
KoverTek
GELCOAT & TOPCOAT
EXPERIENCE WITH AGILITY

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 181 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 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

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 brochure)
- Fire Rated Gel Coats
- ISO NPG Gel Coat
- Low Styrene
- Anti Bacterial
- WRAS Approved
- Sandable
- Scratch Resistant Epoxy Bonding

KoverTek

EXPERIENCE WITH AGILITY

Kovertek are the distributors of NORD Gelcoats in the UK and Ireland. NORD have been setting high performance bench marks in Gelcoats for over 30 years. Trusted by industry leading experts, NORD have now developed the next generation of gelcoat technology and you can find them right here in this brochure.

NORD COMPOSITES since 1988

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. Kovertek would be happy to support you in your next project with samples and demos.

Contact us at **info@kovertek.com** for more info.

Contents

BRUSH Application

SPRAY Application

ROLLER Application

Gelcoats & Topcoats

GELCOAT/ TOPCOAT	DESCRIPTION	APPLICATION
GC610 / TC610	Lloyds approved (Brush/Hand Lay Up) Isophthalic (Marine Grade)	Marine – hulls, decks and components or other building/ transport or industrial applications requiring excellent colour stability and gloss retention when exposed to sunlight. Lloyds approved
GC794 (Brush/795 Spray)	Marine	Low styrene emission Gelcoat with very good UV and hydrolysis resistance. Lloyds approved
GC/TC 8140 (Brush and Spray)	Marine	Very good UV and hydrolysis resistance
Suncoat 900 /901 (Brush / Spray)	Marine	Superior Weathering ISO/ NPG Very good UV and yellowing resistance
GC181/ TC181 SV-I5 (Brush)	Isophthalic industrial type Gelcoat (Brush/Hand Lay Up) ANTIBACTERIAL APPROVAL	Building, transport or any general industrial moulding applications where Isophthalic weathering and mechanical properties are required
GC188 / TC 188 (Spray)	Isophthalic industrial type Gelcoat (Brush/Hand Lay Up) ANTIBACTERIAL APPROVAL	Building, transport or any general industrial moulding applications where Isophthalic weathering and mechanical properties are required
GC121 (Brush /128 Spray)	Sandable Gelcoat (Brush/Hand Lay Up and Sprayable)	Sandable gelcoat ideal for automotive applications where parts are post painted. Easy sanding and zero porosity
GC8120 (Spray)	Sanitary Ware	ISO Low styrene content (20%) and high brightness. Compliant with En 14688 Norm. Good thermal shock resistance
GC794/ (Brush GC795/Spray) (Top coats available TC794 TC795)	Sanitary Ware	794 ISO/NPG Very good thermal shock resistance. Compliant with En 14688 Norm
GC782 (Brush and Spray)	Sanitary Ware	Very good thermal shock resistance. Recommended for dark colours
GC860 (Spray)	Sanitary Ware	Translucent gel coat, very good thermal shock resistance
GC8145 (Spray)	Sanitary Ware	Very good thermal shock resistance meets EN14688 (Low Styrene)
GC185/TC185 (Brush/Spray)	Fire Rated	Class 1 Class 1 following BS476 part 7 with Norester 085 Resin. Also meets M1/F2
GC199/TC199 (Spray /Brush)	Fire Rated	ISO /NPG Fire retardant gelcoat with good thermal shock resistance. Complies to VO*, M2F1*, S4SR2ST2*, CLASS 2*, HL1 R1-R7-R17*
GC886 (Spray /Brush)	Fire Rated	ISO /NPG Fire retardant gelcoat. Complies to HL2 R1-R7*, OMI Floor*, BS2D0*
TOP COAT 933FR (Brush)	Fire Rated	ISO NPG Top Coat meets EN1187 test 4, EXT F.A.A BS476 Part 3, BROOF t4
GC250 (Brush) GC251 (Spray)	Epoxy Bonding Gelcoat	A pre-accelerated and thixotropic gelcoat available in brush and spray variants (GC251). Pigmented to any RAL or BS shade
GC8100 (Spray)	Low Styrene Gelcoats	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 NF
GC/TC 8140 (Brush and Spray)	Low Styrene Gelcoats	Very good UV and hydrolysis resistance. Low Styrene
GC8140 (Bush and Spray)	Low Styrene Gels for Swimming Pools and Ponds and Marine	Low styrene emission Gelcoat based on Iso NPG Resin
Suncoat 900 /901 (Brush / Spray)	Caravans, Recreational Vehicles	Superior Weathering ISO/ NPG Very good UV and yellowing resistance
TOP COAT TC 921 (Spray)	Caravans, Recreational Vehicles	Floor top coat, good aging behaviour based on Iso resin
TOP COAT TC741 (Spray)	Caravans, Recreational Vehicles	Self-levelling floor top coat based on Ortho resin
TOP COAT TC8280 (Brush)	Caravans, Recreational Vehicles	Floor top coat, V.low VOC content. Flexible.
GC296 (Brush GC297 Spray) (TOPCOATS VERSIONS AVAILABLE)	Tanks & Silos (Chemical resistant)	Vinyl Ester Gel Coat with high chemical resistance designed specifically for production of chemical tanks compatible with acids and alkalis
GC165 (Spray)	RTM Gelcoat	Gel coat for making RTM parts, stays tacky for 12 hours. Good UV and hydrolysis resistance
PIGMENT PASTES	All RAL and British Standard Colours along with custom colour matching to exacting standards	1kg,2.5kg, 5kg 20kg and 25kg
TOOLING GELCOAT	Full range of Iso and Vinyl Ester Types	see separate brochure

General Purpose/Industrial Gelcoats

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

BRUSH Application

GC 181 SV-I5

Isophthalic quality

KEY TECHNICAL FEATURES: -	
Brookfield viscosity (ISO 2555 - 23°C - sp6)	300 - 340 Poise
Gel time (ICON 002) 23°C - 2% MEKP on 100g	13-17 mins
Mechanical Properties of cured gel coat	
Elongation at break - ISO 527	1.7%
Temperature of deflection under load - HDT- ISO 75-2	66°C
Barcol Hardness	40-45

A very popular general purpose / industrial grade gel coat suitable for most applications. Available in any RAL or BS shade in packs of 5kg, 20kg, 25kg, 225kg. NOTE: All NORD Gelcoats are fully isophthalic as a minimum quality.

SPRAY Application

GC 188

Isophthalic Gelcoat
Pre-Accelerated

KEY TECHNICAL FEATURES: -	
Gel Time (ICON 002) (23°C – 2% MEKP on 100gr)	10 min
Brookfield Viscosity (ISO2555 - 23°C – sp5)	5 rpm : 140 - 220 Poise
Mechanical Properties of cured gel coat	
Elongation at break	1.8%
Temperature of deflection under load* (HDT) (ISO 75-3)	74°C
BRUSH VERSION	GEL COAT 181 SV-15
TOP COAT VERSION	TOP COAT 188 (with wax addition for tack free finish)
Certificates	Antifungal EN ISO 846-A

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.

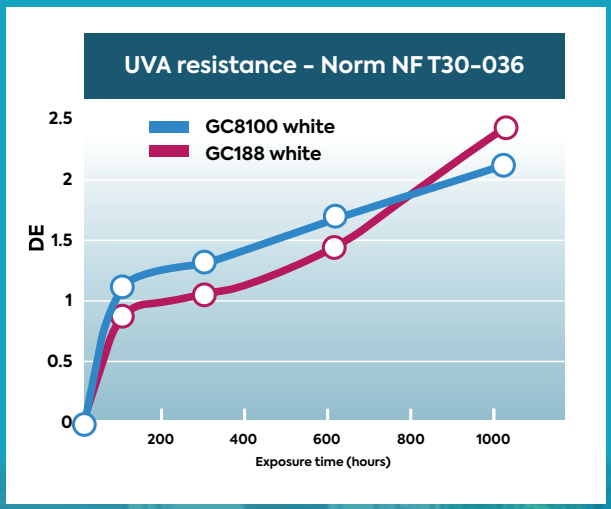
Industrial Parts

GELCOAT

GC 181 SV-15
Isophthalic Gelcoat (Brush/Hand Lay Up) Antifungal approval.

GC 188 SV-10
Isophthalic Gelcoat with UV resistance

GC 8100 SV-10
Low styrene content Isophthalic Gelcoat with UV resistance <or = 22%.



HAND LAY-UP RESINS

NORESTER 8420
Low styrene content Ortho DCPD resin < or = 20%

NORESTER 8435
Low emission styrene Ortho DCPD resin, Lloyds approved < or = 35%

NORESTER 912 TPAV
Low emission styrene Orthophthalic resin, Lloyds approved 912 or 6755 or 920?

High Performance 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.

BRUSH Application

GC 610

Isophthalic Lloyds Approved Marine Grade Gelcoat

Pre-Accelerated

KEY TECHNICAL FEATURES: -	
Gel Time (ICON 002) (– 2% MEKP on 100gr)	10-14 minutes
Brookfield Viscosity (ISO2555 - 20°C – sp6)	5 rpm : 230 - 420 Poise
Mechanical Properties of cured gel coat	
Elongation at break	4.1 %
Heat distortion temperature (HDT)	75 °C
Barcol hardness	50
Topcoat version	TOP COAT 610, 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

SPRAY Application

GC 188

Isophthalic Gelcoat Pre-Accelerated

KEY TECHNICAL FEATURES: -	
Gel Time (ICON 002) (23°C – 2% MEKP on 100gr)	10 min
Brookfield Viscosity (ISO2555 - 23°C – sp5)	5 rpm : 140 - 220 Poise
Mechanical Properties of cured gel coat	
Elongation at break	1.8%
Temperature of deflection under load* (HDT) (ISO 75-3)	74°C
BRUSH VERSION	GEL COAT 181 SV-15
TOP COAT VERSION	TOP COAT 188 (with wax addition for tack free finish)
Certificates	Antifungal EN ISO 846-A

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.

Sandable Gelcoats (Ideal for automotive parts)

Polyester gel coat developed with a zero porosity finish for production of parts which are sanded and repainted. Typical for automotive parts and mouldings.

BRUSH Application

GC 121

Isophthalic Sandable Gelcoat

KEY TECHNICAL FEATURES: -	
Brookfield viscosity (ISO 2555 - 23°C - sp6)	270-370 poise
Gel time (ICON 002) (23°C - 2% MEKP on 100g	10 mins
Elongation at break* (ISO 527) of cured base resin	3.7%
Barcol hardness* ASTM 2583 of cured base resin	40 - 45

GC121 is Pre-accelerated and thixotropic. Curing at ambient temperature by addition of MEKP catalyst. Easy to sand. Fast drying.

SPRAY Application

GC 128

Isophthalic Sandable Gelcoat

KEY TECHNICAL FEATURES: -	
Brookfield viscosity (ISO 2555 - 23°C - sp5)	140-200 poise
Barcol hardness* ASTM 2583 of cured base resin	40 - 45
Gel time (ICON 002) (23°C - 2% MEKP on 100g	10 mins
Elongation at break* (ISO 527) of cured base resin	3.7%

GC128 is Pre-accelerated and thixotropic. Curing at ambient temperature by addition of MEKP catalyst. Easy to sand. Fast drying.

BRUSH Application

TOP COAT 121

Sandable Gelcoat

Industrial quality Topcoat for cost efficient applications.

SPRAY Application

TOP COAT 128

Sandable Gelcoat

Industrial quality Topcoat for cost efficient applications.

Sanitary Market

GELCOAT

8120
ISO Low styrene content and high brightness.
Compliant with En 14688 Norm.
Good thermal shock resistance.

199
ISO/NPG Fire retardant Gelcoat with good thermal shock resistance.

782
ISO/NPG Very good thermal shock resistance.
Recommended for dark colours.

794
ISO/NPG Very good thermal shock resistance.
Compliant with En 14688 Norm.

795
ISO/NPG Very good thermal shock resistance.
Compliant with En 14688 Norm.

860
ISO/NPG Translucent Gelcoat with very good thermal shock resistance.

8145
ISO/NPG Very good thermal shock resistance.
Compliant with En 14688 Norm.

RESINS

NORESTER 8795 AF15
DCPD polyester resin (geltime 6-8 mins)

NORESTER 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

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

ISO/NPG Gelcoats

For extreme weathering, gloss retention and mechanicals. Ideal for Sanitary Ware Swimming Pools and Ponds.

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

BRUSH Application

GC 794

ISO/NPG Gelcoat

Sanitaryware, Swimming Pools and Ponds

KEY TECHNICAL FEATURES: -	
Brookfield viscosity (ISO 2555 - 23°C - sp5)	5 rpm : 300 - 340
Gel time (ICON 002) (23°C - 2% MEKP on 100g	10 minutes
Elongation at break* (ISO 527) of cured resin base	3.5%
Temperature of deflection under load* (HDT) (ISO 75-3) of cured resin base	94°C
Barcol hardness of cured resin base*	50

Gelcoat GC 794 is based on a ISO-NPG Resin (neopenthyl-glycol) with excellent water and chlorine resistance.

SPRAY Application

GC 795

ISO/NPG Gelcoat

Sanitaryware, Swimming Pools and Ponds

KEY TECHNICAL FEATURES: -	
Brookfield viscosity (ISO 2555 - 23°C - sp5)	5 rpm : 170 - 230 Poise
Gel time (ICON 002) (23°C - 2% MEKP on 100 g)	15 minutes
Elongation at break* (ISO 527) of cured base resin	3.5%
Temperature of deflection under load* (HDT) (ISO 75) of cured base resin	94°C
Barcol hardness* of cured base resin	40 - 45
Certificates	Inhibits bacterial growth “AB” version

GC 795 is pre accelerated and promoted, cures at ambient temperature with addition of a MEKP catalyst. GC 795 is formulated of airless application. No drainage on inclined or vertical surfaces. Very good resistance to hydrolysis and UV.

SPRAY Application

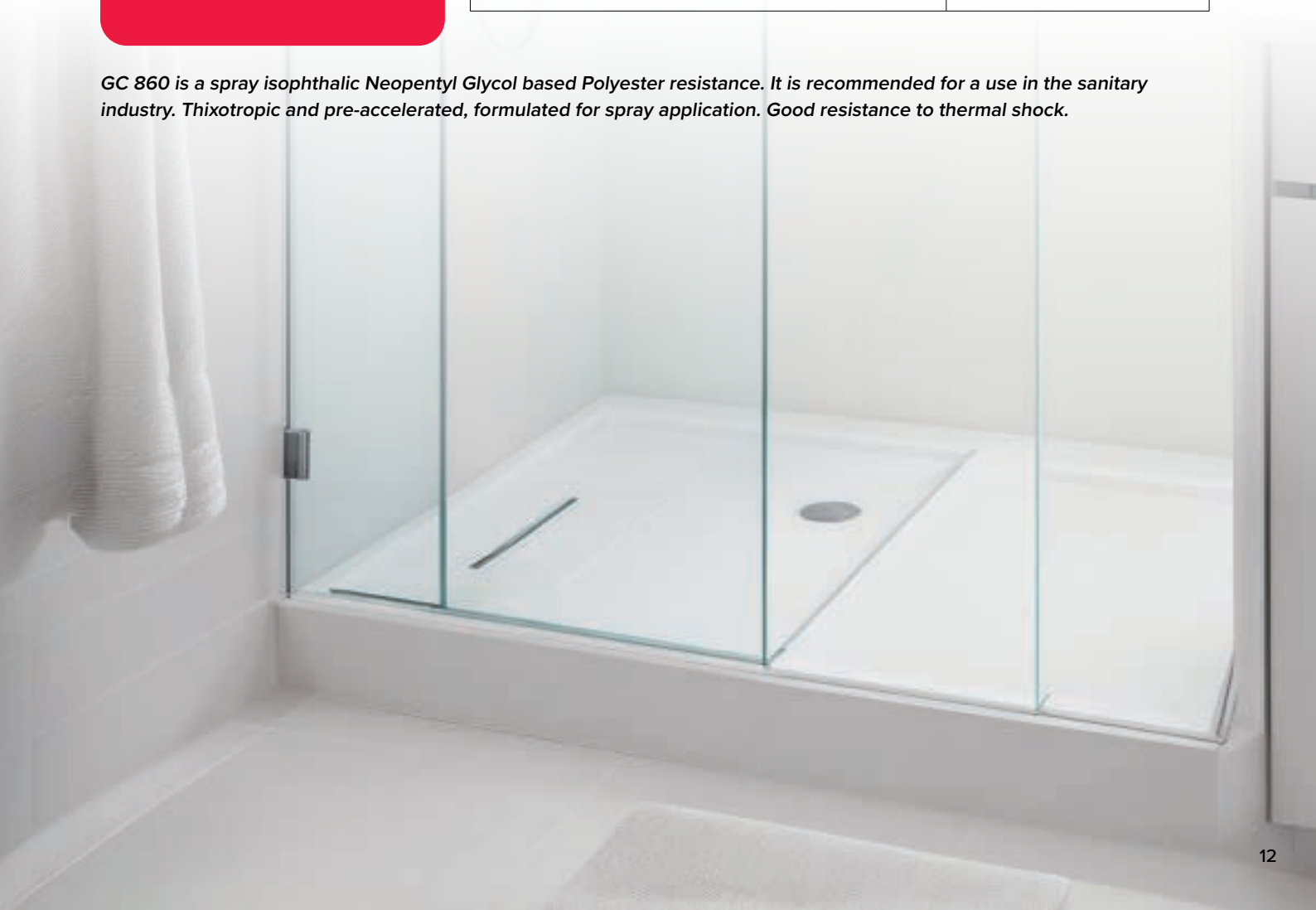
GC 860

ISO/NPG Gelcoat

Ideal for Sanitary Ware

KEY TECHNICAL FEATURES: -	
Brookfield Viscosity (ISO2555 - 2°C – sp5)	5 rpm : 100 - 140 Poises
Gel Time (ICON 002) (20°C – 2% MEKP on 100gr)	22 - 28 min
Elongation at break	4.01 %
Barcol Hardness	45-45
Temperature of deflection under load* (HDT)	70°C

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.

KEY TECHNICAL FEATURES: -	
Drying Time on film at 23°C (-2% MEKP on 100gr)	60 minutes
Brookfield Viscosity (ISO2555 - 20°C – sp6)	140-240 (spray)
Flexural strength + norm	61.1 MPa
Elongation at break + norm	2.48 %
Barcol Hardness + norm	45
Temperature of deflection under load* (HDT) + norm	76.6°C
Flexural modulus* (ISO 178)	4.19 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.

KEY TECHNICAL FEATURES: -	
Gel Time (ICON 002) (– 2% MEKP on 100gr)	10 min
Brookfield Viscosity (ISO2555 - 23°C – sp5)	5 rpm : 140 - 200 Poise
Flexural strength of cast gel coat + norm	60 MPa
Barcol Hardness of cast gel coat + norm	40-
Temperature of deflection under load* (HDT) + norm	65°C
Elongation at break of cast gel coat + norm	1.2%

*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 880/2.*

KEY TECHNICAL FEATURES: -	
Brookfield Viscosity Spray version (ISO 2555 -20°C sp5)	5 rpm : 140 - 230 Poise 50 rpm : 20 - 36 Poise
Specific gravity (ICON 012)	1.65 - 1.75 g/cm^3
Solid content (ICON 003)	76 - 78%
Drying time on film (ICON 002) (20°C -2% MEKP M50 on 100g	50 - 70 mins

GC 886 is a fire rated gelcoat which meets Classification M1F1 with the resin NORESTER 880.

Fire Retardant

GELCOAT

184
ISO Fire retardant Gelcoat.
Complies to M1F1 and IMO floor* standards.*

185
ISO Fire retardant Gelcoat with good UV resistance.
Complies to M1F2 and CLASS 1**
Bacteriostatic "AB" version

199
ISO /NPG Fire retardant gelcoat with good thermal shock resistance.
Complies to VO, M2F1*, S4SR2ST2*, CLASS 2*, HL1 R1-R7-R17**

886
ISO /NPG Fire retardant gelcoat.
Complies to HL2 R1-R7, OMI Floor*, BS2D0**

*With corresponding resin

NOTE:
We also sell Fire rated Adhesives conforming to EN-45545-2 (epoxy and MMA types)

TOPCOATS

933FR
Orthophtalic Fire retardant Roofing Topcoat.
*Complies to B ROOF(t4)**

*With corresponding resin

Epoxy Bonding Gelcoats

BRUSH & SPRAY Application

GC 250

Epoxy Bonding Gelcoat based on Vinyl Ester

KEY TECHNICAL FEATURES: -	
Gel Time (ICON 002) (23 – 2% MEKP on 100gr)	10 min
Brookfield Viscosity (ISO2555 - 23°C – sp5)	5 rpm : 120 - 180 Poise
Temperature of deflection under load* (HDT)	101°C
Elongation at break	2.5%
Barcol Hardness of cured base resin	45

A pre-accelerated and thixotropic gelcoat. Pigmented to any RAL or BS shade.

Low Styrene Gelcoats

SPRAY Application

GC 8100

Low styrene content

Pre-Accelerated

KEY TECHNICAL FEATURES: -	
Gel Time (ICON 002) (23 – 2% MEKP on 100gr)	10 min
Brookfield Viscosity (ISO2555 - 23°C – sp5)	5 rpm : 100 - 140 Poise
Low volatile content <25%	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.

Marine Industry

Lloyds approved Range

Products designed to provide optimum performance properties for marine part production

- Application behaviour
- Osmosis resistance
- Weathering resistance

GELCOAT

Gelcoat 610
Low styrene emission Gelcoat with very good UV and hydrolysis resistance. Brush Application.

Gelcoat 794
Low styrene emission Gelcoat with very good UV and hydrolysis resistance.

Norester GC795
Premium Iso NPG Gelcoat.

Norester GC8140
Low styrene emission Gelcoat based on Iso NPG Resin.

TOPCOAT

610
With very good UV and hydrolysis resistance.

794
With very good UV and hydrolysis resistance.

795
With very good UV and hydrolysis resistance.

8140
With very good UV and hydrolysis resistance.

SKINCOAT

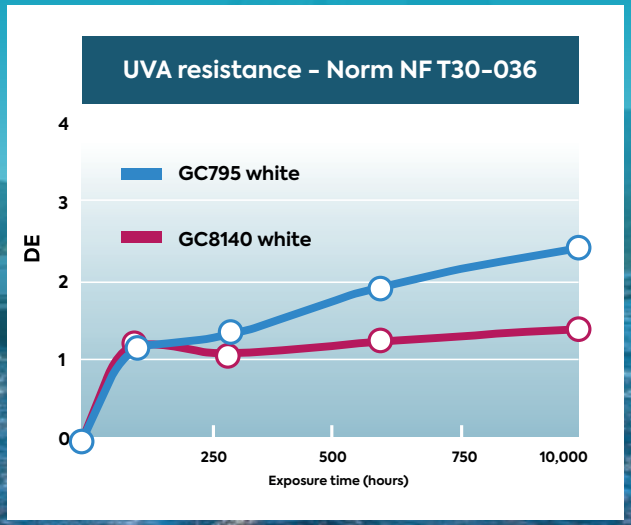
NORESTER 6800
VE resin.

STRUCTURE

NORESTER 912 series
Orthophthalic HLU Resin.

NORESTER 8435 series
Ortho DCPD HLU Resin.

NORESTER 822 PA
Ortho DCPD Infusion Resin.



Swimming Pools

GELCOAT

794
ISO/NPG Gelcoat with resistance to water treatment products and very good hydrolysis resistance.

795
ISO/NPG Gelcoat with resistance to water treatment products and very good hydrolysis resistance.

8140
ISO/NPG Gelcoat with resistance to water treatment products and very good hydrolysis resistance.

TOPCOAT

794
ISO/NPG Gelcoat with resistance to water treatment products and very good hydrolysis resistance.

795
ISO/NPG Gelcoat with resistance to water treatment products and very good hydrolysis resistance.

8140
ISO/NPG Gelcoat with resistance to water treatment products and very good hydrolysis resistance.

SKINCOAT

NORESTER 6800
VE.

NORESTER 6968
IsoNPG.

RESIN SYSTEMS

NORESTER 6755
ortho DCPD resin

NORESTER 6600
Isophthalic resin

Caravan, R.V & Automotive Industry

CARAVAN AND R.V'S

GELCOAT 121
Industrial Gelcoat for cost effective applications and/or for the production of parts to be sanded.

GELCOAT 128
Industrial Gelcoat for cost effective applications and/or for the production of parts to be sanded.

SUNCOAT 900
ISO/NPG Very good UV and yellowing resistance

SUNCOAT 901
ISO/NPG Very good UV and yellowing resistance

TOP COAT 8280
ORTHO/Flexible Floor Topcoat with low VOC content.

OTHER POPULAR GELCOAT OPTIONS

GELCOAT 188
ISO Spray.

GELCOAT 610
ISO Brush.

AUTOMOTIVE INDUSTRY

TOP COAT 741
ORTHO Self levelling floor Topcoat.

TOP COAT 921
ISO Floor Topcoat with good ageing behavior.

TOP COAT 8280
ORTHO/Flexible Floor Topcoat with low VOC content.

INFUSION RESIN OPTIONS FOR POP TOP MANUFACTURING

NORESTER 11712 A 20
DCPD ORTHO with HDT 85^{0}C.

NORESTER 11758
VINYL ESTER HDT 88^{0}C.

Tanks and Silos

GELCOAT

GC 181 SV-15
ISO Non food contact gelcoat with good aging behaviour and Antifungal properties.

188
ISO Non food contact gelcoat with good aging behaviour and Antifungal properties.

296
VE High chemical resistance gelcoat.

297
VE High chemical resistance gelcoat.

TOPCOATS

TOP COAT 181 - SV15
ISO Non food contact Topcoat with good aging behaviour.

TOP COAT 188
ISO Non food contact Topcoat with good aging behaviour.

TOP COAT 296
VE High chemical resistance Topcoat.

Topcoat 297
VE High chemical resistance Topcoat.

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.

TEK-KOTE

KoverTek

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-XPRE	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					
EPOX-B	Higher solids for use on Epoxy or mould B-faces		✓	✓	✓

GELCOAT USER GUIDE

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

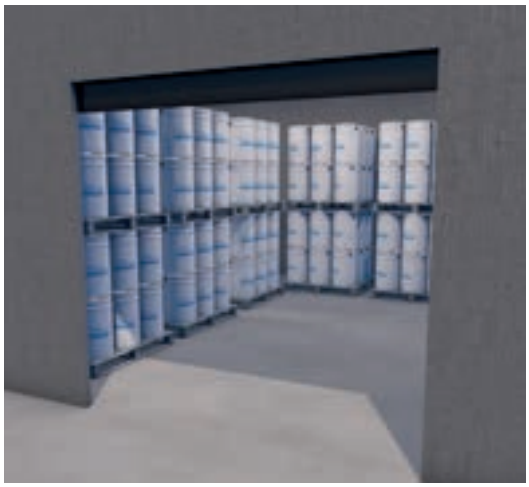
Taking Delivery:-

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

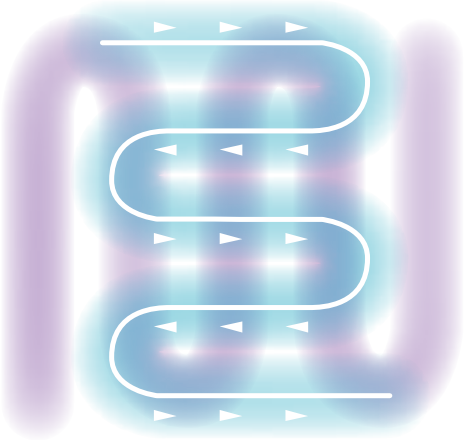
Preparing the Gelcoat:-

- 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).

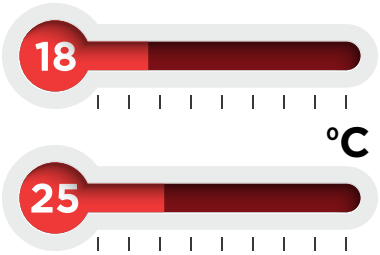
Spray Equipment Check List:-

- 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 spay 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 (66-77F)
- 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

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