

A PRODUCT LINE OF POLYGARD, INC.

HI-BOND™

Easy Do-It-Yourself Boat Repair System



Associated Interior Floor Repair Products

Product No.	Description
1020	(Gallon) Marine Polyester Resin*
1400	(Gallon) Epoxy Glue*
1500	(Gallon) White Gel Coat with Wax*
1810	(2-Gallons) 2 lb. Poly-U-Foam
1900	(Gallon) Acetone*
1940	(Gallon) Styrene*
1965	(4 oz.) Wax-Sol*
2390	(3 Yards) 1 1/2 oz. x 50" Mat*
2810	(1 Yard) 1 1/2 oz. x 6" Mat Tape*
3240	(4") Resin Brush*
3490	(5-Quart) Plastic Pail*

*Other sizes available.



INTERIOR FLOOR REPAIR

Preparation, Mixing and Application Guide

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

www.hibond.net

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Do it once. Do it right.



INTERIOR FLOOR REPAIR

Preparation, Mixing and Application Guide

The procedure outlined in this brochure is for the removal and replacement of the interior flooring of a fiberglass boat. The most common reason for floor replacement is that the floor has become waterlogged and is starting to rot. PolyGard, Inc. assumes no responsibility for any damage which may occur from following this procedure. PolyGard, Inc. encourages you to seek the advice of a professional on any repair that you do not feel comfortable doing.

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1 Old Floor Removal

To remove the old flooring, cut around the entire outside edge of the floor with a saber saw. If the angle of the hull is too severe to use a saber saw then cut around the edges using a skill saw with a

masonry blade. Next, use a crowbar to separate the floor from the keel. This step is neither easy nor fun, so please be careful. Once the old floor is removed, sand the sides of the hull (4-6 inches above the floor level). Remove any screws, nails, etc. from the top of the keel and stringers.

2 New Floor Preparation

Select the New Floor: Traditionally, plywood has been used on the floors of fiberglass boats. If covered correctly with polyester resin a plywood bottom boat will give you years of enjoyment before needing to be replaced. There has, in recent years, been the introduction of alternatives to plywood in the form of polyurethane boards. These boards are designed to have most of the strength of plywood, and in addition will not rot if they get wet. So, in theory, they will never have to be replaced. Whatever you choose as your floor selection, the installation procedure outlined in

this brochure will remain the same.

Cut the new floor into 4 foot sections as they will be installed one section at a time. Trying to do too much at one time will lead to errors, especially if this is the first time you are doing this type of installation. Cut to fit the entire floor area. When you have finished cutting, mix two parts polyester resin with one part styrene and the appropriate amount of hardener. Coat the underside and sides of the new flooring with the catalyzed resin/styrene solution and let the material cure fully (1-2 hours). While the material is curing, sand the tops of the keel and stringers. At this time you may perform the optional task of filling in the voids of the boat between the bottom of the hull and the top of the keel using 2 pound density polyurethane foam.

3 New Floor Installation

A bonding adhesive will need to be added to the top of the keel and stringers before putting the new floor into place. We recommend using Epoxy Glue or mixing talc with polyester resin until a putty like thickness is obtained. Coat just enough of the top of the keel and

stringers with the bonding adhesive for the first 4 foot section of new flooring. Place the first section on top of the bonding adhesive and nail down into place. Remove any excess adhesive from in front of the floorboard as it may prevent the next section from setting flush. Repeat this step of the procedure until all of the new flooring has been set into place.

4 Fiberglass Application

Tear 6" wide strips of 1 1/2 oz. fiberglass mat over the flooring joints and also where the floor meets the hull. Apply liberal amounts of catalyzed polyester resin over the strips. Allow the resin to cure fully and then sand off any burrs or irregularities on the strips to allow the next layer of mat to lay

down flat. Lay 1 1/2 oz. fiberglass mat across the floor and 4-6 inches up the sides of the hull. Once the mat is laid out, saturate the mat with catalyzed polyester resin using a cloth roller and a brush where needed. Let dry completely and sand off any rough areas. Remove all dust and then apply a heavy coat of catalyzed polyester resin over the entire mat surface. Clean all tools with acetone before the resin dries.

The final step...

Carpet or Gel Coat?

If at this time you have decided that carpet or some other flooring material is going to be on top of the fiberglass mat, then you are finished.

If you wish to apply a top coat of gel coat then lightly sand the cured polyester resin and remove all dust.

We recommend that you use a gel coat with wax for a more complete and tack-free cure. You may want to add a non-skid additive to the gel coat to give better traction for your feet. Once the proper gel coat has been chosen, catalyze the gel coat with the correct amount of MEKP hardener and apply to the top of the fiberglass mat using a cloth roller and a brush where needed. You may want to gel coat small sections at a time if the working time of the gel coat is not sufficient to allow you to coat the entire surface area at once.

Clean all tools with acetone before the gel coat cures.

Allow 24 hours for the gel coat to completely cure before walking on it.

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