

ACRYLIC FILLER SURFACE REPAIR

Required Materials:

Safety glasses
Latex gloves
Extension cord
3/8" variable speed drill
Aluminum oxide grinding stone
Heat gun, optional
Flexible filler spreader
Rubber sanding block
100, 220, 320 grit wet/dry sandpaper
Masking tape
Drop cloth
Spray bottle of soapy water

Kits Contents:

Component A acrylic filler resin
Component B catalyst
Graduated mixing cups
Wooden stirring sticks
Latex gloves
Instructions

Safety Requirements:

No smoking or open flame.

Safety glasses, latex gloves – wear at all times.

Read all MSDS sheets prior to starting repair and read and understand all instructions.

Component A Warning – flammable, causes irritation, may cause allergic skin reaction.

Additional safety information caution: contains an acrylic monomer. Keep away from heat, sparks, and open flame. Avoid contact with eyes and skin. Wash thoroughly after handling. Use only with adequate ventilation. Note: When mixed with Component B material will have hazards of both components. Observe all applicable precautions.

Component B Warning – may cause skin, eye, nose and throat irritation, also flammable.

Additional safety information caution: contains less than 10% benzyl peroxides. Keep from contact with clothing and combustible materials. Do not store near combustible material. Avoid contact with eyes and skin. Avoid breathing vapor. Use only with adequate ventilation.

FIRST AID: In case of contact with eyes, immediately flush eyes with plenty of water for at least 15 minutes and call a physician. Flush skin with water. Wash clothing before reuse. Note: When mixed with Component A material will have hazards of both components. Observe all applicable precautions.

Ventilation: Perform this repair in a well-ventilated area.

Keep away from children and animals at all times.

Key Points:

- ▶ Temperature range for repair is 60° to 90° F. Outside this temperature range, this repair will not cure correctly.
- ▶ When mixing Component A resin with Component B catalyst, the pot life of the acrylic filler that has been stirred is approximately 15 minutes, depending on ambient temperature.
- ▶ Before beginning this repair, if the spa shell is cracked, the area behind the shell will have to be repaired and supported.
- ▶ Keep the work area clean by using masking tape and drop clothes. This will assist in clean up later on.
- ▶ Discard empty plastic bottles, used gloves and mixing cups properly. Follow all local, state, and federal government regulations. Wash hands and other exposed skin areas with soap and water when finished.
- ▶ Acrylic filler application – fill the damaged area in a three-step process. In between applications of each layer, cure time is approximately 10 to 20 minutes. On completion of the third acrylic filling, you will have a slightly overfill condition where the acrylic filler will be above the surface of the shell.
- ▶ In any of the three-step process, you can use a heat gun to accelerate the curing process by applying heat around the area of repair – not directly on the acrylic filler material. Caution: too much heat can cause the acrylic filler to generate pinholes.
- ▶ If pinholes occur, or become noticeable in the sanding process, clean out the pinholes of any sanding dust and add one final skin coat of acrylic filler in order to fill any pinholes that may occur.
- ▶ In the sanding process, we recommend wet/dry sandpaper and the use of soapy water. This assists you in the sanding process as soapy water acts as a lubricant for the sandpaper and also cleans the shell area being sanded.

Technical Support: If you have any questions about this repair procedure, please contact Watkins Manufacturing Technical Support at the following telephone number or email. Telephone Number: 800-999-4688 or 760-598-6464 Technical Support Extension 8115.

Email: techsupport@watkinsmfg.com