

HI-BOND™

Easy Do-It-Yourself Boat Repair System



Associated Fiberglass Repair Products

Product No.	Description
1010	(Quart) Marine Polyester Resin*
1880	(Pint) Acetone*
1965	(4 oz.) Wax-Sol*
2320	(1 Yard) Fiberglass Mat 3/4 oz.x 38"*
2390	(3 Yard) Fiberglass Mat 1.5 oz.x 50"*
2420	(1 Yard) Fiberglass Cloth 38"*
2510	(1 Yard) Woven Roving 38"*
3480	(2.5 Quart) Plastic Pail*
3510	(4") Squeegee
1230	Complete Repair Kit (Pictured on front)

*Other sizes available.

FIBER GLASS REPAIR
Preparation, Mixing and Application Guide



FIBER GLASS REPAIR

Preparation, Mixing
and Application Guide

For more products, information and
material safety data sheets visit our website @

www.hibond.net

HI-BOND™

Do it once. Do it right.



FIBER GLASS REPAIR

Preparation, Mixing
and Application Guide

*The procedure outlined in
this brochure is for small
area fiberglass repairs. It is
applicable to boats, cars,
RV's, dock boxes, etc.,
wherever fiberglass is used.
For larger repair areas please
consult a professional.*

Do it once. Do it right.

HI-BOND™
Marine Aftermarket Solutions

FIBER GLASS REPAIR

1 Surface Preparation

Sand the fracture: Sand fractured material from the surface with 220-grit sandpaper or rougher. After sanding, the cross section of fiberglass should look like the illustration below.



2 Fiberglass Preparation

Cut pieces of fiberglass mat in increasing sizes in sufficient amount to overfill the sanded out void starting at the bottom and ending at the top. Remove the fiberglass from the void and have them handy. Wipe the sanded area with a clean, damp rag and let the area dry.

Note: In place of mat you can use woven roving for faster build up or fiberglass cloth for a smoother top layer or a combination of these materials.

3 Resin Preparation

Put on a pair of latex gloves and catalyze a small amount of resin. Mix the polyester resin as follows: add 1/8 oz. hardener to one pint of resin, 1/4 oz. hardener to one quart of resin, and 1 oz. hardener to one gallon of resin. Stir hardener and resin thoroughly. Mix only as much resin as you can use immediately.

Once the hardener is added, you have approximately 15 to 35 minutes working time before the resin starts to harden. Your working time depends on the temperature at the time of use and the amount of hardener used. Please follow all directions on the resin can label.

Note: For a tack-free cure use a resin containing wax or add a wax additive to the resin, for example; Wax-Sol.

RESIN COVERAGE CHART*

These coverages are for experienced users. The more inexperienced a person is the less coverage will be achieved. The resin amounts shown are for wetting out material only. The yardages listed are lineal yards for each width. First and top coats are not included in the coverage. All values are approximate.

*If material is applied in combination such as a layer of mat then a layer of woven roving while the mat is still wet the coverages will be a little more than if they are applied individually.

4 Application

The Easy Hi-Bond Do-It-Yourself Steps

Brush a coat of resin on the repair area. Lay the smallest piece of mat on the center of the fracture, wet the mat out with resin using a dabbing motion with the resin brush. When this piece of mat is completely saturated with resin, it will no longer be white, it will be clear. Lay the second piece of mat on the repair and saturate. Use the same procedure until the mat is built up slightly higher than the fiberglass surface. While the mat is still wet you can obtain a smoother finish if you lay a piece of wax paper over the repair and squeegee the mat down smooth. **Clean Up:** Clean all tools and surfaces with acetone before the resin starts to cure. Cured (hard) resin cannot be cleaned with acetone or for that matter, any other readily available cleaner. **Sanding:** Allow 24 hours for the resin to cure completely. If a top coat of either paint or gel coat is to be applied, sand the fiberglass lightly with 220-grit sandpaper and remove all dust. This will ensure a better physical bond.

1. Sand the area thoroughly with 220-grit sandpaper.
2. Cut pieces of fiberglass.
3. Add catalyst to resin.
4. Apply and wet out fiberglass.
5. Place wax paper over the top and squeegee.
6. Allow 24 hours to dry.
7. If a top coat is to be applied then lightly sand and remove all dust.

FIBERGLASS REPAIR

Weight	Width	Type	Yds/Gal
3/4 oz.	38"	Fiberglass Mat	5
3/4 oz.	50"	Fiberglass Mat	4
1 1/2 oz.	38"	Fiberglass Mat	3.5
1 1/2 oz.	50"	Fiberglass Mat	2.5
1 1/2 oz.	60"	Fiberglass Mat	2.25
24 oz.	38"	Woven Roving	2
24 oz.	50"	Woven Roving	1.5
24 oz.	60"	Woven Roving	1.25
8 oz.	38"	Fiberglass Cloth	7
8 oz.	50"	Fiberglass Cloth	5
8 oz.	60"	Fiberglass Cloth	4
37 oz.	50"	Fab-Mat (Stitchmat)	1