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## MAKE YOUR GELCOAT SPRAY LIKE PAINT

Visit us online to view  
our webinar on  
904-001!

### FEATURES

- NO DULL SURFACE**  
Additive eliminates the need for wax & PVA creating a superior finish.
- ELIMINATES LOW-GLOSS**  
Especially areas on the edges of repairs, like the low-gloss "donut" often seen in gel coat repairs.
- BETTER PROFILE**  
Flat & smooth profile compared to un-modified gel coat or gel coat with wax & styrene.
- REDUCED POROSITY**  
In tooling gelcoat. Improves air release, thus preventing porosity.
- FASTER & EASIER REPAIR**  
The air-cure blend created with gelcoat cures fast and hard, creating a shiny smooth surface that is easy to sand.

REVISED AUGUST 2024

# DURATEC CLEAR HI-GLOSS ADDITIVE

PRODUCT #904-001

### DESCRIPTION

With over 40 years of successful use, Duratec Hi-Gloss Additive is the proven leader for post-application gel coat work. Hi-Gloss Additive converts gel coat to air-cure chemistry, leading to a smooth, porcelain-hard surface. Use this product in applications such as complete gel coat resurfacing, plug and pattern manufacturing, and gel coat repair. Blend with the original gel coat to match to desired color. Make gel coat repair come out perfectly every time!

PRODUCT PROPERTIES	
All time calculations are based on temperatures of 77°F, 25°C Lab tested with Norox 925 MEKP	
Gel time @ 2% MEKP	14-18 minutes
Weight per gallon	8.54 lbs/gal
% Solid Content	52%
Wt% HAPs	34%
Viscosity (DV-E Spindle #1)	average 64 cps. <small>Average provided as reference not as indication of spec range.</small>

### SAFETY & HANDLING

Duratec Hi-Gloss Additive is extremely flammable. Do not apply near sparks, open flames or heat. Keep area ventilated. Do not smoke. Avoid continuous breathing of vapor. Duratec Hi-Gloss Additive contains ingredients which could be harmful if mishandled. Contact with skin and eyes should be avoided and necessary protective equipment and clothing should be worn. Individuals should wash with soap and water before eating or drinking. All containers should be properly labeled to prevent accidental ingestion or improper disposal. Individuals should reseal any partly used material back in the container. Store under cool, dry conditions and away from open flames and high temperatures.

For more detailed instructions on storage, please see the MSDS sheet.

**Liability/warranty statement:** Our products are intended for sale to industrial and commercial customers. We request that customers inspect and test our products before use and satisfy themselves as to contents and suitability. All claim requests must be made in writing and are subject to review, including storage temperature verification and retain evaluations. The exclusive remedy for all proven claims is replacement of our materials. In no event shall we be liable for special, incidental or consequential damages, including damages caused in transit (exworks terms). Nothing herein shall constitute a warranty, expressed or implied, including any warranty of merchantability or fitness, nor is protection from any law or patent to be inferred. All patent and trademark rights are reserved.



# DURATEC CLEAR HI-GLOSS ADDITIVE

APPLICATION GUIDE | PRODUCT #904-001

## PLEASE NOTE

The following use instructions are broad to address multiple applications. We recommend testing for product compatibility with your process. Please contact our Tech Team at (909) 546-1160 with any questions.

**GEL COAT COMPATIBILITY:** Duratec works well with most gel coats. Since there are many options in the market, a test blend is recommended, as every blend is unique and the cure must be tested and assured. The gel and final cure time of the blend will vary based on gelcoat. A cup test will verify gel time.

**A TIP ON TIP SIZE:** Duratec High Gloss Additive will thin the gel coat, depending the gel coat and your blend ratio. Thinner material will flow and resist orange peel with a smaller tip (2.0 mm or less), where thicker material will clog and not disperse with a smaller tip and a larger tip is better (2.5mm or higher).

**HOW TO CATALYZE:** Both the gel coat and the Duratec High Gloss Additive require catalyst. Your gel coat may note less than 2% catalyst ratio, but we advocate catalyzing the full mix with a 2% ratio. Use a full strength MEKP catalyst like Norox 925. Accurate measurement of catalyst using a scale (weight) or an MEKP dispenser (volume) is key. Catalyze only the amount of material you will use within the gel coat gel time (about 15 minutes depending on gel coat type/manufacturer).

**ABOVE & BELOW WATERLINE:** Duratec 904-001 can be used where you use gelcoat. If you are using gelcoat on areas with long-term water exposure (i.e. below the waterline), we do advocate the 50/50 blend on the final passes (10+ mils) to ensure closed, fully cured surface.

## Prepare

Temperature should be at least 64°F. Low temperatures extend cure time.

Sand the repair or resurfacing area with 180 grit. If repairing, remove or fix any cracked or damaged gelcoat. Grind out cracks down to the laminate, and bevel out the edge of the existing gelcoat. Repair laminate or assure the laminate is sound. We recommend Duratec 1799-006 Vinyl Ester Primer, especially below the water line.

## Blend

**OPTION #1- 50/50 BLEND** 1 part (50%) Duratec 904-001, 1 part (50%) gelcoat. Recommended for all repairs where opacity is not an issue. See option #2 for dark gel coat colors.

- 1 Catalyze blend with full strength MEKP catalyst at 2% mix ratio (see above note on catalyst).
- 2 Spray at least 2 passes over the repair, building up an additional 8 mils or more to match surface. Be sure to get back onto the first passes while they are sticky. Cover all the previously coated area. Feather the edge of the repaired area. Once surface cure is sandable (approx. 2-4 hours) sand as outlined below to cut surface and allow full cure.

**NOTE:** if you are not doing a repair area, and instead covering an entire surface, build up 18+ mils overall, 5-7 mils at a time while allowing out-gassing to occur between passes.

**OPTION #2 - 25/75 BLEND** 1 part (25%) Duratec 904-001, 3 parts (75%) gelcoat (see note) Recommended to maximize the hide\* (opacity). If opacity is not an issue, use option #1.

- 1 Catalyze blend with full strength MEKP catalyst at 2% mix ratio (see above note on catalyst).
- 2 Spray 3-4 passes over the repair or surface area, building up 12-15 mils. Allow at least two minutes between passes. Do not allow the Duratec/gelcoat to cure beyond the sticky/thumbprint stage between coats... usually about 30 minutes at 77°F when sprayed, faster in the cup. Feather the edge of the repaired area.

Once surface cure is sandable (approx. 2-4 hours) sand as outlined below to cut surface and allow full cure.

**\*NOTE:** Ultimate hide, particularly with dark, rich gel coat colors, may be best achieved by spraying gel coat without Hi Gloss Additive for initial build coats, and then blending at 50/50 for final coats (10-12 mils recommended especially below water line to ensure full cure through gel coated layers). Will provide smooth finish, allowing ultimate gloss, rich hide, and a fully cured surface.

[ CONTINUED ON NEXT PAGE ]



# DURATEC CLEAR HI-GLOSS ADDITIVE

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## Blend (continued from page 2)

**OPTION #3 - TOOLING GELCOAT UPGRADE:** Blend 10-25% Duratec 904-001 into the tooling gelcoat for a gelcoat upgrade. This will improve the flow and spray characteristics of tooling gelcoat.

- 1 Catalyze blend with full strength MEKP catalyst at 2% mix ratio (see above note on catalyst).
- 2 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 area. Feather the edge of the repaired area. Once surface cure is sandable (approx. 2-4 hours) sand as outlined below to cut surface and allow full cure.

## Sand & Polish

Sand when the surface has cured enough to not clog your paper. Start with the finest grit that is reasonable for the surface finish. With a good finish starting with 400 grit is possible.

The surface must be open for at least 8 hours between initial sanding and the start of polishing. The open time allows for styrene release and full cure.

Sand with progressively finer grits like 400, 600, 800, 1000. Compound and polish with products formulated for gelcoat like Aqua Buff 1000 and Aqua Buff 2000.

## Cure Times

Duratec High Gloss Additive is an air-cure additive designed to be combined with gel coat. Each gelcoat manufacturer and color option will have a different cure time. Those cure times, combined with factors like ambient temperature, 904-001/gel coat ratio, humidity, catalyst ratio, and mil depth can result in a spectrum of cure times. Some surfaces may be ready within two hours, others may take more than 24-hours for full cure.

Avoid spraying in temperatures below 64°F, and where possible, increase heat near part to improve cure time.



# DURATEC CLEAR HI-GLOSS ADDITIVE

TROUBLESHOOTING | PRODUCT #904-001

Problem	Cause	Solution
<b>1:1 Blend with gelcoat fails to cure</b>	Possible incompatibility between additive and gelcoat.	Check both products separately for cure; if ok, the products are not compatible.
	High humidity.	Apply heat or spray in controlled humidity environment.
	Cool temperatures.	Spray in controlled temperature environment.
	Improper catalyst used.	Ensure using full strength catalyst at the recommended 2% ratio.
<b>Fisheyes</b>	Possible incompatibility between additive and gelcoat.	Check both products separately for cure; if ok, the products are not compatible.
	Air contamination. (The lower viscosity of the additive/gel coat blend increases the susceptibility to fisheyes).	Check water and oil filtration in the air line.
<b>Low hide or color lightens when sanding.</b>	Addition of Additive reduces gel coat pigment load resulting in a thinner opacity or hide, particularly in dark gelcoats (black, blue, red).	Reduce or eliminate the Hi Gloss Additive in the first few coats. Use 50/50 blend for final coat. See Option #2 Use Instructions.