

**INSTRUCTIONS for using Polyethylene Film (PE) to apply Aquabond® underwater repair products, including:** UW-5000 (DMK-5000 Kit), UW-5200 (DMK-5200 Kit), SR-3000 (DMK-3000 Kit), AFW-8000 (DMK-W8000 Kit), AFC-8100 (DMK-C8100 Kit).

**OVERVIEW:** This polyethylene film application process allows the user to work with underwater repair adhesives and apply them without direct contact to fingers, hands or spreaders. Additionally, once applied to the crack being repaired, the film provides a barrier to hydrostatic pressure situations commonly encountered in underwater repairs.

Since these adhesives become exponentially more difficult to dispense at lower temperatures, the following process allows the adhesive to be dispensed directly onto the PE film in a warmer environment, then applied to the repair area. All Aquabond adhesives are best applied through a static mixer, at 70 degrees F or warmer.

Full 24 hour cure times are recommended, but working time varies with temperature and formulation. **Wearing gloves and eye protection is recommended when using any adhesive.**

- Aquabond two-part formulations cure exothermically (from the inside out) and do not require the presence of oxygen for curing.
- Properly mixed material will cure underwater in any thickness.
- The above materials are specifically formulated to cure underwater and do not contain UV inhibitors.
- Aquabond PE Film is also available in 8 ½ inch x 10 Foot sections (PEF-10), sold separately for use with higher volume adhesive cartridges.

#### **METHOD OF APPLYING ADHESIVE USING PRESS-ON POLYETHYLENE FILM:**

- 1.** Each kit contains an 8½ inch x 12 inch piece of clear, lay-flat PE tubing. When cut along the seam, it unfolds to 12" x 17". Trim as needed to accommodate the repair area. For example, you can cut 3" x 17", 6"x 8 ½", 3" X 8 ½" or any size necessary as determined on-site in the field.
- 2.** Dispense the Aquabond product through the static mixer, directly and firmly onto the pre-cut PE Film patch. Do this out of the water - ideally in a 70 degree controlled environment.
- 3.** Hold the outside edges of the PE patch as you enter the water. Material will not float away but care should be taken to decrease turbulence around crack repair. Starting at the furthest point of the crack, spread patch evenly and force water away as you press the Aquabond material into the crack or section that you are repairing.
- 4.** Feather the edges of the adhesive a minimum of 1/2" either side of the repair area to increase the bonding surface. **ALSO FEATHER THE REPAIR MATERIAL BEYOND ONE EDGE of the PE FILM (either the top or bottom). A plastic spreader may be used to evenly spread the material along the crack area.**  
Each repair specialist will undoubtedly develop their own technique with continued use.
- 5.** After 24 hours, **slowly peel away the polyethylene film. START FROM THE END WHERE YOU FEATHERED THE MATERIAL BEYOND THE FILM.**  
With continued steady pressure, the film will peel away leaving a clean, perfect patch behind. Alternatively, you can cutaway and remove the excess film with a razor blade and leave the rest of the film in place over the patched area (this will be virtually invisible under water).
- 6.** Leave the static mixer on the adhesive cartridge or replace original cap. Use a new static mixer for next use. Keep material in a cool dry place for storage. Refer to material specs for additional information on shelf life.

Patent Pending

# Polyethylene film application process

# Quick Start

## instructions

- 1. Cut a piece of the polyethylene (PE) film larger than the crack repair area.**
  - *The film comes to you as a tube. Cut along the seam and unfold it.*
- 2. Dispense the Aquabond product through the static mixer, directly and firmly onto the pre-cut PE Film patch.**
  - *Do this out of the water - ideally in a 70 degree controlled environment*
- 3. Hold the outside edges of the PE patch as you enter the water, taking care to not create turbulence around the crack repair.**

**Starting at the furthest point of the crack, spread the film patch evenly over the surface area to be repaired.**

- 4. Force water away as you press the Aquabond material into the crack or section that you are repairing.**

**Feather the edges of the material a minimum of 1/2" each side of the repair area to increase the bonding surface.**

**ALSO FEATHER THE REPAIR MATERIAL BEYOND ONE EDGE of the PE FILM (either the top or bottom). A plastic spreader may be used to evenly spread the material along the crack area.**

- *Each repair specialist will undoubtedly develop their own technique with continued use*

- 5. After 24 hours, slowly peel away the polyethylene film. START FROM THE END WHERE YOU FEATHERED THE MATERIAL BEYOND THE FILM.**
  - *Alternatively, you can cut away and remove the excess film with a razor blade and leave the rest of the film in place over the patched area (this will be virtually invisible underwater)*

- 6. Leave the static mixer on the adhesive cartridge or replace original cap.**
  - *Use a new static mixer for next use*

**Keep material in a cool dry place for storage.**

**Refer to material specs for additional information on shelf life.**

**Aquabond, LLC**

6444 E. Spring St #275 • Long Beach, CA 90815

714-961-1420

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AquabondAdhesives.com