

• When filling screw or nail holes, ensure that all dust has been removed and apply the filler mix, leaving the hole very slightly over-filled. Once sanded, no further filling will be required.

• During construction, it is advisable to use pre-drilled and counter sunk screw fastenings rather than using annular ring nails. The nails tend to pull the timber fibres below the true surface of the hull and after final painting, the timber often slowly returns to its original position. This leaves a slight hollow, giving the impression that the filler has shrunk when in fact, the area around the filler has actually swollen.



GLUING

International has two glues available:

 <p>EPIGLUE®</p> <p>Epigluce® is a non staining, high-strength, gap-filling two-component epoxy resin adhesive. Supplied ready to use, Epigluce only requires to be mixed with its hardener, at two parts of resin to one part of hardener by volume.</p>	 <p>EPIGLASS® HT9000®</p> <p>Epiglass® HT9000® Epoxy Resin System has been developed to offer a comprehensive range of resin and hardener combinations for the boatbuilding industry. It includes systems for gluing, filling, fairing and sheathing timber, GRP, steel, aluminium and ferro hulls.</p>
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There can be no compromise when using adhesives. Bonding failure may result in loss of life or property. International Epigluce® and HT 9000® have been specifically developed to provide outstanding strength and durability under all conditions, but you must be careful to follow the appropriate preparation advice.

PREPARATION GUIDELINES	
1	TIMBER – Make sure the timber is well-seasoned as well as dry and clean. For oily resinous timbers such as Teak, sand then degrease thoroughly with International Universal Thinners #4. Allow to dry and glue straight away.
2	FIBREGLASS (GRP) – When gluing an exterior gelcoat surface, clean with a suitable detergent followed by slight sanding. Do not sand too heavily, simply remove the gloss to provide a key for the adhesive. When gluing to interior gel coats or waxed and unwaxed resins, sand the surface thoroughly. Wipe down with International Universal Thinners #4 or Polyurethane Spraying Thinners #10 to confirm there is no uncured resin which will show up as sticky residue (which should be removed by solvent wiping with fresh rags as many times as required), then sand surface again and glue as required.



IMPORTANT: SURFACE PREPARATION IS VITAL TO ACHIEVING A SATISFACTORY JOINT.