

## TotalBoat Polyester Structural Repair Putty – Tech Data Sheet

### SUPPORT PRODUCTS:

- Cleaner/Prep:** Acetone  
**Airdry Product:** Paraffin wax additive, PVA (polyvinyl alcohol)  
**Cleanup:** Before cured, clean up with acetone. Once cured, it must be removed mechanically.

### SURFACE PREPARATION:

**NEW LAMINATION:** TotalBoat Polyester Structural Repair Putty will cure directly to polyester resin-based laminates that are catalyzed and cured at the same time, and no surface preparation is required.

**BONDING PREVIOUSLY CURED** Substrates must be free of any coatings, grease, oil, paint, or wax.

**LAMINATES:** Grind the surface until rough, or sand with 36-grit sandpaper.  
Thoroughly remove any grinding/sanding residue, and wipe with acetone.

### APPLICATION:

**APPLICATION CONDITIONS:** Application temperature range is 60-90°F and 0-90% RH.  
DO NOT apply when rain, dew, or other contaminants may be present or affect the cure.

#### APPLICATION:

- 1-2% MEKP catalyst (included) must be added for TotalBoat Polyester Structural Repair Putty to cure. More catalyst will shorten working time, but will maintain working time at cooler temperatures.
- For a 100g mass, catalyze with 1% MEKP for roughly 15-20 minutes of working time at 70°F (14 drops of MEKP per ounce of putty).
- \*\*Note that the gel time of catalyzed putty will be faster for larger masses, and slower for smaller masses.\*\*  
The cure is an exothermic reaction and will create heat.

#### FOR AIR DRY:

For applications where this product will not be laminated over, a polyester resin air dry solution can be added at the rate of 1 ounce per quart of putty before catalyzing. Polyvinyl alcohol can also be sprayed or brushed over the surface, allowing the polyester resin to cure fully.

### APPLICATION DATA:

<b>Material Consistency:</b>	Smooth, Putty
<b>Application Method:</b>	Spreader/Trowel
<b>Working Time:</b>	Dependent on temperature, catalyst amount, and mass of Polyester Structural Repair Putty **10-15 minutes (100g mass catalyzed with 1% MEKP @ 77°F)
<b>Cure Time:</b>	Dependent on temperature, catalyst amount and mass of Polyester Structural Repair Putty **20-30 minutes (100g mass catalyzed with 1% MEKP @ 77°F)
<b>Application Temperature:</b>	50-95°F, 0-90% RH
<b>Cleanup:</b>	Acetone. Once cured, it must be removed mechanically
<b>Cure Methods (not included with purchase):</b>	Air Dry: Paraffin wax (4 oz. of wax per gallon of putty); polyvinyl alcohol Vacuum Method: Vacuum bag

### PHYSICAL DATA:

<b>Components:</b>	Two - Resin and Catalyst
<b>Flash Point:</b>	88°F
<b>Units:</b>	Quart, Gallon
<b>Weight Per Gallon:</b>	8.9-9.1lbs.
<b>VOC Content:</b>	41-46%
<b>Smell/Scent:</b>	Styrene
<b>Viscosity:</b>	450,000-650,000 cps
<b>Storage:</b>	Cool, dry, well-ventilated area away from oxidizing materials. Keep container closed tightly.
<b>Color:</b>	Blue
<b>Shelf Life/Stability:</b>	3-4 months (can be longer, depending on storage conditions)
<b>Filler Materials:</b>	Milled glass fibers **Does not contain TiO <sub>2</sub> , CaCo <sub>3</sub> , or Talc**

DATE: March 7, 2018

