Read all directions, including safety information on Resin/Hardener packet, before using. Prepare parts to be bonded. Check for proper fit. Bonding surfaces should be CLEAN, DRY and Sanded.

1. Empty entire contents of a Resin/Hardener packet into the Handy Pack container. Mix the resin and hardener thoroughly using the square end of the mixing stick.

2a. **GENERAL COATING and BONDING**

   Apply the mixture with the brush as a waterproof coating, or to pre-wet porous bonding surfaces before applying thickened epoxy.

2b. **HARDWARE BONDING**

   Before bonding hardware, pre-wet porous fastener holes using the pipe cleaner.

3. Thicken the remaining epoxy by stirring in filler until it reaches the desired consistency. The mixture should be thick enough to fill gaps between mating surfaces without sagging. The more uneven or wider the gap, the thicker the mixture should be. The mixture may be thinned to a very thick, peanut butter-like consistency for maximum gap filling or for filling and shaping low area or filling holes.

4a. **Apply thickened epoxy**

   Apply thickened epoxy to the mating surfaces using the mixing stick. Clamp the parts in position using only enough pressure to assure good contact and prevent movement.

4b. **Apply thickened epoxy to the cleaned hardware bonding surface, fastener holes and threads. Position the hardware and tighten fasteners until epoxy squeezes out. Do not overtighten.**

4a. **Apply thickened epoxy**

   Apply thickened epoxy to the mating surfaces using the mixing stick. Clamp the parts in position using only enough pressure to assure good contact and prevent movement.

5a. **Shape or clean excess**

   Increase bonding area by shaping excess epoxy mixture into a fillet using the round end of the mixing stick.

5b. **Scrape off excess epoxy with the square end of the mixing stick.**

   Wipe away remaining residue using the alcohol cleaning pad or a paper towel and nail polish remover. Allow 24 hours at 72°F before subjecting to load.

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6a. **Add reinforcing**

   Add extra reinforcing to a joint by applying fiberglass tape over the fillet. Trim tape to the appropriate size then use the brush to saturate the fabric with epoxy and smooth the fabric in place.
**The Solid Solution**

WEST SYSTEM resin, hardeners, fillers, additives, reinforcing materials and application tools provide the ideal solution for hundreds of repair problems on fiberglass, wood, steel and aluminum structures. WEST SYSTEM Epoxy’s ability to bond a wide range of materials also makes it ideal for composite construction. WEST SYSTEM Epoxy is available in larger quantities to suit projects of any size. Anywhere you need an extremely strong, water-resistant bond or coating, WEST SYSTEM epoxy products are your affordable, efficient, high-quality solution.

WEST SYSTEM products are easy to find and use, and are backed by detailed instructional publications and the helpful West System Technical Staff.

If you would like additional information or have questions or comments about the use of WEST SYSTEM products:
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- visit westsystem.com
- or send for our Free Literature Pack. Fill out and mail this coupon to:
  West System Inc.
  P.O. Box 665
  Bay City, MI 48406 USA

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**Using epoxy**

Read and follow the directions, including safety information, on the Resin/Hardener packets.

Mixing resin and hardener together starts a chemical reaction that transforms the combined liquid ingredients into a solid.

Before the curing epoxy begins to gel in the mixing container, about 10 minutes at 70°F (21°C), you must—
- Apply and spread epoxy if you are coating.
- Apply epoxy, assemble and clamp parts if you are bonding.
- Wet out and smooth fabric if you are applying fiberglass reinforcing.
- Spread the epoxy to a thin layer, to extend the working and cure time.

Epoxy cures faster in warmer temperatures and in a thicker layer (as it is in the mixing container). Epoxy cures slower in cooler temperatures and in thinner layers. A thin film of epoxy can take 2–3 hours to gel.

The epoxy mixture will reach a workable cure in 5–7 hours. Clamps can be removed and the epoxy may be sanded, but it should not be subjected to high loads for 24 hours. When a quicker cure is desired, applying moderate heat will reduce cure time.

**Gluing tips**

- Before mixing epoxy, check all parts to be bonded for proper fit. Gather all necessary application tools and clamps. Keep a roll of paper towels handy.
- For maximum adhesion, be sure bonding surfaces, including surfaces to be coated, are clean and dry. Sand all non-porous surfaces with 80-grit paper.
- Use only enough clamping pressure to hold parts in place without moving. Use enough epoxy adhesive so that a small amount will squeeze from the joint when clamped. Avoid squeezing all of the epoxy out of the joint with too much pressure.

**Cleanup**

Clean uncured epoxy from skin and clothes with a waterless skin cleaner, followed by washing with soap and water. Remove excess epoxy from work surfaces with the flat end of a mixing stick or with paper towels. Cleanup residue with a solvent such as acetone or lacquer thinner.

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Please send me the WEST SYSTEM Free Literature Pack, which includes the User Manual & Product Guide, current price list, the WEST SYSTEM dealer list, The Other Uses guide to household repairs with epoxy and an issue of Epoxyworks Magazine.

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