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Inflatable Repair Instructions - PVC & Urethane

Read Carefully Before Starting!

The most common problems with inflatable rafts occur due to excessive high pressure and heat and improper care in transportation. Tarp your raft when transporting it and frequently monitor pressure. Heat from the sun and the ground can drastically raise pressure and damage your raft. Recommended floor pressure – 1 to 1.5 PSI.

1. If possible the boat or tear should be moved to a clean, dry, flat area away from sunlight. Place an oar, or piece of wood under the area to be repaired to give a hard flat surface to work the patch against.
2. All repairs on the river should be made with the 3" bias out (cut an angle to the base fabric to allow stretching) tape. Later you can cover the tape with colored material of cosmetic purposes.
3. If the tear is more than 1" long an inside patch should be applied first. This is more difficult than an outside patch, but will provide better air retention and insure the repair. Use bias tape for the inside patches.
4. Mix the glue with catalyst in a plastic re-useable cup, stir with a tongue depressor. Glue and catalyst are pre-measured, so if you use $\frac{1}{2}$ of the glue, use $\frac{1}{2}$ the catalyst; $\frac{1}{4}$ the glue, use $\frac{1}{4}$ the catalyst, ECT. Add a dropper of MEK to the mix.
5. Use the patch trace around the area where it will be applied. For repairs on the urethane surface. **THOROUGHLY SAND THE URETHANE SURFACE FIRST!** Lightly brush off excess particles both the area and the patch with cheesecloth dampened with MEK (be careful not to brush all the sanding). Using a paintbrush, apply a thin, even coat of glue mixture to both the area and the patch. **DON'T MISS ANY SPOTS.** Let dry (about 20 minutes). Apply a second thin, even coat to area and the patch.
6. Let the glue surfaces become tacky, starting on one edge, lay the patch over the area and press on it with your hand. Then, using the Pusher set a 45-degree angle, push across the patch area to remove all air and set the patch. Work the edge of the pusher along any ridges formed by underlying overlapped materials. If the glue surfaces dry before you can put them together, you can lightly wipe them with a damp cloth of MEK to reactivate, wait until tacky again, then apply. Or you can add a third, thin coat of glue.
7. Let the patch cure for 1 hour before use. Do not pump to full pressure for at least 12 hours!

Hints: Don't glue an area much larger than the patch. Exposed glue will darken with age and make a sloppy looking raft and patch. Be careful with the inside patch and don't glue the inside of the tube together. Take your time. A properly done patch is virtually impossible to remove without damage to the fabric. Don't over use MEK. Squeeze the excess out of your cheesecloth or towel before using.

Caution: glue, catalyst, and solvent should be used in a well-vented area. Avoid contact with eyes and wounds. If ingested **DO NOT INDUCE VOMITING.** Contact a physician or poison control.