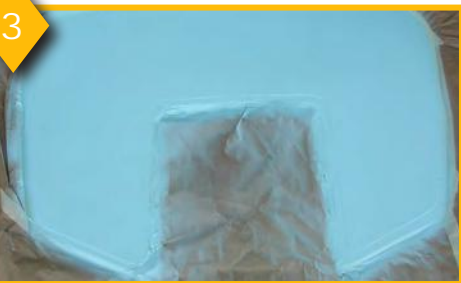


Repattern/Repair Large Areas



1. Make necessary substructure repairs.
2. Sand off all existing texture (40 to 80 grit surface scratch). Mask off sanded area. Make sure border tape is wide enough to allow a 1/2" to 3/4" (12-19mm) overlap of the FLEX-MOLD to lay flat.
3. Make pattern of area and transfer to back side of FLEX-MOLD. Cut to shape, making sure to leave 1/2"-3/4" (12-19mm) border.
4. The background color of the area to be textured must be of like and even color. To achieve this, gelcoat should be thinned with appropriate thinner or styrene and sprayed on thick enough to give an even color. Let cure thoroughly.

*If *surfacing agent is used in your gelcoat, it must be removed by sanding, along with solvent wipe to assure a proper bond with textured coat.*

**A surfacing agent is a solution containing paraffin wax. When added to gelcoat or polyester resin, it will rise to the surface during cure cycle to seal off air. Exposure to air will prevent a complete surface cure. If no surfacing agent is used, the surface will remain slightly tacky in the shade and extremely sticky in the sun. Avoid exposure to sun during next step.*

5. Lay FLEX-MOLD in place to check fit, secure determined starting edge with tape. Check fit and make sure overlapping border lays down flat and is not held up by wrinkles in the tape or other objects. A seal must be formed around edge that will not allow air to bleed gelcoat down before it can cure.

Note:

The FLEX-MOLD is coated with green polyvinyl alcohol (PVA) to serve as a release agent as well as a barrier coat that prevents a chemical reaction that will occur between the FLEX-MOLD and gelcoat, resulting in a distorted pattern.

6



7



8a



6. Lightly sprinkle backside of FLEX-MOLD with talcum powder for a lubricant. Remove excess.

7. Prepare gelcoat by checking viscosity with a #2 viscosity cup (available at Gibco FLEX-MOLD). Gelcoat should run through in 60-65 seconds. Be sure to clean cup between each test.

Gelcoat may be thinned with some of the following products with varied results. The gelcoat must be fluid enough to flow into the cavities of the non-skid pattern to avoid air entrapment. Also, thick gelcoat makes it difficult to squeegee FLEX-MOLD down level over large areas. Catalyze gelcoat cool enough to allow sufficient cure time to complete procedure.

8b



8a.

Hold FLEX-MOLD up and pull back to secure end. Pour enough gelcoat to start a wave in front of and across entire width of FLEX-MOLD as not to leave any air bubbles trapped. Use a stick as illustrated in spot repair #9 to push gelcoat up under FLEX-MOLD if necessary.

8c



8bcd.

Use a proper tool (squeegee, board, paint roller) to push along behind the FLEX-MOLD in a manner that will move a wave of gelcoat before the face of the FLEX-MOLD as it is lowered into the wave. Add gelcoat as needed and continue process across entire area.

8d



9a



9ab.

Once FLEX-MOLD is down, start in the middle and push, with a squeegee, excess gelcoat out from under FLEX-MOLD. Squeegee across in all directions. Run hand over surface to feel out any high spots that will need to be squeegeed out. Use some of excess gelcoat to lubricate the squeegee it will slide easily. You may use acetone sparingly to wipe back of FLEX-MOLD clean if you intend to reuse. Squeegee should be of adequate size for size of application, stiffened up to help apply even pressure across width of squeegee.

9b



10ab.

Let gelcoat cure and peel off FLEX-MOLD. Remove masking from around border. Sand and polish edges using graduated grit. Starting with 100, 220, 320, 500, then compound and polish.

10a



11. Finished product.

The FLEX-MOLD can be used repeatedly as long as the PVA coating is intact. Once PVA has begun to come off the FLEX-MOLD, wash remaining PVA off with water. Let FLEX-MOLD dry and reapply PVA with a spray gun by misting on about six coats, let dry thoroughly between each coat.

APPLICATION TIP

When practical, roll FLEX-MOLD on a tube and then unroll slowly to push wave of gelcoat along. Then Squeegee out.

10b



11



Painted Non-Skid Surfaces

Polyurethane Paints

1. FLEX-MOLDS come with PVA already sprayed on them, an additional mold release such as Frekote applied on top of the PVA will be needed. This will keep the paints from sticking to the PVA.
2. Cut your patterns from the FLEX-MOLD, spray a heavy coat of polyurethane on to fill all the cavities. Allow to cure to about 80% (or until you can handle the FLEX-MOLD).
3. You are going to secondary bond the FLEX-MOLD to your deck. Put the FLEX-MOLD in place and tape down at the beginning point. Hold FLEX-MOLD up and pour enough polyurethane on surface to start a wave in front of FLEX-MOLD face. Use a proper tool (squeegee) to push along behind the FLEX-MOLD in a manner that will move a wave of polyurethane before the face of the FLEX-MOLD as it is lowered into the wave. Continue process across entire area.
4. Once FLEX-MOLD is down, start in the middle and push, with a squeegee, excess polyurethane out from under FLEX-MOLD. Squeegee across in all directions. Run your hand over surface to feel out any high spots that still need to be squeegeed out.
5. Let polyurethane cure and peel off FLEX-MOLD. Remove masking from around border. Sand and polish edges using graduated grit, starting with 100, 220, 320, 500, then compound and polish.



Epoxy

Use of epoxy is much the same as using gelcoat. If you are going to paint your epoxy, it is suggested that you use an epoxy close to the color of the paint that you will be using. This will allow for a longer lasting surface as the paint wears off, the under lying epoxy will be a close color match and it will not be as noticeable.

Endurance Technologies custom epoxy formulations for mold application achieve excellent impact resistance and little or no shrinkage. Endurance epoxies are compatible with all of the latest fabrics and cores. By using epoxy tooling systems you will have more durable tools with excellent thermal stability allowing for more parts out of the same mold.