



# Midwest Raft Distributors, Inc.

## Materials Needed:

- Hypalon patch material, Hypalon d-ring, or Hypalon foot-cup
- Shore adhesive
- Roller Rasp or 150-180 Grit Wet/Dry Sandpaper
- Rubbing alcohol or Toluene for cleaning
- Pro Roller or Roller Rasp
- Lint free towel
- Pencil

## Recommended Safety Precautions:

- Work in a well ventilated area (garage or shady area works well).
- Organic Fume Respirator
- Chemical resistant gloves (i.e. Nitrile gloves).
- Eye protection

## Environmental Conditions:

- Ideal ambient temperature for gluing: 75T and below 50% humidity.
- Maximum humidity: **Do not** try to mix and apply glue if the humidity exceeds 70%.

## Fabric Preparation;

1. All contact/gluing surfaces must be thoroughly buffed, using a sanding wheel, 150 or 180 grit sandpaper, or a roller rasp. Just buff the fabric shine off; dont rasp down to the threads.
2. Cut patch, round the edges.
3. Clean the buffed surfaces with rubbing alcohol or Toluene using a Sint free towel.
4. Trace area of patch (extending 2" from all sides of the damaged area) with a pencil.

## Application of Glue:

1. Both surfaces to be joined must be coated with adhesive.
- Note:** The surfaces to be joined must be dry prior to applying adhesive,
2. Apply one thin, even coat of adhesive to each surface.
  3. Wait until the first coat of adhesive is dry-approximately 10 to 30 minutes, depending on conditions. Use the "knuckle" test - touch your gloved finger to the glue. You should be able to fee! adhesion without your knuckle sticking.
  4. Apply a second thin, even coat to each surface. Wait until the second coat has an even, tacky finish (surfaces should not be visibly wet). Use the knuckle test again to gauge the optimum surface condition for joining the surfaces. Don't allow the layer to dry completely.
  5. Immediately press both sides of the fabric together and apply pressure to the entire glued surface using a roller, rolling from the center out. This forces air bubbles out and meshes the two fabrics together. Use a lint free towel to wipe up excess glue.
  6. Complete drying time takes approximately 24 hours,
  7. Be careful when roiling up a repaired boat for storage. Make sure drying is complete.