



Supplier of fibreglass raw materials

68 Broadmeadow Rd

Broadmeadow NSW 2292

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How to do a Small Fibreglass Job

Instructions:

1. Wash the mould with soap and water, dry thoroughly. Remove any old Gelcoat by using a piece of wood or Perspex as a scraper
2. Wax the mould as per instruction on the can of wax. Allow to dry for at least 30 minutes after the last coat.
3. (Optional) Apply PVA release agent either by wiping it on with a small piece of clean sponge or by spraying. Be care not to leave runs, they will take a long time to dry and will come out in the finished product. Do not apply by brush as it will leave brush marks (train lines) in the release coating which will also come out on the finished product. Allow to dry. On a hot day it will take approximately 10 minutes, on a cold/wet day it will take 2 hours or more.
4. Work out the amount of Gelcoat you will need, based on 500ml per square metre.
EG. For 0.5mt² of mould surface use 250ml of Gelcoat
For 1mt² of mould surface use 500ml of Gelcoat
For 1.5mt² of mould surface use 750ml of Gelcoat
For 2mt² of mould surface use 1lt of Gelcoat

On jobs less than 0.5mt² allow a bit extra for waste. Pour the Gelcoat into a mixing cup (small amount) or ice cream containers (large amount).

5. Work out the amount of catalyst needed. On a hot day allow 1.5%, on a cold day allow 2%. For amounts less than 2ml we recommend you use a pipette. For amounts over 2ml we recommend you use a medicine measure.
EG. For 200ml of Gelcoat on a hot day add 1.5% catalyst (which is just over 3ml)
For 250ml of Gelcoat on a cold day add 2% catalyst (which is 5ml)
CAUTION: catalyst is a dangerous product and for safety reasons please read the safety instructions on the side of the bottle before using.
6. Mix the catalyst in the Gelcoat using a flat stirring stick. Mix thoroughly
7. Brush the Gelcoat onto the mould using light even strokes, preferably going in the same direction. Do not push down on the brush, let it 'float' over the surface of the mould leaving a 0.5ml thick coating. Go over thin spots and smooth out thick areas until you are satisfied you have a consistent coverage. Spray application can also be used with the same desired coverage required. Work fast as the Gelcoat has a gel time of approximately 15 minutes (different brands will have varying gel times).
Allow the gel coat to cure until it is touch dry or no colouring comes off onto your finger (approximately 2 hours on a hot day and up to 6 hours or more on a cold day)
8. Clean the brush or spray gun in acetone immediately.

9. Cut or tear the chopped strand matt to fit the mould, allow an extra cm around the edges. On tight curves tear the matt (dart) to fit and add extra pieces if required. Put the matt onto a clean surface until ready for use (eg newspaper).
10. Working out the amount of resin needed (mix no more than you can use in 30minutes)
EG. 450ml of resin for every square metre of 225gram SSM
600ml of resin for every square metre of 300gram CSM
900ml of resin for every square metre of 450gram CSM
1.2lts of resin for every square metre of 600gram CSM

The above resin to glass ratio is worked off 2:1.

11. Work out the amount of catalyst required. On a hot day use 1% through to a cold day use 2%.
EG. 100ml of resin on a hot day requires 1ml of catalyst
1lt of resin on a hot day requires 10ml of catalyst
100ml of resin on a cold day requires 2ml of catalyst
1lt of resin on a cold day requires 20ml of catalyst
12. Mix the catalyst into the resin using a flat stirring stick. Mix thoroughly.
13. Brush a thick coat of resin onto the gel coated mould.
14. Position the glass in the mould on top of the wet resin and then add another coat of resin taking care not to displace the fibres. It may be necessary to 'dab' the brush against the glass fibres rather than brush the surface to avoid moving them. Make sure that every part of the glass is 'wet out' thoroughly and that there are no white (dry) spots. Wait 2 minutes to allow fibres to fully saturate.
15. Consolidate the laminate by using a metal roller over the surface. This removes air bubbles and gives a quality laminate free of voids. Don't push the roller too hard or it may clump the glass. If the roller picks up the glass rinse in acetone and continue. Allow to cure of 1-2 hours.
16. Clean the roller and brush in acetone immediately.
17. Add additional layers of glass and resin as required, noting that the second and subsequent layers can be laminated at the same time as long as each is rolled properly.
18. Remove 'nibs' from the laminate with a sharp knife or abrasive paper (80grit).
Please note, if the laminate has been left for 24 hours or more it should be sanded all over before additional layers of glass or flow coat is applied.
19. Working out the amount of flow coat required is the same as the ratios used to work out Gelcoat. (See step 4 for Gelcoat ratios).
Catalyst addition rates for flow coat is also the same as Gelcoat (see step 5)
20. Mix the catalyst into the flow coat and brush or spray onto the job. Use the same application methods used for Gelcoat (see step 7). Flow coat will gel in approximately 15minutes.
21. Clean the brush or spray gun in acetone immediately

Please note: This is to be used as a guide only, the Technical Data Sheet for each item should be referred to for more information along with the MSDS for all the safety information.

If you would like any further information or assistance please call:



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