

CRYSTIC[®] GLOSSCOAT

High Gloss Polyester Coating

INTRODUCTION

Crystic[®] GlossCoat is a polyester coating designed to be applied over prepared **Crystic[®] PrimeCoat** to give a glossier and more durable surface. The material hardens rapidly and can be easily sanded to a smooth surface that can be polished to high gloss.

Crystic[®] GlossCoat can be mixed with **Crystic[®] PrimeCoat** to improve the surface gloss and gloss retention of **Crystic[®] PrimeCoat**. Mixing 1 part of **Crystic[®] GlossCoat** to 1 part of **Crystic[®] PrimeCoat** will give a significant improvement in gloss, higher proportions of **Crystic[®] GlossCoat** to **PrimeCoat** will further improve the gloss. For optimum levels of gloss **Crystic[®] GlossCoat** can be used on its own, as described below.

APPLICATION

Crystic[®] GlossCoat is designed to be spray applied using gravity fed, siphon or pressure pot systems.

Gravity fed or siphon guns will require a line pressure of 40-60psi (2.5-4 bar) and a 1.5-2.0mm material nozzle. For pressure pot systems use a 10-20psi (0.7-1.3 bar) pot pressure and 40-60psi (2.5-4 bar) line pressure. It is important that the compressed air is free from impurities such as water and oil mist. Use an in-line filter to remove these.

APPLICATION GUIDE FOR PATTERNS

Ensure that the **Crystic[®] GlossCoat**, the workshop and the pattern are at a minimum temperature of 15°C; 20°C will give improved results. Curing should not be carried out at temperatures below 15°C. Scott Bader (Pty) Ltd. will not be liable for problems caused by use at lower temperatures than recommended.

1. Prepare pattern and apply **Crystic[®] PrimeCoat** as per the **Crystic[®] PrimeCoat** data sheet.
2. Abrade the **Crystic[®] PrimeCoat** initially with 180 grit abrasive paper and finish with 240 grit, remove surface dust and degrease with an acetone dampened cloth.

3. Mix **Crystic[®] GlossCoat** thoroughly before use, add 3-5% of **Crystic[®] Pigment Paste** and stir thoroughly.
4. Dilute **Crystic[®] GlossCoat** with 20-40% of **Crystic[®] GlossCoat Thinners** and stir thoroughly until the desired consistency has been obtained.
5. Catalyse the resin content with 2% Catalyst M (Curox[®] M200 or Butanox[®] M50) and stir thoroughly. The pot life of this mixture should be at least 30 mins so large areas can be sprayed without fear of gelation in the spray equipment.

N.B. Peroxide catalysts are highly reactive and may decompose with explosive violence, or cause fires, if they come into contact with flammable materials, metals or accelerators. For this reason they must never be stored in metal containers or be mixed directly with accelerators.

6. Apply a mist coat and allow 2-5 minutes for the solvent to evaporate. Follow with slightly heavier coats again allowing time between each coat for evaporation. Six of these coats should give sufficient thickness to allow for abrasion to remove orange peel and final polishing while still leaving a reasonable thickness of **Crystic[®] GlossCoat**.
7. The surface can be abraded after approximately 3 hours. Depending on the smoothness, use good quality 600 to 800 grit wet or dry paper used wet. Follow this with successively finer wet or dry paper, again, used wet, up to 1200 grit.
8. After 24 hours, the surface can be compounded, with a high quality polishing compound and glaze from our range.
9. Finally, a suitable mould release agent, from our range, should be applied before starting to build the mould.

APPLICATION GUIDE FOR MOULDS

1. Ensure that the mould surface is free from unrepaired cracks and pinholes. If necessary, fill these with suitable high quality mould repair putty. Attend to the root causes of cracks. For example, unbraced flanges and corners in the mould will concentrate stress on part removal. If sufficient bracing is not present, the cracks will reappear in the **Crystic[®] GlossCoat** surface.
2. Abrade the mould surface with 80 grit dry paper. Remove a substantial amount of the gelcoat, but it is not advisable to sand back to the laminate. This may reveal more porosity, which must be filled as in Step 1.
3. Apply **Crystic[®] PrimeCoat** using the same method as described for patterns in Technical Leaflet no. 234.3.

4. Allow the **Crystic[®] PrimeCoat** to thoroughly cure, then abrade it, initially with 180 grit abrasive paper, then with 240 grit. Remove surface dust, and degrease with an acetone dampened cloth.
5. Apply **Crystic[®] GlossCoat**, following steps 3-8 as described for coating patterns above.

STORAGE

Crystic[®] GlossCoat should be stored in the dark in suitable closed containers. It is recommended that the storage temperature should be less than 20°C where practical, but should not exceed 30°C. Ideally, containers should be opened only immediately prior to use.

PACKAGING

Crystic[®] GlossCoat is supplied in 5kg and 25kg containers.

HEALTH AND SAFETY

Please see the applicable Material Safety Data Sheets.

If further information is required, please contact our Technical Service Department.

Technical Leaflet No. 245.8SA
July 2006

Before you use this information, kindly verify that this data sheet is the latest version.

All information is given in good faith but without warranty. We cannot accept responsibility or liability for any damage, loss or patent infringement resulting from the use of this information.



SCOTT BADER (Pty) Ltd
Reg. No. 93/00466/07
1 Lubex Road, Hammarsdale
P.O. Box 1539, Hillcrest, 3650
South Africa
Telephone: +27 (0) 31 736 8500
Telefax: +27 (0) 31 736 8511

Gauteng
11 Belgrade Avenue,
Aeropot, Spartan Ext.2
Kempton Park
Tel: (011) 974 7104
Fax: (011) 974 1300

KwaZulu Natal
1 Lubex Road,
Hammarsdale
Tel: (086) 167 3746
Fax: (086) 107 3746

Eastern Cape
Corner Ries & Burman Roads,
Deal Party
Port Elizabeth
Tel: (086) 117 3746
Fax: (086) 107 3746

Western Cape
4 Beverly Road,
Montague Gardens
Cape Town
Tel: (021) 552 0970
Fax: (021) 552 1031

