

Quarite Surface Repair Instructions

TOOLS REQUIRED:

Safety Glasses	Sanding Discs for Drill -	Optional:
Latex Gloves	24, 36, and 50 grit	Heavy Duty
Vapor/Particulate	Wet and Dry Sand Paper –	Polisher/Buffer – 2500-
Respirator	100 and 220 grit	3500 rpm w/Buffer Pad
Heavy-Duty Flameless	Acetone or Lacquer	Buffing bar or Rubbing
Heat Gun	Thinner	Compound – Medium
3/8" Variable Speed Drill	Clean Cloth	Grit
Cutting Tip for Drill	Foam Blocks – approx 5"x	
	5" x 5 (8 – 10)	

SAFETY REQUIREMENTS:

- ✓ Safety glasses, latex gloves and respirator.
- ✓ Read all enclosed MSDSs prior to the start of repair.
- ✓ Close all containers after each use.
- ✓ Keep all compounds away from heat, spark or flame. Vapors may cause flash fire.
- ✓ Perform this procedure in a well-ventilated area.

NOTES:

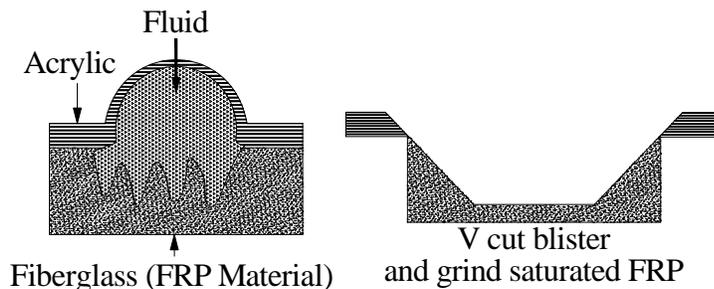
- ✓ Inform the spa owner that the spa will need to be drained prior to technician's arrival.
- ✓ The average cure time is 60 minutes. This repair can be done in the field. However, if the ambient temperature is outside the range of 60-80°F, the spa should be shaded or moved to an area that can ensure the proper surface temperature.
- ✓ Do not leave Compound A or mixtures containing Compound A uncovered. They may over-thicken or develop a surface skin.
- ✓ A properly prepared repair mix will cure even at a minimal thickness of 5-15mm (1/8").
- ✓ If there is more than one blister on the surface of the spa, complete one step on all of the blisters before proceeding to the next step.
- ✓ This repair is cosmetic only, and color variations may exist depending on the age of spa and location of repair. This repair does not affect the functionality of the spa.

STEP 1. Drain the spa if spa owner has not done so, and thoroughly dry the appropriate area(s).

STEP 2. Clean the area using the cloth and acetone or lacquer thinner.

FOR FIBERGLASS-BACKED SPAS ONLY

NOTE: Remove only the top layer of fiberglass, as the new material will be applied to it.





Locate the blister



Remove blister area by cutting and grinding

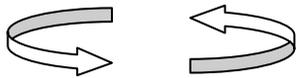
STEP 3. Remove the blister with a 3/8" Variable Speed Drill, using a sanding disc. Grind enough of the blister and any saturated FRP (fiberglass) material to level the surface.



Dry out the fiberglass with heat gun.



Fiberglass after drying



STEP 4.

To prevent future blistering, you must thoroughly dry out the fiberglass with a heavy-duty flameless heat gun, using a circular drying motion.



Remove scorched or melted material



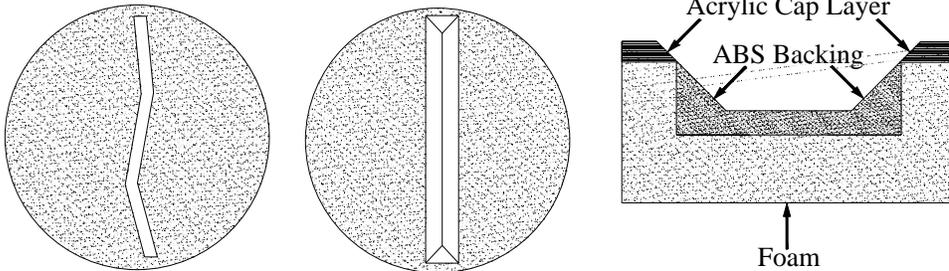
Clean prepared FRP

STEP 5.

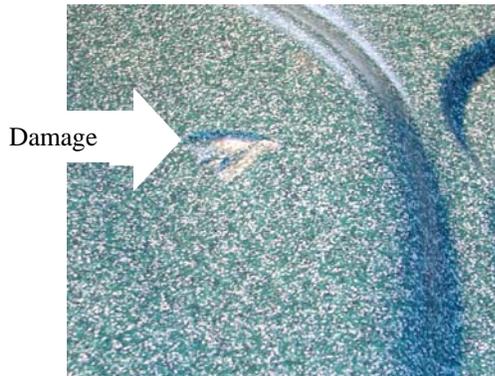
After the material has been thoroughly dried, grind away any material that is scorched or melted. Clean the area using the cloth and acetone or lacquer thinner.

FOR ABS-BACKED SPAS ONLY

NOTE: Do not drill through the ABS backing. Should this occur, the shell would need to be repaired on the back side before proceeding with this surface repair.



V cut the surface damage with 45 degree sides. Do not cut through the ABS backing.



Locate the damage.



Prepare the damaged area by cutting and grinding.

STEP 3. Remove the blister with a 3/8" Variable Speed Drill, using a sanding disc. Grind enough of the blister and any saturated FRP (fiberglass) material to level the surface.

PREPARING THE COLOR MIXTURE





Adding Component B

Amount of Component A	Amount of Component B
½ Ounce	30 drops

STEP 1. Place the desired amount of Component A into a mixing cup.

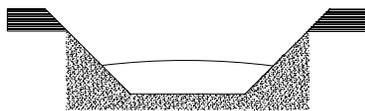
NOTE: *It is best if the mixture is prepared in small batches as it will set up in approximately 15 minutes and will not be usable.*

STEP 2. Shake Component B (catalyst) and add appropriate drops to the color mixture.

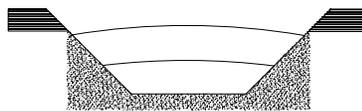
STEP 3. Mix thoroughly with a stir stick for approximately **30 seconds**.

STEP 4. Using the mixing stick, apply the color mixture to the prepared area. It is best to apply in three small layers. Between applications, dry each layer with a heat gun, using a circular motion around the filled area. The cure time in between layers is 15-20 minutes, but can be accelerated by heat curing.

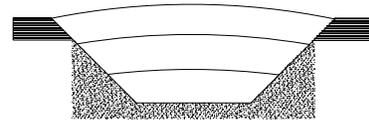
IMPORTANT: *Use gentle, continuous, circular heat around the edges of the applied texture to heat cure each layer. Direct heat will form pinhole air pockets, which could lead to more blisters.*



1st Underfill



2nd Underfill



3rd Slight Overfill



Application – There must be an excess layer of cured repair mix, which will be sanded away.



Proper Drying Technique – Use gentle, continuous, circular heat around the edges of the applied texture.



STEP 7. Once the area has fully cured, sand down the top layer with the appropriate grit of sand paper so that the surface is smooth and level to the rest of the shell.

STEP 8. Add the hardener to the urethane and mix for 30 seconds.

NOTE: *It is best if the mixture is prepared in small batches as it will set up in approximately 15 minutes and will not be usable.*



Protective Clear Topcoat - Urethane	Hardener
3 parts	1 part

STEP 9. Using the tip of a paintbrush, dab the topcoat on the repair. It can be dried with a heat gun using a circular drying motion around the filled area. The cure time between layers is 15-20 minutes, but can be accelerated by heat curing.

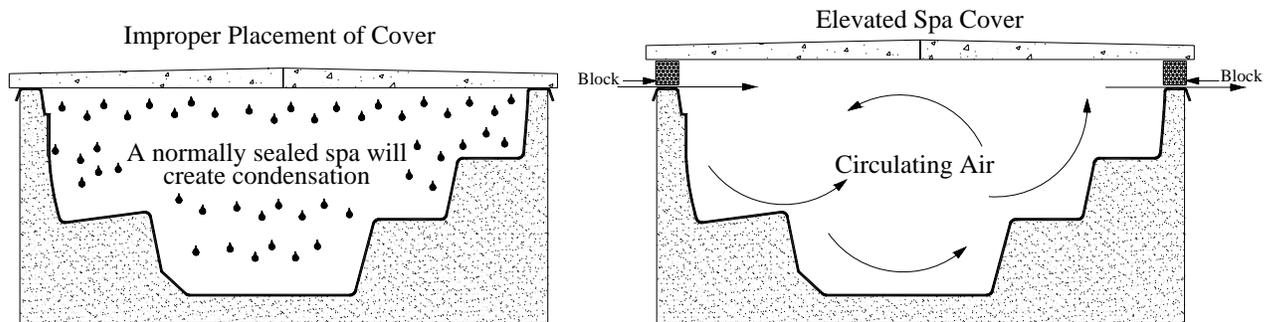
IMPORTANT: *Use gentle, continuous, circular heat around the edges of the applied texture to heat cure each layer. Direct heat will form pinhole air pockets, which could lead to more blisters.*



STEP 10. *This step is optional.* Using the heavy-duty polisher/buffer and buffing bar or rubbing compound, polish the repaired area of the spa.

STEP 11. Position the cover on foam blocks to ensure that the surface remains dry and there is enough air circulation and curing.

NOTE: *In locations where there might be a lot of wind, it may be necessary to place an object on top of the cover to keep it in place, since the cover tie-downs cannot be used.*



STEP 12. Please give the homeowner the attached page informing them of the proper cover position and the curing time of 7 days. Include the dealership phone number in case they have any questions.

Watkins™

The Home Relaxation Specialists

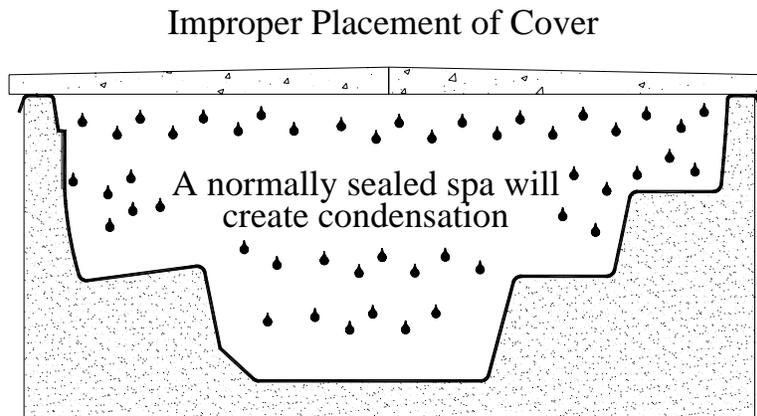
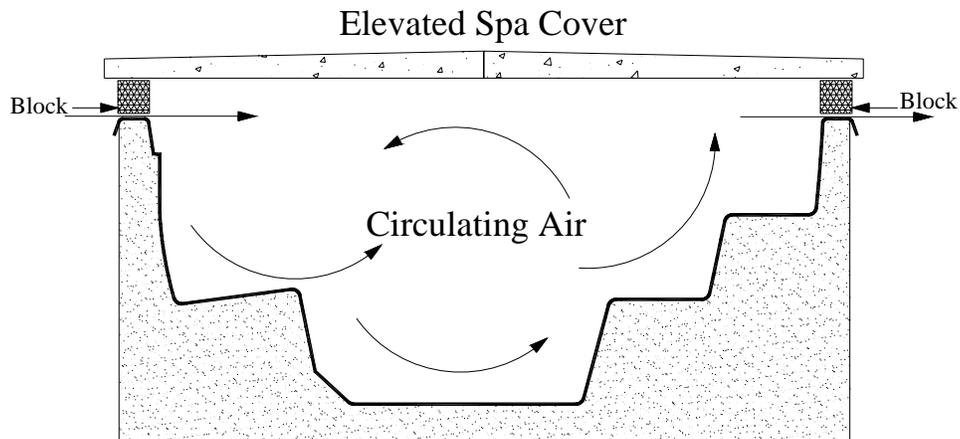
Dear Homeowner,

Now that the surface of the spa has been repaired, it is necessary to allow a curing time of 7 days before the spa can be filled with water. During this time, keep the surface dry. You may want to check the spa from time to time to ensure that the surface remains dry. Additionally, it is important that the cover remains up on blocks to ensure proper air circulation.

NOTE: In locations where there might be a lot of wind, it may be necessary to place an object on top of the cover to keep it in place since the cover tie-downs cannot be used.

This repair is cosmetic only, and color variations may exist depending on the age of spa and location of repair. This repair does not affect the functionality of the spa.

Do not uncover the spa before the 7-day curing time is over.



If you have any questions or concerns, please call

Dealership Telephone Number ()

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