



HH-66 Vinyl Cement

Bonds:

PVC (Vinyl)
Urethane

Materials Needed:

HH-66 Vinyl Cement
Patch material, D-ring or foot-cup
150-180 grit sandpaper
PVC Cleaner (MEK - Methyl Ethyl Ketone) - you may also use acetone or rubbing alcohol
Pencil
Lint free towel
Pro Roller or Roller Rasp

Recommended Safety Precautions:

Read safety warnings on container before using product
Work in a well ventilated area (garage or shady area works well).
Chemical resistant gloves (i.e. Nitrile gloves).
Organic Fume Respirator is recommended
Eye protection

Environmental Conditions:

High humidity may interfere with glue bond.

Material Preparation:

1. Cut patch to extend at least two inches beyond the edges of the tear. Round the edges; square cornered patches are more likely to catch and peel than rounded ones.
2. Trace the outline of the patch on the damaged surface with a pencil.
3. Lightly buff both contact/gluing surfaces, using the fine sandpaper or a roller rasp. Just buff the fabric shine off; don't rasp down to where the threads are visible.
4. Clean the buffed surfaces with PVC Cleaner (MEK) or other solvent, using a lint free towel. This removes any oils or other contaminants that can interfere with the glue bond. Allow area to dry thoroughly.

Application of Glue:

1. Apply one thin, even coat of adhesive to each surface, using brush in the can lid.
2. Allow glue to dry only 2-5 minutes.
3. Although the material may be bonded while wet, optimum results are achieved when waiting 2-5 minutes before bonding the surfaces together.
4. Carefully align the patch and press both surfaces together. Apply pressure to the entire glued surface using a roller. Roll every millimeter of patch in multiple directions, working from the inside to the outside of the patch. This step is very important.
5. If glue dries completely before you can apply the patch, the glue can be reactivated by lightly rubbing surfaces with a cloth soaked in MEK.
6. Use a lint free towel and PVC Cleaner (MEK) to wipe up excess adhesive.
7. Complete curing time takes approximately 24 hours.
8. Be careful when rolling up a repaired boat for storage. Make sure drying is complete.
9. Keep container tightly closed between uses.

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