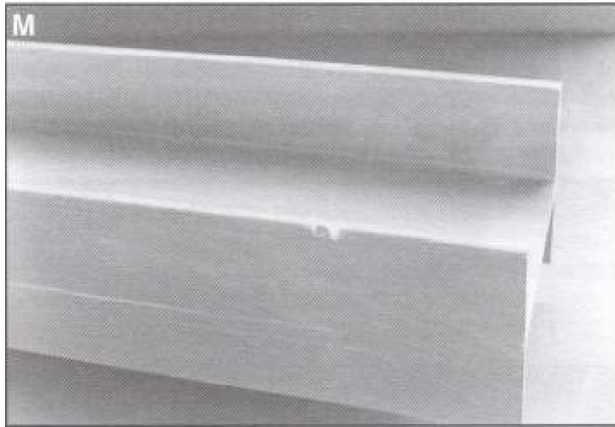


REPAIR PROCEDURE – RESIN FILLING

This procedure will discuss repair techniques when a portion of the flange has received minor damage due to chipping. An example of this can be seen in Picture M. In this situation, the repair is not severe enough to warrant a splice repair; however, some repair is required to prevent the absorption of contaminants. The following procedure will be less expensive than Resin Splicing and still functional.



Procedure

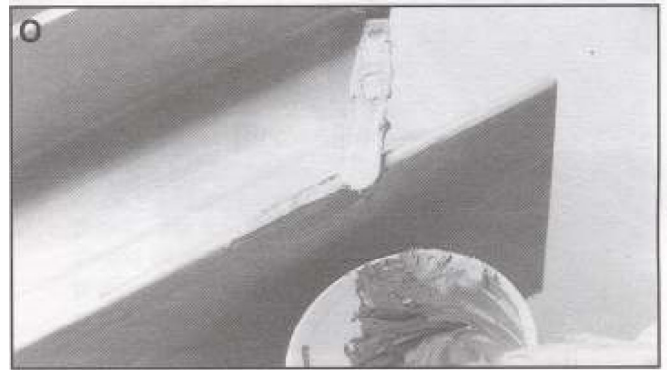
1. Sand the damaged area to remove all loose material and to provide a good bonding surface. After sanding, the damaged area must be cleaned and dried.



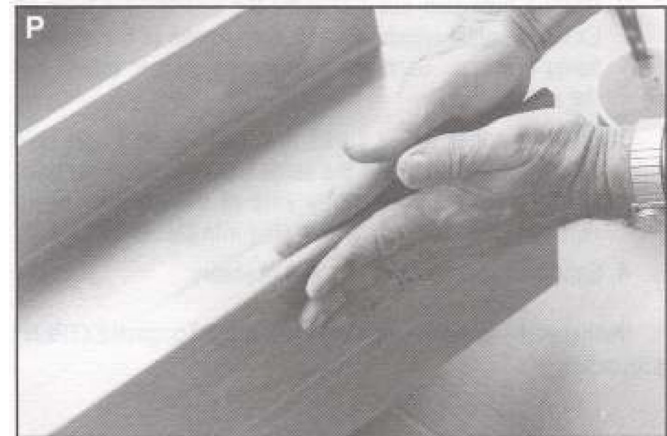
2. Epoxy or catalyzed resin may be used in this repair. If epoxy is used, the mixing procedure of the previous section is applicable. If catalyzed resin is used, mix 4 ounces of

Hetron 92 with a few drops of DDM catalyst. (The exact ratio can be altered for ambient temperature). If so desired, milled fibre, Cab-o-Sil, or another filler may be added to improve the workability of the filling paste. Pigment can be added to match the colour of the section to be repaired.

NOTE: If the resin/catalyst combination begins to 'smoke' the ratio of catalyst to resin is too high. Make a new mix of resin using less catalyst.

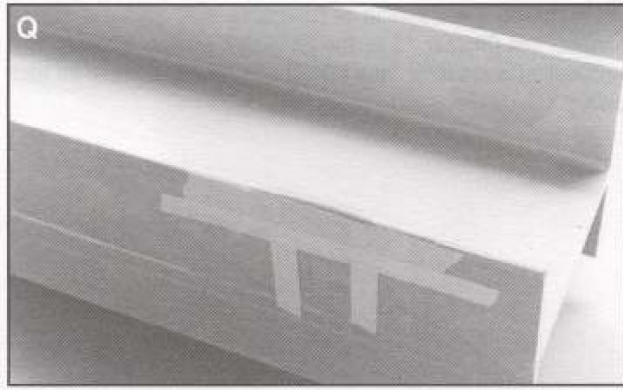


3. Using a spatula or putty knife, fill the damaged area as seen in Picture O.
4. Cover the repair with cellophane and press together, massaging the repaired area to remove entrapped air as seen in Picture P.



REPAIR PROCEDURE – RESIN FILLING

5. Tape the cellophane securely into position protecting the repair while the resin cures, as seen in Picture Q. Allow 24 hours for proper curing.



After 24 hours, remove the tape and cellophane and carefully sand the repaired area as seen in Picture R. Complete this repair by employing the Resin Sealing repair procedure.

