



Product **ADD-UP2**

Application: Additive for ISO; ISO-NPG and Vinylester Gel Coat for use with Epoxy Resin.

Description: ADD-UP2 must be added to the Gel Coat according to the instruction below

- ADD-UP2 improves the cure time of Polyester/Vinylester Gel Coat.
- ADD-UP2 provides perfect adhesion between Polyester/Vinylester Gel Coats and Epoxy Resins.
- Incorporating ADD-UP2 into the Gel Coat allows laminating after 1 hour and up to 24 hours thereafter.
- ADD-UP2 does not affect the quality of the Gel Coat, it retains all original characteristics including:
 - UV stability
 - Sanding
 - Water resistance
 - Flame retardancy
 - Hardener
 - Gloss retention etc.

It is suitable for transparent and coloured Gel Coats. This product helps to maintain high gloss and the colour of the Gel Coat, even after storing for an extended period of time.

TYPICAL PRODUCT CHARACTERISTICS

Aspect						Opaque Liquid	
Viscosity at 25°C	IO-10-50 (ISO3219)	10 - 20	mPas	Density at 25°C	IO-10-51	0.84 – 0.90	g/ml
Solids Content						26 - 28	%
Weight ratio on 100g of Gel Coat or ISO, ISO-NPG resin						1.8 – 2.2	g

Instructions: ADD-UP2 is an opaque liquid that has the potential to separate and partially solidify when exposed to temperatures below

20°C. Prior to use ensure the ADD-UP2 is at the correct temperature and correctly mixed. Based on a mix ratio of 2% by weight the standard tin is ready for use with a 20kg container of Gel Coat/Polyester Resin.

If the additive is to be used in smaller quantities please ensure correct mixing and close the package immediately after use. Recommended volume of ADD-UP2 is 1.8 → 2.2% by weight.

Pour ADD-UP2 into the Gel Coat at the correct volume and mix thoroughly. The finished Gel Coat can be stored up to 3 week but ensure the product is mixed thoroughly at the recommended temperature.

ADD-UP2 slightly accelerates the cure, over and above the normal cure cycle for Gel Coats. It is therefore possible to proceed with the lamination of the Epoxy Resin 1 hour after gel, or even up to 24 hours after. Avoid ambient and product temperatures below 20°C. The use of preheated moulds optimizes the production cycles and improves the properties of the final composite.

Storage: Additive is solvent based, it can be stored for two years in the original sealed container. Store in the manner required by safety regulations.

Handling: **Do not use gel coat containing paraffin or internal mould release.**
Due to the large number of brands and products on the market and different methods of application, it is advisable to always carry out a test before using the product on a production cycle.
Consult the MSDS, and follow the provisions relating to industrial hygiene and waste disposal.

The information given in this publication is based on the present state of our technical knowledge but buyers and users should make their own assessments of our products under their own application conditions.