# FiberPatch White

## FiberPatch Application Instructions

This easy-to-apply patch is designed to be applied to Fiberglass, Steel and any other properly prepared substrate as a permanent patch. This patch will be fully cured in 10 – 40 minutes after exposure to direct sunlight or a UV emitting light source (UVA range of 340 – 410 nm). Ambient temperatures of -32°C/0°F to 49°C/120°F have little effect on cure time and physical properties. However, low temperatures do affect the work ability of the product during application.

It is recommended that the MSDS "Material Safety Data Sheet" for the Fiber patch is read, and all safety precautions are followed during the repair.

**Step 1.** Locate the repair area were the patch is going to be applied. Clean the surface with a clean cloth until all contaminates (mud, grease, oil, etc.) have been removed. Then proceed to step 2.

If the surface is contaminated with grease or oil, clean with a solvent. (acetone, xylene, toluene etc.)

**Step 2.** Using a grinder with "36 Grit" pad, sand an area equal to the repair site with a minimum of 1 1/2" inch around the circumference of the repair site. Sand the entire repair site, removing the texture of the substrate until a uniform abraided appearance is obtained. Remove all sanding dust from the repair area with a dry clean cloth or shop air. Then proceed to step 3.

If required, add foam or rigid insulation into the hole to restore insulative values.

**Step 3.** Take the patch package and open it by carefully cutting the edges of the foil pouch. Do not open the patch until the repair area has been properly prepared (Step 1-3). Fiber patch begins to cure as soon as it is exposed to the sunlight or any UVA light source**.** Once the foil bag has been opened, the patch is good for 4 – 6 months depending on storage conditions.

Remove the smooth layer of nylon film, carefully and slowly to ensure that the mat does not separate, from one side of the patch and apply onto the clean, dry abraded repair area. Make sure the repair area is clean and dry, moisture will hinder and effect the performance of the patch. Using a squeegee, roller or your fingers to work the resin on the embossed side of the patch from the center out towards the edges. Continue to work the product out from the center until a small amount of resin is squeezed out around the perimeter of the patch. This ensures that no air pockets remain behind the patch.
***The embossed nylon film is left on during and after cure.***
**OPTIONAL**: ***Cover the perimeter of the patch with clear packing tape (prior to curing) and smooth the squeezed out resin with your finger.***

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**Step 4**. Allow the patch to cure in direct sunlight for approx. 10- 40 minutes or with a UV curing lamp for 5 or 30 minutes depending on the type of lamp used. FiberPatch is fully cured when it becomes too hard to dent with your fingernail and cannot be moved on the repaired surface. Full bonding strength of the patch is achieved approximately 2 hours after cure.


The fluorescent curing lamp shroud (right photo) must be placed tight against the wall to achieve a 30 minute cure.

The 400-watt Metal Halide lamp (bottom photo right) requires a 5 minute warm-up and then 5 minute cure for each thickness of the patch. Overlapping to cover larger areas will require a minimum curing time of 10 minutes on the overlap seam. The lamp must be placed a maximum of 12" away for the surface to be cured to achieve a 5 minute cure. Safety glasses (UV absorbing lens) are required when using this high intensity UV A light (UVA range of 340 – 410 nm).


**Sun or artificial light intensity influences the cure rate**.

**OPTIONAL**: ***Any resin that was not covered with the clear nylon or tape may have a tacky feel, but if the patch feels hard, it's cured. The sticky film can be removed with Acetone on a white rag and will not effect the patch. Remove any tape that was placed around the perimeter of the patch.***

Keep patch dry until fully cured. Dispose of nylon film and bag after curing any residual resin by leaving it exposed to UV light for 5 – 20 minutes depending on intensity.

# The End Result


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