

# Product Data



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## HK Research Preferred Patching Procedure LHM-White Gel Coat

### Materials Needed

- 150 Grit Sand Paper
- DA Disk in P240, P500, P800, P1000 grits
- Clean Acetone
- Dual-Action Sander
- Variable Speed Electric Buffer
- I0517 Patch Booster or Premixed Patching Gel Coat
- 3M Dry Guide Coat
- 3M Imperial Compound and Finishing Material
- White 100% Wool Compounding Pad
- Graduated cups and catalyst droppers or a gram scale (to ensure proper level of catalyst)
- Clean rags
- MEKP-9 or 46-702 or Cadox L50a catalyst
- “Touch-up” spray gun

### Procedure

- 1) Prep area to be patched with 150 grit sand paper. Sand past the necessary patch area. Be sure not to leave any “shiny” areas. Blow off dust with compressed air, or wipe with a clean rag to remove sanding dust. Tape and mask off surrounding area to prevent overspray contamination.
- 2) Mix 25% I0517 patch booster with 75% gel coat (not necessary with premixed repair gel coat). Carefully measure 2.5% MEKP-9 or 46-702 or Cadox L50a catalyst into gel coat. Stir for at least one minute before spraying.
- 3) Spray area to be patched with the minimum amount of air pressure necessary to develop a fan pattern with the touch-up spray gun. Do not spray all the way to tape lines. Be sure to “feather” the edges of the patch. Insufficient “feathering” of the sprayed patch will lead to “halos.”
- 4) Allow patch to cure. A patch can be worked down after an hour if external heat is used. If using a heat gun, be careful not to “burn” the patch. If the heat gun is too hot for your skin, then it is too hot for the patch. The longer a patch is allowed to cure; the better the end result will be.

- 5) Apply 3M dry guide coat to highlight the "orange peel." 3M Dry guide coat is preferred over liquid dye coats. Liquid dyes contain solvents that can penetrate the patch and cause discoloration and poor cure.
- 6) If the "orange peel" is heavy sand, with P240 paper until the dry guide coat is removed. If the "orange peel" is not heavy, start with P500. (You must sand with P500 after the P240 if you started with P240).
- 7) Blow or wipe off the sanding dust.
- 8) Apply 3M dry guide coat to highlight the sanding scratches.
- 9) Sand with P800 until the dry guide coat is removed
- 10) Blow or wipe off the sanding dust.
- 11) Apply 3M dry guide coat to highlight the sanding scratches.
- 12) Sand with P1000 until the dry guide coat is removed
- 13) Blow or wipe off the sanding dust
- 14) Buff the patch using the white 100% wool pad with a variable speed electric buffer and 3M Imperial Compounding and Finishing Material. Apply a generous amount of compound to the sanded area. Using the slow setting on the buffer work in the compound while holding the buffer at about a 10 deg. Angle. Slowly increase the speed of the buffer until all the compound is removed. Inspect the area. The buffing process can be repeated if desired gloss is not achieved.