

Instint™ gelcoat

handling best practices

For Best Results:

- ❑ As with all gelcoats and coating technology, it is imperative that INSTINT products are mixed well prior to use.
- ❑ Prior to spraying on a production part, a test panel should be made to verify color accuracy and determine that the material meets the intended fitness for use by evaluating properties, including but not limited to: application, porosity resistance, ease of repair, weathering, blistering, blushing, and scratch resistance.
- ❑ If multiple pails of the same color are needed to make a part, Ashland recommends mixing all the pails together in a suitable container to ensure a homogeneous mixture.
- ❑ Optimum application temperatures of the gelcoat, mold, and environment are 70 – 90°F.
- ❑ Select a suitable size and angle of the spray gun tip depending on the size and complexity of the mold.
- ❑ Use the lowest possible pump pressure that achieves a uniform spray pattern.
- ❑ Set the recommended catalyst between 1.5% – 2.5%.
- ❑ Ensure the catalyst is dispersing properly within the spray pattern.
- ❑ Spray the part using continuous parallel strokes to a thickness of 18 – 24 mils. This thickness should be built up in 3 passes of 6 to 8 mils with each pass perpendicular to the prior pass and a 60 second flash time between passes.
- ❑ For best repair results the part should be patched with the same batch of gelcoat from which it was sprayed.

For further instructions on best practices, please contact your local Ashland Sales or Technical Service Representative.



North America — Dublin, OH USA
Tel: +1 614 790 3361

Europe — Barcelona, Spain
Tel: +34 93 206 5120

India — Navi Mumbai
Tel: +1 800 209 2475

Asia Pacific — Shanghai,
P.R. China
Tel: +86 21 2402 4888

Latin America — Araçariquama,
Brazil
Tel: +55 11 4136 6477

ashland.com/recreational-markets

® Registered trademark, Ashland or its subsidiaries, registered in various countries

™ Trademark, Ashland or its subsidiaries, registered in various countries
© 2017, Ashland / PC-13433.2

The information contained in this brochure and the various products described are intended for use only by persons having technical skill and at their own discretion and risk after they have performed necessary technical investigations, tests and evaluations of the products and their uses. Certain end uses of these products may be regulated pursuant to rules or regulations governing medical devices, drug uses, or pesticidal or antimicrobial uses. It is the end user's responsibility to determine the applicability of such regulations to its products.

All statements, information, and data presented herein are believed to be accurate and reliable, but are not to be taken as a guarantee of fitness for a particular purpose, or representation, express or implied, for which seller assumes legal responsibility. No freedom to use any patent owned by Ashland, its subsidiaries, or its suppliers is to be inferred.

