

Adhesive Instructions/How to Order



Bonding Instructions:

- › Fabric to Fabric
- › Fabric to PVC Accessory
- › Fabric to Fiberglass
- › Fabric to Aluminum
- › How to Order

Fabric to Fabric Bonding:

INSTRUCTIONS FOR USING ROYAL ADHESIVE UR5208 FOR INFLATABLE BOAT MANUFACTURING WITH SEAMAN CORPORATION XR-MARINER® 4138 FABRIC

- 1) Lightly manually abrade the fabric coating where the seam will be located with 150 grit emery cloth to provide a clean surface.
- 2) Wipe the seam repeatedly with a clean cloth saturated with ideally THF (tetrahydrofuran) or MEK to remove any waxes, skin oil or sanding residue that may be present. The THF/MEK saturated cloth should be folded to expose a fresh surface with every third stroke.
- 3) Mask of the seam area to avoid having the UR5208 adhesive application to extend beyond the seam area.
- 4) Apply two (2) uniform coats of thoroughly mixed UR 5208/Cat UR, (100 parts UR 5208/2.5 parts Cat UR) to each surface with a stiff bristled brush. A paint brush cut to ½inch long bristle length works very well. Apply the 2 uniform coats of adhesive using long even strokes applying a fair amount of pressure to thoroughly wet the surface and coat the entire bond area on both surfaces. Allow each coat to dry until tack free before proceeding with additional coats. Do not use a heat gun to facilitate drying.
- 5) Once the second (2nd) coat is dry, reactivate the adhesive within 2-3 hrs (on each surface) with another uniform coat of catalyzed adhesive and bond when aggressively tacky (this may only be 10-20 seconds depending on the amount of adhesive used and the temperature).
- 6) Use a steel lamination roller (2 Lb metal roller that is 2 inches wide) to obtain full contact and exclude any trapped air from the seam.
- 7) Allow 7 days at room temperature for the adhesive to fully cure before initial use.
- 8) To remove excess glue residue, use THF within a 2-3 Hour period of the glue application.

Note: Royal Adhesive recommends that fresh UR 5208 adhesive be mixed each time fabrication work is being conducted and does not recommend the use of aged, mixed UR 5208/Cat UR catalyzed adhesive. The UR 5208/Cat UR catalyzed mixture has a maximum pot life of 8 hrs. Royal Adhesive also recommends that the dried UR 5208/Cat UR adhesive mixture be reactivated and laminated within 2-3 hrs hours of the final coat to optimize performance. Excessive delay in reactivation/lamination may cause a decrease in adhesion performance due to partial curing of the catalyzed adhesive.

Adhesive Instructions/How to Order



Bonding Instructions:

› [Fabric to Fabric](#)

› [Fabric to PVC
Accessory](#)

› [Fabric to Fiberglass](#)

› [Fabric to Aluminum](#)

› [How to Order](#)

Fabric to PVC Accessory Bonding:

INSTRUCTIONS FOR USING ROYAL ADHESIVE UR5208 FOR INFLATABLE BOAT MANUFACTURING WITH SEAMAN CORPORATION XR-MARINER® 4138 FABRIC

- 1) Lightly manually abrade the fabric coating where the seam will be located with 150 grit emery cloth to provide a clean surface.
- 2) Wipe the seam repeatedly with a clean cloth saturated with ideally THF (tetrahydrofuran) or MEK to remove any waxes, skin oil or sanding residue that may be present. The THF/MEK saturated cloth should be folded to expose a fresh surface with every third stroke.
- 3) Mask of the seam area to avoid having the UR5208 adhesive application to extend beyond the seam area.
- 4) Apply two (2) uniform coats of thoroughly mixed UR 5208/Cat UR, (100 parts UR 5208/2.5 parts Cat UR) to each surface with a stiff bristled brush. A paint brush cut to ½inch long bristle length works very well. Apply the 2 uniform coats of adhesive using long even strokes applying a fair amount of pressure to thoroughly wet the surface and coat the entire bond area on both surfaces. Allow each coat to dry until tack free before proceeding with additional coats. Do not use a heat gun to facilitate drying.
- 5) Once the second (2nd) coat is dry, reactivate the adhesive within 2-3 hrs (on each surface) with another uniform coat of catalyzed adhesive and bond when aggressively tacky (this may only be 10-20 seconds depending on the amount of adhesive used and the temperature).
- 6) Use a steel lamination roller (2 Lb metal roller that is 2 inches wide) to obtain full contact and exclude any trapped air from the seam.
- 7) Allow 7 days at room temperature for the adhesive to fully cure before initial use.
- 8) To remove excess glue residue, use THF within a 2-3 hour period of the glue application.

Note: Royal Adhesive recommends that fresh UR 5208 adhesive be mixed each time fabrication work is being conducted and does not recommend the use of aged, mixed UR 5208/Cat UR catalyzed adhesive. The UR 5208/Cat UR catalyzed mixture has a maximum pot life of 8 hrs. Royal Adhesive also recommends that the dried UR 5208/Cat UR adhesive mixture be reactivated and laminated within 2-3 hrs hours of the final coat to optimize performance. Excessive delay in reactivation/lamination may cause a decrease in adhesion performance due to partial curing of the catalyzed adhesive.

Adhesive Instructions/How to Order



Bonding Instructions:

› [Fabric to Fabric](#)

› [Fabric to PVC
Accessory](#)

› [Fabric to Fiberglass](#)

› [Fabric to Aluminum](#)

› [How to Order](#)

Fabric to Fiberglass Bonding:

INSTRUCTIONS FOR USING ROYAL ADHESIVE UR5208 FOR INFLATABLE BOAT MANUFACTURING WITH SEAMAN CORPORATION XR-MARINER® 4138 FABRIC

- 1) Sand the fiberglass seam area with 150 grit emery cloth to provide a rough surface, free of wax or mold release agents.
- 2) Wipe the fiberglass seam area repeatedly with a clean THF saturated cloth as indicated above, exposing a fresh cloth surface every few strokes.
- 3) Mask off the seam area to avoid having the UR5208 adhesive application to extend beyond the seam area.
- 4) Prepare the fabric surface for bonding as indicated above. Mix and apply two (2) uniform coats of the UR 5208/Cat UR (100 parts UR 5208/2.5 parts Cat UR) mixture to each surface allowing adhesive to dry 20 – 30 minutes until tack free. Use a short bristled brush applying a fair amount of pressure to thoroughly wet the surface using long even strokes to coat the entire bonding area on both surfaces. A paint brush cut to ½ inch long bristle length works very well. Allow each coat to dry 20-30 minutes until tack free before proceeding with additional coats. Do not use a heat gun to facilitate drying.
- 5) Reactivate the adhesive within 2-3 hrs after the 2nd coat has dried (each surface) by applying a third (3rd) uniform coat of catalyzed adhesive. Once the adhesive becomes aggressively tacky (generally 10-20 seconds depending on the amount of adhesive used and temperature) join the two surfaces.
- 6) Use a steel lamination roller (2Lb metal roller that is 2 inches wide) to obtain full contact and exclude any trapped air from seam.
- 7) Allow 7 days for the adhesive to fully cure at room temperature before initial use.
- 8) To remove excess glue residue, use THF within a 2-3 year period of the glue application.

Note: Royal Adhesive recommends that fresh UR 5208 adhesive be mixed each time fabrication work is being conducted and does not recommend the use of aged, mixed UR 5208/Cat UR catalyzed adhesive. The UR 5208/Cat UR catalyzed mixture has a maximum pot life of 8 hrs. Royal Adhesive also recommends that the dried UR 5208/Cat UR adhesive mixture be reactivated and laminated within 2-3 hrs of the final coat to optimize performance. Excessive delay in reactivation/lamination may cause a decrease in adhesion performance due to partial curing of the catalyzed adhesive.

Adhesive Instructions/How to Order



Bonding Instructions:

[› Fabric to Fabric](#)[› Fabric to PVC
Accessory](#)[› Fabric to Fiberglass](#)[› Fabric to Aluminum](#)[› How to Order](#)

Fabric to Aluminum Bonding:

INSTRUCTIONS FOR USING ELLSWORTH EP1056LV EPOXY GLUE AND ROYAL ADHESIVE FA1076 GLUE FOR INFLATABLE BOAT MANUFACTURING WITH SEAMAN CORPORATION XR-MARINER™ 4138 FABRIC

- 1) Sand the aluminum vigorously with 150 grit emery paper to completely remove the layer of oxide at the surface and provide a clean, roughed up surface.
- 2) Wipe the sanded aluminum repeatedly with a clean cloth saturated with THF. Fold the cloth to expose a fresh surface after several strokes. Continue to wipe the aluminum repeatedly until no more oxide residue is observed on the cloth.
- 3) The sanded aluminum surface should immediately be primed with Ellsworth EP1056LV white epoxy, which is supplied in a dual cartridge assembly.
- 4) Follow the cartridge application gun assembly instructions. Using the dual tube cartridge and application gun, attach a static mixer to the dual cartridge tube assembly and dispense the required amount of mixed epoxy into an appropriate container.
- 5) To ensure complete mixing of each component, it is advisable to gently mix the epoxy after decanting from the cartridge avoiding trapping air in the mixed epoxy.
- 6) Mask off the seam area as to avoid having the EP1056LV epoxy extend beyond the seam area.
- 7) Using a brush or foam roller, apply a 4 to 6 mil coating of EP1056LV epoxy to provide a smooth primer coat.
- 8) Allow epoxy to cure at room temperature for at least 24 hrs, ensuring it is fully hardened before proceeding.
- 9) Next, using 150 grit emery cloth, lightly sand the cured epoxy primer coat smooth. Wipe with a clean cloth saturated with acetone or THF to remove any epoxy sanding residue.
- 10) Lightly abrade the fabric coating in the seam area with 150 grit emery cloth to provide a clean surface.
- 11) Wipe abraded fabric seam area with THF to remove sanding residue.

[› continued on next page](#)

Adhesive Instructions/How to Order



Bonding Instructions:

- › [Fabric to Fabric](#)
- › [Fabric to PVC Accessory](#)
- › [Fabric to Fiberglass](#)
- › [Fabric to Aluminum](#)
- › [How to Order](#)

Fabric to Aluminum Bonding:

INSTRUCTIONS FOR USING ELLSWORTH EP1056LV EPOXY GLUE AND ROYAL ADHESIVE FA1076 GLUE FOR INFLATABLE BOAT MANUFACTURING WITH SEAMAN CORPORATION XR-MARINER™ 4138 FABRIC

- 12) Apply 2 uniform coats of FA 1076 (as received) to each surface, allowing each coat to dry (20-30 minutes) between applications. Use a short bristled brush applying a fair amount of pressure to thoroughly wet the surface using long even strokes to coat the entire bonding area on both surfaces. A paint brush cut to ½ inch long bristle length works very well.
- 13) Reactivate adhesive using THF/MEK and apply a third (3rd) uniform coat of FA 1076. Once adhesive becomes tacky (10 to 20 seconds depending on amount of adhesive and temperature) join the two surfaces.
- 14) Use a steel lamination roller to obtain full contact and exclude any trapped air.
- 15) Allow FA 1076 adhesive to cure for at least 1 week at room temperature before initial use.

Note: For Fabric to Fabric or Fabric to PVC Accessory bonding, use Royal UR 5208 adhesive.

Adhesive Instructions/How to Order



Bonding Instructions:

- › [Fabric to Fabric](#)
- › [Fabric to PVC Accessory](#)
- › [Fabric to Fiberglass](#)
- › [Fabric to Aluminum](#)
- › [How to Order](#)

How to Order:

UR 5208 Adhesive

for Fabric to Fabric Bonding, Fabric to Fiberglass Bonding and Fabric to PVC Accessory Bonding.

For countries located in North America, please contact:

[Royal Adhesives and Sealants](#)

For countries located outside North America, please contact:

[Ellsworth Adhesives](#)

EP 1056 Epoxy Adhesive Dispensing Gun

for Fabric to Aluminum Bonding.

All countries, please contact: [Ellsworth Adhesives](#).

EP 1056 Epoxy Adhesive

for Fabric to Aluminum Bonding.

All countries, please contact: [Ellsworth Adhesives](#).

FA1076 Adhesive

for Fabric to Aluminum Bonding.

All countries, please contact [Royal Adhesives and Sealants](#).

› [Royal Adhesives and Sealants Website](#)

› [Ellsworth Adhesives Website](#)