

## Instructions

# Stop It<sup>®</sup> Flat Patch

### Important

Read the entire set of instructions before beginning! The application of this composite repair product involves a number of time sensitive steps that need to be executed in the order described below.

### Precautions

- Prolonged or repeated exposure to vapors, contact with skin or clothes, and internal consumption should be avoided. See SDS for more information. In the event of contact with skin, use the included waterless hand sanitizer to remove epoxy resin.
- Mixture of two-part epoxy in large quantities will produce high temperatures associated with its curing. As such, the use of the static mixer to dispense only the required quantities is preferred over bulk mixing.

### Site Preparation

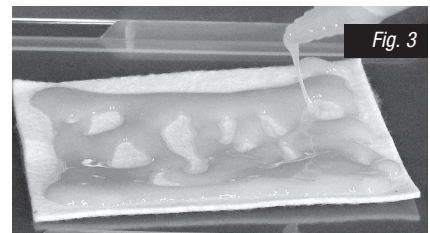
- The system should be relieved of all pressure until the product is applied and fully cured.
- Before applying STOP IT<sup>®</sup> FLAT PATCH, the surface must be prepared by removing all loose scale, lubricant or grease. This process may involve the use of a wire brush, sandpaper, and/or solvent cleaner as required (Fig. 1). At minimum, the surface should be degreased with soap and water and rinsed with clean water.
- Surfaces should be completely dry prior to application of the first component. The pipe surface should be warmed if less than 50°F (10°C).



### Application Procedure

**Step 1:** Lay out the fabrics to be used in the repair. Use the box lid as a wetting trough and a convenient site for preparing the composite materials (Fig. 2).

**Step 2:** Remove the plastic end cap from the cartridge assembly and attach the static mixer to the cartridge with the plastic threaded cap. Retain the green plug and attached retaining clip for sealing if entire contents of cartridge are not to be used. Load the dual cartridge assembly into the dispensing gun\*.



**Note:** Do not dispense any resin until immediately before application.

**Step 3:** Fully depress the cartridge gun trigger four times to load the static mixer and dispense a small quantity of epoxy. Discard this initial material as waste.

**Note:** The epoxy in the static mixer is now activated and must be expelled within an eight-minute time frame. If the epoxy cures in the mixer, it should be detached and discarded. Attach a new static mixer to the cartridge to use the remaining contents.

\*Dispensing gun sold separately.

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**Step 4:** Dispensing the epoxy at an even rate, apply the indicated amount to the white fabric (Fig. 3) – depress plunger to the (F) indicator located on the cartridge. With gloved hands, gently massage the fabric in order to assist the wicking process (Fig. 4). The fabric should be fully wetted, taking on a translucent appearance. Set aside.

**Step 5:** With even pressure, dispense epoxy onto 2 pieces of carbon fiber. Apply epoxy to the 1<sup>st</sup> carbon fabric until the cartridge plunger reaches the (C1) indicator on the cartridge. Apply epoxy to the 2<sup>nd</sup> carbon fabric until the cartridge plunger reaches the (C2) indicator on cartridge.

**Step 5:** Knead epoxy into each carbon fiber patch, being careful to retain all epoxy that has been applied, until it is fully soaked. A properly kneaded and fully soaked carbon fabric will have a translucent appearance, showing even color with no dry spots. (Fig. 5) Combine both pieces of carbon fabric, one on top of the other, and press together. Knead to ensure all air pockets have been removed. Set aside carbon fabric.

**Step 6:** Apply a small amount of epoxy directly to the leak site using the spatula provided. Avoid forming air bubbles.

**Step 7:** Apply the epoxy soaked white felt directly centered over the leak site. (Fig. 6) Remove all trapped air between the repair surface and the felt working from the center out to the edges. Avoid significant shifting/movement of the felt as this step is performed.

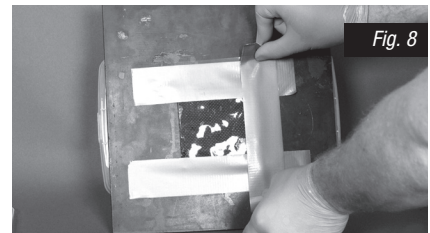
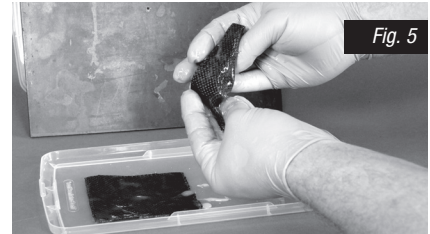
**Step 8:** Apply the epoxy soaked carbon fiber layers directly on top of the white felt, again working from the center out to the edges to eliminate any air pockets. (Fig. 7)

**Step 9:** To complete the application, immediately secure the clear PVC plastic over the carbon fiber using utility tape. (Fig. 8)

**NOTE:** Accelerated cures are possible with the STOP IT<sup>®</sup> Flat Patch Annealing Kit

Allow the assembled repair to cure for a period of 4 hours at an ambient temperature of ~80°F (27°C). After cure time has elapsed, the clear PVC plastic may be removed if desired. To save any unused portion of epoxy in the cartridge assembly for a second repair: remove the static mixer nozzle from cartridge assembly by removing the plastic threaded cap, insert the cartridge plug (retained earlier) and secure with plastic threaded end cap. Affix metal retaining clip.

**STOP IT<sup>®</sup> Flat Patch Kits – 4x4 kit yields two repairs; 6x6 kit yields one repair. Repeat instructions for second repair, if applicable.**



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