

# ***Universal Inflatables***

## ***PVC REPAIR INSTRUCTIONS***

### ***Fabric Preparation***

- 1. Cut patch to extend at least two inches beyond 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 fine sandpaper, ~ 180-grit, or a roller rasp. Just buff the fabric shine off; don't rasp down to the threads. This step can be eliminated by using generous amounts of MEK solvent and rubbing thoroughly.*
- 4. Using MEK SOLVENT thoroughly clean off residual glue (if any). You would use MEK to prep virgin PVC before application of new glue anyway. MEK SOLVENT will make virgin PVC tacky, it softens the substrate making application of new glue more binding to surfaces. Use a lint free towel or rag. This removes any oils or other contaminants that can interfere with the glue bond.*

### ***Application***

- 1. Apply one thin, even coat of adhesive to each surface, using a stiff bristle brush, brush it on rapidly making sure complete coverage of surfaces. Allow it to dry at least 3-5 minutes if in air conditioned environment.*
- 2. Allow area to dry thoroughly. Preferably using a hair dryer (rather than waiting 3 -5 minutes for natural dry) to dry the glue applied to the surfaces. This removes any moisture that settles on the drying hydroscopic adhesive. Glue should have a transparent finish when properly dried. If it appears cloudy then the glue is too thick or contains moisture.*
- 3. If time has elapsed beyond 30 minutes before surfaces have been glued together Adhesive can be reactivated up to 24 hour after application with heat (hair dryer). Both surfaces will adhere as long as warm/hot.*

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 important because it forces air bubbles out and helps the two pieces of material bond.
5. Use a lint free towel and PVC Cleaner to wipe up excess glue.
6. Complete curing time takes approximately 24 hours.
7. Be careful when rolling up a repaired inflatable for storage. Make sure drying is complete.
8. IF REPLACING A DAMAGED ACCESSORY IT MAY NOT BE NECESSARY TO REMOVE THE ENTIRE ORIGINAL ACCESSORY PAD. REMOVE THE DAMAGED PORTION AND SIMPLY PREP THE ACCESSORY PAD LEFT BEHIND. MAKE SURE ALL THAT IS LEFT OF THE ORIGINAL ACCESSORY IS THE PAD, NO OTHER LOOSE PARTS. PVC WILL ONLY GLUE TO PVC USING PVC ADHESIVES.

#### Recommended Environmental conditions and Safety Precautions

- Ideal ambient temperature for gluing: 75°F and below 50% humidity.
- Maximum humidity: Do not try to mix and apply glue if the humidity exceeds 70%.
  - 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