655 Epoxy Adhesive General Use

- Avoid skin contact with resin, hardener or mixed adhesive. Wear liquid-proof gloves and adequate protective clothing to keep the epoxy off your skin.
- Avoid eve contact with resin, hardener or mixed adhesive. Wear protective glasses. In case of contact with eyes, flush with water for 15 minutes and consult a physician.
- Avoid inhalation of vapors. Provide adequate ventilation. Wear a dust mask when sanding epoxy, especially epoxy that has not fully cured.
- Read and follow safety information on resin and hardener containers.

Starting out

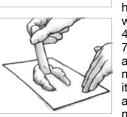
Puncture the seal in each tube with the point in the top of the cap. Enlarge the opening as necessary to improve flow.

Before mixing epoxy, gather all necessary application tools, clamps and equipment. Check all parts for proper fit and be sure all surfaces to be glued are properly prepared.

Mixing and curing

the square end





to thoroughly blend the resin and hardener (2). After mixing the resin and

of a mixing stick

hardener, you will have about 45 minutes, at 72°F (22°C), to apply the mixture before it begins to gel and up to 75 minutes to

assemble and clamp parts after it is initially applied. At 72°F (22°C), the adhesive mixture will solidify in 3-4 hours and reach a workable cure in 7-10 hours. The adhesive may be sanded clamps can be removed, and joints can be moderately loaded. Wait 24 hours before subjecting joints to high loads.

G/flex 655 Epoxy Adhesive cures faster in warmer temperatures and slower in cooler temperatures. When a guicker cure is desired, apply moderate heat to substantially reduce cure time. Cure time is reduced by half with each 18°F (10°C) increase in temperature.

G/flex 655 will cure in temperatures as low as 40°F (4°C), but cure very slowly. When using 655 at lower temperatures, it is a good idea to warm resin and hardener to room temperature for easier dispensing and mixing.

Curing epoxy generates heat. Thicker layers of 655 generally cure a little faster than thinner layers, as this heat is concentrated in thicker layers and dissipated in thinner layers.

Cleanup

Clean uncured epoxy from skin and clothes with alcohol, followed by washing with soap and water. Remove excess epoxy from work surfaces with the flat end of a mixing stick or with paper towels. Clean up residue with alcohol, citrus-based cleaner or a solvent such as lacquer thinner or acetone.

Basic surface preparation

Dispense equal volumes of G/flex 655 Resin G/flex 655 Epoxy will bond to many different and Hardener onto a mixing pallet (1). Use materials. For best adhesion to most materials, bonding surfaces should be:

> CLEAN-Remove loose, chalky or flaky coatings, and contaminants such as grease, oil, wax, and mold release. Clean contaminated surfaces with an appropriate solvent applied with plain white paper towels. Wipe the surface with a clean, dry paper towel before solvent dries. Do not use laundered rags to apply or remove solvents as they may contaminate the surface with fabric softener residue.

SANDED - Sand non-porous and smooth surfaces with 80-grit aluminum oxides and paper to provide good texture for the epoxy to "key" into. Brush away sanding dust. Refer to the chart (right) for recommendations.

DRY—Although G/flex 655 Epoxy can be used to bond damp and wet surfaces, maximum adhesion will be achieved when bonding to dry surfaces.

Additional surface preparation Plastics

Sand or grit-blast the surface to expose bright metal.

Clean the area with acetone or lacquer thinner using white paper towels. Allow the surface to dry completely

Abrade through wet epoxy—Apply a thin coat of G/flex 655 Epoxy and immediatelv scrub metal surfaces through the wet epoxy coating with a fine wire brush or sandpaper.

Hardwoods, including tropical woods

Bonding to dry wood (between 6 and 12% moisture content) is best for achieving long-term reliable bonds. Sand mating surfaces with 80-grit parallel to the grain. Clean oily woods with a solvent such as isopropyl alcohol or acetone. Apply solvent with plain white paper towels. Wipe the surface with a clean, dry paper towel before solvent dries. Do not use laundered rags to apply While flame treating will improve adheor remove solvent.

The extent of wood failure in tensile adhesion tests indicate that tensile adhesion achieved using G/flex 655 Epoxy. with proper surface preparation, approached or exceeded the grain strength of the wood in all of the woods we tested.

Clean plastics, except for polycarbonate, with isopropyl alcohol to remove contamination. Sand all plastics including polycarbonate with 80-grits and paper to provide texture for good adhesion. Flame Clamp the components in position before angles, fillets can be used to add considtreat ABS and PVC for additional benefit.

HDPE (high-density polyethylene) and LDPE (low-density polyethylene) must be flame treated for good adhesion.

FLAME TREATING is a method for improving adhesion to plastics by quickly passing the flame of a propane torch across the surface after it is cleaned and sanded. Allow the blue part of the flame to touch the surface. Keep it moving at the rate of 12 inches per second.

No obvious change takes place, but the flame oxidizes the surface and dramatically improves adhesion. Make multiple passes of the torch 3/4" apart to treat wide areas. Be careful not to melt or burn the surface.

sion to most plastics, it appears to provide the greatest benefit to polyethylene (HDPE and LDPE). If you are unsure of the type of plastic, it doesn't hurt to flame treat.

Surface preparation for various dry materials		
Material	Basic surface preparation	Additional surface preparation
Fiberglass laminate	As necessary, Remove soft and loose surface material Remove contamination with solvent wipe Sand with 80-grit sandpaper	
Aluminum		Abrade with 80-grit sandpaper
Steel		
Steel-galvanized		Wire brush through wet epoxy
Copper		
Bronze		
Lead	333 23 23	
lpe	Sand with 80-grit sand- paper parallel to grain	Isopropyl Alcohol wipe
Teak		
White oak		
Walnut		
Purpleheart		
Greenheart		
ABS	Isopropyl Alcohol wipe Sand with 80-grit	Flame treat
PVC		
HDPE, LDPE plastic		Flame treat required
Polycarbonate (Lexan™)	Sand with 80-grit	

Bonding

Apply the epoxy mixture to all properly prepared mating surfaces. Apply enough epoxy to fill voids and bridge gaps on uneven mating surfaces.

the epoxy begins to gel—about 75 minutes at 72°F (22°C). Use just enough clamping pressure to squeeze a small amount of epoxy out of the joint. Leaving some glue in the joint increases bonding strength. Allow the epoxy to cure thoroughly before stressing the joint.

Use a spreader or notched trowel to apply G/flex 655 to larger surfaces prior to clamping. Use a pipe cleaner or syringe to apply adhesive to hard to reach areas such as cracks and fastener holes when bonding hardware.

Bonding to wet surfaces and surfaces underwater

While gluing to a dry and properly pre-pared surface is best for producing reliable long-term bonds, gluing to damp, wet and even underwater surfaces is possible.

Abrade bonding surfaces with 80-grit sandpaper.

Mix an appropriately sized batch of G/flex 655 Epoxy Adhesive. Forcefully apply the 655 onto the bonding surfaces with a plastic spreader or stiff brush to displace water in the scratches and pores at the bonding surface.

Bring the mating surfaces together and apply just enough clamping pressure to squeeze out excess adhesive and moisture.

If one bonding surface is dry, apply extra adhesive to it, so excess will displace water at the bonding surface. It is important that significant excess adhesive squeezes from the joint for proper bonds to form.

Gluing things to plastic boats

G/flex 655 is a toughened epoxy adhesive

strength—the ability to adequately transfer

another—depends on the combined effects

GLUE STRENGTH—Careful metering and

thorough mixing will assure the epoxy

adhesive mixture cures to full strength

designed to bond to many different

materials in addition to plastic. Joint

a load from one part, one material, to

of three factors.

ADHESION—For the best adhesion, the joint's bonding surfaces must be properly prepared. Refer to the chart on the left for the proper surface preparation for the plastic and the material you are gluing to it.

a load on the joint.

Making fillets

before the epoxy gels (4).

Light weight fiberglass fabrics and tapes

(4-9 oz/sq yd range) can be used with G/flex

655 Epoxy Adhesive when fiber re-inforce-

ment is desired to add stiffness or abrasion

resistance, or to patch a damaged area.

Cut the fabric to fit the area. If heavier

reinforcing is desired, use multiple thin

layers rather than a single thick layer.

Properly prepare the surface before

Coat the substrate with 655. Lav the

and sub- strate have been saturated,

fabric in position on the wet adhesive.

Spread mixed adhesive on to the fabric

use the spreader to smooth and remove

excess epoxy. Repeat the process with

using a plastic spreader. When the fabric

Fiberglassing

applying fabric.

additional layers.

When parts are joined at or near right

erable strength to the joint by increasing

the surface area

of the bond.

Make fillets by

of G/flex 655

corner of the

epoxy into a

cove section

using the round

end of a mixing

stick (3). Clean

off the excess

epoxy with the

beveled end of

the mixing stick

joint. Form the

applying a bead

along the inside

JOINT AREA—The bonding area of the joint must be adequate for the load on the joint and materials being joined. Increased overlap, scarf joints, fillets and reinforcing fibers can be used to increase the joint bonding area.

Allow to cure 7-10 hours before remov-G/flex 655—a West System® Epoxy ing clamps and 24 hours before applying

G/flex 655 Epoxy is the result of years of experimentation to develop a toughened epoxy that was simple to use, viscous enough not to drain out of a joint, and would adhere tenaciously to a variety of materials under difficult conditions.

G/flex 655 is all that, and more. It is a marine-grade glue that can be accurately mixed in small batches with a simple 1:1 mix ratio. It has the advantage of a long open working time and a relatively short cure time.

G/flex 655 is, first of all, a high-strength epoxy—designed for permanent, waterproof, structural bonding. Further more, G/flex has a modulus of elasticity of 150,000 psi, giving G/flex the toughness to make structural bonds that can absorb the stresses of expansion, contraction, shock, and vibration.

G/flex adheres tenaciously to difficult-toglue hardwoods and even has the ability to glue damp woods.

G/flex is ideal for bonding a variety of other materials, including dissimilar ones-metals, plastics, glass, masonry, and fiber-glass. It can be used to wet out and bond fiberglass tapes and fabrics.

We encourage you to read these instruction and then experiment with G/flex. We think you will find many projects for which the particular properties of G/flex are ideally suited.

West System reliability

G/flex 655 Epoxy is the latest addition to the West System line of epoxy products. While G/flex offers physical properties and applications that are different than West System 105 Resin-based epoxies, they share the same high standards for performance and reliability.

West System is the worlds leading brand

of marine epoxy, created by Gougeon Brothers—sailors, boatbuilders, and formulators who literally wrote the book on wood/epoxy boat building. We know the engineering and chemistry required to formulate epoxies for high-performance composite structures. It requires thorough research, rigorous test programs, skillful shop work and direct experience with today's high-performance boats and other engineered structures. This experience and dedication to performance has given West



System another quality that sets it apart from other brands of epoxy.

For forty years, reliability has been the

hallmark of West System. We adhere to the highest standards of quality assurance in our formulating and manufacturing practices, from raw material qualification to testing and certification of finished resins and hardeners. This means that every properly mixed batch of West System Resin and Hardener, including G/flex Resin and Hardener, will cure as it is supposed to, everytime. This commitment to quality has earned certification to the ISO9001:2008 standard. West System is your reliable solution.

Outstanding customer service

WEST SYSTEM provides you with something else as reliable as our epoxy-knowledge. Whether your project is large or small, the West System Technical Staff and comprehensive instructional publications will help assure the success of your building and repair project. West System is renowned for its outstanding customer service

The West System website provides basic product information, dealer locations and links, project articles and galleries, and safety information. Visit westsystem.com.

Further assistance can be obtained by contacting the friendly and knowledgeable Technical Staff. Send e-mail to tech-support@westsystem.com or call 866-937-8797 (toll free).

Because West System Inc. cannot control how its products will be used, it makes no warranties, either expressed or implied, including no warranties of merchantability and fitness for purpose intended. West System Inc. will not be liable for incidental or consequential damages.



Repair Kit

PLASTIC BOAT

Repair plastic boats

Step-by-step instructions show you how to use the materials in this kit to repair splits, cracks and small holes in plastic canoes, kayaks and other small boats.

Tools required

In addition to the materials in this kit, you will need a propage torch, a sabre saw or hack saw. scraper or chisel, clamps, 80-grit sandpaper, 2"-wide packaging tape, plastic spreader, paper towels, color matched plastic-compatible paint and laquer thinner or acetone as necessary for clean up.

Repairs requiring additional materials

With the addition of 4–6 oz. fiberglass or Kevlar[™] fabric and a plastic spreader, you can create abrasion resistant surfaces on worn stems and bottoms and repair larger holes. Instructions are included.

Repairs to inflatable boats

Patch air leaks, re-bond attachment points, repair delaminated transoms and damaged floors. Instructions are included.

Finishing

G/flex Epoxy is compatible with Krylon® Fusion™ or Rust-oleum® Universal All Surface™ paint to match existing finishes.

Kit contents

4.2 fl. oz. G/flex 655-A Resin, 4.2 fl. oz. G/flex 655-B Hardener (9 fl. oz. mixed epoxy), 2 reusable mixing sticks/applicators, 2 pair disposable neoprene gloves, mixing palettes and complete handling and repair instructions.

WARNING IRRITANT, POSSIBLE SKIN SENSITIZER. May cause irritation to eyes and skin. May cause allergic reaction. Avoid skin and eye contact. Do not ingest. Use with adequate ventilation. Use with liquid-proof gloves, eye protection and protective clothing.

FIRST AID: SKIN CONTACT—Immediately wash with soap and water. EYE CONTACT—Immediately flush with water for at least 15 minutes. Consult physician, INHALATION—Remove to fresh air. Consult physician if coughing or irritation develops, INGESTION—Do not induce vomiting, If conscious, give 2 glasses of water. Get immediate medical attention, KEEP OUT OF REACH OF CHILDREN

655-A RESIN CONTAINS: bisphenol-a epoxy resin, bisphenol-f epoxy resin, amorphous silica. 655-B HARDENER CONTAINS: ATBN polymer, aminoetheylpiperazine, tris-2,4,6-(dimethylaminomethyl)phenol, triethylenetetramine, phenol 2,4,6-tris[(dimethylamino)methyl] reaction products with triethylenetetramine, phenalkamine curing agent, cashew nutshell liquid, 1,3-benzenedimethanamine, amorphous silica.



Manufactured for West System by:



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Plastic Boat Repair

Plastic canoes and kayaks are most often made of thermoformed plastics like HDPE (high-density polyethylene), ABS, and occasionally PVC. G/flex Adhesive bonds to these materials and is used to repair damage to products made of these materials. Refer to the safety and general use information on the reverse side of this sheet.

beveled joint, over filling it slightly.

Repair splits and cracks in plastic boats

2. Bevel the

edges of the

crack with a

sharp tool to

create a smooth

4. Flame treat

the repair area

to improve

taper (2).

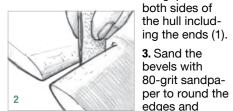
The repair procedure will differ depend- 6. Apply mixed G/flex to one side of the ing on whether you will have access to the back side of the repair area. Repairing splits and cracks with this kit and the following items:

- ☐ Sabre saw or hack saw
- ☐ Chisel, knife or other sharp scraper
- □ 80-grit sandpaper
- ☐ 2"-wide packaging tape
- ☐ Propane torch
- ☐ Matching spray paint (optional)

Repair with access to both sides

1. Drill a 1/8"diameter hole at the ends of the crack. Open the crack or split with a saber saw or hack saw blade to create a slight gap in the break.







adhesion as described in Additional Surface Preparation on the reverse side

of this sheet (3).

5. Mix an appropriately sized batch of G/flex 655 Adhesive. Refer to Mixing and Curing on the reverse side of this sheet

7. Cover the

ioint with 2"

adhesive-filled

wide cellophane

packaging tape

excess (overfill)

epoxy through to

the other side of

the joint (4). Avoid

forcing too much

peveled area on

the opposite

epoxy from the

taped side.

8. Fill the

while forcing

reverse side of this sheet. 5. Apply adhesive to the beveled joint

Curing on the

slightly. Use the side of the mixing stick or plastic spreader to feather the edges flush with the surrounding surface and scrape away excess epoxy (7). Add more epoxy as needed to fill low areas. Allow to cure 7-10 hours.

6. Remove high spots and smooth the surface with a scraper or sandpaper

7. Wipe the area with water, dry thoroughly. Sand with 180-grit sandpaper and paint with a plastic-compatible paint if desired.

Repair holes in plastic boats

Canoes and kayaks can be punctured as **8.** Wipe the area with water, sand for a result of impacts with rocks and other sharp objects. Repair holes with G/flex 655 Epoxy and the following items not included in this kit:

Additional Surface Preparation on the

4. Mix an appropriately sized batch of

G/flex 655 Adhesive. Refer to Mixing and

reverse of this sheet.

- □ 80-grit sandpaper
- ☐ 2"-wide packaging tape
- ☐ A propane torch

☐ Matching spray paint (optional) Repair techniques can vary depending

on hole diameter and accessability. The goal is to replace the missing material with G/flex 655 Epoxy and providing adequate bonding area.

Repair holes up to ¼" diameter

- 1. Drill out the hole with the smallest diameter bit that bridges the hole.
- 2. Run a slightly larger sheet metal screw into and out of the hole to tap threads on the inside of the hole (8a).
- 3. Apply a piece of packaging tape or duct tape over the back of the hole to prevent epoxy from squeezing through the hole.

6. Remove excess cured epoxy and

shape the surface to suit with a cabinet

reverse side of

adhesive to the

void, overfilling

it slightly (8b).

Allow to cure

this sheet.

5. Apply the

4. Mix an appropriately sized batch of G/flex 655 Adhesive. Refer to Mixing and Repair with access to one side only Curing on the

7-10 hours.

scraper or sandpaper.

1. Drill a 1/8" diameter hole at the ends of the crack.

side of the repair with more G/flex 655.

surrounding surface and scrape away

9. Clean uncured epoxy residue with a

paper towel and acetone or lacquer

thinner. Allow G/flex to cure 7-10 hours

10. Remove high spots and smooth the

11. Wipe the area with water, dry thorough-

ly and paint with a plastic-compatible paint

surface with a scraper or sandpaper.

like Krylon® Fusion™ or Rust-oleum®

Universal All Surface[™] paint if desired.

Use the side of the mixing stick to

feather the edges flush with the

before removing packing tape

excess epoxy (5).

2. Bevel the edges of the crack with a sharp tool to create 3/4" to 1" wide bevels on both edges



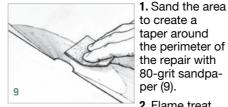
of the crack and at each end (6) 3. Flame treat the repair area to improve

adhesion as

described in

better adhesion and paint with a plastic-compatible paint if desired.

Repair holes over 1/4" diameter

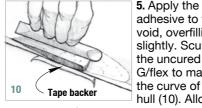


to create a taper around the perimeter of the repair with 80-grit sandpaper (9).

2. Flame treat the repair area to improve adhesion as described in Additional Surface Preparation on the reverse side of this sheet.

Apply a piece of packaging tape over the back of the hole to prevent epoxy from squeezing through the hole. Tape a piece of cardboard or other stiff material to the back of the hole if necessary to maintain the shape of the hull.

4. Mix an appropriately sized batch of G/flex 655 Adhesive. Refer to Mixing and Curing on the reverse side of this sheet



adhesive to the void, overfillina it slightly. Sculpt the uncured G/flex to match the curve of the hull (10), Allow

to cure 7-10 hours.

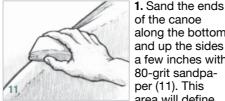
6. Remove excess cured epoxy and shape the surface to suit with a cabinet scraper, or sandpaper.

7. Wipe the area with water, dry thoroughly. Sand with 180-grits and paper and paint with a plastic-compatible paint.

Repair worn surfaces/create skid plates

Repair and extend the life of plastic canoes and kayaks by applying reinforcing fabric wear strips along the keel and stems to patch worn holes and provide abrasion resistance. Reinforce and patch worn areas with G/flex 655 Epoxy and the following items not included in this kit:

- ☐ 80-grit sandpaper
- ☐ A propane torch
- □ 4–6 oz. fiberglass or Kevlar[™] fabric ☐ Matching spray paint (optional)
- □ Plastic spreader



of the canoe along the bottom and up the sides a few inches with 80-arit sandpaper (11). This area will define

the size of the skid plate.

- 2. Flame treat the repair area to improve adhesion as described in Additional Surface Preparation on the reverse of this sheet.
- 3. Cut three or four layers of lightweight fiberglass or Kevlar fabric to cover the sanded areas. Cut the bottom piece of fabric to fit to the sanded/flame treated boundary. Trim each successive layer an inch or two narrower and shorter than the previous. This tapers the thickness of the fiberglass skid plate/patch toward the edges so it will easily deflect and cling to the hull as it flexes.

4. Place packaging tape or duct tape across the back of large holes if necessary, to support the repair during cure.

5. Mix an appropriately sized batch of G/flex 655 Adhesive. Refer to Mixing and Curing on the reverse side of this sheet.

6. Apply a coat of epoxy to the sanded/flame treated area. Lav the largest piece of fabric onto the adhesive. Apply more adhesive to saturate the fabric. If necessary, warm the epoxy with a heat gun to lower the viscosity and improve wet out in cooler temperatures. Use the side of the mixing stick or a plastic spreader to smooth the fabric and remove excess epoxy



fabric applica ion with the remaining piece(s). Center each smaller laver on the one

2. Apply a

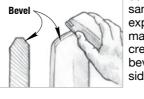
before it. Wet out the fabric, and then use a spreader to smooth the fabric and remove excess epoxy (12).

- 8. Apply a coat of G/flex 655 to fill and smooth the edges of the fabric while the fiberglass application is still tacky (optional). Allow to cure 7-10 hours.
- **9.** Remove excess cured epoxy and shape the surface to suit with a scraper. file, or sandpaper.
- 10. Wipe the area with water, sand for adhesion and paint with a plastic-compatible paint if desired.

Paddle tip reinforcement

The tips of wooden canoe and kayak paddles take lots of abuse from scraping bottom and pushing off rocks. Use G/flex 655 Epoxy Adhesive to create durable edges to protect tips from damage.

1. Sand the tip of the paddle with 80-grit



sandpaper to expose fresh material and create a 45° bevel on both sides of the tip.

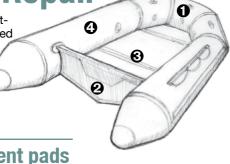


- and build up a thick layer that covers the beveled edges and extends the length of the tip. Allow the epoxy to cure.
- 3. Sand the cured epoxy to shape with 80-grit sandpaper. Apply varnish or paint as desired.

Inflatable Boat Repair

There are four common problems associate ed with inflatable boats that can be resolved with G/flex Epoxy:

- 1. Attach/re-attach accessories
- Transom damage and de-lamination
- Stripped fasteners
- 4. Small air leaks in tube chamber



Repair accessory attachment pads

Accessory attachments such as oar locks, tow rings and hand holds are mounted to larger flexible base pads which provide a generous bonding area to the inflated tubes. Rub strakes are glued directly to the tubes. They usually begin failure gradually, peeling from one edge and will detach completely if neglected. Accessory pads and rub strakes can be reattached and new ones attached with G/flex 655 Epoxy and the following items not included in this kit:

- □ 80-grit sandpaper
- ☐ Masking or packaging tape
- ☐ Acetone solvent

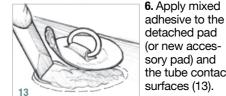
Inflatable tubes should be filled to the designed pressure. If that is not possible, lay the tube flat so no wrinkles exist.

1. Mark the location where the pad will be reattached (or attached) and mask off the area outside of the pad to protect adiacent surfaces.

and the tube with acetone to remove the previous adhesive. 4. Abrade contact surfaces with 80-grit

3. Clean the contact areas on the pad

- sandpaper. Hand sand in all directions so surfaces are evenly abraded.
- 5. Mix an appropriately sized batch of G/flex 655 Adhesive. Refer to Mixing and *Curing* on the reverse side of this sheet.



4. Insert and lightly tighten the fastener. sory pad) and Clamp it if necessary to hold it in place. the tube contact Allow to cure overnight before applying load. surfaces (13).

7. Cover pad with plastic (food wrap) film then place a soft cushion-like material such as a sponge over the pad then exert mild force with a weight or wraps of tape to insure full and even contact until epoxy cures. (7–10 hours). ■

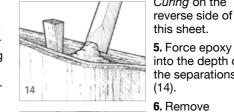
Repair transom damage

Fixed plywood transoms on inflatable boats usually rest in a channel fitted to pads glued to the tubes. Forces exerted from out board motors often cause delamination of the plywood or degradation from rot especially around the motor mount locations. Repairs range from gluing delaminated plywood back together to replacing the transom with new plywood.

Repair delaminated plywood

- 1. Open up delaminated plywood with wedges or chisels.
- 2. Dry the wood thoroughly.
- Clean debris and loose wood from from closing tight.

4. Mix an appropriately sized batch of G/flex 655 Adhesive. Refer to Mixing and Curing on the



into the depth of the separations (14).6. Remove

wedges and

clamp lightly

(15). Clean up

excess epoxy

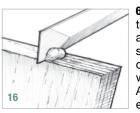
and allow to

cure 7-10 hours

before using. ■

5. Make or buy a patch of the same

5. Mix an appropriately sized batch of G/flex 655 Adhesive. Refer to Mixing and Curing on the reverse side of this sheet.



6. Glue layers together and after shaping

seal the edges of the plywood with 655 Adhesive to seal end grain (16).

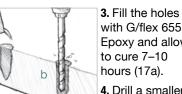
7. Sand smooth, then bond new transom into the channel using G/flex 655.

Repair enlarged and stripped fastener holes

Folding floor boards often have issues with
Procedure for stripped fastener holes

hinge fasteners separating from the boards. 1. Dry the stripped screw holes. Usually, the fasteners are simply stripped.

> 2. Mix an appropriately sized batch of G/flex 655 Adhesive. Refer to Mixing and



Curing on the reverse side of this sheet

Epoxy and allow to cure 7-10 hours (17a).

pilot hole and

screw the fastener into it (17b).

Repairing pinhole leaks

Replace damaged plywood

2. Clean this channel thoroughly.

bond together with the epoxy.

channel.

original transom.

1. Remove the transom from retaining

3. Locate new plywood of the same

4. Use the old transom as a pattern. If you

can't get plywood thickenough, laminate

multiple pieces of thinner plywood and

Procedure enlarged fastener holes

2. Mix an appropriately sized batch of

G/flex 655 Adhesive. Refer to Mixing and

Curing on the reverse side of this sheet.

3. Fill the holes with G/flex 655 Epoxy

1. Dry the screw holes.

type and thickness as used in the

occur from punctures and abrasion. The repair is similar to reattaching a delaminated accessory pad using the following materials not included in this kit:

☐ 80-grit sandpaper

☐ Masking or packaging tape

Apply 50/50 mix of water and liquid soap over the suspected area and observe for

bubbles are created.

6. Cut a 4" diameter round patch. Avoid

7. Trace the patch size with pencil on

8. Abrade tube around leak with 80-grit sandpaper, hand sanding in all directions. Do same to the under side of the patch material.

9. Mix an appropriately sized batch of G/flex 655 Adhesive. Refer to Mixing and Curing on the reverse side of this sheet

10. Apply G/flex 655 to the tube and



surface. Cover the patch with

with 1/2" thick

of boowyla

distribute weight. Place a 5-10 lb weight on top of the plywood (18).

12. Allow to cure 24 hours before

Pinhole leaks in tube chambers typically

Locate exact location while inflated.

2. Mark the location with a pencil where

3. Dry and clean surface with acetone.

4. Deflate the hull and lav area of the repair flat so no wrinkles exist.

material as the inflatable tube is made of and of a similar thickness

corners and sharp curves.

patch and place patch onto plastic, then

inflating to the recommend pressure.

gaps that would prevent the veneers