



# GLUING INSTRUCTIONS FOR STABOND



**TO ENSURE SUCCESS WHEN ATTEMPTING GLUE REPAIR, PLEASE KEEP IN MIND THAT PLANNING AND PREPARATION PRIOR TO APPLYING THE GLUE IS 90% OF THE EFFORT.**

## »» PREPARATION:

1. Calculate size of patch (usually 2 inches larger than tear, all the way around).
2. If attaching D-rings or handles, chamber should be inflated.  
If repairing a tear or installing footcones, deflate air chamber and place on a flat, firm surface. Make alignment marks on both the surface and the patch at 12-3-6-9 o'clock positions, so you can see where to sand and where to line up the patch when applying to surface. *(Use a grease pen or pencil for easy removal).*
3. With 40 grit sandpaper, lightly sand both the patch and surface, only enough to remove the sheen. If you are replacing a patch, be sure both surfaces are free of old glue.
4. Make sure room is well ventilated. Install fan if necessary to remove fumes.  
**CAUTION:** The mixture is flammable and contains Free Isocyanate.
5. Stabond is MEK based, so you can wipe the sanded area with MEK to clean. If not available, you can use acetone or rubbing alcohol.

## »» MIXING GLUE:

We chose 2 part glue because it has a faster set up time and a much stronger adhesion. Glue mixing is required. Stabond UK-148 consists of both a resin (clear in can) and an activator (brown in bottle).

### TIPS:

- When humidity is over 55%, DO NOT attempt to glue. Apply glue indoors for best results. If outside, WORK IN THE SHADE, as direct sunlight will speed dry time.
- Mixing in a glass jar with a cap is the best method and use a stick when mixing.
- If glass jar not available, you can use a tuna can, but keep in mind you may need a cap.

7. Calculate the amount of glue needed.
  - A. 4 ounces will cover approximately 2 sq. ft. with 2 coats
  - B. Each size comes pre-measured with 8 parts resin to 1 part activator. (1 can to 1 bottle, ½ can to ½ bottle and so on). Mix appropriate amount of activator and resin using a mixing stick.
  - C. MIXED GLUE ONLY LASTS 4 HOURS WHEN CAPPED AND PLACED IN A COOL DRY PLACE. After each use, seal remaining UNMIXED glue preferably in glass. This should last the remainder of the shelf life (1 year). *(See Storage section for best results.)*



more on reverse »»

## »» APPLICATION:

### TIPS:

- Most common problems arise from putting too much glue on any one surface during application. Thick heavy coats will actually create LESS of a bond between the fabrics, so go with two light coats!
- Make sure you plan for no interruptions during the application.
- If available, get an egg timer to keep drying time consistent. The longer you take, the faster the base of the glue will evaporate, making the glue thicken.
- Cut bristles on brush down to 1/2 inch to assure a stiff end, to hold less glue.

8. Apply very thin coats of glue to both sanded surfaces using brush. When applying, you want to put it on so thin, you won't even see the brush strokes.
9. Let first coat dry for minimum of 20 minutes depending on temperature and humidity, or to a non-tacky state.
10. Apply a second coat to both surfaces and let stand until slightly tacky. (approx 5-10 minutes depending on humidity)

## »» PATCH PLACEMENT:

11. While the glue is still tacky, carefully line up patch with marks you've made and press both surfaces together firmly. The patch should be applied on a firm surface so you can use your weight to ensure the two surfaces have made contact. This is particularly true when you have something like a D-ring that has multiple layers of materials fabric and webbing to flatten.
12. Fully deflate chamber and place on firm surface. (If repairing a tear or installing footcones, you've already done this). Using a roller, roll all areas of the patch to ensure surface contact to all areas. Working from the center towards the outside, use the roller to work out any wrinkles or bubbles.

### TIP:

- If your patch goes down crooked or wrinkled, use a heat gun to re-activate the glue making it easier to remove and reapply.
- DO NOT PATCH OVER A SEAM. Seam leaks travel, so lift the seam and find the origin of the leak.

## »» CLEAN UP:

13. When gluing, it's okay to go over the lines, but you want to make sure to remove the excess glue within 24 hours, before it turns brown. There are a couple options:
  1. You can wipe the excess glue with MEK, but don't soak it or it may seep into the edges and loosen the glue bond.
  2. Using a soft nylon wheel and drill, remove excess glue from the surrounding area of repair. Make sure the direction of the spinning wheel spins outward, away from the patch, so you don't lift an edge.

## »» STORAGE:

Keep glue stored in a dry area at room temperature. Date bottom of can and replace annually. You can re-use the brushes if they are stored in MEK in a jar that has a hole in the lid large enough to slide the brush in. Use aluminum foil to fill any gaps.