

**GRUBER META GELCOAT REPAIR KIT  
INSTRUCTIONS FOR USE**

**Gruber's Meta Gelcoat is a high performance metal filled vinyl ester Gelcoat. This Gelcoat has been formulated to withstand fast cycle multiple run production processes. Thermo set plastics require heat to cure so it is important to maintain adequate ambient room temperatures as well as the mold temperature that is being repaired. Repairs should not be attempted when room or mold temperature are below 70°F. This Gelcoat does not contain a surfacing agent, if desired a surfacing agent such as 970-C940 Wax Solution can be added up 5% by weight to obtain good surface cure without coverings.**

**Mixing & Application Instructions**

- **Measure a known amount (50 or 100ml) of Gelcoat in a container**
- **Accurately add 1.5% by weight MEK Peroxide (such as Lupersol DDM 9) into container. Too much catalyst will increase air entrapment. Working time for mix in the container is approximately 50 minutes**
- **Gently stir catalyst into the Gelcoat; rapid stirring will increase the air in the mix. Ensure that the catalyst is thoroughly mixed, be sure to scrape sides and bottom frequently.**
- **Allow to sit for a few minutes to allow any air to dissipate**
- **Apply Gelcoat to repair area being careful to remove any air as you are building the patch**
- **Always over fill the repair as there will be some shrinkage as the product cures**
- **If patch is to be sprayed apply in 1 to 2 mil passes, allowing some time between passes for the product to de air**

**Curing Process**

- **Allow product to cure at room temperature for a couple of hours or until patch is hard to the touch**
- **Post cure the patch at 160° for 4 hours to ensure full cure**
- **Allow mold and patch to return to room temperature before continuing**

**Finishing Process**

- **After product has reached room temperature start sanding with 220 grit or equivalent sand paper and continue using progressively finer sand papers up to 1200-1500 grit or equivalent. Sanding in perpendicular directions between grits is recommended.**
- **When sanding is complete buff with buffing compound until desired gloss is achieved. Gruber's Meta Gelcoat takes longer to buff to gloss than standard gelcoats, some patience may be required. Buffing should be done at high speed with very little pressure to reduce heat produced during the buffing process.**
- **Normal new mold prep procedures should be followed to prepare mold for use.**