

Instructions: Stabond Adhesive

Source: [NRS Website](#)

Bond PVC- and urethane-coated materials with Stabond Adhesive. It can also be used to glue those materials to synthetic rubber-coated materials.

Stabond Adhesive can be used to repair:

- PVC (vinyl)
- Urethane
- Hypalon® and other rubber compounds
- Can be used to bond PVC to Hypalon and other rubber products

Materials Needed

- Stabond and Accelerator
- PVC Cleaner (MEK- Methyl Ethyl Ketone), or Toluol (Toluene) - see recommendation below.
- Roller Rasp or Pro Roller
- Your patching material. See material for all our patching material options.
- 180 grit sandpaper (optional)
- Lint-free towel
- Pencil
- Container with lid (margarine tub works well)

Recommended

- Work in a well-ventilated area (garage or shady area works well)
- Use a respirator and chemical-resistant gloves (i.e. Nitrile gloves).
- Eye protection
- See the container for further precautions.
- Use methyl ethyl ketone (MEK) to clean any urethane or PVC materials and use toluene to clean any Hypalon or synthetic rubber materials.

Preparation

1. All contact/gluing surfaces must be thoroughly buffed, using a sanding wheel, 150 or 180 grit sandpaper, or a roller rasp. Just buff the fabric shine off; don't rasp down to the threads.
2. Cut patch 2" larger than damaged area and round the edges.
3. Clean the buffed surfaces with recommended solvent, using a lint-free towel.
4. Trace area of patch with a pencil.

Mixing Adhesive with Accelerator

Prepare your glue, mixing at a ratio of 10 parts glue to 1 part accelerator in a container that has a lid. Add 3 ml of accelerator per ounce of adhesive. Keep the glue covered while not in use.

Application

1. Both surfaces to be joined must be coated with adhesive.
Note: The surfaces to be joined must be dry prior to applying adhesive.
2. Apply one thin, even coat of adhesive to each surface.
3. Wait until the first coat of adhesive is dry-approximately 10 - 30 minutes depending on conditions. Use the "knuckle" test - touch your gloved finger to the glue) You should be able to feel adhesion without your knuckle sticking.
4. Apply a second thin, even coat to each surface. Wait until the second coat has an even, tacky finish (surfaces should not be visibly wet). Use the knuckle test again to gauge the optimum surface condition for joining the surfaces. Time will be 5 - 10 minutes. Don't allow the layer to completely dry.
5. Immediately press both sides of the fabric together and apply pressure to the entire glued surface using a roller, rolling from the center out. This forces air bubbles out and meshes the two fabrics together. Use a lint-free towel to wipe up excess glue.
6. Complete curing time takes approximately 24 hours. If you must inflate a repaired chamber before that, it's best to minimize the pressure.
7. Be careful when rolling up a repaired boat for storage. Make sure drying is complete.

Note: Year-round use of 303 Protectant is recommended between uses, and before storage of your inflatable.