

# Gluing Instructions using Shore Adhesive and Toluol Solvent

- for Hypalon Accessories (on Hypalon, Royalex, fiberglass, Kevlar and aluminum boats)
- for Hypalon Repair Kits (on Hypalon boats)

1 Place Tie-Down D-Ring where you want it. Make sure it does not interfere with your feet or knees in any paddle position.

2 Mark perimeter of apron with pencil.



3 Roughen the penciled-in area with medium sandpaper (see fig. A). Tie-Down D-Rings are pre-roughened for your convenience. Don't risk cutting the threads under the pad, roughen only the boat.



4 Apply two coats of Toluol to roughened area of boat and the bottom of the Tie-Down. Allow it to evaporate after each coat.



5 Apply a thin coat of Shore adhesive to both surfaces and allow to dry 15 to 20 minutes (see fig. B & C).



Without hairdryer or heatgun (the old way)      Reactivate with hairdryer or heatgun

6a Apply a second coat and wait 5 to 15 minutes or until tacky.

6a Apply a second coat and wait 15 to 20 minutes or until dry to the touch. Using a heat source to "reactivate" the adhesive minimizes the complicating effects of humidity and air temperature. Also it won't be necessary to re-roll later.

Warm both surfaces with a hairdryer or, if you promise not to melt a hole in your boat, you can use a heatgun. You can feel the adhesive get tacky again as it gets warmer. The surfaces are ready to join when they are warm and tacky (see fig. D).



7 Join surfaces from the center out towards the edges so no air is trapped under the apron. Curving the apron so the center contacts the surface first and pressing firmly helps insure 100% adhesion in the highest stress area directly under the D-Ring (see fig. E, F, G, H, & I). Bond is immediate.



8 If you have a roller, now is the time to use it. Roll out from the center towards the edge (see fig. J & K). If you did not "reactivate" the adhesive you might benefit from re-rolling in two or three hours.



9 Dries in six hours. For inflatable boats, do not inflate to full pressure for 12 hours.

## Tips & Techniques



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Cleaning out the whole boat will help prevent dust and dirt from getting on tacky glue.

Don't set the heatgun down on the boat -- the tip can be 1000°. When applying the solvent and adhesive, spread it to 1/8" outside the penciled area. It is easier to remove excess glue than to add glue under the edge after you've attached the Tie-Down.

To remove excess Shore adhesive use Toluol on a rag. Avoid contact with Toluol, as it is easily absorbed through the skin.

Don't let the roller go off the apron -- the roller can mark the boat, particularly when the boat has been softened with solvent, adhesive and heat.