

STORAGE:

Uncatalyzed Patch Reducers have a Shelf Life of 60 to 90 days from date of manufacture when stored at 73° F or below in a closed, factory-sealed, opaque container and out of direct sunlight.

SHIPPING:

This product is normally shipped in unlined, pint, quart, gallon and five gallon containers. Refer to the Transportation Classification Report before shipping.

TECHNICAL DATA SHEET

PATCH REDUCER

This TDS Applies to the following Part Numbers:

(MCG)765PB100 • 765PB200 • 765PB300

(MCG)766PB100 • 766PB200 • 766PB300

(MCG)788PB100 • 788PB200 • 788PB300

(MCG)799PB100 • 799PB200 • 799PB300

(MCG)765PBPV100 • 765PBPV200 • 765PBPV300

(MCG)766PBPV100 • 766PBPV200 • 766PBPV300

(MCG)788PBPV100 • 788PBPV200 • 788PBPV300

(MCG)799PBPV100 • 799PBPV200 • 799PBPV300

DESCRIPTION:

Patch Reducer is specially designed to aide in the process of Gel Coat Patching. When mixed with Gel Coat according to the instructions the results will produce a harder surface to sand upon, reduce halo's and patch marks which produces a higher gloss when buffing and polishing. However, Gel Time and Sanding Time can vary greatly depending on humidity and tempature.

TYPICAL PROPERTIES: (AT 77° F)

These values may or may not be a manufacturing control criteria; they are listed for a reference guide only. Particular batches will not conform exactly to the numbers listed because storage conditions, temperature changes, age, testing equipment (type and procedure) can each have a significant effect on the test results. Materials with test results outside of these readings can perform acceptably. Final suitability is in the end use performance.

Viscosity

Brookfield LVF #2 spindle @ 60 rpm 80 - 150 cps

Thix Index 1.4 minimum

Non-Volatile Material 48%

Weight per gallon 8.8 lbs.

Gel Time of Patch Reducer with 2.0% MEKP:

Gel Time 6 - 12 minutes

Sanding Time 45 - 60 minutes

Mini-Craft of Florida, Inc.

900 Industrial Drive * Wildwood, Florida 34785

PHONE: (352) 748-5200 * 1(800) 282-8244 * FAX: (352) 748-5338

E-Mail: sales@minicraft.com * Web Locator: www.minicraft.com

(ADV)MC293

RECOMMENDED PROCEDURE:

1. Prepare the repair area by scuff sanding to remove the gloss. Avoid sandpaper coarser than 320 grit, as the deep scratches may affect the patch quality. Wipe with Acetone to remove sanding dust.
2. Shake the Patch Reducer before using. This is necessary to provide a uniform mixture. Some active ingredients may settle and can be easily reincorporated by shaking.
3. Start by preparing the patching mix. Quantity can be scaled up or down, depending upon needs.

Minimum Mix**Typical Mix**

a. Gel Coat	8oz	16oz
b. Patch Reducer	1.5oz	3.5oz
c. MEK Peroxide	5 cc's	10 cc's

4. Spray gel coat using Mini-Craft Spray Gun (AES)128 or equivalent. Use 25 - 50 psi to achieve acceptable atomization.
5. Some Gel Coats may require the patch to be oversprayed with PVA, wet-on-wet, to achieve complete tack-free surface. PVA can be eliminated by incorporating Wax Solution into the mix. Use Mini-Craft wax solution part number (MCPMC278). Add 2oz of wax solution per 1 quart mix. Stir well before applying.
6. For Gel Coat application refer to Mini-Craft Tech. Data Sheet (ADV)MC291
7. For Buffing and Polishing Techniques refer to Mini-Craft Tech. Data Sheet (ADV)MC312
8. It is recommended any excess patching mix be placed on a solid surface in a well ventalated area.

PRECAUTIONS:

Always shake or mix before use. This assures a uniform mix.

Secure the lid after each use. An open container can have a negative effect on patches.

Catalyzed masses get very hot as they cure. It is recommended any excess patching mix be placed on a solid surface in a well ventalated area.

Using a heat source such as heat gun or infrared light to speed the cure time takes special care.

1. Use the heat source only where it will not be a fire hazard. Electrical appliances are an ignition source around flammable materials, including acetone and styrene-containing products.
2. The spray patch must be gelled and partially cured before heat is applied. Ungelled patches are a fire hazard. This can produce unacceptable results.
3. Heat will speed up the cure, but it must be done right for best results. The patch must be heated slowly and evenly.
 - a. If heated too fast, only the surface will be cured. That can result in unacceptable patches.
 - b. If the temperature is too high, the color of the patch may be unacceptable. Generally, surface temperature should be slightly warm to the touch.
 - c. Use of heat can cause additional surface distortion and fiber pattern near the patched area. BE CAREFUL - don't get the patch too hot.
4. Do Not add any materials to the mix that are not recommended or manufactured by Mini-Craft of Florida, Inc. Using "Like" products will produce the best results.