How to Patch Hypalon

You can use: FA4844 Adhesive, FA1065 Shore Adhesive, or Stabond Adhesive

Optional: ACC4844/4009 Accelerator can be used with FA4844

Tools Needed: 80 Grit Emery Cloth Sandpaper, Brush, Small Tin Can – CLEAN, Toluene (Toluol), Patching material, scissors, pen or pencil, rag. Optional: Roller hasp, Nylon Brush wheel and drill, Heat gun or hair dryer

Step 1. ***Fabric Prep*** – This step should be done in a well-ventilated area. Breathing adhesive and solvent fumes is bad for your health. Take care not to get solvents on your skin as that is also bad for your health. Clean the Patch Material and the area to be patched with Toluene using a rag or brush. Cut your patch material so that there is approximately 2" of Patch Material extending past the hole and leave no sharp corners. Place the patch over the area to be patched and draw the outline of your patch. To help line up the patch, draw "alignment marks" from the patch onto the object you are patching (3 or 4 tick marks). Using the sandpaper or nylon brush wheel, rough the surface of the area inside the patch outline (Stay inside the lines) and do the same to the Patch Material. Surfaces to receive adhesive should have all "sheen" removed and look dull (This is a very important step). Lastly, remove the dust created from roughing by blowing it clean (air compressor with blower nozzle works best). Pro tip – if the patch isn't to patch a hole (wear patch or D-ring) consider having object fully inflated, air leaks will require object to be fully deflated. If you're adding a wear patch or D-ring, you can keep your boat fully inflated. If you're patching an air leak, you should have your boat fully deflated.

Step 2. ***Mix Accelerator*** – If using Stabond (Or if using FA4844 with an accelerator) Add the accelerator to the adhesive and mix thoroughly. If not using the whole can, you will need to remove the desired amount of adhesive into a separate container and mix the approximate amount of accelerator to the adhesive and mix. If using a separate container, try to have a container you can close when not in use. Once the accelerator is mixed the glue will start to harden. Generally, you can work with the mixed adhesive for a couple of days depending on how much adhesive is left in the container and how much air space is in the closed container.

Step 3. ***Apply Adhesive*** – Using a brush, paint a thin coat of adhesive onto the area to be patched and the underside of the Patch Material. Too much glue is not good and will cause the patch to have a weak bond. Think thin to win! Let the first coat of glue dry completely – about 30 min to 1 hour. The idea is to bond the adhesive to the fabric. If using a brush that is not part of the can, place the brush in a tin can that has enough Toluene to keep the bristles wet. Next, apply a second thin coat of adhesive in the same manner as the first coat. After about 5 min, check the "tack" of the adhesive by touching a small part of your knuckle to the adhesive to see if it wants to stick to your knuckle. You do not want the adhesive to feel wet. The idea is to off-gas the solvents to allow the adhesive to dry. Once the adhesive has a tack, the patch is ready to be applied.

Step 4. ***Apply Patch*** – Using the alignment marks, line up one edge of the patch very carefully. Slowly roll the patch into place. Firmly press on the patch (Rollers are a great tool to do this). If you can warm the patch with a Heat Gun or Hair Dryer this will help the bond but, be careful, it can also cause the patch to start to curl. Babysit the patch by continuing to press down firmly. Try to remove any excess glue extruded from the sides of the patch.

GOOD LUCK!