Laminating guide
Acrystal Prima

Preparation

1. prepare the mould for lamination. If it is not a silicone mould you must use a release agent.
2. prepare 2 layers of 200-4D stitched fibres at the size of the piece to laminate.
3. prepare the material according to the users guide of the product used as gelcoat:
   - Acrystal Prima
   - Acrystal Decor Metal
   - Acrystal Decor Carrara
4. if necessary, for a better adhesion to vertical parts of the mould, add some thixotrope at the end.

Préparation du moule

Préparation de la fibre 200-4D

Laminating

1. apply a gelcoat layer of 1 to 3 mm thickness in the mould.
2. let the gel coat dry until it becomes a satin-finish and is no longer tacky to the finger.
3. during that time prepare the Acrystal Prima for lamination. If necessary, add some retarder to increase pot life.
4. apply Acrystal Prima onto the gel coat.
5. put the first layer of 200-4D fibres on it.
6. wet the fibres by taking care to remove all air pockets.
7. apply a new coat of Acrystal Prima.
8. apply the second layer of 200-4D fabric and wet it with Acrystal.
9. finish the lamination with a last coat of Acrystal.

Apply a gel coat

Let the gel coat dry

Apply Acrystal Prima

Put a layer 200-4D fibre

Wet the fibres

Apply Acrystal Prima

Apply a second layer 200-4D fibres

Finish with a last coat Acrystal Prima

Laminating option

- Lamination with 200-4D fibre very rarely requires more than two layers of fibre.
- To increase panel rigidity, simply increase the space between the two layers of 200-4D fibre.
- A simple method is to sprinkle chopped fiberglass between the two layers.

Sprinkle chopped strand

Wet this layer with Acrystal Prima

Finishing

- demoulding is possible after 20 minutes to 2 hours depending on the size and the shape of laminatings.
- for the finishing processes refer to the users guide of the Acrystal product used as gel coat.