

THX-6TM is a highly efficient thickener concentrate used in conjunction with an already mixed **Aqua-Resin[®]** gel/surface coat or laminating mix. By adjusting the proportions of **THX-6** used, 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 thicker viscosities are also useful, often in conjunction with **Aqua-GlassTM** chopped fiberglass, as a covering and reinforcement for rigid foams such as **Styrofoam[®]** or EPS.

Mixing: In most cases, **THX-6** is most easily incorporated into the L/S3 mix as a water dilution (**THX-6 Premix**): Add one part water to one part **THX-6**. A quantity of this premix can be made in advance and saved for future use. *Note, water diluted pre-mixes of **THX-6** can be thicker than the neat material.*

Most efficient thickening is with a 1:3 by weight (1:2 by volume) L/S3 mix. For hand mixing slowly add **THX-6 Premix** up to 0.5% of the mix weight 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, a maximum of approximately 0.5% of the total L/S3 mix is all that is needed to make a heavy clay-like putty.** Thinner viscosities will, of course, require considerably less **Premix**. Gel coats may require as little as 0.1% (1 part per 1000) or less.

In practice, since mix quantities may be as little as a few ounces, it may not be practical to weigh small amounts of the THX-6 Premix. In such cases simply add one drop at a time, mixing well between each single drop addition.

Larger quantities may be power mixed in the above proportions using a high torque mixer.

OR: If hand mixing with undiluted **THX-6**, as is often the case when mixing clay-like consistencies, 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 to help 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 consistency.

TIP: If encountering lumps when mixing, the **THX-6** is being added too quickly; add in smaller increments, mixing well between each addition.

Application: Apply **THX-6** thickened mixes with brush, spatula, or notched trowel as appropriate.

Gel Coats: Sometimes, gel/surface coats may release prematurely from the mold surface (primarily from silicone rubber), which can cause pitting or other deformation of the gel coat surface. Thickening with **THX-6**, possibly with the addition of **Aqua-GlassTM** ½” chopped fiberglass, can provide enough “structure” or “body” to prevent this from happening

Please Note: For best adhesion, the substrate 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. In addition to **Aqua-GlassTM** and other fiber reinforcement, various fillers* such as perlite and vermiculite may be added to bulk the material to further increase viscosity, reduce weight, and reduce material cost. As with other **Aqua-Resin[®]** products, **THX-6** thickened mixes are particularly easy to shape, tool, and wet sand during the *beta* stage. For faster set times incorporate **XLR-8TM** accelerator into the **THX-6** thickened mix.

*Please note: The use of fumed silica products such as Cabosil[®] is not recommended for thickening.

Consult MSDS for more information.

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 with warrantee. 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.

www.aquaresin.com