

# GLUE INSTRUCTION

Instruction Provided by Seamax Marine. (Canada. 2016)

Mix 5% hardener (treatment) to the glue before use. Maximum 10% hardener when in Cold Weather 10C-15C or High Humidity 50-75%. Do NOT exceed a mixture of 10% to the glue. M.E.K. is the thinner for glue. If the glue hardens, you can add up to 10% MEK to the glue to reactivate the glue.

Glue mixed with hardener can be kept for up to 6 hours. Glue and hardener sealed in the bottles can be kept up to 3 years. We suggest to use a small painting brush to apply 1-3 layer(s) glue on both material surfaces. Wait 5 minutes between applications to allow glue to dry and then attach the two pieces of material together. Once you have applied the patch, work from the center out with something like a teaspoon to force out any air bubbles and then apply pressure to the repaired area for at least 24 hours. Wait 48 hours for the glue to cure before using.

Glue can be used as one part if missing the hardener. For a better result, please do 2 Part glue (glue and hardener) to ensure the overall quality of the repair and extend the life time of the bonding. For any repairs related to air leaks, please use 2 Part Glue.

Note: Suggested to apply the glue 1-2 layers on new fabric surface; 2-3 layers on old fabric surface; 3-4 layers for wood or plywood surface; 2-3 layers for parts or aluminum surface. (The surface of Hypalon boat fabric has a coating layer, sanding the boat fabric to get rid of this coating is a must before gluing.)

Only mix the amount of glue you require for the repair. Seal the bottle right away and store it in a cool area so that it may be used again. If the hardener turns to crystals or gets sticky, it is no longer usable. To clean the area that needs to be repaired, use Methyl Hydrate, Acetone or MEK.

## WARNING:

Product Content Polyurethane. M.E.K. Harmful if inhaled; eye irritations. May cause sensitization if inhaled. Repeated exposure may cause skin dryness and cracking; Keep away from sources of ignition-No smoking; Don't breathe vapor / spray. In case of contact with eyes, rinse immediately with plenty of fresh water & seek medical attention. Use Only in well-ventilated areas. Don't smoke or work near open flames, sparks or other heat sources.

Glue and all chemical materials are dangerous goods. Keep out of Reach of Children. Store in a cool and safe spot.

## OPTIMAL USE:

For the best results when gluing, the relative humidity should be less than 60% and ambient air temperature should be between 18C to 25C (65 F to 77F) and not in direct sunlight. Clean the patching area on the boat as well as the contact side of the patch, it is best to use M.E.K. (Methyl Ethel Ketone) patching solvent and cleaner. Keep solvent off skin. After applying the solvent, you will notice that the area will become tacky. This tackiness ensures good glue adhesion.