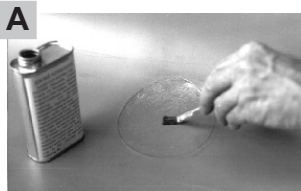


Vinyl Tie-Down Installation Instructions for Royalex and vinyl boats.

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 Apply two coats of MEK (Methyl Ethyl Ketone) to penciled area of boat (fig. A) and the bottom of the Tie-Down (fig. B). Allow it to evaporate after each coat. MEK melts PVC so don't put on any more than is absolutely necessary.



4 Apply a thin coat of Vinyl Adhesive to both surfaces and allow it to dry 3 to 10 minutes.

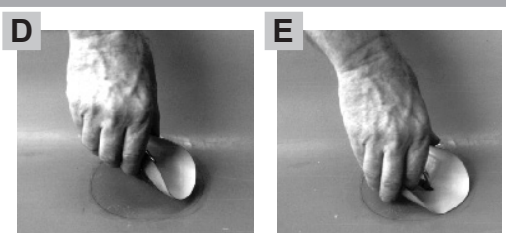


Without hair dryer or heat gun Reactivate with hair dryer or heat gun

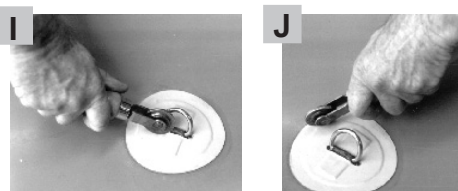
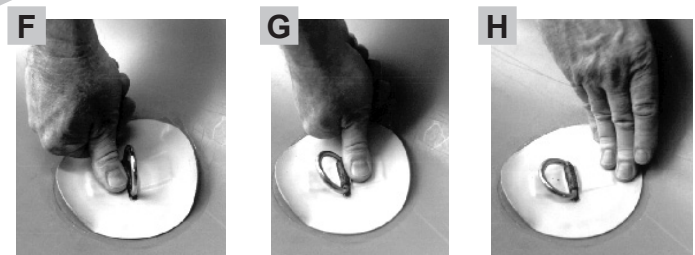
5a Apply a second thin coat of adhesive and wait 3 to 10 minutes until dry. Serious caution must be taken here: if wet adhesive is covered it can melt a hole through your boat. Make sure the adhesive is dry to the touch before you proceed to the next step.

5b Apply a second thin coat of adhesive and wait 3 to 10 minutes or until dry to the touch.

Using a heat source to reactivate the adhesive minimizes the complicating effects of humidity and air temperature. Warm both surfaces slowly with a hair dryer or, if you're careful and promise not to melt the boat, you can use a heat gun. The surfaces are ready to join when they are warm (see fig. C).



6 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. D, E, F, G, & H). Bond is immediate.



7 If you have a roller, now is the time to use it. Roll out from the center towards the edge (see fig. I & J). If you did not "reactivate" the adhesive you might benefit from re-rolling in 2 or 3 hours.

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

Tips & Techniques

- Cleaning out the whole boat will help prevent dust & dirt from getting on tacky glue.
- Don't set the heat gun down on the boat — the tip can be 1000°.
- When putting on the glue spread it to 1/8" outside the penciled circle. Be very careful applying the adhesive, it permanently marks the surface.
- Avoid contact with the MEK as it is easily absorbed through the skin.
- Don't let the roller go off the patch — the roller can mark the boat, particularly when the boat has been softened with solvent, adhesive and heat.
- Our tests show that Vinyl Adhesive without MEK does not make a good bond. We mention this because the instructions on some Vinyl Adhesive containers do not mention MEK. MEK actually dissolves the outer coating of PVC and allows the adhesive to penetrate the surface, producing a better bond. It is important to allow the adhesive to completely dry to the touch. Not doing this can cause a hole to melt in the boat or bag.



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