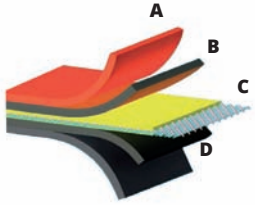
POLYMARINE Hypalon Adhesive Products

Hypalon Inflatable Boat Adhesive. A 250 ml can of 2990 adhesive is supplied with a 10ml bottle of 3965 Curative * Solvent based polychloroprene rubber adhesive giving high strength bonds when used in conjunction with 3695 curing agent; particularly suitable for manufacture and repair of inflatable boats * Will bond natural rubber, polychloroprene, butyl, nitrile , hypalon and polyurethane rubber materials and leather. Please note - not for use on plasticised PVC - use Polymarine 3026 PVC Adhesive * Excellent resistance to heat, salt water and humidity * Easy to apply by brush or roller... * Contact bonds in 10-15 minutes, full cure 48 hours * Shelf life – see expiry date on tin, mixed adhesive has pot life of 3-4 hours * Coverage - using 2 coats 1 litre bonds 1 square metre * As used by MOD, liferaft service stations and major manufacturers.

Single part Hypalon Adhesive.
* Solvent based polychloroprene rubber glue giving high strength bonds, particularly suitable for emergency repair of inflatable boats, RIBs and Dinghies.
* Will bond natural rubber, polychloroprene, butyl, nitrile , hypalon and polyurethane rubber materials, leather. Please note - not for use on plasticised PVC - use Polymarine 3026 PVC Adhesive * Excellent resistance to heat, salt water and humidity * Easy to use as a single part glue for quick and temporary repairs.

P510 Solvent & Cleaner for Hypalon Fabrics.
* For degreasing hypalon surfaces before adhering and cleaning brushes * Use sparingly with a soft cloth, evaporates quickly * Suitable for reactivating applied adhesive.



Hypalon Inflatable Boat Fabric.
For construction & repairs. Colour Range : White, Yellow, Blue, Black, Grey, Light Grey, Orange, Red.

A. External Layer
B. Layer Of Neoprene
C. High Tensile Textile
D. Interior Neoprene Sheets

Not sure if your Tubes are PVC or Hypalon?
If you're about to repair tubes or apply patches, it's essential to know what fabric your inflatable's sponsons are made from. It's very important to use the correct adhesive for either the PVC or Hypalon material.
There is a guide to fabric identification on-line:-

http://www.polymarine.com/advice/pvc-or-hypalon/

POLYMARINE

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Hypalon Adhesive User Guide

Repair & Patch Hypalon Tubes
Adhere Patches, D Rings
& Rubber Accessories

Making Repairs with Hypalon Adhesive

Materials needed:-

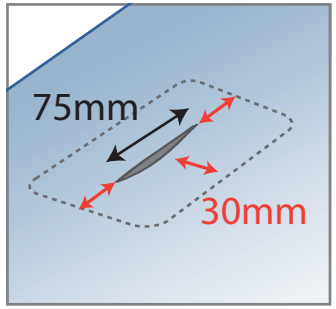
- **P510 Hypalon Cleaner & Solvent**
- **2 part Hypalon Adhesive**
- **Paint brush (cut down to 20-25mm bristle.)**
- **Lint free cloth**
- **Hypalon material**
- **Masking tape**
- **Polythene**
- **60 grit Sandpaper / emery cloth**
- **Smoother (Rubbing Down)**

Pic: Polymarine Professional Hypalon Repair Kit, plus Smoother

IMPORTANT:
Before you start any gluing please note:- your workplace needs to be well ventilated, warm and dry. If the air is humid don't try to use the adhesive as it will bloom. Do not use a gas fire or naked flame heat source as the solvents are highly flammable. Do not use the adhesive if it has been mixed for more than 4 hours.

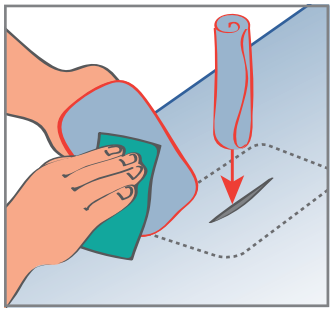
MIXING:
Mix adhesive with Curative at the ratio of 25:1
The Curative supplied is in ratio with the adhesive, so half the curative and half the tin will also be 25:1

REPAIRING A HOLE
If the damage to your tube is more than 75mm in any direction an 'inside patch' needs to be applied. The procedure is the same as for an Outside Patch but is made more difficult because you are working on the inside of the tube.



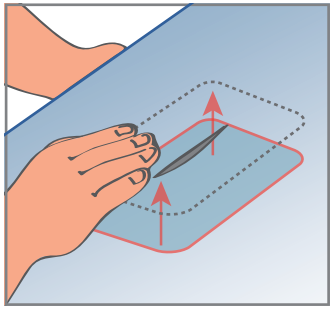
INSIDE PATCH
1. Mark out and cut your material to size. This should be big enough to cover the damage plus 30mm on every side. Make sure that all the corners are rounded.

2. Sand down the top surface on the patch until it is lightly abraded to a matt finish and the back surface of the tube is sanded until the surface starts to break up and looks like suede. Wipe the surface of the patch and the tube that is going to have the adhesive on with the P510 solvent cleaner. Allow the solvent to flash off (evaporate). If you apply the adhesive to soon it will bloom (turn slightly white) the adhesive will need to be removed and new adhesive will have to be applied.



3. Mix half of the adhesive (2990 two part adhesive) as directed on the tin. Brush onto the surface thinly, the surface should look wet. Allow the adhesive to dry for at least 30 minutes.

4. Apply second coat of adhesive to both surfaces, Leave until tacky to the touch (5 to 15 minutes). With the inside patch lay a piece of polythene onto the adhesive, so it can be rolled up and put through the hole. Place inside the tube and put into position, remove polythene. Work one side down with your Smoother, pressing hard, then work the other side. Work from the middle to the outside of the patch. You must make sure that there is no air trapped between the surfaces. Please note:- the adhesive is a contact type, as soon as it touches the other surface it will stick. Make sure that the patch is in the correct position before the surfaces come into contact.

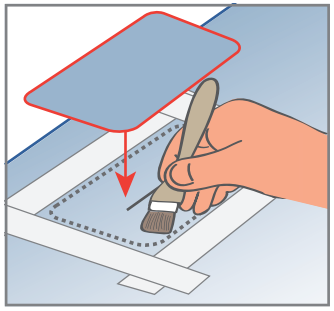


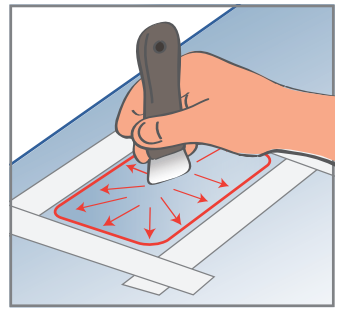
5. Leave to dry for at least six hours.

6. When dry, pump up the chamber and check for air leaks. The inside patch must be air tight.

OUTSIDE PATCH
7. With the tube inflated prepare the outside of the tube and your outside patch. Using masking tape around the patch leaving about a 3mm gap to allow for stretch in the material.

8. Sand down the surface of the tube until it is lightly abraded to a matt finish, and sand the back of the patch until the surface starts to break up and looks like suede. Wipe both surfaces with P510 solvent cleaner. Mix the rest of the adhesive. Apply first coat of adhesive, leave for 30 minutes, apply second coat of adhesive. Leave until 'tacky' (5 to 15 minutes).





9. Put down the patch and rub down from the centre out with your Smoother. Check that all the edges are stuck down.
You must make sure that there is no air trapped between the surfaces. Remove the tape and rub off any excess adhesive with P510 solvent cleaner. If the adhesive is left on it will turn brown.

10. Leave to dry for at least six hours before putting pressure in the tube. **Full cure 48 hours. Maximum Bond Strength 7 days.**

D-Ring Patches & Accessories

Rubber, Hypalon and Neoprene accessories can be glued with Hypalon Adhesive using a similar technique to the patch repairs.

1. Sand the surface of the Hypalon Inflatable where the accessory is to be glued until it is lightly abraded. Sand the accessory if Hypalon or Rubber (Don't sand PVC).

2. The surfaces of the inflatable & accessory should be cleaned with the Hypalon Cleaner & Solvent to remove any trace of finger oils or dust.

3. Paint both surfaces to be adhered with a thin coating of glue. Allow the adhesive to dry for at least 30 minutes.

4. Next spread a second thin layer of adhesive on both pieces and leave 5 to 15 minutes until the surface is tacky to the touch.

5. Bring both together with as much pressure as possible. Rub the air out with Smoother. You may want to deflate the boat to assure a better bond for the accessory. It is critical to get all the air out from between the pad and the surface of the inflatable, and the pad is sealed completely around the edges.

6. Once the air is out from under the accessory, **let it cure for 48 hours. Max bond strength 7 days.**