



Ensure you have all the equipment required to apply Repair Epoxy.

Items included in this kit:

1 - Piston Repair Epoxy Kit	1 - Repair Epoxy MSDS Data Sheet	1 - 4 oz. Plastic Cup with Lid
Hardener	1 - 4 oz. Simple Green® Spray Cleaner	1 - 2" x 6' 80 Grit Emery Cloth
Resin	1 - 1 1/2" Plastic Putty Knife	1 - 2" x 6' 400 Grit Emery Cloth
Wooden Paddles		

Read instructions completely prior to mixing. Repair Epoxy has a working time of only 20 minutes.

1. Prepare surface using **Simple Green® Spray Cleaner** included to clean surface of the piston of all dirt, dust, grease or other foreign materials.
2. Light sanding to roughen the surface will result in better bonding. Surface must be clean and dry.
3. Extract in equal parts **Piston Repair Epoxy Kit** resin and hardener tubes into **Plastic Cup**. Mix quickly and thoroughly using included wooden paddles ensuring streaks have disappeared and material is an even color throughout.

Note: *If temperatures are below 65° F use an approved heating device to bring the work area and components to a temperature above 65° F.*

4. Apply the mixed Repair Epoxy material immediately to the bonding surface using **Plastic Putty Knife**.

Note: *Repair Epoxy has a working time of only 20 minutes.*

5. Repair Epoxy will setup in 3 hours and cure in 6 hours at room temperature.
6. Ensure the Repair Epoxy has cured to a hardened state prior to sanding. Use **80 Grit Emery Cloth** to sand off all excessive dried material from the work area.
7. Use the **400 Grit Emery Cloth** to polish the affected area to the desired smoothness.

Note: *This surface should be as smooth as the rest of the piston.*

For questions or assistance with this procedure contact customer service.