



TotalBoat Gelcoat Tech Data Sheet

TotalBoat White & Neutral Gelcoats (with and without wax) are ISO NPG, thixotropic, polyester gelcoats designed for cosmetic concealment of small to large FRP parts at an ambient temperature. These gelcoats are pre-promoted for curing at room temperature with the addition of methyl ethyl ketone peroxide (MEKP) catalyst. They are designed to be used with both the spray-up and hand layup techniques. Uses include yacht/boat construction and manufactured parts.

Features: High-gloss finish, good weather resistance, good heat resistance, and good water resistance

TYPICAL PROPERTIES (Uncured resin)

TEST	VALUE
Heat Distortion Temperature	185°F – 205°F
Viscosity, 77°F	5,000 – 8,000 cps
Specific Gravity, 77°F	1.1 – 1.4
Curing Property, 77°F	2% MEKP 9% active
Gel Time	8-12 minutes
Thix Ratio	7.5 – 9.5
Peak Exothermic Temperature	335°F – 400°F

DIRECTIONS: TotalBoat Gelcoat requires MEKP (methyl ethyl ketone peroxide) catalyst to cure. As with all polyester resin, rate and degree of cure are a function of catalyst concentration and of temperature. Resin and work area should be between 70°F and 95°F to ensure satisfactory results.

At 77°F, TotalBoat Gelcoat requires the addition of 2% MEKP catalyst, by volume: 14-16 drops per ounce, or 2 teaspoons per pint, for a working time of 10-15 minutes. The amount of catalyst may be adjusted in small, incremental amounts, either upward or downward, to account for temperature differences (more for cooler temperatures, and less for warmer temperatures). The acceptable amount of MEKP is 1-3%. Do not use more or less catalyst than this or you may get an improper cure, with laminates exhibiting moderate to severe post cure after demolding. Once cured, the gelcoat can be dewaxed, wet sanded, and buffed.

TINTING INSTRUCTIONS: Note: If used, gelcoat colorants are added before adding MEKP catalyst. Adding color to white gelcoat creates lighter, pastel colors. Adding color to neutral gelcoat creates bold or darker colors. TotalBoat White Gelcoat (with wax or without wax) can be can be tinted by adding up to 1% polyester resin or gelcoat colorants prior to adding MEKP catalyst. TotalBoat Neutral Gelcoat can be tinted by adding up to 10% polyester resin or gelcoat colorants (up to 12% for red, yellow, purple, orange, and light green).

The information herein is general information designed to assist customers in determining whether TotalBoat products are suitable for their applications. TotalBoat products are intended for sale to industrial and commercial customers. We require customers to inspect and test our products before use and to satisfy themselves as to contents and suitability for their specific applications. Nothing herein constitutes any warranty, express or implied, including any warranty of merchantability or fitness for a particular purpose, nor is any protection from any law or patent to be inferred. The exclusive remedy for all proven claims is limited to replacement of our materials and in no event shall we be liable for special, incidental or consequential damages.



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HOW TO GET A TACK-FREE CURE FOR GELCOAT WITHOUT WAX: TotalBoat Gelcoat Without Wax is commonly used for the first layer of a polyester resin layup, but if it is used for a repair, either add a paraffin wax additive (20 drops per ounce of gelcoat without wax), or spray PVA (polyvinyl alcohol) over the finished product, for a proper cure.

CLEANUP: Clean up gelcoat with acetone before the gelcoat has cured. Once cured, it must be removed mechanically.

STORAGE: To ensure maximum stability and maintain optimum resin properties, resins should be stored in closed containers at temperatures below 75°F, and away from heat sources and sunlight. All storage areas and containers should conform to local fire and building codes. Stock should be stored away from all sources of flame or combustion. Inventory levels should be kept to a reasonable minimum, with first-in, first-out stock rotation.

SAFETY: Read and understand the Safety Data Sheet before working with this product.

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