Before mixing epoxy, gather all necessary equipment. Check all parts for proper mixing and cleaning. 

Mixing and curing

Dispersal equal volumes of G/flex Resin and Hardener into a mixing container. Stir or use a mixer to blend the container thoroughly. Bubbles are a good sign. This indicates a thorough mix. If the epoxy does not separate, you have not mixed it thoroughly enough. Mix until you have a uniform consistency and no more than 3 minutes. Epoxy is highly reactive and causing delays will affect the bond strength between mating surfaces.

Never heat the epoxy mixture. This could cause the hardener to separate from the resin. The mixing ratio is important. If the resin is not mixed in the proper proportion, the bond strength may be affected. Do not add water to thin the epoxy. The addition of water could cause the bond to fail. The mixing is complete when the color of the materials is uniform.

The epoxy cures at room temperature. If the temperature is a little warmer, the bond will cure faster. If the temperature is a little cooler, the bond will cure slower. The proper temperature range is 60°F (16°C) to 90°F (32°C). The bond strength increases with temperature. In warmer temperatures and slower in cooler temperatures. When a quicker cure is desired, apply moderate heat to the joint. G/flex adheres to many different materials. It is a good idea to test the adhesive on a material you wish to bond in a small area that is inconspicuous. If you are using multiple materials, you may want to test the adhesive on all of them. The adhesive strength will be the same throughout the entire area. The joint will cure to its best bond strength.

No bond will cure if the surface is not clean. The surface must be properly prepared before bonding.

Safety

Avoid contact with skin, eyes and mucous membranes. Wash hands after handling. Avoid prolonged inhalation of dust. When using G/flex at lower temperatures, it is a good idea to wear warm and protective clothing. Avoid aspiration of dusts. Provide adequate ventilation when working, especially in confined areas. Avoid breathing any dusts. Read and follow safety information on the labels and material data sheets. Improper mixing and curing can cause reduced strength.
Propane torch
80-grit sandpaper
Sabre saw or hack saw
Following items:
Opening splits and cracks with this kit and the
G/flex 655 Adhesive. Refer to
the safety and general use information on the reverse side of this sheet.

Repair holes in plastic boats
Curved or beveled surfaces can be patched as
solid plastic objects. Repair holes with G/flex 655 Epoxy as described in this
list.

Apply Mix to areas of side that were not sanded.

Repair holes over ½” diameter
3. Drill a 1/8” diameter hole at the ends of
the repair area to improve adhesion as
shown in the image.

Apply the

Mixing and
Curing on the reverse side of this sheet.

6. Mix an appropriately sized batch of
G/flex 655 Epoxy and the
adhesive to the

area

7. Allow to cure overnight before applying load.

8. Clamp it if necessary to hold it in place.

9. Insert and lightly tighten the fastener.

10. Fill the holes with G/flex 655
Epoxy and allow to cure.

11. Replace the transom from retaining
channel.

12. Cover the

Paddle tip reinforcement
The lip of wooden canoes and kayak paddles
is often reinforced with a strip of tape and
pressure sensitive adhesive. Canoes and
kayaks are usually reinforced as per the
manufacturer’s instructions. The
recommended G/flex 655 is available in a
strip and as a roll for this purpose.

Repair transom damage
Advanced transoms on inflatable boats
may be patched with G/flex 655 Epoxy
and G/flex 655 Reinforcement Tape as
shown. Use Skipless Reinforcement Tape
from outboard motors often causes
delamination of the transom, usually near the
mounting locations. Repair range from
gluing糖尿病无损检测}