



KoverTek



GELCOAT & TOPCOAT

PERFORMANCE COATINGS, COMPOSITES AND CHEMICALS



KoverTek is a manufacturer and distributor of Performance Coatings, Composites and Chemicals designed for the Building & Construction, Land Transport, Wind Energy and Marine sectors.



Images courtesy of Fibreglass Technology Ltd

Fibreglass Technology Ltd, a company based in Glasgow established by Darren Ferrier in 2006, specialise in design through to manufacture of GRP parts. Having used the Nord Gelcoat 161 Industrial grade supplied by KoverTek for many years now, Darren is a fan of the consistent material and fast service that the Nord and Kovertek teams facilitate. Darren says,

“

By using these quality materials the finished product is always the same and in my opinion produces beautiful finished mouldings. The 161 Gelcoat gives Fibreglass Technology the balance of quality and cost effectiveness, which is quite important in these uncertain times.

Darren Ferrier - Managing Director
Fibreglass Technology Ltd

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Gelcoats & Topcoats

Approved range of coloured Polyester Gelcoats. Choose from a full range of RAL and British Standard Colours

- General Purpose/ Industrial
- Isophthalic
- Vinyl Ester
- Tooling (more detail in the dedicated Tooling section)
- Fire Rated Gel Coats
- ISO NPG Gel Coat
- Low Styrene
- Anti Bacterial
- WRAS Approved
- Sandable
- Scratch Resistant
- Epoxy Bonding

GELCOAT/ TOPCOAT	DESCRIPTION	APPLICATION
GC161 / TC161	General Purpose / Industrial Gelcoat (Brush/Hand Lay Up)	Building, transport or any general industrial moulding applications
GC168 / TC168	General Purpose / Industrial Gelcoat (Spray Applied)	Building, transport or any general industrial moulding applications
GC610 / TC610	Lloyds approved (Brush/Hand Lay Up) Isophthalic	Marine – hulls, decks and components or other building/ transport or industrial applications requiring excellent colour stability and gloss retention when exposed to sunlight
GC181/ TC181	Isophthalic Gelcoat (Brush/Hand Lay Up) ANTIBACTERIAL APPROVAL	Building, transport or any general industrial moulding applications where Isophthalic weathering and mechanical properties are required
GC188 / TC188	Isophthalic Gelcoat (Spray Applied) ANTIBACTERIAL APPROVAL also WRAS approved for potable water	Building, transport or any general industrial moulding applications where Isophthalic weathering and mechanical properties are required
GC511	Sandable Gelcoat (Brush/Hand Lay Up)	Sandable gelcoat for easy and precise abrasion. Transport market or any parts that need to be post-painted
GC524	Compliant with En 14688 Norm (Spray Applied)	Sanitary gelcoat with good abrasion resistance
GC194 / TC194	ISO/NPG Gelcoat (Brush/Hand Lay Up)	Sanitary ware gelcoat or other applications requiring excellent colour stability and gloss retention when exposed to sunlight
GC195 / TC195	ISO/NPG Gelcoat (Spray Applied)	Marine - hulls, decks and components or other applications requiring excellent colour stability and gloss retention when exposed to sunlight
GC794	ISO/NPG Gelcoat (Roller or Brush Applied)	Pools & Ponds requiring chemical resistance
GC795 GC796	ISO/NPG Gelcoat (Roller or Brush Applied) Low styrene emission spray	Marine - hulls, decks and components or other applications requiring excellent colour stability and gloss retention when exposed to sunlight
GC860	ISO/NPG Gelcoat (Spray Applied)	Sanitaryware applications - sinks, shower trays, baths requiring good resistance to chemicals & thermal shock
GC165	ISO/NPG (Spray Applied)ISO/NPG (Spray Applied)	RTM grade
GC184	Fire Rated Gelcoat (Brush Applied)	M1F1 & HL2 Fire rated with Norester 80/83
GC185 / TC185	Fire Rated Gelcoat (Brush/Spray)	Class 1 *with Norester 85
GC199 / TC199	Fire Rated Gelcoat (Brush)	Class 2 *with Norester 895/880 or 056/113
GC151	Fire Rated Gelcoat (Brush and Spray Applied)	Class 1 & 2 *with Norester 8435, Norester 912 and achieves class 1 with Norester 880
GC296	Vinyl Ester Gelcoat, Anti Static (Brush Applied)	Electrical Conductive Gelcoat for antistatic applications with good chemical resistance and mechanical strength
GC250 / GC251	Epoxy Bonding Gelcoat (GC 250 Brush Applied) (GC 251 Spray Applied)	Vinyl ester Gelcoat specially formulated to obtain adhesion with epoxy resins
GC886	Fire Rated Gelcoat (Spray Applied)	Class 1, HL2 M1F1 with Norester 880
GC8100	Low styrene content (20%) Isophthalic Gelcoat with UV resistance (Spray Applied)	Suitable for industrial parts where good UV resistance is required. Excellent handling
GC8120	Low styrene content (20%) and high brightness. Compliant with En 14688 Norm (Spray Applied)	Sanitary gelcoat with good abrasion resistance, complies with EN14688 norm. High brightness
GC8140	Low Styrene Iso Gelcoat for Marine Parts (Spray Applied)	Marine - hulls, decks and components or other applications requiring excellent colour stability and gloss retention when exposed to sunlight
Pigment Pastes	All RAL and BS shades Supplied	1kg, 5kg, 20kg, 25kg sizes
Tooling Gelcoats	Full range of Iso and Vinyl Ester types	See separate tooling brochure

General Purpose/Industrial Gelcoats

Very popular general purpose / industrial grade gel coat suitable for most non marine applications. Available in any RAL or BS shade in packs of 5kg, 20kg, 25kg, 225kg

GC161

Pre-Accelerated



BRUSH

KEY TECHNICAL FEATURES: -

Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	12 minutes
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5 rpm 30000 mPa 50 rpm 7000 mPa
Flexural strength	80 to 100 MPa (ISO 178)
Flexural modulus	3.6 to 3.8 GPa (ISO 178)
Tensile strength	38 to 50 MPa (ISO 527)
Elongation at break	2.3 to 2.8 % (ISO 527)
Heat distortion temperature (HDT)	72 °C (ISO 75-3)
Barcol hardness	50
Topcoat version (TC161)	With wax addition for tack free finish

*A very popular general purpose / industrial grade gel coat suitable for most non marine applications.
Available in any RAL or BS shade in packs of 5kg, 20kg, 25kg, 225kg*

GC168

Pre-Accelerated



SPRAY

KEY TECHNICAL FEATURES: -

Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	10-14 minutes
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5 rpm : 140 - 200 Poise 50 rpm : 22 - 28 Poise
Flexural strength	80 to 100 MPa (ISO 178)
Flexural modulus	3.6 to 3.8 GPa (ISO 178)
Tensile strength	38 to 50 MPa (ISO 527)
Elongation at break	2.3 to 2.8 % (ISO 527)
Heat distortion temperature (HDT)	72 °C (ISO 75-3)
Barcol hardness	50
Topcoat version (TC168)	With wax addition for tack free finish

A popular sprayable general purpose/industrial gel to use for most industrial applications (non marine) available in any RAL and BS shades in pack sizes 5kg, 20kg, 25kg and 225kg



Isophthalic Gelcoats (For Good Weathering & Mechanicals)

Based on Isophthalic resin to use for quality applications. Easy to Brush & spray, do not drain on inclined surfaces. Good handling and coverage. No porosity. Fast drying. Good mechanical and impact resistance. Excellent resistance to hydrolysis. Certain grades suitable for food contact.

GC610

Isophthalic
Lloyds Approved
Marine Grade
Gelcoat

Pre-Accelerated



BRUSH

KEY TECHNICAL FEATURES: -

Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	10-14 minutes
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5 rpm : 270 - 430 Poise 50 rpm : 65 - 85 Poise
Flexural strength	111 MPa (ISO 178)
Flexural modulus	3 gpa (ISO 178)
Tensile strength	61 MPa (ISO 527)
Elongation at break	4.1 % (ISO 527)
Heat distortion temperature (HDT)	75 °C (ISO 75-3)
Barcol hardness	50
Topcoat version (TC160)	With wax addition for tack free finish

Market leading high quality Lloyds approved brush-able Gelcoat with excellent coverage, handling, hide and with superior gloss. Suitable for all demanding applications including marine where weathering performance is important. If you are brushing you will love this gel! in pack sizes 5kg, 20kg, 25kg and 225kg

Low viscosity version: GC610BV with a viscosity at 5 rpm: 195 - 245 Poise, at 50 rpm: 55 - 65 Poise (20°C - sp6) and a gel time of 11 - 15 min (20°C - 2% MEKP M50 on 100g).



Nord has been setting performance benchmarks in marine gelcoats for over 30 years. Trusted by leading, Nord has now developed 610PA - the next generation brush marine gelcoat, to rival old benchmark iso gelcoats.

Lloyds Approved -

610PA retains all the benefits such as excellent handling properties, proven osmotic blistering resistance and reliable product quality, but with four major improvements: improved weathering performance, excellent handling and hide, but also excellent gloss straight from the mould.

All our gelcoats come with the proven, quality guarantees associated with Nord Composites, plus a technical support service you can rely on to help your business to be more successful.



GC181

Isophthalic Gelcoat Pre-Accelerated

ANTIBACTERIAL
APPROVED



BRUSH

KEY TECHNICAL FEATURES: -

Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	6-10 min
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5 rpm : 375 - 525 Poise 50 rpm : 70 - 90 Poise
Flexural strength	77.1 MPa
Tensile strength	48.35 MPa
Elongation at break	2.29%
Temperature of deflection under load* (HDT) (ISO 75-3)	81,9°C
Topcoat version (TC188)	With wax addition for tack free finish
Antibacterial Approval	We can add an antibacterial additive to this gelcoat to comply with food contact applications
Barcol hardness	45

GC181 is a gel coat based on Isophthalic resin to use for quality applications.

For brush application. GC181 is easy to apply and does not drain on inclined surfaces. Good handling and coverage.

No porosity. Fast drying. Good mechanical and impact resistance. Excellent resistance to hydrolysis. Food contact applications: according to the global migration test. Report RE N° -15/12299 of 21 July 2015. Pack sizes 5kg, 20kg, 25kg and 225kg

GC188

Isophthalic Gelcoat Pre-Accelerated

ANTIBACTERIAL
APPROVED



SPRAY

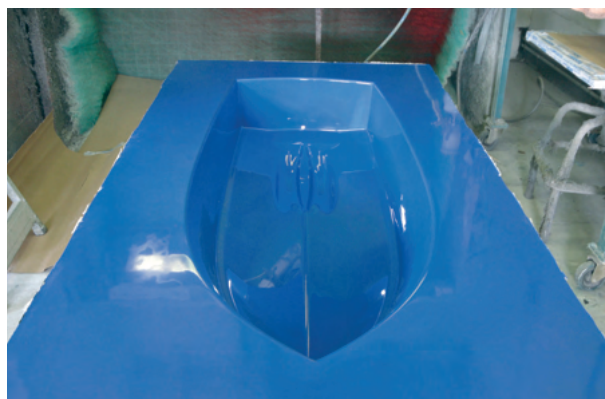
KEY TECHNICAL FEATURES: -

Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	10 - 14 min
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5 rpm : 140 - 200 Poise 50 rpm : 22 - 28 Poise
Flexural strength	159,2 MPa
Tensile strength	58,43 MPa
Elongation at break	2.67%
Temperature of deflection under load* (HDT) (ISO 75-3)	81,9°C
Brush Variant GC 181 Topcoat version (TC188)	With wax addition for tack free finish
Antibacterial Approval	We can add an antibacterial additive to this gelcoat to comply with food contact applications

GC188 is a gel coat based on Isophthalic resin to use for quality applications.

For spray application. GC188 is easy to spray and does not drain on inclined surfaces. Good handling and coverage.

No porosity. Fast drying. Good mechanical and impact resistance. Excellent resistance to hydrolysis. Food contact applications: according to the global migration test. Report RE N° -15/12299 of 21 July 2015. Pack sizes 5kg, 20kg, 25kg and 225kg



Sandable Gelcoats (Ideal for automotive parts)

Polyester gel coat developed for production of parts which are sanded and repainted.
Typical for automotive parts and mouldings.

GC511

Sandable Gelcoat



BRUSH

GC511 is Pre-accelerated and thixotropic. Curing at ambient temperature by addition of MEKP catalyst. Easy to sand. Fast drying.



KEY TECHNICAL FEATURES: -	
Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	6-10 MINS
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5 rpm : 375 - 525 Poise 50 rpm : 70 - 90 Poise
Flexural strength	159,2 MPa
Tensile strength	58.3 MPa
Elongation at break	2.67%
Heat distortion temperature (HDT)	81,9°C



ISO/NPG Gelcoats (For extreme weathering, gloss retention and mechanicals)

Isophthalic Neopentyl Glycol based Polyester gelcoat developed for superior UV weathering performance in the most testing environments (marine) Excellent colour and gloss retention over time, superb water resistance with very low pick-up, high resistance to osmotic blistering, tough, long-lasting and durable surface, excellent handling

GC194

ISO/NPG Gelcoat

Sanitaryware



BRUSH

KEY TECHNICAL FEATURES: -	
Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	8-10 min
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5rpm 375 - 525 Poise, 50 rpm: 70 - 90 Poise
Flexural strength	113 MPa
Tensile strength	63 MPa
Elongation at break	4%
Barcol Hardness	45
Topcoat version (TC194)	With wax addition for tack free finish

GC194 Superior UV weathering performance. Excellent colour and gloss. retention over time, superb water resistance with very low pick-up, high resistance to osmotic blistering, tough, long-lasting and durable surface, excellent handling.

GC195

ISO/NPG Gelcoat

Sanitaryware



SPRAY

KEY TECHNICAL FEATURES: -

Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	10-14 min
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5 rpm : 140 - 200 Poise 50 rpm : 22 - 28 Poise
Flexural strength	113 MPa
Tensile strength	63 MPa
Elongation at break	4%
Barcol Hardness	45
Topcoat version (TC195)	With wax addition for tack free finish

GC195 is a spray isophthalic Neopentyl Glycol based Polyester gelcoat developed for superior UV weathering performance in the most testing environments. Excellent colour and gloss retention over time, superb water resistance with very low pick-up, high resistance to osmosis blistering, tough, long-lasting and durable surface, excellent handling.

GC794

ISO/NPG Gelcoat

Ideal for Swimming Pools and Ponds



BRUSH



ROLLER

KEY TECHNICAL FEATURES: -

Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	8 - 12 minutes
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5 rpm : 150 - 210 Poise 50 rpm : 35 - 45 Poise
Flexural strength	107.9 MPa
Elongation at break	2.85%
Barcol Hardness	50
Temperature of deflection under load* (HDT)	72°C
Flexural modulus* (ISO 178)	4.38 GPa

GC794 is a brush isophthalic Neopentyl Glycol based Polyester gelcoat developed for Excellent colour and gloss retention over time, superb water resistance with very low pick-up, high resistance to osmosis blistering, tough, long lasting and durable surface, excellent handling. It is formulated for swimming pool industry. Pre-accelerated and thixotropic gel coat. Roller application. No drainage on vertical surfaces. High quality of covering power. Excellent water resistance and chlorine resistance.

GC860

ISO/NPG Gelcoat

Ideal for Sanitary Ware



SPRAY

KEY TECHNICAL FEATURES: -

Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	22 - 28 min
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5 rpm : 100 - 140 Poises 50 rpm : 19 - 25 Poise
Flexural strength	134.6 MPa
Elongation at break	4.01 %
Barcol Hardness	45-45
Temperature of deflection under load* (HDT)	70°C
Flexural modulus* (ISO 178)	3.93 GPa

GC 860 is a spray isophthalic Neopentyl Glycol based Polyester resistance. It is recommended for a use in the sanitary industry. Thixotropic and pre-accelerated, formulated for spray application. Good resistance to thermal shock.

Fire Rated Gelcoats

Polyester gel coat developed for production of parts which require a fire rating. Typically for land transport or construction applications.

GC185

Class 1 Fire rated
Gelcoat



BRUSH



SPRAY

KEY TECHNICAL FEATURES: -

Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	8 - 12 minutes
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5 rpm : 375 - 525 Poise 50 rpm : 60 - 80 Poise
Flexural strength	61.1 MPa
Elongation at break	2.48 %
Barcol Hardness	45
Temperature of deflection under load* (HDT)	76.6°C
Flexural modulus* (ISO 178)	4.196 GPa

Pre accelerated and thixotropic. A quality UV Stable gelcoat that cures at ambient temperature with MEKP peroxide. Available in all RAL and BS shades. Food contact applications: according to the global migration test. Report RE N° -15/12303 of 21 July 2015. *With Norester 85

GC199

Class 2 Fire rated
Iso-NPG Gelcoat



BRUSH



SPRAY

KEY TECHNICAL FEATURES: -

Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	10 - 14 min
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5 rpm : 140 - 200 Poise 50 rpm : 22 - 28 Poise
Flexural strength	130 MPa
Tensile Strength	80 MPa
Barcol Hardness	45 after 24hrs
Temperature of deflection under load* (HDT)	95°C
Elongation at break	3.5%

Pre accelerated and thixotropic halogen free. A quality UV Stable gelcoat that cures at ambient temperature with MEKP peroxide. Available in all RAL and BS shades. Great water and weathering resistance. *With Norester 056/113, 895 or 880

GC151

Class 1/ 2 Fire rated
Iso-NPG Gelcoat



BRUSH



SPRAY

KEY TECHNICAL FEATURES: -

Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5 rpm : 140 - 230 Poise 50 rpm : 20 - 36 Poise
S.G	1.40 - 1.55 g/cm ³
Solid content	74 – 76 %
Drying time on film (ICON 002) (23°C - 2% MEKP M50 on 100 g)	50 - 70 minutes

Gelcoat GC151 is formulated with ISO-NPG polyester resin. It is filled and suitable for applications which require fire-retardant classification. Halogen free gel coat. Thixotropic and pre-accelerated. Curing at ambient temperature with addition of MEKP peroxide. GC151 is classified Class 1 with the resin NORESTER® 880 CONTACT following the norm BS476-7. GC151 is classified Class 2 with the resin NORESTER® 912 or NORESTER® 8435 following the norm BS476-7.

Boat Industry

Lloyds approved Range

Products designed to provide optimum performance properties for marine part production

- Application behaviour
- Osmosis resistance
- Weathering resistance

GELCOAT

Norester GC795

Premium Iso NPG Gelcoat.

Norester GC8140

Low styrene emission Gelcoat based on Iso NPG Resin

SKINCOAT

Norester 690 TPA

Vinylester urethane modified resin

STRUCTURE

Norester 912 series

Orthophthalic HLU Resin

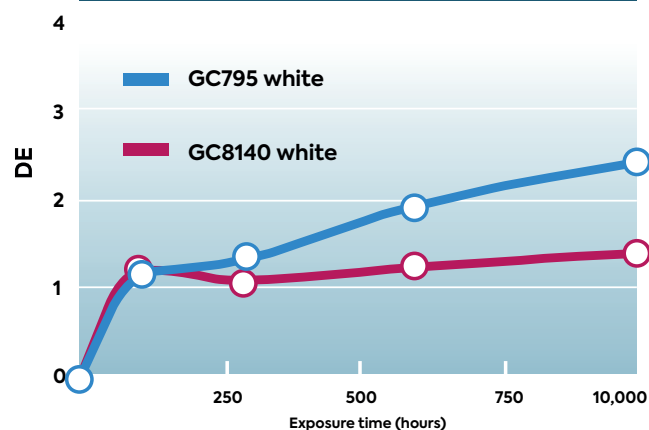
Norester 8435 series

Ortho DCPD HLU Resin

Fenapol 11117 AZ

Orthophthalic Infusion Resin

UVA resistance - Norm NF T30-036



Industrial Parts

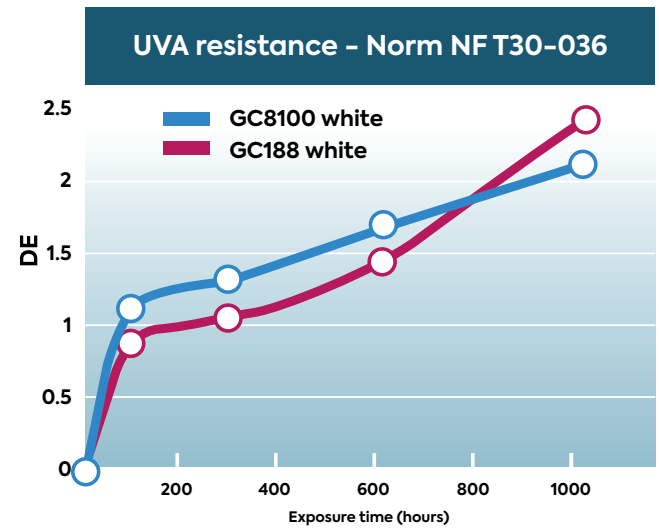
GELCOAT

Norester GC188

Isophthalic Gelcoat with UV resistance

Norester GC8100

Low styrene content (20%) Isophthalic Gelcoat with UV resistance



HAND LAY-UP RESINS

Fenapol UP 8415 TAE 30

Low styrene content Ortho DCPD resin

Fenapol UP 8420 TAE 30

Low styrene content Ortho DCPD resin

Norester 8435 TAE

*Low emission styrene Ortho DCPD resin,
Lloyds approved*

Norester 912 TPAV

*Low emission styrene Orthophthalic resin,
Lloyds approved*



Sanitary Market

RESINS

Fenapol UP 8793 AFX 15

ISO NPG Resin designed for polymer concrete.
Light colour with good chemical resistance and
high thermal shock resistance

Fenapol UP 8330 AZ 10

Polyester resin designed for solid surface with
low shrinkage and a viscosity that allows for a
high level of fillers for polymer concrete

GELCOAT

NORESTER GC524

Compliant with En 14688 Norm

NORESTER GC8120

Low styrene content (20%) and high brightness.
Compliant with En 14688 Norm



RESISTANT TO SCRATCHING

Scratch Depth
<100µm



RESISTANT TO ABRASION

Tough, durable formula
that lasts



RESISTANT TO CHEMICALS & STAINING AGENTS

Acids, Alkalis, Alcohol,
Bleaches, Staining
Agents, Salts



RESISTANT TO TEMPERATURE CHANGES

No visible defects
after 1000 cycles



Epoxy Bonding Gelcoats

GC250

Epoxy Bonding
Gelcoat based on
Vinyl Ester



BRUSH



SPRAY

KEY TECHNICAL FEATURES: -

Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	10 - 14 min
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5 rpm : 120 - 180 Poise 50 rpm : 35 - 45 Poise
Flexural strength	143.7 MPa
Tensile Strength	44.93 MPa
Barcol Hardness	45
Temperature of deflection under load* (HDT)	105°C
Elongation at break	2.66%

A pre-accelerated and thixotropic gelcoat available in brush and spray variants (GC251). Pigmented to any RAL or BS shade.

Low Styrene

GC8100

Low styrene
content

Pre-Accelerated



SPRAY

KEY TECHNICAL FEATURES: -

Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	10 - 14 min
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5 rpm : 140 - 200 Poise 50 rpm : 22 - 28 Poise
S.G	1,30 - 1.41 g/cm ³

GC8100 is based on an Isophthalic polyester resin. It is recommended for the production of industrial parts. Thixotropic and pre-accelerated. Formulated for spray application. Cures at ambient temperature by addition of MEKP (type Butanox M50) catalyst. Low styrene content. Good abrasion resistance according to NF14688 (Indicative test).



Tek-Kote Range

A range of Semi Permanent, Silicone free Release Agents for mould preparation, release and care. Available in 1Ltr and 5Ltr pack sizes.



KOVERTEK	DESCRIPTION	VE & PE RESINS		EPOXY RESINS	
TEK-KOTE		Gel Coat	Non-Gel Coat	RTM/Infusion	Prepreg
Tek-Kote Resi-Release	Wipe on Leave On or Spray On release agent		✓	✓	✓
Tek-Kote Fast-Release	High gloss wipe on only release agent	✓		✓	
Tek-Kote Fast-Release-XPRES	High gloss wipe on only release agent	✓			
Tek-Kote Spray-Release Gloss	High gloss fast dry sprayable release agent	✓		✓	
Tek-Kote Mould Cleaner	NOTE: All mould surfaces should be cleaned using Tek-Kote Mould Cleaner. New Moulds should be cleaned with Mould Cleaner and treated with 2 coats of Mould Sealer before adding 4 coats of the relevant sealer. Never use cotton rags, always use "Kovertek Dry Roll Wipes". When release agent has been opened, replace the lid straight away after use.				
Tek-Kote Mould Sealer					



GELCOAT USER GUIDE

- Storage
- Catalyst
- Planning
- Preparation
- Application
- Temperature
- Finishing



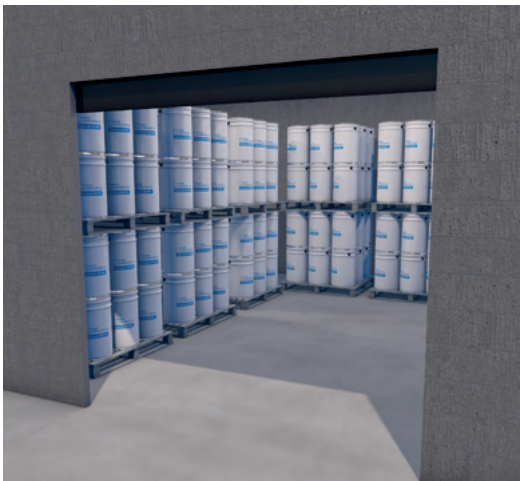
Taking Delivery:-

When a delivery arrives, check the order details / shipping advice for:

**ALWAYS STORE
CATALYST IN A DRY
LOCATION AWAY FROM
GELCOATS , RESINS &
CONTAMINANT RISKS**

CHECKLIST

- ☒ Packing condition
- ☒ Correct quantity
- ☒ Product Type & Colour
- ☒ Spray/Brush
- ☒ Batch number



Storing Your Gelcoat:-

- Keep in a separate storage room and out of direct sunlight
- Keep stock in original cans and drums with lids and caps tightly closed
- Pay attention to product shelf life and exercise regular stock rotation
- Store below 20°C. If storage is cold (eg outside shed), then product needs to be acclimatised to an ambient temperature (18 - 23°C) before use

Preparing Your Mould:-

- Clean the mould properly with Tek-Kote mould cleaner to remove any debris, dust or loose contaminants
- Apply Tek-Kote release agent to the surface of the clean mould, following the instructions carefully
- For a new mould, ensure that the surface is sealed with Tek-Kote mould sealer prior to application of the chosen release agent and apply release agent 5 times with an hour between each coat.
- Keep area used for gelcoating dust free, clean and free from air born contamination such as debris from your finishing area.
- Wear suitable PPE





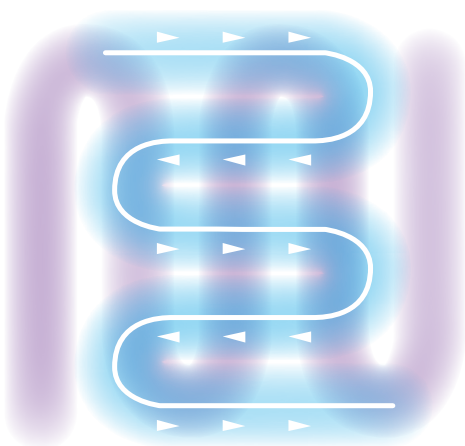
Preparing the Gelcoat:-

- Check that the drums or kegs picked from storage are in good condition and free from any damage prior to opening
- Check product code for correct colour and type
- Ensure enough product is mixed to spray or brush the mould in one session ensuring even and consistent thickness
- Using a low shear mechanical mixer, mix the gelcoat in its original can or drum and allow to stand for 10 minutes to allow the thixotropy to recover
- Prior to use, make sure the gelcoat is at its optimal working temperature of 18-25°C, absolute minimum temperature is 15°C. Remember the temperature will impact the cure rate of the gelcoat quite dramatically
- Use a clean pail if the gelcoat is decanted from its original packaging. (Buckets available from Kovertek).



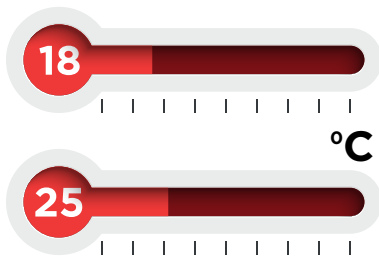
Spray Equipment Check List:-

- Make sure the machine filters are clean and clear
- Select an appropriate size of spray gun nozzle and angle to best suit the mould size and degree of complexity
- Check and adjust the spray pattern
- Use the lowest possible gun pressure that will achieve a uniform spray fan pattern typically 100-120psi is adequate.



Spray Application:-

- Check the mould surface and ensure its at room temperature
- Keeping the wrist flexible, start by spraying away from the mould and bring the gun towards it maintaining an even left to right spraying pattern at a consistent distance of approximately 50 -80cm. The gun should always be perpendicular to the mould.
- Avoid tilting or arcing the gun as this will result in uneven coverage and could lead to poor opacity or porosity in heavy areas.
- Avoid creating too much build-up of gelcoat in corners or along seams. Gelcoat thickness' above 500-600 microns will cause trapped air and lead to porosity.
- Avoid putting the gelcoat down in one single pass. Best practice is to create a mist coat followed by two thin coats of max 300 microns each, allowing for a minute or 2 in between coats.
- Cross-hatch the gelcoat spray pattern on the mould for even coverage
- Test gelcoat when coat is still wet. The wet film thickness target should be 500 - 600 μ .



Working area:-

- Ensure effective ventilation
- Good lighting for the mould area
- Ensure it's a dust free environment during and after spraying
- Ambient Temperature range 18-25°C (66-77°F)
- Humidity max 80%

Brush Application:-

- Check the mould surface is at room temperature.
 - Always use the best quality KoverTek brushes with long and soft bristles that don't drop hairs
 - Stir gelcoat in its original packaging before use (Don't over mix with high shear mixers)
 - Decant the required amount of gelcoat into a clean KoverTek bucket
 - Add 2% MEKP Catalyst to the gelcoat and mix thoroughly to ensure even distribution of catalyst through the liquid. Make sure the catalyst is a quality medium or high reactivity type. (Check with KoverTek if unsure) Some low reactivity types are not suited and offer poor cure through.
 - Apply to the mould immediately using positive brush movements but giving even coverage.
 - Test gelcoat when coat is still wet. The wet film thickness target should be 500 - 600 μ .
 - Use the thickness gauge measuring tool to check the wet film thickness during application.
 - Adhere to the gel time quoted on the TDS
 - Never add more than 4% catalyst (cure will be inhibited) but also ensure catalyst is measured out carefully each time.
- All too often catalysts are added without enough consideration to the recommendations.

We can offer a variety of Catalysts to suit the conditions and time of year.



When to Laminate:-

- Depending on room temperature, the gelcoat film will need approximately 1.5 - 2 hours to cure when it should then be tack-free and ready for laminating. As stated above room temperature plays a big part on cure times.
- Ensure an even and complete cure has occurred before commencing lamination.
- **DO NOT LEAVE THE GELCOAT TO CURE LONGER THAN 8 HOURS BEFORE STARTING LAMINATION**



Get in touch:

Tel: 01604 781702
Email: Info@kovertek.com
Web: kovertek.com

KoverTek Limited
Units 1-4 Poldermere
Red House Lane
Hannington
Northamptonshire
NN6 9SZ

Follow us on Facebook, Twitter, LinkedIn and Instagram

