

**Premium Marine Grade Gel Coat**

- Chemical Resistant
- Patch Existing Gel Coat
- New Construction
- Fiberglass Repair



**ISO/NPG Series**



**OVER  
40  
YEARS**

**PRODUCT DESCRIPTION**

Sea Hawk Gel Coat is a premium quality isophthalic NPG gel coat formulated to meet rigid requirements in the boating, transportation, and sanitary applications. Meets American National Standard for plastic bath tubs, show receptors, and shower stalls. (ANSI Z124.1, .2005, Sec. 6.1). May be used to patch gel coating, or for new application. Common uses include boats, RV's, showers, tubs, pools, and more.



**PRODUCT INFORMATION**

**Colors:** White-8115, Black-2017, Jade Mist Green-4089 Sea Foam-4256, Flag Blue,-5002, Ice Blue-5004, Marlin Blue-5011, Teal-5328, Clear-6000, Orange Tooling-7000, Toreador Red-7161, Vivid Red-7367, Matterhorn White-8003, Whisper Gray-8035, Fighting Lady Yellow-9093, Federal Yellow-9298,

**Sizes:** Quart, Gallon, 5 Gallon Pail

**Finish/Sheen:** Gloss

**Shipping Weight:** 9-11 Lbs./Gal. (Depending on Color)

**Flash Point:** 82-88° F

**VOC:** 35-42%

**Required Film Thickness:** 1 coat at 20 mils wet film thickness (WFT) to achieve proper cure (requires three passes to get required thickness in 1 coat)

**Catalyst Level (MEKP):** 1.2% Minimum - 3.0% Maximum

**Gel Time at 1.8% MEKP Catalyst @ 77°F:** 10-17 minutes

**Theoretical Coverage:** Approx. 48-52 Sq.Ft./Gal. @ typical film thickness

**Storage:** Avoid prolonged exposure at temperatures above 85°F and to direct sunlight. Increased storage temperatures will negatively effect shelf life. Store in a cool place.

**Shelf Life:** 270 Days when stored under cool, dry conditions.

**FEATURES & BENEFITS**

- Premium Marine Grade Gel Coat
- Ready to Use, Easy to Spray, Sag Resistant
- High Gloss Retention
- Excellent Weatherability and Chemical Resistance
- Resistance to water blistering

**APPLICATION DETAILS**

**Method:** This product may be applied by airless and conventional



# GEL COAT

## Technical Data Sheet

spray, solvent resistant rollers and brushes for small areas only.

### Dry Times and Overcoating Intervals in Hours:

Substrate Temp.	Overcoating	Sand/Compound	Max
73°F (23°C)	2 hrs	12 hrs	Not Critical
95°F (35°C)	1 hrs	6 hrs	Not Critical

Do not apply directly over painted surface. Please contact your Sea Hawk representative for **Catalyzing with MEKP:**

Size	MEKP (Catalyst)					
	Warmer ← Temperature Conditions → Cooler					
	1.2% (Minimum)		1.8% 77°F (Ideal)		3% (Maximum)	
	CC	OZ	CC	OZ	CC	OZ
1 pint	5	0.19	8	0.25	14	0.50
1 quart	9	0.33	16	0.50	28	1
1 gallon	37	1.25	65	2.13	112	4

### GEL COAT PREPARATION

Stir container thoroughly before using. Add any additives such as Sea Hawk 7125 MEK Gel Coat Thinner, Sea Hawk Patch Aid 8185, or colorants (tints) prior to catalyzing with MEKP Catalyzer.

### SURFACE PREPARATION

Gel Coat over clean, dry surfaces. Remove all grease, oil, wax, or other foreign material by using Sea Hawk S-80 Wax N Grease Killer. All surfaces must be sanded. Do not apply directly over paint.

### ADDITIVES

**Patch Aid 8185:** Add 25-33% Sea Hawk Patch Aid 8185 when applying gel-coat for small repairs, to improve the working properties of traditional Gel Coat spray patches.

**Wax Additive:** Do not add wax additive if using Patch Aid. Patch Aid already contains a wax additive. If not using Sea Hawk 8185 Patch Aid, then you may add up to 4oz of Sea Hawk 8140 Wax Additive per gallon for tack free surface on final coat.

**Tinting:** Sea Hawk Gel Coat may be tinted using Sea Hawk colorants designed for use in Sea Hawk resins and gel coats. Do not use more than 1 oz tint per quart.

**Catalyzing Gel Coat with MEKP:** The catalyst level (MEKP) should not exceed 3.0% or fall below 1.2 for proper cure. Ideal range is 1.8% @ 77°F. Gel time at 1.8% MEKP is 10-17 minutes. This time element is dependent on material temperature, room temperature, humidity, air movement, and catalyst concentration. Gel Coat should not be used when temperature conditions are below 60°F, as curing may be adversely affected. See Catalyst mixing ratios on page 1.

### APPLICATION

Best when applied by spray. Gel Coat delivery rate of no more than 2.5 pounds per minute with conventional air atomized spray, and no more than 4 pounds per minute with airless equipment. For more detailed gel coat application please go to [www.seahawkpaints.com/GelCoat](http://www.seahawkpaints.com/GelCoat)

**Storage:** Avoid prolonged exposure at temperatures above 85°F and to direct sunlight. Store in a cool, dry place. This material will remain stable for three months when stored at 73°F or below. Warmer temperatures will reduce the usage life of this product. Keep away from heat, sparks, and flame. Keep container tightly closed. Prevent contamination with foreign material. Store below 100°F, out of sunlight. Avoid contact and wear protective clothing including goggles and gloves. Use with adequate ventilation.

### LIMITATIONS:

Apply in good weather when air and surface temperatures are above 60°F (16°C). Surface temperature must be a least 6°F (1°C) above dew point. For optimum application properties, bring material to 70-80°F (21-27°C) temperature range prior to mixing and application. Unmixed material (in closed containers) should be maintained in protected storage between 40° and 74°F (4-23°C). Prolonged atmospheric exposure of this product may detract from performance and reduce shelf life. Technical and application data herein is for the purpose of



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establishing a general guideline of the coating and proper coating application procedures. As application, environmental and design factors can vary significantly due care should be exercised in the selection, verification of performance, and use of the coating.

#### APPLICATION DATA

**Mixing:** Stir container thoroughly before use. Do not over mix.

**Thinning:** If necessary, maximum 10%Sea Hawk 7125 MEK Gel Coat Thinner. Do not thin when using Patch Aid 8185.

**Clean Up:** Acetone or MEK

**Pot Life:** 10-17 Minutes depending on atmospheric conditions and MEKP Catalyst Ratio.

**Brush/Rolling:** (For smaller repairs /applications only) Solvent Resistant Roller Cover 3/16" pile (nap), or Natural bristle brush. **Spraying recommended.**

**Spray: Airless or Conventional** - 2.0-2.5 orifice tip. Use ES Manufacturing Gel Coat Spray Gun G830, ES-G100, or equivalent.

**Safety:** Prior to use, obtain and consult the "Safety Data Sheet" of this product for health and safety information. Read and observe all precautionary notices on container labels.