



INSTRUCTIONS FOR ENVELOPE REPAIR

Repair Kit consists of:

- Gum Stock: 1 pound (Keep stored in a clean, dry, cool environment)
- Repair Cement: 8 ounces

Procedure:

1. Clean the damaged area with a petroleum based solvent, such as Hexane. Follow all safety and environmental requirements in the Hexane SDS.
2. Buff an area 1" larger than the area to be repaired.
3. Clean the buffed area with solvent.
4. Apply a moderate coat of cement to the repair area, and let dry for 15 minutes.
5. Cut a section of gum stock, approx ¼" larger than the area to be repaired.
6. Remove the poly and place the gum stock on the repair area.
7. Stitch the gum stock to the repair area.
8. Place the repair area on a 345-deg F spot repair hot plate.
9. Let cure for 15 minutes using 40-psi air pressure in the air pad
10. Remove and inspect.
11. If damage is completely through the envelope, repeat all steps for the inside.