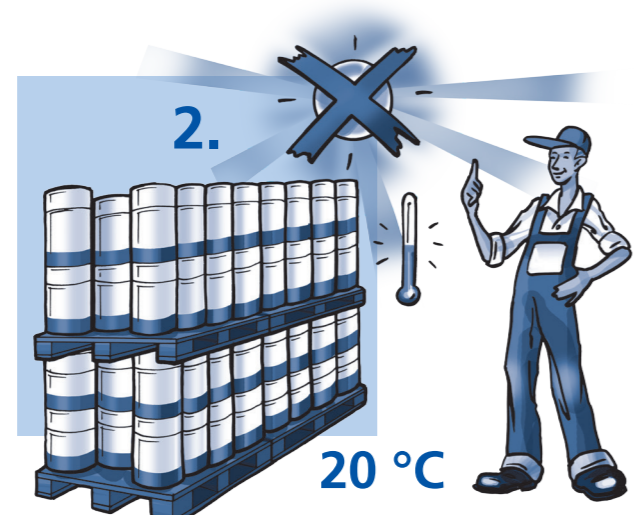
Composites



### 1. DELIVERY

Inspect

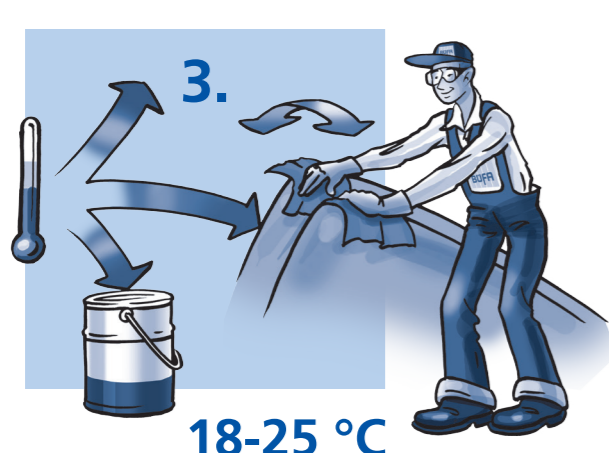
- Quality
- Shade of colour
- Quantity



### 2. STORAGE

Please observe!

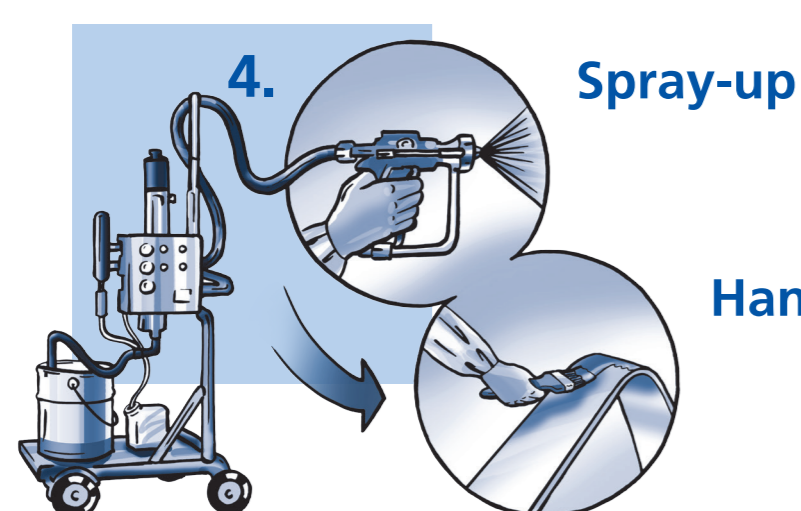
- Store under roof
- Protect from direct sunlight
- Storage temperature approx. 20 °C
- Humidity 50-75 %



### 3. MOULD RELEASE AND PREPARATION OF THE MATERIAL

Please observe!

- Protection/protective clothing for users
- Room temperature between 18-25 °C
- Manufacturer's recommendations for mould release
- Homogenous stirring of the material in the original container



### 4. GELCOAT APPLICATION:

Please observe!

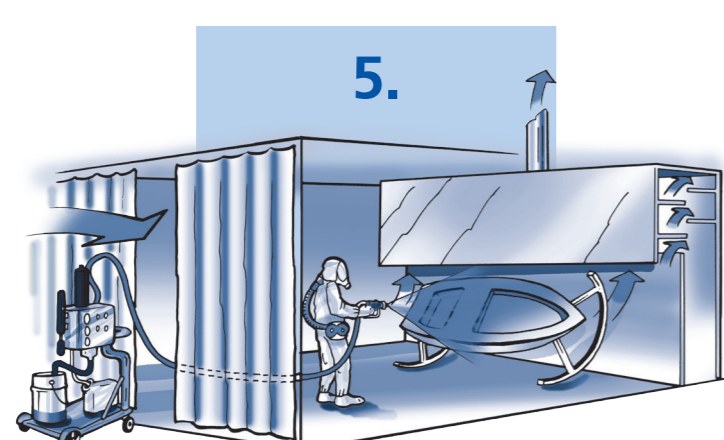
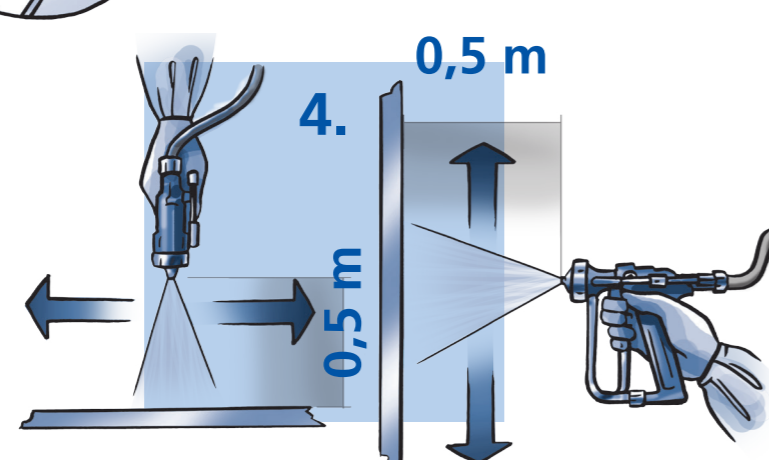
- Use only the specified hardener
- Observe quantity to be added in % (1.5-2.5 %)

### HAND LAY-UP:

- Ideally in two layers each 300-400 µm
- Make sure the layers are uniformly thick

### SPRAY APPLICATION:

- Adjust machine parameters according to instructions given by the manufacturer
- Apply two layers. The first layer should be approx. 200 µm. With the second layer, a total layer thickness of approx. 700-800 µm should be applied.
- Lead the gun lengthwise and crosswise vertical to the surface of the mould
- Observe a distance of 0.5 m!



### 5. WORK PLACE

Please observe!

- Ensure optimum ventilation at the work place
- Protective measures for employees
- Dust-free surroundings



### 6. AFTER WORK

Please observe!

- Close containers tightly after work
- Return containers to their proper storage space
- Clean machines, equipment and tools