

TECHNICAL DATA SHEET

PRODUCT: PATTERN-COATTM HI-GLOSS

DESCRIPTION Pattern-CoatTM Hi-Gloss is a special polyester coating resin designed to be applied over prepared Pattern-CoatTM Primer to give a glossier and more durable surface. The material hardens rapidly and can be easily sanded to a smooth surface which can be polished to high gloss.

Pattern-CoatTM Hi-Gloss can be mixed with Pattern-CoatTM Primer to improve the surface gloss of the Primer. Mixing 1 part of Pattern-CoatTM Hi-Gloss to 1 part of Pattern-CoatTM Primer will give a significant improvement in gloss. Higher proportions of HI-Gloss to Primer will further improve the gloss. For optimum levels of gloss, Pattern-CoatTM Hi-Gloss can be used on its own, as described below.

APPLICATION Hi-Gloss can be applied by brush for excellent results although spray application (see below) will mean less finishing work is required.

Gravity fed or siphon guns will require a line pressure of 40-60psi and a 1.5-2.0mm material nozzle. For pressure pot systems use a 10-20psi pot pressure and 40-60psi line pressure. It is important that the compressed air is free from impurities such as water and oil mist.

DIRECTIONS FOR USE Ensure that the materials and the workshop are at a minimum temperature of at least 15°C; 20°C will give improved results. Curing should not be carried out at temperatures below 15°C.

When not using Pattern-CoatTM Primer, patterns made from very low density foams (anything less than around 40kgs/m³) should be 'scrimmed' with a layer of polyester resin reinforced with a lightweight glass cloth before application of the Pattern-CoatTM Hi Gloss.

If applying directly to a wood or MDF pattern (no Pattern-CoatTM primer) it is suggested to paint the pattern with a thin coat of catalysed polyester resin, allow to cure and then flat back any raised grain or texture, repeating if necessary, before application of Pattern-CoatTM Hi Gloss.

To ensure a good bond to the pattern surface (including Pattern-CoatTM Primer), key the surface initially with 180 grit abrasive paper and finish with a 240grit abrasive paper and remove any dirt or grease using acetone.

Pattern-CoatTM Hi-Gloss should be mixed with MEKP Catalyst at a ratio of 2% catalyst (can be adjusted according to pot-life required and ambient temperature). If spraying, see notes on thinning below.

BRUSH APPLICATION Hi-Gloss can be applied by brush for excellent results although spray application (see below) will mean less finishing work is required.

1. Apply Pattern-Coat™ Hi-Gloss to the prepared pattern using smooth brush strokes, attempting to leave an even layer or around 0.5mm.
2. Allow the first application to cure to a 'B stage' (still tacky but firm) before applying a second layer of Hi-Gloss, as per the first layer.

SPRAY APPLICATION

Application by gelcoat spray gun will yield the best results and mean much less finishing work is required. When spraying, thin the Pattern-Coat™ Hi Gloss using pure acetone at a ratio of 25%.

1. Start by spraying a 'mist coat' over the pattern. Wait 2-5 minutes for the solvents to evaporate.
2. Pattern-Coat™ Hi-Gloss can be applied wet-on-wet but sufficient time must be left between passes (2-5 minutes) to allow time for the solvent to evaporate. Around 5 passes should leave a sufficient thickness of Hi-Gloss to ensure the surface can be properly flatted.

FINISHING

1. Once initial cure is reached (around 3hours depending on ambient temperature) Hi-Gloss can be wet-sanded using abrasive papers from 120grit (following brush application) or 400grit (following spray application) up to 1500grit.
2. The coating should then be allowed to cure fully (around 12hrs) before polishing by hand or machine polisher up to a stunning high gloss using appropriate polishing compounds.

STORAGE

Pattern-Coat™ Hi Gloss 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 it should not exceed 30°C. KEEP THE PACKING TIGHTLY SEALED WHEN NOT IN USE.

SHELF LIFE

If stored under the above conditions the Pattern-Coat™ Hi Gloss will have a shelf life of 3 months, from the date of production.

This data is not to be used for specifications. Values listed are for typical properties and should not be considered minimum or maximum.

Our technical advice, whether verbal or in writing, is given in good faith but Easy Composites Ltd gives no warranty; express or implied, and all products are sold upon condition that purchasers will make their own tests to determine the quality and suitability of the product for their particular application and circumstances.

Easy Composites Ltd shall be in no way responsible for the proper use and service of the product, nor for the safeguarding of personnel or property, all of which is the duty of the user. Any information or suggestions are without warranty of any kind and purchasers are solely responsible for any loss arising from the use of such information or suggestions. No information or suggestions given by us shall be deemed to be a recommendation to use any product in conflict with any existing patent rights.

Before using any of our products, users should familiarise themselves with the relevant Technical and MSDS provided by Easy Composites Ltd.

Easy Composites Ltd, Unit 39 Park Hall Business Village, Longton, Stoke on Trent. ST3 5XA
Tel. +44 (0)1782 454499 Web. www.easycomposites.co.uk Email. sales@easycomposites.co.uk