

FiberPatch Application Instructions

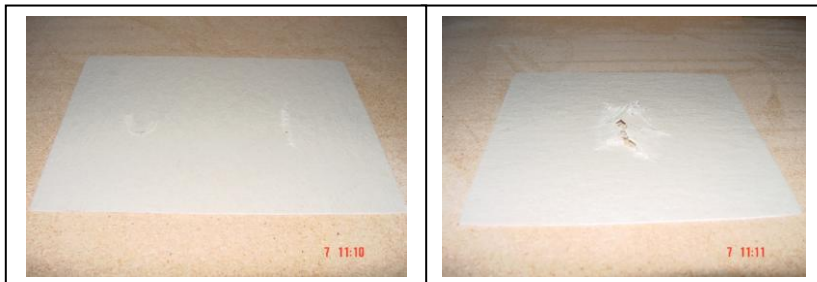
The easy-to-apply patch is designed to be applied to fiberglass and aluminum roofs on trailers for the transportation industry as well as wood, steel, concrete and other properly prepared substrates as a permanent patch. This clear patch will be fully cured in 5 – 20 minutes after exposure to direct 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 workability of the product during application.

It is recommended that the MSDS (Material Safety Data Sheet) for FiberPatch is read, and all safety precautions are followed during the repair.

Step 1

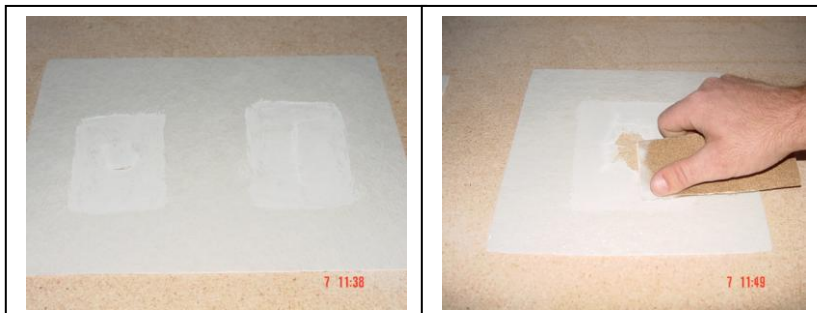
Locate the repair area where the FiberPatch is going to be applied. Clean the surface with a clean cloth until all contaminants (mud, grease, oil, etc.) have been removed. Then proceed to step 2.

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



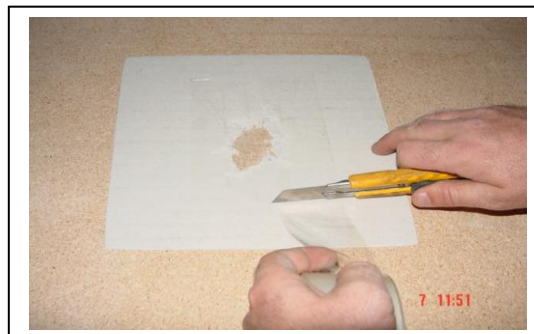
Step 2

Using "80 Grit" sandpaper, 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 until a uniform, dull appearance is obtained. Remove all sanding dust from the repair area with a dry clean cloth or shop air. Then proceed to step 3.



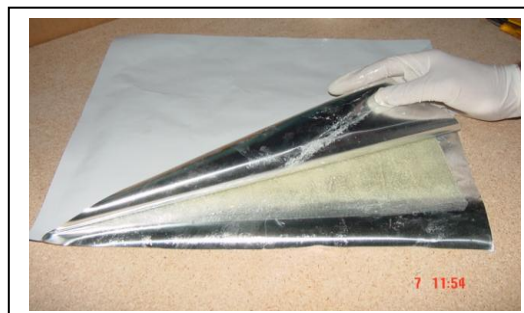
Step 3

If you have access to the back side of the repair area (translucent roof repair), apply masking tape or packing tape to seal and hold all loose edges of the repair together. Although this step is not a necessity, this will help the repair patch adhere to all the loose edges. Then proceed to step 4.



Step 4

Take the FiberPatch 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). FiberPatch begins to cure as soon as it is exposed to the sunlight or any UVA source. In a sealed foil bag, the shelf life is 1 year.



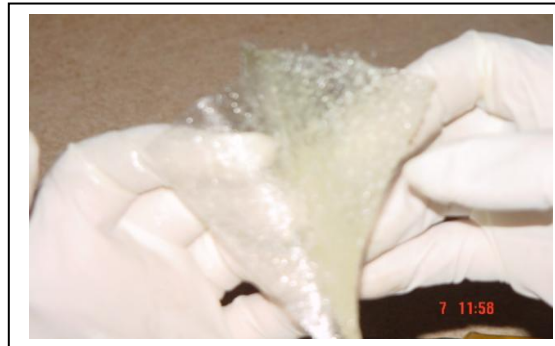
Step 5.

Cut the patch to the desired size using a sharp utility knife. Place the remaining material back into the foil pouch to protect it from UV light. Place foil bag inside a sealed can or zip lock bag to prevent solvent from escaping which will dry out the patch. Once the foil bag has been opened, the patch is good for 4 – 6 months depending on storage conditions.



Step 6

Remove the nylon film from one side of the patch (either the smooth or textured nylon depending on the surface finish desired). Remove the film carefully and slowly to ensure that the mat does not separate. Place the exposed side of the FiberPatch onto the clean, dry, abraded repair area leaving the nylon film on the topside until fully cured. It is essential that the repair area is clean and dry, moisture will effect the performance of the patch.



Step 7

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.

OPTIONAL: *Cover the perimeter of the patch with clear packing tape (prior to curing) and smooth the squeezed out resin with your finger.*

Allow the patch to cure in direct sunlight or artificial UV A light until fully cured (5-20 minutes on a sunny day). Full bonding strength of the patch is achieved approximately 2 hours after cure.



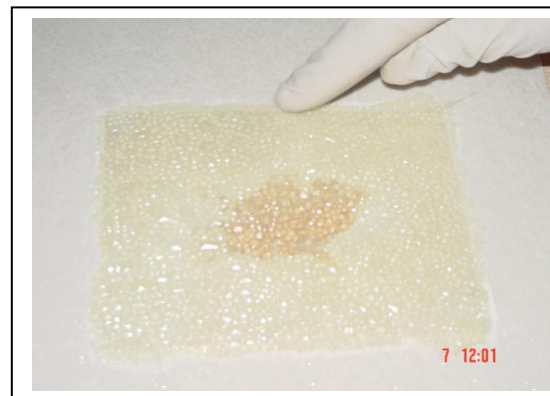
Sun or artificial light intensity influences the cure rate.

Step 8

FiberPatch is fully cured when it becomes too hard to dent with your fingernail and cannot be moved on the repaired surface.

OPTIONAL: *The nylon film can be left on or removed after cure.*

Any resin that was not covered with the clear plastic may have a tacky film, but if the patch feels hard, it is cured. The tacky 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 or on the backside of the repair. If you want to spray paint the repaired area, use an exterior grade paint (acrylic urethanes or acrylic enamels work the best).



Step 9

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.