

## **APPLICATION INSTRUCTIONS**

### **EPOXY SEAM SEALER & FRP FLATTIES ON STEEL SUBSTRATES**

1. For galvanized steel, wire brush the surface to remove any rough spots and wipe the surface with rubbing (isopropyl) alcohol or other mild solvent to remove any moisture or contaminants. Bare steel will require grit blasting or wire brushing to white metal. If necessary mark the area that will be accepting the FRP Flattie.



Roughen one side of the FRP Flatties with course emery cloth and wipe clean with rubbing alcohol. Verify the surface is clean and dry.



\*Epoxy Seam Sealer is mixed in a 1:1 Part A to Part B ratio by weight or volume. Mix the two parts until a uniform gray color emerges with no streaks. Partial kit amounts can be mixed as needed.  
**REFER TO STANDARD APPLICATION SHEET IF NECESSARY.**

2. With gloved hands carefully apply the mixed epoxy to the prepared surface side of the FRP Flattie. Spread the material with the disposable putty knife applicator so the entire prepared surface side of the FRP Flattie is covered. Spread evenly to prevent voids.



3. Place the Flattie onto the steel substrate and secure in place using c-clamps to ensure uniform surface contact with steel substrate. Trowel off any excess epoxy from around the edges and check there are no voids or gaps.



4. Allow the epoxy to cure 12-24 hours @ 73°F (23°C). Average dry time @ 75°F (24°C) is four hours.

\* See Epi-Seal Epoxy Seam Sealer data sheet

**WE RECOMMEND MECHANICAL FASTENING BE USED AS THE PRIMARY METHOD TO SECURE FRP FLAT STOCK, MECHANICAL FASTENING CAN BE USED IN CONJUNCTION WITH THE EPOXY SEAM SEALER TO SEAL THE FRP/STEEL INTERFACE.**

**ONLY IF MECHANICAL FASTENING IS NOT POSSIBLE OR PERMITTED SHOULD THE EPOXY SEAM SEALER BE USED AS THE PRIMARY METHOD TO SECURE THE FRP FLATTIES TO A FLAT STEEL SUBSTRATE.**