Figure 6 Clean the surface. Use a solvent, if necessary, to remove all contaminates.

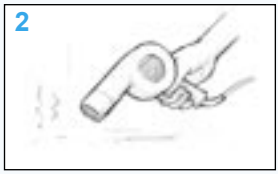

Figure 7 Dry the Surface. Allow wet surfaces to dry thoroughly or use heat or a fan to speed the drying.

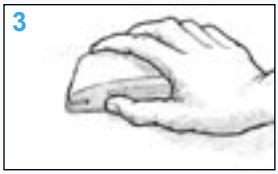

Figure 8 Sand non-porous surfaces. Provide a texture for the epoxy to key into.

Primary/Secondary bonding

Primary bonding relies on chemical linking of adhesive layers such as the wet lay-up of fibreglass laminate in a mould. All the layers of adhesive cure together in a single fused layer. Epoxy applied over partially cured epoxy will chemically link with it to form a primary bond. The ability to chemically link diminishes as the previous layer of epoxy cures and the bond becomes a secondary bond.

Secondary bonding requires a mechanical, rather than chemical linking of an adhesive to a material or cured epoxy surface. The adhesive must "key" into pores or scratches in the surface - a microscopic version of a dovetail joint. Correct surface preparation provides a texture that will help link the cured epoxy to the surface.

Special preparation for various materials

Cured epoxy - Amine blush can appear as a wax like film on cured epoxy surfaces. It is a by-product of the curing process and is more noticeable in cool, moist conditions. Amine blush can clog sandpaper and inhibit subsequent bonding but it is water soluble and can easily be removed. It is not unreasonable to assume it has formed on any cured epoxy surface.

To remove the blush, thoroughly wash the surface with clean water and an abrasive pad. Dry the surface with fresh paper towels to remove the dissolved blush before it dries on the surface. Sand any remaining glossy areas with 80-grit sandpaper and clean.

Wet-sanding will also remove the amine blush. If a release fabric (peel ply) is applied over the surface of fresh epoxy, amine blush will be removed when

Removing epoxy

Removing uncured or non-curing epoxy. Scrape as much material as possible from the surface using a stiff metal or plastic scraper - warm the epoxy to lower its viscosity. Clean the residue with WEST SYSTEM 850 Cleaning Solvent. (Follow safety warnings on solvents and provide adequate ventilation). Allow solvents to dry before recoating. After recoating wood surfaces with epoxy, brush the wet epoxy (in the direction of the grain) with a wire brush to improve adhesion.

Removing fibreglass cloth applied with epoxy. Use a heat gun to warm and soften the epoxy. Begin in a small area near a corner or edge. Apply heat until a putty knife or chisel can be slipped under the cloth. Grab the edge with a pair of pliers and slowly pull up the cloth while heating just ahead of the separation. On large areas, use a utility knife to score/cut the glass and remove in narrower strips. Resulting surface texture may be coated or remaining epoxy may be removed as follows.

Removing cured epoxy coating. Use a heat gun to soften the epoxy. Heat a small area and use a paint or cabinet scraper to remove the bulk of the coating. Sand the surface to remove the remaining material. Provide ventilation when heating epoxy.