

10. Atomize the tooling gel coat thoroughly when spraying. Low spray pressures will result in poor breakup, and will leave entrapped air in the gel coat. To check atomization for porosity, spray catalyzed tooling gel coat over glass to a film thickness to 18 (± 2) mils. Laminate, pull, sand, stain and examine for entrapped air. This procedure should be followed gel coat is sprayed. These spray-outs should be saved along with other mold records.
11. In spray application of tooling gel coats, use slow, even strokes, triggering the spray gun at the end of each stroke to prevent excess buildup at overlaps.
12. Do not apply tooling gel coat over wet Polyvinyl Alcohol (PVA) parting film.
13. Install an oil and moisture trap on the compressed air line leading to the spray gun to remove lint, rust, oil and moisture.
14. Use the catalyzed tooling gel coat within its working life, with a proper allowance of time for cleanup of equipment.
15. Tooling gel coats may leave a certain amount of “coloring” when sanded and/or buffed. This is a function of the pigment used and is not an indication of cure.
16. Do not add anything, other than the appropriate methyl ethyl ketone peroxide, to these products.

STORAGE:

Uncatalyzed tooling gel coats have a usage life of 60 days from date of manufacture when stored at 23°C or below in a closed, factory-sealed opaque container and out of direct sunlight. The usage life is cut in half for every 15°C over 23°C.