Flex-Tec HV™
ART 401

Flexible Epoxy Repair Compound

Brush on
Prime-A-Trate™
Bonding Agent

Order Number: Art 901

Fill area to be repaired
with Flex-Tec HV™

Order Number: Art 401

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Advanced Repair Technology, Inc.
The Science of Repair

Advanced Repair Technology
PO Box 510
Cherry Valley, NY 13320

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Step-by-Step Instructions

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Questions?
Try our Technical Support Hot Line!
607-264-9040

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ART 401

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Step-by-Step Instructions

DIRECTIONS:

1. **Remove all paint near the area to be repaired**
   by sanding or scraping until the bare wood is exposed.
   (A hot air gun may also be used, avoid burning the wood fibers.)

2. **Remove all decayed wood material to sound, bright,**
   unaffected wood using a chisel, router, die grinder, or flexible shaft router. Wood should be of even color without red-brown and/or gray spots and should not be soft and/or brittle.

3. **Dilate checks and open joints to a width of 1/4"**
   using a cutting tool.

4. **Sand to a bare wood and thoroughly remove**
   loose wood fibers, paint, sawdust and dirt.

5. **Check that wood moisture is below 18%**
   using a moisture meter. Do not proceed if moisture is above 18%.

6. **Pre-treat the bare and sanded wood with a thin film**
   of Prime-A-Trate™ epoxy wood primer using a disposable cup and brush. Mix 2 parts of **A** component to 1 part **B** component. Allow 10 minutes for penetration, maximum of 30 minutes.
   Do not allow Prime-A-Trate™ to dry completely.
   Remove excess material with paper towel before application of Flex-Tec HV™

   PLEASE NOTE: Prime-A-Trate™ may be purchased separately and is not included in the Flex-Tec HV™.

7. **Dispense desired amount of Flex-Tec HV™**
   onto a flat mixing surface and mix both parts thoroughly with a putty knife.

   PLEASE NOTE: Flex-Tec HV™ must be mixed thoroughly before application. Reseal after use.

8. **Apply a thin layer to Flex-Tec HV™ to the pre-treated**
   area to ensure optimal adhesion to the wood, then fill the repair completely to smooth an even finish.

   TIP: *To achieve a right angle such as a corner surface, Plexiglas strips can be used to create a form.*

9. **After curing (12-24 hours at 70° F.)**
   sand the repair even and smooth.

10. **Remove all sanding dust before application**
    of second coat (if required) of Flex-Tec HV™. Always sand between coats. Always sand before painting.

11. **Repaired area can be treated like bare wood**
    for painting and varnishing. Follow the paint manufacturers' recommendation for painting bare wood surfaces. We recommend using a latex primer.

    TIP: *Molding profiles can be achieved by first using a profile gauge to create a template. Next cut profile out of a plastic putty knife. You can replicate the missing profile with a putty knife.*

    TIP: *Dry and in the dark - the durability of an epoxy repair is only as good as the surface preparation and continued protection from moisture and sunlight. The means applying and maintaining a quality paint coating. Keep the wood dry and in the dark and it will last forever.*

A WORD ABOUT POOR SURFACE PREPARATION:

Solely addressing the condition of the paint film rarely solves the real problem. The underlying condition is the wood itself! Leaving the decayed and damaged wood behind greatly compromises the bonding strength of the epoxy repair material. Decayed wood, fungi spores, dirt, air-born particles carried by rain, oil, and moisture all inhibit proper bonding of repair materials to a sound surface. Therefore it is imperative that all contaminates be removed to a clean sound surface. Impregnating decayed wood fibers with epoxy provides only a short term solution.

Helpful Hints

Thoroughly mix Flex-Tec HV part A and B before application to wood surfaces.

Always remove decayed wood material. Do not apply to checks or open joints without dilating and removing all dirt and decay. Cutter should be used to expose sound unaffected material and create sufficient volume of width and depth to allow for natural movement. *(Simply wire brushing or raking loose material out or joint or check may compromise bonding strength).*

For optimal adhesion, apply Flex-Rec HV™ directly to uncured Prim-A-Trate™.

Avoid over filling repair. Position epoxy as close as possible to desired shape. Overfilling will require excessive sanding.

For natural wood finishes, Flex-Tec HV™ can be colored using universal tinting compounds *(tinting must be added to the epoxy during the mixing stage for correct stain color)*.

Avoid application in direct sunlight. Do not leave repair unpainted/varnished.

Thick applications cure faster. Warmer temperature speeds cure - cooler temperature slows cure.

Avoid applying epoxy directly to existing paint. Always remove paint from affected area before beginning repair.

Avoid contact with skin. Work in well ventilated area. Refer to the Material Safety Data Sheet (MSDS) for complete safety and handling information.

Clean Up. Uncured epoxy material can be removed using Handi-Towels (*order # ART 5020*); household vinegar or industrial hand cleaner.

"The greenest building is one that is already built."

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