

## TOPCOAT-BRUSH

### PERSONAL PROTECTION

Please familiarise yourself with the Material Safety Data Sheets before starting. Personal protection should be worn at all times, safety goggles, gloves, apron and overalls. If you have any queries please contact us on 028 41753738.

### MATERIALS

Topcoat Kits are supplied with the following materials

1. Topcoat
2. Catalyst / Hardener

### WORKING AREA

Topcoating should be done at warm temperatures ideally around 20°C, as this ensures the resin will cure correctly. Topcoat will not cure adequately below 15°C, and at temperatures above 30°C, they will cure too quickly.

Topcoats also known as flowcoats or painting resins are used in contact moulding (hand or spray lay-up). The topcoat, which is usually pigmented, provides a finished surface. It is a weather and wear-resistant coating over the glass reinforcement.

There are specific top coat products for either spray or brush applications.

A brush topcoat can only be applied with a brush.

### COVERAGE

Approx. 500g per m<sup>2</sup> of topcoat is recommended.

## PREPARING TOPCOATING

If working on existing GRP mouldings they should be sanded/abraded with at least 100 grit sand paper so that the topcoat will bond. A new fibreglass laminate does not need any preparation. Old fibreglass laminates will benefit from a quick sanding. Painted surfaces usually react badly with topcoat so it is advisable to remove all paint by sanding. Only paint strippers designed for use on fibreglass should be used. All surfaces should be clean & dust free.

## MIXING CATALYST

All topcoats require the addition of catalyst (hardener) to initiate the curing process. Use a safety dispenser to add 20ml of catalyst per kilo of resin. Stir thoroughly. The hardening process begins immediately, so only add catalyst to a working quantity.

Thorough mixing of catalyst into resins and topcoat is very important. Also the correct quantities should be used for the best results. Dispensers are advised for accuracy. 1% catalyst is considered a slow mix, 2% is ideal, 3% is a fast mix.

The higher the temperature the faster the cure. As a general guide 2% addition at 20°C gives 15-20 mins pot life.

Once catalysed the topcoat gradually cures, taking on a jelly-like consistency in about 10-20 minutes before becoming hard in about 30-40 minutes at room temperature (about 20°C). The curing process generates heat within the resin. Too much catalyst or large volumes of topcoat increase this heat. Over catalysing the topcoat can cause the material to overheat and sometimes cause a fire.

## APPLYING THE TOPCOAT

- Mix a maximum of 2kgs at a time, enough for about 3 to 4m<sup>2</sup> of fibreglass.
- Ensure that the surface is dry and clean. Paint on a coat of catalyzed topcoat to the surface ensuring good coverage.
- When fully cured it can be sanded with wet & dry paper followed by polishing with a cutting compound to form a good finish.