FLEX-MOLD
NON-SKID PATTERNS & RE-DECK

# G4 with Adhesive Installation Guide

**Materials:**

- Spray Bottle
- 16 Fl oz Water
- Dawn Dish Soap
- Acetone
- ¼" & 1" Masking Tape
- Pencil & Sandpaper
- Lint-free Cotton Cloth
- 3M 94 Tape Primer (Optional)
- Fiberglass Shears
- Microfiber Cloth
- J-Roller
- Template Material

**Preparation:**

1. Use template material to trace the outline of the bonding area. Mark the fore to aft orientation of the non-skid pattern on template
2. Place your template on the **G4** non-skid panel. Align fore to aft orientation of non-skid pattern with template. Use strips of 1" masking tape to prevent the template from shifting
3. Use a pencil to trace the outline of the template onto the **G4** non-skid panel
4. Use fiberglass shears or a hand router with flush trim bit to cut your **G4** non-skid panel to shape. Reference the previously traced outline as a cutting guide. After the **G4** panel is cut, sand any rough edges with 220-grit sandpaper
5. Fair and sand bonding surface to a 220-grit finish. Clean thoroughly with acetone and a microfiber towel to remove any dust and oil. For best results, bonding surface must be completely flat with no cracks, gouges, dips or seams
6. Place the same pre-cut template from Step #1 on the bonding surface and align. Use 1" masking tape to prevent the template from shifting
7. Use a pencil to trace the outline of the template onto the bonding surface
8. Place ¼" masking tape around the outer perimeter of the pencil outline. This will prevent the pencil outline from being removed by any solvents used to clean the bonding surface
9. Wipe down the bonding surface thoroughly with acetone using a microfiber cloth

**Installation Procedure:**

1. Before starting, verify the bonding surface and **G4** non-skid panel are both at 70°F or higher
   **Option A:** Use a heat gun and digital thermometer
   **Option B:** Set the **G4** non-skid panel and bonding surface in the sun for a few hours prior to installation
2. Wipe down bonding surface with microfiber cloth to remove any contaminants or dust
   a. **Optional:** For increased bond strength, apply a thin coat of 3M 94 Tape Primer to your bonding surface with lint-free cotton cloth. Allow it to dry completely for 5 minutes
3. Add 1–2 drops of Dawn Dish soap to 16 oz spray bottle of room temperature water and mix
4. Spray the soapy water mixture onto bonding surface and coat well
5. Remove the plastic backing from the cut **G4** non-skid panel to expose the adhesive
6. Spray the soapy water mixture onto the back of the **G4** non-skid panel and coat the adhesive well
7. Flip over the cut **G4** non-skid panel and lightly place it on the bonding surface. The water allows the panel to "float", making alignment easier
8. Align the **G4** non-skid panel with the previously traced pencil outline on the bonding surface
9. Once aligned, use 1" masking tape on the edges of the **G4** non-skid panel to hold it in place and prevent shifting during installation
10. Starting from the center of the **G4** non-skid panel, use a J-Roller to push out the water from underneath the panel. Use medium to firm pressure
    a. Always roll from the center toward the edges. Once you reach the edge, lift the roller and return to the center before making the next pass. This is to avoid pushing water towards the center of the panel
    b. Continue this process along the entire length of the **G4** non-skid panel
11. Run a hand lightly over the **G4** non-skid panel to feel for any remaining trapped water bubbles. Re-roll with the J-Roller as necessary. Larger panels may need to be rolled multiple times to remove all water
12. Remove masking tape, wipe off any remaining water and inspect

**Cure & Bond Time:**

- Allow the **G4** non-skid panel to sit for 24 hours before continuing work
- Full bond strength will be achieved after 72 hours

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# G4 with Epoxy Installation Guide

**Materials:**

- Acetone
- Pencil & Sandpaper
- Fiberglass Shears
- Microfiber Cloth
- ¼" & 1" Masking Tape
- Vacuum Pump
- Vacuum Lines & Fittings
- Vacuum Bag & Sealant Tape
- Infusion Mesh & Breather Fabric
- Template Material
- Mixing Cups & Stir Stick
- Two Part Epoxy with Slow Hardener
- Foam Brush or Squeegee
- Wax / Release Agent

**Preparation:**

1. Use template material to trace the outline of the bonding area. Mark the fore to aft orientation of the non-skid pattern on template
2. Place your template on the **G4** non-skid panel. Align fore to aft orientation of non-skid pattern with template. Use strips of 1" masking tape to prevent the template from shifting
3. Use a pencil to trace the outline of the template onto the **G4** non-skid panel
4. Use fiberglass shears or a hand router with flush trim bit to cut your **G4** non-skid panel to shape. Reference the previously traced outline as a cutting guide. After the **G4** panel is cut, sand any rough edges with 220-grit sandpaper
5. Apply wax or preferred release agent to top of **G4** pattern along the edges of the panel**.** This will prevent any epoxy from bonding to the top of the **G4** during installation
6. Fair and sand bonding surface to a 220-grit finish. Clean thoroughly with acetone and a microfiber towel to remove any dust and oil. For best results, bonding surface must be completely flat with no cracks, gouges, dips or seams
7. Mix two-part epoxy resin with slow hardener
   a. Apply approximately 1-2 fl oz of epoxy per 1 $ft^2$ of **G4** that will be bonded
8. Spread epoxy in a thin even layer across bonding surface
   a. Foam brush or roller: Use on small to medium **G4** non-skid panels
   b. Squeegee: Use on medium to large **G4** non-skid panels

**Installation Methods:**

**Vacuum Bag Method: (Flex-Mold Preferred Method)**

1. Place **G4** non-skid panel onto the previously prepared bonding surface and align.
2. Cut the vacuum bag film, infusion mesh / breather material to size. Vacuum bag film should extend 3-6" past perimeter of **G4** non-skid panel
3. Apply sealant tape around the perimeter of the **G4** non-skid panel, be sure to maintain a minimum 1-inch offset from the edge of the **G4** non-skid panel
4. Install vacuum port and vacuum bag material. Ensure vacuum bag material and sealant tape are well adhered to surface to prevent vacuum leaks
   a. Minimum vacuum time: Dependent on epoxy gel time. Check epoxy TDS
   b. Maximum vacuum time: Overnight

**Weight Method:**

1. Place **G4** non-skid panel onto the previously prepared bonding surface and align.
2. Place an MDF template directly on top of **G4** non-skid panel
3. Apply evenly distributed weights or sandbags on top of MDF template to press **G4** non-skid panel firmly against the bonding surface. More weight is better
4. Allow epoxy to cure overnight. Remove weights and MDF template after cure is complete

**Cure & Bond Time:**

- Full bond strength is dependent on epoxy manufacturer
- Reference the epoxy manufacturer TDS sheet to determine full cure time before continuing work

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