



West Marine's Marine R/X Epoxy is a non-slumping paste that may be applied to vertical and horizontal surfaces and is used to fill gaps or shaped to repair damaged substrates. Marine R/X may be used with fiberglass cloth to reinforce structural repairs as needed. The finished repair may be carved, sanded, shaped or drilled as required to achieve the desired result.

Bonded to steel, Marine R/X will produce a sheer strength that exceeds 1,700 psi and is stronger than fiberglass or wood. The tensile strength is 4,200 psi. Marine R/X is rust proof, corrosion proof and it resists most chemicals. Marine R/X is effective for temperatures not exceeding 250°F.

#### Directions:

1. Prepare the surface by removing any loose material including rust, paint and scale. Clean with acetone or lacquer thinner to eliminate any contaminants before sanding with 80-grit sandpaper.
2. Clean the prepared surface with solvent to be sure all dirt and sanding dust is removed
3. The repair surface should be heated to a temperature above 55°F (13°C.) For best results, Marine R/X should be mixed and applied at 72° to 78°F (22° to 25°C.)
4. Mix the entire contents of the resin jar and catalyst container (2 oz. kit) on a stiff, flat mixing board. Stir thoroughly for at least 2 minutes with a paint stick or putty knife to achieve a uniform texture.
5. The larger, 14 oz. kit may be mixed in smaller batches by simply adding 1 part of catalyst to 5 parts of resin by volume. There is a small margin for error when mixing allowing for a little more or a little less catalyst to resin. It is better to err on the side of less catalyst as too much catalyst may prevent hardening.
6. Apply the epoxy mixture with a plastic putty knife or squeegee to the repair area. Marine R/X may be applied up to a 1 ½" thickness on vertical surfaces without sagging. It may also be layered to achieve greater thickness, though sanding is required between layers if the first layer has cured before the next is applied. Larger repairs requiring reinforcement may be accomplished by combining Marine R/X Epoxy with fiberglass cloth to the repair area. Marine R/X will begin to harden in 2 to 3 hours at 72°F (22°C) and will be fully cured in 18 to 24 hours at similar temperatures. Ambient temperature will affect cure speed and working time as epoxy works faster at higher temperatures and more slowly at lower temperatures. If you would like to accelerate the cure, place a constant heat source 1 or 2 feet from the repair surface.  
**NEVER USE OPEN FLAME TO SPEED THE CURING PROCESS.**
7. Before Marine R/X sets up it can be shaped and smoothed using water with a plastic trowel or putty knife to reduce the amount of sanding required later. After full cure is achieved, sand or file to achieve the desired surface repair.

Marine R/X may be tinted by adding pigments that are epoxy compatible. Do not add more than 5% pigment to the epoxy mix.

8. Clean tools with soap and water before the material begins its initial cure. Wash hands with soap and water immediately.

**Caution: Always wear protective gloves and glasses and follow all instructions and safety warnings on the containers.**