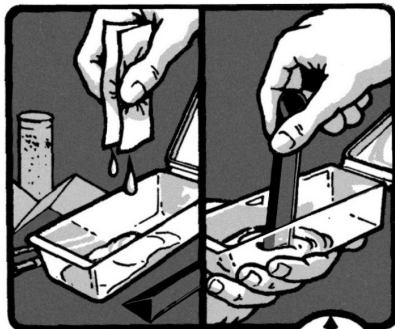


Dispense and mix

Read all directions, including safety information on Resin/Hardener packet, before using. Prepare parts to be bonded. Check for proper fit. Bonding surfaces should be **CLEAN, DRY** and **SANDED**.

1 Empty entire contents of a Resin/Hardener packet into the Handy Pack container. Mix the resin and hardener together thoroughly using the square end of the mixing stick.

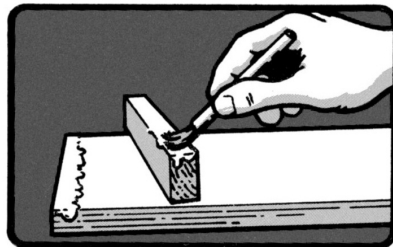


Important! Once resin and hardener are combined, you will have 10-15 minutes of working time.

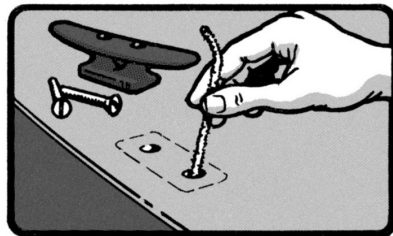


Wet out

2a GENERAL COATING and BONDING Apply the mixture with the brush as a waterproof coating, or to pre-wet porous bonding surfaces before applying thickened epoxy.

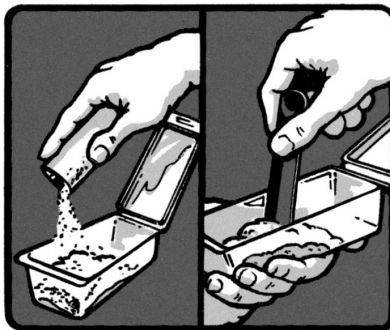


2b HARDWARE BONDING Before bonding hardware, pre-wet porous fastener holes using the pipe cleaner.



Add Filler

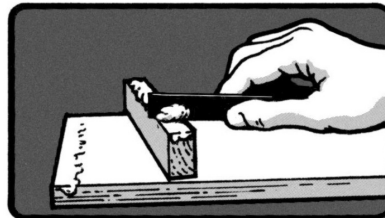
3 Thicken the remaining epoxy by stirring in filler until it reaches the desired consistency. The mixture should be thick enough to fill gaps between mating surfaces without sagging. The more uneven or wider the gap, the thicker the mixture should be. The mixture may be thickened to a very thick, peanut butter-like consistency for maximum gap filling or for filling and shaping low area or filling holes.



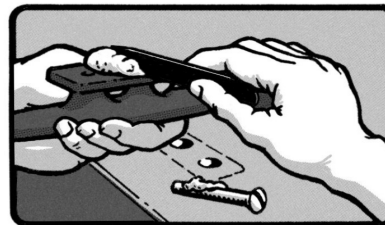
Apply epoxy, assemble and clamp parts within fifteen minutes. Working and cure time will be shorter in warmer temperatures—longer in cooler temperatures.

Apply thickened epoxy

4a Apply thickened epoxy to the mating surfaces using the mixing stick. Clamp the parts in position using only enough pressure to assure good contact and prevent movement.



4b Apply thickened epoxy to the cleaned hardware bonding surface, fastener holes and threads. Position the hardware and tighten fasteners until epoxy squeezes out. Do not over-tighten.



Shape or clean excess

5a Increase bonding area by shaping excess epoxy mixture into a fillet using the round end of the mixing stick.



5b Scrape off excess epoxy with the square end of the mixing stick. Wipe away remaining residue using the alcohol cleaning pad or a paper towel and nail polish remover. Allow 24 hours at 72°F before subjecting to load.

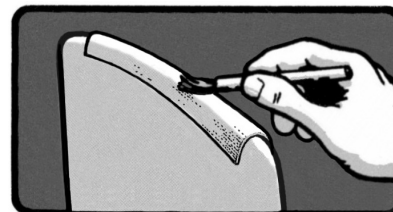


Apply reinforcing

6a Add extra reinforcing to a joint by applying fiberglass tape over the fillet. Trim tape to the appropriate size then use the brush to saturate the fabric with epoxy and smooth the fabric in place.



The fiberglass tape can be used to patch cracks and holes, or provide abrasion resistance to wear points such as stems and keels or the edges of paddle blades and centerboards.



Using epoxy

**WEST
SYSTEM**

Mixing and Curing

Read and follow the directions, including safety information, on the Resin/Hardener packets.

Mixing resin and hardener together starts a chemical reaction that transforms the combined liquid ingredients into a solid.

Before the curing epoxy begins to gel in the mixing container, about 10 minutes at 70°F (21°C), you must—

- Apply and smooth epoxy if you are coating.
- Apply epoxy, assemble and clamp parts if you are bonding.
- Wet out and smooth fabric if you are applying fiberglass reinforcing.
- Spread the epoxy to a thin layer, to extend the working and cure time.

Epoxy cures faster in warmer temperatures and in a thicker layer (as it is in the mixing container). Epoxy cures slower in cooler temperatures and in thinner layers. A thin film of epoxy can take 2–3 hours to gel.

The epoxy mixture will reach a workable cure in 5–7 hours. Clamps can be removed and the epoxy may be sanded, but it should not be subjected to high loads for 24 hours. When a quicker cure is desired, applying moderate heat will reduce cure time.

Gluing tips

- Before mixing epoxy, check all parts to be bonded for proper fit. Gather all necessary application tools and clamps. Keep a roll of paper towels handy.
- For maximum adhesion, be sure bonding surfaces, including surfaces to be coated, are clean and dry. Sand all non-porous surfaces with 80-grit paper.
- Use only enough clamping pressure to hold parts in place without moving. Use enough epoxy adhesive so that a small amount will squeeze from the joint when clamped. Avoid squeezing all of the epoxy out of the joint with too much pressure.

Cleanup

Clean uncured epoxy from skin and clothes with a waterless skin cleaner, followed by washing with soap and water. Remove excess epoxy from work surfaces with the flat end of a mixing stick or with paper towels. Cleanup residue with a solvent such as acetone or lacquer thinner.

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