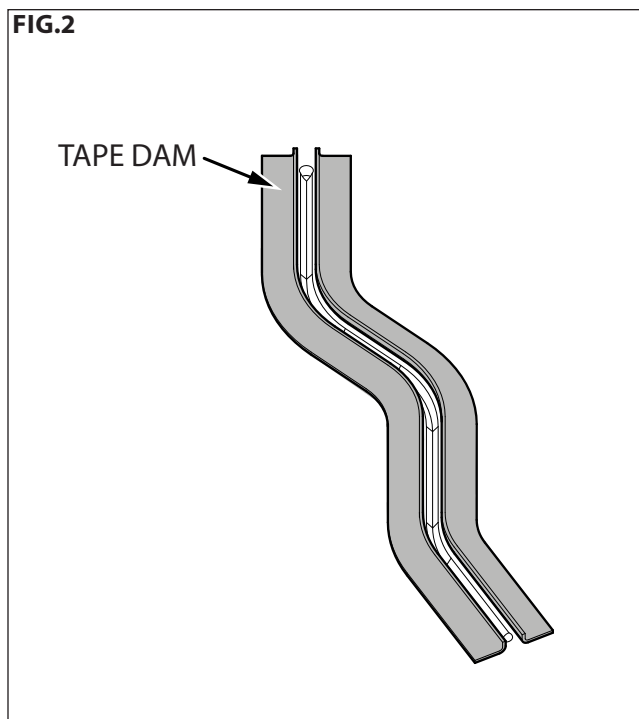
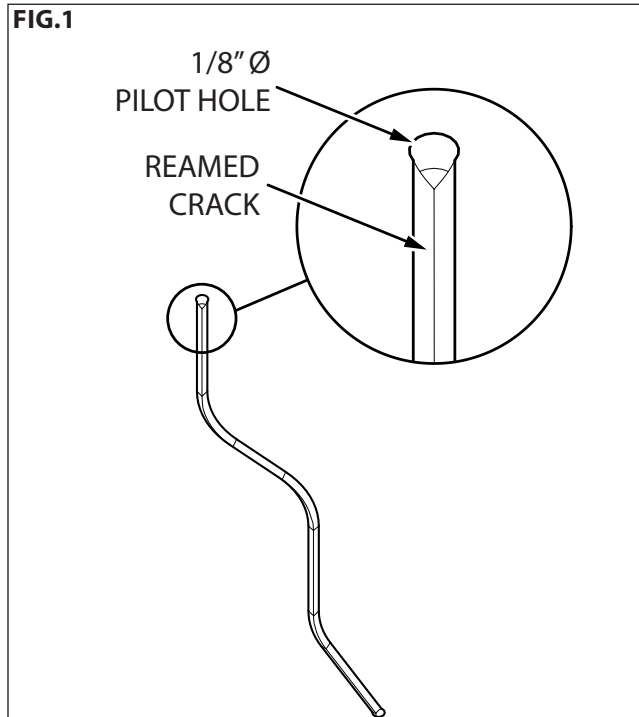


BioPrism® Solid Surface Installation Instructions Patch Repair Kit

Please read all instructions before installing products.

Contents: Two paper cups for measuring and mixing, Wooden mixing sticks, Bio-resin, ATH filler, Color filler, Pigment (solid colors), Catalyst



1. When repairing a crack, drill an 1/8" diameter hole through the material at both ends of the crack. This will "dead-end" the crack and stop it from spreading. Ream out the crack, a minimum 1/8" deep, with a dremel. Use dremel bits #125, #107, or similar. For best results, slightly bevel the very top edge of the reamed area. *See Figure 1*
2. Clean damaged surface and surrounding area with denatured alcohol. Make sure to get down into any voids. Allow to dry.
3. Take blue painters tape and create a dam around damaged area to eliminate any over spill onto other surfaces. *See Figure 2*
4. After damaged area is prepped, mix the patch kit. From the start of the next step (#5), you will have approximately 15 minutes until the repair material is beginning to cure and be un-pourable.
5. Pour 25g of resin (approximately 1/4" high in paper cup) into the paper cup.
6. Dispense 18 drops of catalyst into resin cup with eyedropper. Stir catalyst for about 30 seconds. Resin will change from a pink/purple color to a yellow/tan color. If mixing together a Class A solid color or Class A1 solid color with a particulate filler color, continue to step #7. If mixing together a particulate filler color, skip to step #8.
7. If mixing a Class A solid color or a Class A1 color that includes both pigment and a particulate filler color, add 4-5 drops of pigment and check color of mix to color of material. Add more pigment until satisfied with color match. Note: The more pigment added, the longer it will take for the mix to solidify.
8. If mixing together a particulate filler color or a Class A1 color, add 20g of ATH and 20g of particulate filler color (approximately 1 bottle cap each) in the paper cup and mix thoroughly, stirring and blending the components completely together. If making a Class A solid color, double the amount of ATH used since solid colors do not use a particulate filler color.

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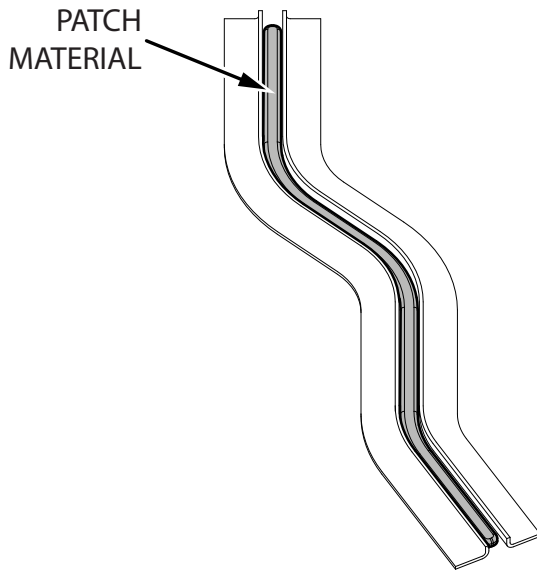
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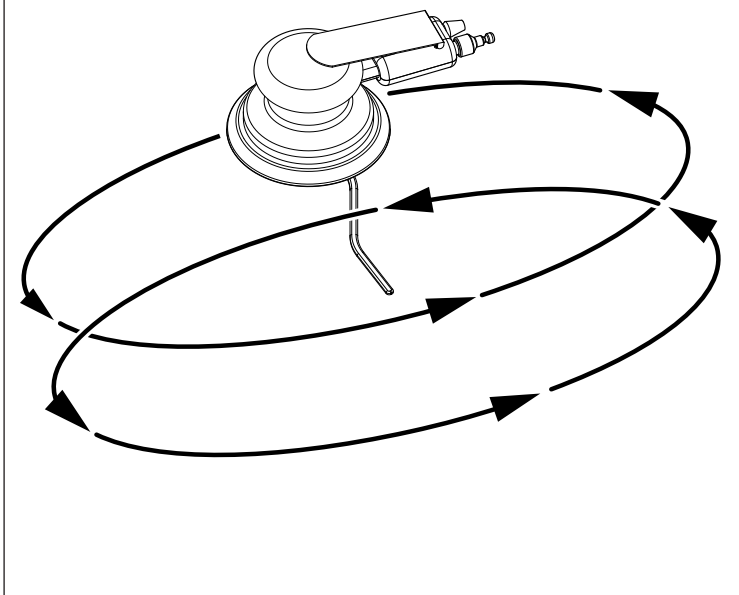
BioPrism® Solid Surface Installation Instructions Patch Repair Kit

FIG.3



9. Stir steadily with a mixing stick for about 1 minute or until mix looks thoroughly combined.
10. Overfill the damaged area with the mixture and allow it to harden completely. 24 hours is recommended; cooler temperatures require longer set-up times. *See Figure 3*
11. After mixture is fully cured, sand area with 80-120 grit sandpaper on a random orbital sander to just about flush with the surface. Sand in an orbital pattern overlapping 50% with each pass. *See Figure 4*
12. Continue sanding with 100 Micron paper, then 60 micron paper and finish with a maroon scotch-bright pad. For darker colors, you may need to continue finishing with grey and, if necessary, white scotch-bright pads. For best results blend patched area into a larger area surrounding it.

FIG.4



The above formula produces 2 ounces of material which is enough to patch 2 cubic inches. Due to lot variations, some color differences may occur.