

180 Clear Gel Coat



Overview: #180 Clear Gel Coat is a high performance, premium quality gel coat for both airless and air atomized spray applications. #180 offers UV light stability, excellent clarity, crack and chemical resistance. This deep, crystal-clear and non-yellowing gel coat is compatible with underwater and water contact marine applications as well as sanitary ware such as showers and tubs. It is recommended to be used as a protective clear coat over Chromaveil™, other colors or glitterflake. Blend with #1040 Duratec Hi-Gloss Additive when top coating. Requires 1.5% MEKP

Available in quarts, gallons and 5 gallon pails as well as resin/hardener kits

Features & Benefits:

- MACT Compliant
- Isophthalic Acid Derived
- Neopentyl Glycol Derived
- Excellent Color
- Enhanced Weather Ability
- Excellent Spray Ability
- Enhanced Shelf Life

Typical Cure Schedule:

Gel Time	8-10 mins
Gel to Peak	6-8 mins
Peak Exotherm	390-405°F

Catalyst @ 77°F w/1.5% MEKP

Typical Product Properties (Uncured):

Viscosity @ 77°F LVF #4 @ 6 RPM	10-13,000 cps
Viscosity @ 77°F LVF #4 @ 60 RPM	17-2000 cps
Thix Index	5.9 - 6.5
HAP's	44-46%
Coverage @ 20 mils, wet	approx. 80 ft ² /gallon

Mixing Directions: Shake well before using. To initiate hardening add PART #69 MEKP HARDENER in a ratio of 1.5%. For easy measure, use 1.5 teaspoons of hardener per pint (pound) of resin or 3 teaspoons per quart. For very small quantities use 19 drops of hardener per ounce of resin. Measure the components, do not guess at them.

At a temperature of 77°F the resin will begin to harden in about 12 minutes and be ready for applying reinforcements in about one hour. At cooler temperatures the mixture will take longer to harden and at warmer temperatures it will take less time. The ratio of hardener may be adjusted to compensate for temperature extremes; add up to 50% more hardener when cooler and correspondingly less when warmer.

Do not apply when temperatures are below 60°F. Mix only small quantities when the temperature is about 85°F as hardening will occur very rapidly. Never apply in direct sunlight. Mix in clean glass, paper, plastic or metal containers. Do not use foam containers. Mix no more than you can use before the resin will begin to harden, and thereafter let your experience guide you. Do not return mixed (catalyzed) gel coat to container.

Clean tools with #9 PURE VIRGIN ACETONE or lacquer thinner.

Surface Preparation: A previously gel coated surface must be clean and free from dirt, oil or other foreign materials and then lightly sanded prior to repairs. Mold surfaces should be prepared as instructed by the mold release manufacturer.

Gel Coat Repairs: Small spot repairs are best done by dabbing the gel coat onto the area with a small brush and then covering with a piece of plastic to make sanding easier. In 4-6 hours the area can be sanded and the process repeated as many times as necessary until the damage is filled. Large repairs are best achieved by spraying the material through automotive siphon or HVLP spray equipment which provides excellent material control. #180 Clear Gel Coat should be reduced with #1040 Hi-Gloss Gel Coat Additive to be sprayed through this type of equipment. To ensure a tack-free surface, wait 30 minutes after spraying gel coat and then spray on a layer of #13 PVA Parting Film. This will form a barrier to the air and prevent the tackiness problem. Wash film off with water in 4-6 hours before polishing.

Problems:

- Dullness: Dull mold surface, insufficient catalyst.
- Slow Gelatin: Cold mold surface, insufficient catalyst, gel coat too thin.
- Pinholes: Initial pass too heavy, insufficient atomizing pressure.
- Wrinkling: Cold mold, insufficient catalyst, insufficient gel coat thickness.
- Glass Pattern Print-Through: Gel coat too thin, cold mold, insufficient catalyst.
- Sagging: Excessive gel coat, insufficient atomization.
- Lifting of Gel Coat From Mold: Too much catalyst, mold too warm, gel coat applied too thick.

Safety & Handling: #180 Clear Gel Coat 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. Individuals should observe conditions of good industrial hygiene and safe working practice. For more detailed instructions on handling please see the MSDS Sheet.

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 # 180 Clear Gel Coat at 73°F, in dry conditions away from open flames and high temperatures. For more detailed instruction on storage please see the MSDS Sheet.