

Instructions for Applying Stabond 2-part Adhesive

- 1) Using 2" masking tape, tape off the desired area to be coated.
NOTE: Make sure to make straight lines and rounded corners. Applying a drip guard around the bottom of your taped off area helps prevent chemicals from coming in contact with tubes outside the desired area.
- 2) Using THF (TetraHydroFuran) wipe the area to be coated until an shiny and tacky surface is achieved.
- 3) Once a shiny and tacky surface has been achieved, double check all tape to make sure it is in good condition with no leaks around the drip guard.
- 4) To prepare Stabond adhesive mix three parts glue with one part MEK (MethylEthylKetone). For each quart of mixed glue you will need to add 2oz. of accelerator/catalyst.
NOTE: When mixed correctly the glue will have the appearance of golden honey or 'light beer'. Too much catalyst will cause the glue to cure to fast and make it extremely hard to get a proper adhesion to the patch and tube. Too little catalyst will have the adverse effect.
- 5) Using clean THF rewet the entire surfaces to be glued and immediately (while it is wet) use a 2" paint brush or small standard nap paint roller to apply the glue to the surface.
NOTE: Both surfaces that are to be adhered will need to have glue applied. This is in reference to both the tube and the patch.
- 6) Allow to dry for about one hour.
- 7) Wipe both surfaces with MEK and this will reactivate the glue.
Immediately stick the patch to the tube and use a putty knife or other similar flat edge to work out any wrinkles or air bubbles. This adhesive, once reactivated, is essentially contact cement and you only get one chance to stick the patch.
- 8) Once you have finished gluing your project remove all of the tape from around the area and lightly wipe with MEK to remove any dirt or debris from around the area. MEK also works to remove excess glue as long as it is relatively fresh.