BioPrism® Solid Surface
Installation Instructions Patch Repair Kit

Please read all instructions before installing products.

Contents: Two paper cups for measuring and mixing, Wooden mixing sticks, Bio-resin, ATH filler, Color filler, Pigment (solid colors), Catalyst

1. When repairing a crack, drill an 1/8” diameter hole through the material at both ends of the crack. This will “dead-end” the crack and stop it from spreading. Ream out the crack, a minimum 1/8” deep, with a dremel. Use dremel bits #125, #107, or similar. For best results, slightly bevel the very top edge of the reamed area. See Figure 1.

2. Clean damaged surface and surrounding area with denatured alcohol. Make sure to get down into any voids. Allow to dry.

3. Take blue painters tape and create a dam around damaged area to eliminate any over spill onto other surfaces. See Figure 2.

4. After damaged area is prepped, mix the patch kit. From the start of the next step (#5), you will have approximately 15 minutes until the repair material is beginning to cure and be un-pourable.

5. Pour 25g of resin (approximately 1/4” high in paper cup) into the paper cup.

6. Dispense 18 drops of catalyst into resin cup with eyedropper. Stir catalyst for about 30 seconds. Resin will change from a pink/purple color to a yellow/tan color. If mixing together a Class A solid color or Class A1 solid color with a particulate filler color, continue to step #7. If mixing together a particulate filler color, skip to step #8.

7. If mixing a Class A solid color or a Class A1 color that includes both pigment and a particulate filler color, add 4-5 drops of pigment and check color of mix to color of material. Add more pigment until satisfied with color match. Note: The more pigment added, the longer it will take for the mix to solidify.

8. If mixing together a particulate filler color or a Class A1 color, add 20g of ATH and 20g of particulate filler color (approximately 1 bottle cap each) in the paper cup and mix thoroughly, stirring and blending the components completely together. If making a Class A solid color, double the amount of ATH used since solid colors do not use a particulate filler color.
9. Stir steadily with a mixing stick for about 1 minute or until mix looks thoroughly combined.

10. Overfill the damaged area with the mixture and allow it to harden completely. 24 hours is recommended; cooler temperatures require longer set-up times. See Figure 3

11. After mixture is fully cured, sand area with 80-120 grit sandpaper on a random orbital sander to just about flush with the surface. Sand in an orbital pattern overlapping 50% with each pass. See Figure 4

12. Continue sanding with 100 Micron paper, then 60 micron paper and finish with a maroon scotch-bright pad. For darker colors, you may need to continue finishing with grey and, if necessary, white scotch-bright pads. For best results blend patched area into a larger area surrounding it.

The above formula produces 2 ounces of material which is enough to patch 2 cubic inches. Due to lot variations, some color differences may occur.