



Clifton Urethane Adhesive

Materials Needed:

Patch material, D-ring or foot-cup
Clifton Urethane Adhesive
150 - 180 Grit Wet/Dry Sandpaper
PVC Cleaner (MEK - Methyl Ethyl Ketone) - you may also use acetone or rubbing alcohol
Stiff Bristle Brush - 4-oz. can of adhesive has brush in lid
Pencil
Lint free towel
Pro Roller or Roller Rasp

Recommended Safety Precautions:

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

Environmental Conditions:

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%.

Fabric Preparation:

1. Cut patch to extend at least two inches beyond the edges of 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 the fine sandpaper or a roller rasp. Just buff the fabric shine off; don't rasp down to where the threads are visible.
4. Clean the buffed surfaces with PVC Cleaner (MEK) or other solvent, using a lint free towel. This removes any oils or other contaminants that can interfere with the glue bond. Allow area to dry thoroughly.

Application of Glue:

1. Apply one thin, even coat of adhesive to each surface, using a stiff bristle brush (the 4-oz. can has a brush in the lid). Allow it to dry at least 3-5 minutes.
2. Apply another thin coat to each surface.
3. Although the material may be bonded while wet, optimum results are achieved when waiting 3-5 minutes before bonding the surfaces together.
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 very important.
5. Use a lint free towel and PVC Cleaner (MEK) to wipe up excess adhesive.
6. Complete curing time takes approximately 24 hours.
7. Be careful when rolling up a repaired boat for storage. Make sure drying is complete.
8. Maintenance: Year round use of 303 Protectant is recommended for all boating gear. Inflatables can use a coat of 303 in between uses, before storage and while sitting in storage.

Note: Clifton Urethane Adhesive can be mixed with Clifton Hypalon Accelerator. Addition of the Accelerator doesn't improve the bond strength but it does make it more chemical and heat resistant. If the bond will be subjected to temperatures greater than 140 degrees F, use of the Accelerator is recommended.

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