

Wall Patching Procedures

- 1. Cut a rectangular hole** in the polymer around the damaged area. A neat square or rectangular patch is easiest to cut with the wall filled with concrete and easiest to patch. Inspect for cracks and loose material. Clean concrete and wall to ensure surfaces is free of any loose material, dust, oil, grease etc. Chip concrete flush to inside face of polymer, if required.
- 2. Bevel cut the edge** of the polymer all around the hole at 45° angle or flatter to provide good bond for patching compound. Before sanding, protect the adjacent wall finish from damage, by apply masking tape at 40 to 50 mm beyond the opening at the top and bottom and at the closest joint between components on the sides of the opening.
- 3. Sand around the hole** with medium aluminum oxide sandpaper (80 to 100 grit). Vigorous sanding must create a small depression with a rough surface, 0.5 mm deep and 10 to 15 mm beyond the hole. This will improve the bond for the patching compound, allow a flush finish for the patch and reduce the possibility of future cracks. Ensure that the sanded area and hole are dry and clean.
- 4. Apply the patching compound**, a two-part polyester resin all-purpose putty, to the hole and the sanded depression. Mix the compound and the cream hardener, thoroughly, following the instructions on the label. Apply the compound with a 2" or 3" putty knife or a plastic spreader, depending on the size of the patch. Also, the compound may have to be applied in 2 or 3 layers depending on the size of the patch. For large patches or patches over insulation of the Conform walls, apply a layer of fiberglass cloth between layers and extend 10 to 15 mm beyond the hole. Apply the compound to leave a smooth, flat surface that raised very slightly above the surrounding surface. A good quality trowel finish can significantly reduce the sanding required to obtain an acceptable patch.
- 5. Sand the patching compound**, after it is dry. Follow the instructions on the label. It usually requires a drying time of 10 to 15 minutes in good conditions before sanding. First, use aluminum oxide medium sandpaper (80 to 100 grit), to eliminate all excess material and to featheredge the patch to the desired shape and surface. Allow the compound to dry an additional 10 to 15 minutes and then sand with fine wet or dry sandpaper (200 to 320 grit).

Finally, sand with fine wet sandpaper (200 to 320 grit), that is moistened, and create a finish surface as smooth as the original polymer. Ensure that the entire surface is dry and free of all dust prior to painting. Prior to painting, repair and extend the masking around the area to be painted, as required
- 6. Paint the patched area**, with a color-matched paint, which is formulated for permanent use on PVC and other rigid thermoplastics. Apply the paint to avoid over-spray and apply in light layers to avoid runs and dripping. Allow first coat to dry before applying a second coat. Between coats, lightly sand the area with fine wet sandpaper (1000 or 1500 grit), which is moistened. After the final coat, remove the masking and lightly sand the area again with fine wet sandpaper (1500 or 2000 grit), that is moistened. The final sanding is to blend the edge of the paint to the existing polymer and the sanding must be parallel to the joints (parallel to length of the components). Finally, buff the painted area with an electric buffer and a very mild abrasive paste or wax (vinyl floor wax or polishing compound)

Patching Materials

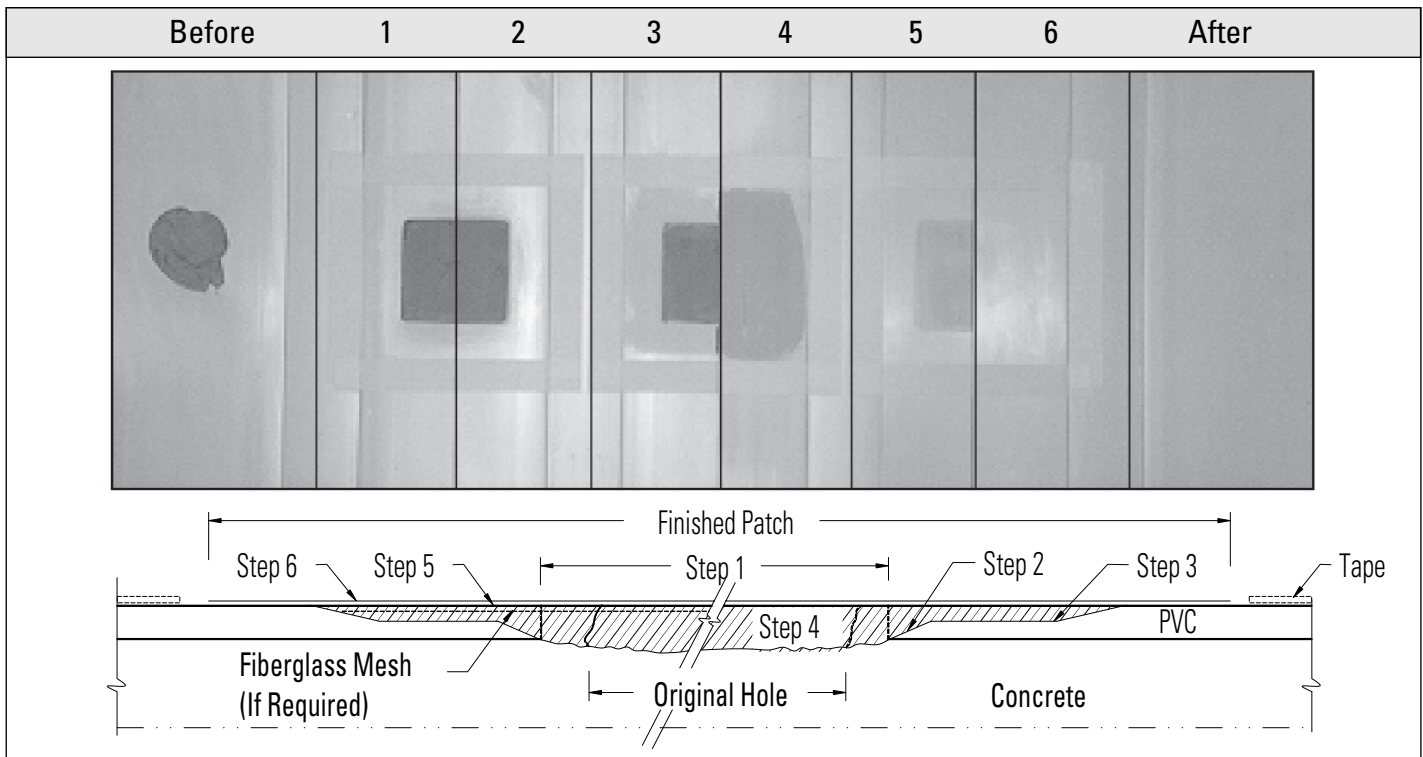
- All Purpose Putty by Bondo Corporation
- Fiberglass Cloth for Automotive and Marine Repairs
- Kolorbond Spray Paint by Formula 40 USA Inc

Patching Tools

- Utility knife
- 2' or 3" putty knife or plastic spreader

- Masking tape
- Medium Aluminum Oxide sandpaper 80 to 100 grit
- Fine wet/dry Aluminum Oxide sandpaper, 200 to 320 grit
- Fine wet/dry Aluminum Oxide sandpaper, 1000 to 1500 grit
- Fine wet/dry Aluminum Oxide sandpaper, 1500 to 2000 grit
- Tack cloths
- Electric buffer with very mild abrasive paste or wax
- Light duty grinder for medium sandpaper (optional)

Patching Steps 1 to 6



Patching Cracks or Butt Joints

- 1. Clean the cracks** and remove any loose material. Clean area as much as possible and ensure surface is free of any loose material, dust, oil, grease, etc.
- 2. Bevel cut the edge** of the polymer along both sides of the crack. Before sanding, protect the adjacent wall finish from damage by applying masking tape at 40 to 50 mm beyond the crack at the top and bottom and at the closest joint between components on the sides of the crack.

3. Follow steps 3 to 6

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