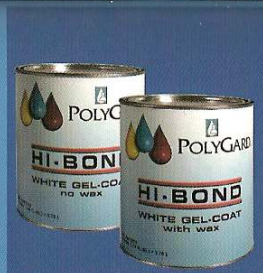


# HI-BOND™

Easy Do-It-Yourself Boat Repair System



## GEL COAT REPAIR

Preparation, Mixing  
and Application Guide

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For more products, information and  
material safety data sheets visit our website @

[www.hibond.net](http://www.hibond.net)

*The procedure outlined in  
this brochure is for small  
area, gel coat repairs. In  
order for this procedure to  
be successful, the laminating  
resin and fiberglass behind the  
repair area must be intact.  
For larger repair areas please  
consult a professional.*

### Associated Gel Coat Repair Products

Product No. Description\*

|      |                         |
|------|-------------------------|
| 1440 | White Gel Coat No Wax   |
| 1480 | White Gel Coat with Wax |
| 1540 | Neutral Gel Coat No Wax |
| 1720 | (1 oz.) Pigment         |
| 1890 | Acetone                 |
| 1965 | (4 oz.) Wax-Sol         |

\*All Products are available in other sizes.

# HI-BOND™

Do it once. Do it right.

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## GEL COAT REPAIR

Preparation, Mixing and Application Guide

## HI-BOND™

Marine Aftermarket Solutions

GEL COAT REPAIR

## Before you begin...

### Select the Gel Coat:

Determine the color of the area that is to be repaired. If the color is white or an off-white then select a white gel coat. If the color of the area is a bright color; red, blue, or green, then choose a neutral gel coat. The white gel coat contains a white pigment and it is impossible to achieve a bright color by adding pigment to a white gel coat no matter how much pigment is added. The gel coat should contain wax to help with the cure. If it does not, then purchase a wax additive such as Wax-Sol.

### Select the Pigment:

Unless the color of the repair area is exactly the color of the pigment (there are 10 to choose from), it will be necessary to select a pigment that is closest to the desired color. You will need no more than 1 oz. of pigment per 1 quart of gel coat.

## The Easy Hi-Bond Do-It-Yourself Steps

### Gel Coat Application



### Gel Coat Preparation



### Surface Preparation



Wipe the affected area clean using acetone to remove any grease or oils that may affect the bond with the new gel coat. Sand the affected area with a 220-grit sandpaper until a "V-shaped" opening has been achieved. Remove

Pour out about twice the amount of gel coat needed into a clean, plastic container. Slowly add the desired pigment and mix thoroughly until the proper color is achieved. Please note that the heat generated during the cure of the gel coat will have an affect on the final color. There is almost no chance that the color match

Once the gel coat color has been adjusted to your satisfaction, add the MEKP hardener (1-2% by weight). Mix well for 2 minutes. Now add the gel coat to the affected area until the area is completely filled and the level of the gel coat is higher than the surface. Allow 1-2 hours for the gel coat to cure. If the level of the new gel coat is lower than the surface then sand with 220-grit and repeat the process.

**Sanding and Buffing:** Sand the cured gel coat with a 320-grit sandpaper. Once the level of the gel coat is about even with the surface

1. Select the gel coat, pigment, and wax additive.
2. Sand the affected area with 220-grit sand paper. Wipe clean.
3. Mix gel coat with the pigment and wax additive.
4. Catalyze the gel coat.
5. Apply the gel coat.
6. Sand with 320-grit sandpaper.
7. Wet sand with 400-grit and then 600-grit sandpaper.
8. Buff with a finishing compound.

the dust using a clean cloth or rag. Do not use acetone to remove the dust.

will be perfect. Now add the wax additive (1 oz. per quart) if needed.

then switch to 400-grit sand paper. Once thoroughly sanded switch to 600-grit sand paper and continue sanding. We recommend using a wet/dry sand paper and wet sanding at the 400-grit and 600-grit level, otherwise the sandpaper gets clogged very quickly.

Buff using a wool pad and a finishing compound. It is considered normal when there appears to be a "halo" around the edge of the repaired area.

**GEL  
COAT REPAIR**