

INSTRUCTIONS

DESCRIPTION

THX-6™ is a highly efficient thickener concentrate used in conjunction with an **Aqua-Resin Lxf/S3** mix. By adjusting the proportions of **THX-6**, viscosities such as a thick syrupy consistency (for gel/surface coats), an easy-sanding, putty-like consistency (similar to auto body filler) and even a clay-like consistency are possible. The various viscosities are also useful, usually in conjunction with **Aqua-Glass™** chopped fiberglass, as a covering and reinforcement for rigid foams such as Styrofoam® or EPS and for direct modeling on an armature. **THX-6** will also provide color uniformity to a finished surface.

MIXING INSTRUCTIONS

In most cases (other than for clay-like consistencies), **THX-6** is most easily incorporated into an **L/S3** mix as a water dilution (**THX-6 PREMIX**): Add one part water to one part **THX-6** (wt. or vol.). Note, water diluted pre-mixes of **THX-6** can be thicker than the undiluted material. A **THX-6 PREMIX** should be tested or discarded after 24 hours.

Most efficient thickening is with a normal mix (1:3 by weight 1:2 by volume) **L/S3** mix. Slowly add **THX-6 PREMIX** in small amounts—mix until desired consistency is reached. **Please note that thickening action continues with mixing; mix until thickening has stopped; only then add more THX-6 PREMIX if needed. Use sparingly.** For greater accuracy and repeatability both **THX-6 PREMIX** and undiluted **THX-6** may be added in weighed percentages as follows:

Gel Coats (Brushable Consistencies): To a 1:3 (wt.) **L/S3** mix add 0.2 to 0.6% **THX-6 PREMIX**. Power mix till perfectly smooth and “seed” free. Then, for gel coats add about 0.2-0.5 % 1/2” **Aqua-Glass™** and hand mix. The addition of **Aqua-Glass** will not only strengthen a gel coat when applied on a soft rubber mold surface, keeping the coat from cracking and lifting as subsequent coats are applied, but will also, because of a grinding action of the glass fiber, facilitate making a smooth seed-free surface. (Gel coats made in this way will be tackified and thick enough not to run or pool when brushed onto a silicone mold.)

Once the gel coat mix is smooth and seed-free, scrub it forcefully onto the mold surface using a circular motion. Then brush this coat out to a smooth seed-free surface. Once this coat has solidified, a second, optional, gel coat may be added at any time. Once the gel coat has solidified, wait several hours before adding backup reinforcing coats.

Trowel-able consistencies: The **THX-6 PREMIX** is added to a **1:3** by weight **L/S3** mix. For hand mixing, slowly add the measured **THX-6 PREMIX** in small amounts—mix with a rigid spatula until desired consistency is reached. Use sparingly; a maximum of approximately 3% of the total L/S3 mix is all that is needed to make a thick trowelable consistency. Larger batches may be power mixed in the above proportions using a high torque mixer.

Clay-like Consistencies: Add the **THX-6** undiluted to a **1:4** by weight **L/S3** mix. When the **THX-6** is first added there may be a tendency for thickened material to accumulate on the end of the spatula. If so, scrape this thickened material on the side edge of mixing container and then incorporate it back into the mix. Once this mixture has thickened substantially it may be transferred onto a mixing slab and worked with a trowel or spatula to more easily produce a homogeneous clay-like consistency.

Percent Addition by Weight

	MIX RATIO(wt.	THX-6 PREMIX	THX-6 (undiluted)
GEL COAT	1:3	0.2 - 0.6%	-----
TROWEL (patching)	1:3	2 - 3%	-----
CLAY	1:4	-----	2%

General Patching: For best adhesion, the substance should be clean and slightly roughened or sanded. Most finishing operations can begin as soon as the **THX-6** thickened mix has solidified -- adhesion will increase substantially with time. As with other **Aqua-Resin** products, **THX-6** thickened mixes are particularly easy to shape, tool, and wet sand immediately after hardening (*beta* stage.) For faster set times, incorporate **XLR-8** accelerator into the **L/S3** mix before **THX-6** is added.

TIP

If encountering lumps (seeds) when mixing, the **THX-6** is being added too quickly. Add in smaller increments, mixing well between each addition.

When preparing a **THX-6** thickened patching putty for a **Aqua-Resin** surface, use the same **L/S3** mix ratio for the patching mix as was used originally in the part being patched. Doing so will result in a surface with the same sanding characteristics as that original part.

Please note:

Color will vary from lot to lot.

The use of fumed silica products such as Cabosil® is **not** recommended for thickening.

Consult **SDS** for more information. aquaresin.com/sds

The above recommendations and instructions provided for **Aqua-Resin®** products are presented in good faith and believed to be correct and accurate. However, since user methods and conditions of application are entirely beyond our control, this information is offered without warranty. The user is advised to do their own testing to determine suitability for their particular application.

Please contact us or visit our website for the most up to date product instructions and information.

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