SAFETY GEAR

Latex Gloves | Eye Protection | Dust Mask | Work clothes

PREP STEPS

- Set yourself up in a dry, clean and warm environment.
- Stabilize hull in sturdy slings, strapped down
- Remove damaged material with chisel / box cutter
- Clean the area with a clean rag and acetone
- Scuff the bonding area with 80 grit sandpaper and a sanding block
- Back the hole with masking tape if necessary

FILL STEPS

- Paper cup, tongue depressor to mix
- One pump West Systems Epoxy Resin 105
- One Pump West Systems Fast Hardener 205 / Slow Hardener 206
- Add West System 403 Microfiber filler to achieve creamy peanut butter consistency
- Fill void and leave proud
- For more structural support, cut a piece of fiberglass or carbon fiber to fit over repair. Wet out with a paintbrush and WS Epoxy Resin and Hardener. If fiberglass or carbon fiber is needed, leave fill slightly depressed, so glass/fiber does not get sanded away
- Cure 6-8 hours @ +/- 60-70 degrees
- Sand with 220 grit sandpaper and a sanding block
- Use Bondo (mix filler and hardener) to fill low spots. Apply thin and even layers with a clean putty knife or similar spreader
- Cure 15-30 minutes
- Sand with 600-800 grit wet sandpaper and a sanding block
- Repeat as necessary

FINISH STEPS

- Clean surface with acetone and allow to dry
- Evenly spray with fresh spray paint
- Cure 12+ hours @ 60-70 degrees
- Wet sand with 1200 grit wet sandpaper using cross-hatching until surface is smooth to the touch
- Buff with 3M Marine Compound (Buffer @ 1500 RPM or less)
- Polish with 3M Imperial Compound Finishing Material