Technical Datasheet

MAXGUARD™ CR-03000

Maxguard™ CR-03000 PROPATCH Additive, when added to the gelcoat creates a patched area that is virtually indistinguishable from the remaining gelcoated surface. Maxguard CR-03000 PROPATCH additive is very easy to use and performs reliably and consistently over a variety of repair conditions and techniques. It levels and cures quickly to reduce sanding time. Maxguard CR-03000 PROPATCH additive complements the premium gelcoat surface with minimal color change both before and after buffing. For best results, use the Maxguard CR-03000 PROPATCH with Maxguard gelcoats.
Fast cure and leveling for reduced sanding time
Buff-friendly
Maintains patch invisibility over long term UV exposure

Use 25-35% of the Maxguard CR-03000 PROPATCH additive (less for high hap materials, more for low hap materials) mixed in to the base gelcoat. A 2% MEKP type 9% active oxygen initiator/catalyst is recommended. Use the same batch of gelcoat that the part was sprayed with to make the repair. For proper cure of the patch, ideal working temperatures are between 70-85°F(21-29°C) for the PROPATCH additive, the gelcoat with which it is mixed, the ambient atmosphere and the part. Please consult Ashland's Cosmetic Repair Seminar guide, available in English, Spanish and French, for further tips on patching.

Responsible Care*

Ashland is committed to the continuous evolution of technology and service solutions that promote health, safety and environmental protection around the world.
* Registered service mark of the American Chemistry Council. ® Registered trademark and ™ trademark of Ashland Inc.

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Typical Properties (77°/25 °C)

Typical Values ![1]!	Value	Unit
Viscosity, Brookfield RV, spindle 2 @ 20 rpm	100	cps
Geltime, 2% MEKP-9 ![2]!	6	min

(1)Typical values: Based on materials tested in our laboratories, but varies from sample to sample, and should not be construed as a guaranteed analysis of any specific lot or as specification items.
(2)Registered trademark of Syrgis Inc.

Application and use

1.Prep the area around the defect with an 80 – 120 grit sand paper.
2.Mix 3 parts gelcoat (2 parts if low hap/high weatherable series) to 1 part CR-03000 PROPATCH additive for 1 minute. Add 2-2.5% MEKP catalyst and mix this material for 1 more minute. This will have a cup gel time of ~10 minutes.
3.Spray patch to approximately 10 mils thick.
4.Let patch cure for 45 – 60 minutes.
5.Wipe the patch area with acetone to remove any tacky patch material.
6.Sand the initial patch down with 320 or 400 grit sand paper. Take care to work the edges of the patch well, to remove the 80 – 120 scratches. 600 grit sand paper is not aggressive enough to remove these deeper scratches. If after finishing you still see sand scratches on the patch edge, rework the area with the 320 or 400 grit sand paper and rebuff.
7.Sand the area with 600 grit sand paper to remove the 320 or 400 grit sand scratches.
8.Sand the area with 800 grit sand paper to remove the 600 grit sand scratches.
9.Buff the patch.
10.The whole process should take around 60 minutes at temperatures above 70 °F.

Certificates and approvals

The manufacturing, quality control and distribution of products, by Ashland Performance Materials, are complying with one or more of the following programs or standards: Responsible Care, ISO 9001, ISO 14001 and OHSAS 18001.

Handling and storage

DOT label: flammable. It is highly recommended that all materials are stored at 25 °C, preferably indoors and away from direct sunlight or heat sources. A high quality methyl ethyl ketone peroxide (MEKP) catalyst should be used between 1.5 - 2.5%. Gelcoats must be gently agitated before use. For good handling and working practices, see Ashland "Gelcoat Handling Guide". The commercial

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warranty period for this product is 60 days from shipment.

All other conditions being equal, higher storage temperatures will reduce product stability and lower storage temperatures will extend product stability.

Notice

All information presented herein is believed to be accurate and reliable, and is solely for the user's consideration, investigation and verification. The information is not to be taken as an express or implied representation or warranty for which Ashland assumes legal responsibility. Any warranties, including warranties of merchantability, fitness for use or non-infringement of intellectual property rights of third parties, are herewith expressly excluded.

Since the user's product formulations, specific use applications and conditions of use are beyond the control of Ashland, Ashland makes no warranty or representation regarding the results which may be obtained by the user. It shall be the sole responsibility of the user to determine the suitability of any of the products mentioned for the user's specific application.

Ashland requests that the user reads, understands and complies with the information contained herein and the current Material Safety Data Sheet.

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