

## REPAIR PROCEDURE – GLASS LAY-UP

This technique applies when the crack is small and the structural integrity is not threatened. The technique is similar to some procedures used in automotive body repair.

### Procedure

1. Sand the damaged area. Taper both sides of the damaged area approximately 2" to 3" above and below the crack and 2" to 3" on either side of the crack.
2. Remove all dust and clean the area to be repaired.
3. Cut a piece of glass mat to cover within ½" at the edges of the sanded area.
4. Cut a piece of 10 mil veil to cover all of the sanded area (multiple pieces may be used to overlap at joints).
5. Weigh the glass veil and mat. Weigh 4 times that weight in resin and add 1% - 5% of DDM catalyst (start with 1%). Stir thoroughly. The pot life of this mixture is dependent upon the percent catalyst and the ambient temperature and must be determined on sight. *Do not* attempt to use catalysed resin after it begins to gel (becoming like jelly).
6. Paint the sanded area with this resin/catalyst mixture.
7. Apply glass material and thoroughly wet with the resin/catalyst mixture.
8. Add layers of glass and resin to obtain the desired repair thickness removing air from each layer.
9. Cover with cellophane until the repair is cured.
10. Sand to a smooth finish and coat with resin mixture for corrosion protection.