

Accessory Plate Gluing Instructions – updated 8.5.2022, pa

NOTE: The following instructions outline adding a pre-fabricated accessory such as a MOLLE Plate or Universal Mount Plate to a Duratex PVC inflatable (aka tarpaulin). Please note: these accessory items are available for sale on www.Aquaglide.com or through your local Aquaglide Paddlesports dealer. These instructions are not intended for repair of leaks or other damage. Please contact Aquaglide for additional instructions.

PREPAIR

1. Position yourself in a clean, dry area with good ventilation. You will want protection from wind and sun. A temperature range of 65 – 85 degrees F is ideal for proper curing of adhesives.

2. Gather materials:

- Accessory patch (i.e. [MOLLE Plate](#), [Universal Mount Plate](#), etc.)
- Sandpaper (~120grit)
- HH-66 PVC glue
- Solvent (ideally MEK, rubbing alcohol or med wipes can work in a pinch)
- Clean shop towel
- Small to medium disposable brushes *(brushes up to 1.5" wide help apply glue more quickly but may be harder to control)

3. Additional items may be needed: china marker (aka grease pencil), clamps or weights (can be helpful). You may want to consider using a respirator and nitrile gloves.

4. This work may be done with the product inflated or deflated. The goal is to apply glue quickly and evenly to both contact surfaces, then press the surfaces together with firm pressure. Clamping or bracing gluing work until the glue has set can be critical to a permanent lamination. In general, MOLLE Plates and other 'soft' accessories may be easier installed while the product is inflated, whereas Universal Mount Plates and other 'hard' accessories may be best applied with the product deflated. The goal is for all glued surfaces to be continually pressed together (or at least not pulled apart) until cured. Taking some time to think through the steps will improve the end result.

5. First, find a good location for the accessory plate. For best lamination, avoid gluing over seams or other layers of PVC. Dry-fit the accessory plate to ensure good fit, position, and alignment. Use china marker to outline the accessory plate. This will mark the gluing area.

- MOLLE Plates are typically oriented on the cockpit inner side tube, 12 – 24" (30 – 60cm) forward of the normal seating position, with MOLLE strips horizontal. These can also be attached to the kayak or SUP deck in almost any preferred orientation.
- Universal Mount Plates are typically mounted facing directly upward, either on cockpit side tubes or floor. Positions vary greatly depending on the intended use (i.e. Angling accessory, oarlocks, camera mount, etc.). Try to avoid the stiff plate fighting to pull away from a curved shape before glue has cured.

PRO TIP: Use low-tack masking tape to isolate the gluing area and avoid messy over-gluing.

6. Use a fresh cloth with MEK or other solvent to quickly clean the gluing area. Don't rub, just swipe to remove surface oils. Make sure to clean BOTH contact surfaces (i.e. the kayak or SUP AND the back of the accessory patch). Allow to dry (a few seconds).
7. Use clean sandpaper to lightly rough up the gluing surfaces making sure to sand BOTH contact surfaces.
8. Again, use a cloth with solvent to quickly remove sanding residue from the gluing area on all contact surfaces. Don't rub.
9. Dry-fit the layers one final time. Use a china marker (if necessary) to outline where the gluing surfaces are located. If the gluing areas are clear, this may not be necessary, but it is best to avoid over-gluing, which makes the repair look messy.
10. Use a disposable brush top apply an even layer of glue to the gluing area making sure to cover completely – all the way to the edge. Try to work quickly. Stay INSIDE the china marker outline or masking tape (if using).
11. Evenly glue the back side of your accessory patch – cover all the way to the edges.
12. Allow glue to cure briefly until the surfaces glaze slightly (approximately 30 seconds).
13. Repeat the gluing steps to apply a second layer of glue to both contact surfaces, again allowing glue to cure for approximately 30 seconds.
14. Starting at one corner, carefully align the two gluing surfaces. Once the surfaces touch, the bond will be immediate, so take care.
15. Working away from the first corner contact, carefully press the repair area together making sure to avoid wrinkles or bubbles first, then pressing together using very firm pressure.
16. Rub the entire patch area and the edges of the patch using very firm pressure. For optimal lamination, clamp flat or press with boards and weights during curing.
17. Allow to cure for at least 12 hours before inflating – 24 hours for maximum strength.