

Van Dusen Racing Boats

Division of Composite Engineering

Homepage: www.composite-eng.com

GELCOAT REPAIR INSTRUCTIONS

Please read all instructions before you begin your repair. If you have any questions, please call us at (508)-788-4466.

MATERIALS:

- Ammonia or alcohol
- Two-part gelcoat epoxy:
 - pigmented epoxy resin
 - Versamid hardener

TOOLS:

- Fine grit sand paper: 400 and 800 grit
 - Wooden block
 - Body file (if available)
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1. Take a look at your resin and hardener. They should be both be heavy, viscous liquids. If they have solidified, seal the containers well and put them in hot tap water until they soften and liquefy.
2. Use ammonia or alcohol to clean the area in and around the scratch of any oils or dirt.
3. Mix only the quantity needed. *The resin and hardener need to be mixed in the proper ratio of two parts resin to one part hardener (by volume).*
4. Fill the scratch with the mixture using a razor blade or something similar. Use a minimum of gelcoat: try to fill only the scratch without covering a larger area. Let the gelcoat cure for at least hours at room temperature. (In cold weather, the epoxy can take up to 3 days to cure so plan ahead!)
5. Once the epoxy has set up completely, (it is hard enough so you can't make a mark in it with your fingernail) file it down using a body file, if available. If you do not have one, use your 400 grit sandpaper wrapped around a wooden block to sand down the fill until it is almost flush with the hull. Use the 800 grit sandpaper to sand it flush. Be careful to sand or file only the fill, or you will start sanding through the surrounding gelcoat. When the fill is sanded flush, polish with a standard automotive polish. We do not recommend using any products containing wax or silicone.