HOW TO REPAIR FIBERGLASS

All repairs should be performed in dry and warm conditions. The part being repaired should be at least 65F, and the ambient air temperature should be at least 65F. Moisture will cause the repair to fail.

Included in the kits are the MSDS for the materials, please read and familiarize yourself with the materials to be used.

The repair kit includes:

- 1 Pint of Resin
- 1 Pint of Green Gel Coat
- 1 Piece of Fiberglass cloth
- 4 – 11ml tubes of Liquid Hardner
- Stir Sticks
- Rubber Gloves
- 32oz White Paper Cups
- Sand Paper

IN ADDITION TO THE MATERIALS SENT IN THE REPAIR PACKAGE YOU WILL NEED ACETONE FOR CLEAN UP AND SOME COTTON WIPING RAGS.

MAKE SURE TO USE GLOVES AND OSHA APPROVED EYE PROTECTION WHEN DOING ANY REPAIRS

STEP 1: Clean out damaged area. It is important that all the loose and broken area be removed and that the area be free of all dirt and debris.

We typically would use a small hand held rotary tool (like a Dremel), with a coned shaped rasp bit to remove all the damaged area. Once all the bad material has been removed, clean out the area with a clean wiping rag soaked in acetone.

Make sure to sand an area larger than the repair area to give you a good bonding surface for the fiberglass and gel coat.

STEP 2: Once the repair area has been sanded out, prepare a fiberglass patch from the fiberglass piece included in the kit. Cut a piece that is slightly larger than the repair area.

STEP 3: Pull the ends of the fiberglass mat to remove some of the fiberglass. You do not want the edges to be clean, you want the patch to have a taper around the edges, otherwise it will be difficult for the repair to be blended properly.

You will need the following items to complete the next steps:

1. Gloves
2. Stir Stick
3. 32oz White Cup
4. Resin
5. Liquid Hardener
6. Fiberglass Patch prepared in STEP 3
7. Chip Brush

STEP 4: Once you have the patch prepared, it is time to mix up some resin. Using a clean White Cup pour about half the resin into the cup (16oz), and mix the appropriate amount of liquid hardener, about .32 of an oz (almost an entire tube). Stir in well using a stir stick. You will have 10-12 minutes of time to work with the material.

STEP 5: Using the Chip Brush wet the repair area with the catalyzed resin.

STEP 6: Lay the Fiberglass Patch over the repair area and push into the resin with the Chip Brush.

STEP 7: Using the Chip Brush saturate the Fiberglass with resin and make sure to get all the fiberglass imbedded into resin, feathering out the edges.

Make sure that the fiberglass and resin is slightly proud of the repair to allow for sanding once cured.

Allow Resin to cure for at least 60 minutes. It will be 100% Dry and Hard to the touch.

Once the resin/fiberglass has cured, sand down the repair area and blend into surrounding area. Once you are satisfied with the look of the repair it is time to apply the Gel Coat.

You will need the following items to complete the next steps:

1. Gloves
2. Stir Stick
3. 32oz White Cup
4. Gel Coat
5. Liquid Hardener
6. Chip Brush

STEP 8: Mix the gel coat; you will not want to mix too much Gel Coat at one time, saving some in case you need to touch up later. Pour about 8oz into the White Cup (1/4 of the cup) and mix in about ½ tube of liquid hardener. Stir thoroughly with stir stick.

STEP 9: Using the Chip Brush DAB, do not brush, on the Gel Coat to cover the area. The right amount of gel coat should fill in all small air pockets and imperfections in the fiberglass. Allow the gel coat to cure for 60 minutes before handling.

STEP 10: Inspect the repair for any small holes in the gel coat. If there are some areas that require more Gel Coat, sand the area again, mix, and reapply gel coat if necessary.

Once your repairs are complete, it will be necessary to harden off the unused portion of the putty, resin and gel coat. Simply mix the remaining liquid hardener into each can in an amount sufficient to harden off the material.

DO NOT DISPOSE OF THE MATERIALS IN THEIR LIQUID STATE, they are considered hazardous materials. Once hardened they become inert and can be simply thrown in the trash.

Should you have any questions please call either John Miller or Tracy Switzer at 314-664-9300.