



## **INSTRUCTIONS FOR REPAIRING A LARGE HOLES OR SLICES IN AN AIRCELL UNIT USING A 2 PATCH SYSTEM WITH HH-66 VINYL CEMENT™.**

### **Items to have BEFORE you begin the repair:**

- can of HH-66™ vinyl cement
- nitrile gloves
- an old cloth or paper towels
- isopropyl alcohol or nail polish remover (acetone)
- white pencil, chalk marker, or metallic sharpie
- a plastic knife, a plastic putty knife, popsicle stick-something flat to use to spread the adhesive (disposable)
- sand paper or cardboard emery board (nail file)
- patch material from patch kit

Be sure to work in an open space with good ventilation.

### **INSTRUCTIONS:**

1. Locate the hole/slice to be repaired.

2. Using sand paper or a cardboard nail file "scuff" the area approximately 1.5 inches around the hole by gently scratching off the shiny vinyl coating. Do not rub off the black vinyl coating.
3. Wipe off the area using alcohol or acetone on a rag/paper towel. This will remove both the remnants of grit and the remaining shiny protective coating on the tube.
4. Next, place a piece of patch material next to the hole to determine the size and shape of patch needed. Determine the shape of the patch depending on whether the coverage would best be as a circle or oval. Cut out 2 identical patches.
5. Using the hole as a guide, cut out 2 small slits (less than a half inch) which will help make room to insert a patch on the **INSIDE** of the tube-facing the hole. Place a patch inside the hole and center it, by feeling it from the top, then use a white pencil, chalk marker, or metallic sharpie to mark the center of the hole with a cross. This will serve as a reference point and ensure the patch is centered quickly once the glue is applied. This patch will cover the hole from the **inside**, patch #1.
6. Take the HH-66 and brush on a thin layer of adhesive along the inside rim of the hole on the tube. Take care by ensuring the adhesive side doesn't touch the opposite side of the tube when you insert the patch. Align the cross with the center of the hole. Then work from the outer edge of the inner patch towards the center to smooth the patch onto underside of the hole. This will help any excess glue to be squeezed onto the inner patch (it'll be covered by the outer patch).
7. Next take the second patch and apply a thin layer of adhesive coating over the entire patch as well as on the hole (and 1<sup>st</sup> patch) on the tube.
8. Wait for the adhesive to become tacky (20-30 seconds depending on the temp/humidity).
9. Apply the patch to the area, if possible, align with the inner patch. Working from the center of the patch take the Popsicle stick or plastic putty knife and gently smooth towards the outer edge of the patch to ensure any air bubbles have been released and the patch is properly sealed.
10. If desired, take a black Sharpie® and trace along the outer edge of the patch to help it blend into the rest of the tube. This is strictly for cosmetic purposes. You may also clean up any excess adhesive with the alcohol or acetone.
11. Allow the patch to cure. This process can be sped up by using a hair dryer on a cool setting. A hot setting will reactivate the vinyl cement and prolong the curing process.
12. Wait at least an hour before attempting to inflate. Ideally this patch should be allowed to sit facing upwards overnight to cure entirely.

13. Repair is complete.