

Fibreglass polyester resin is a heavy, non-sag, general purpose resin that can be used on fiberglass and metal. It cures to a hard, non tacky surface that can be sanded or filed. Liquid hardener included.

### PRODUCT

PF 323

### KIT CONTAINS

236 ml (8 fl oz) Resin  
14 ml (0.5 fl oz) Liquid hardener  
3 sq ft Fibreglass cloth  
1.75" x 1.75" Plastic spreader  
Instructions

**READ ALL INSTRUCTIONS AND SAFETY PROCEDURES PRIOR TO USING!**

**IMPORTANT! This product contains hazardous materials.**

Proper protective equipment should be used at all times. Please consult labels on each product as well as the safety data sheet for complete safe handling procedures and personal protection information.

**NOTE: TEST ON A HIDDEN AREA BEFORE USING TO MAKE SURE THE PRODUCT PERFORMS TO YOUR SATISFACTION.**

### SUITABLE SUBSTRATES

- Steel
- Galvanized Steel
- Aluminum
- SMC
- Fiberglass
- Most Rigid Plastics

### ADVANTAGES

- Will not run
- Waterproof
- Can be shaped and drilled

### WHEN WORKING WITH RESINS:

1. Read the instructions on packages ENTIRELY before beginning the job. Have all supplies on hand. Read safety cautions.
2. Always work in a well-ventilated area.
3. Protect your skin and eyes from contact with chemicals. If you get resin mixture on your skin refer to package instructions for removal and care.
4. **DO NOT** work in direct sunlight. This could cause the resin to cure too quickly.
5. **DO NOT** apply resin over wet or dirty surfaces.
6. **DO NOT** apply resin mixture over painted or finished surfaces.
7. **DO NOT** apply resin like a coat of paint. Resin should be used with fiberglass reinforcement (mat, cloth, tape). Use only enough resin to saturate the fabric. Excessive layers of resin over the glass fibres will eventually crack.
8. **DO NOT** over work the resin. Only work it long enough to saturate the fabric. Overworking could cause the resin to cure tacky.

### HOW TO LAY UP RESIN WITH FIBREGLASS FABRIC:

1. Clean repair area to remove all dirt, wax, grease and oil.
2. Rough sand surface, wipe clean and dry.
3. Mix and apply resin to surface. If resin soaks in, a second coat may be required. **NOTE:** Only apply enough resin to thoroughly saturate the fibreglass mat or cloth.
4. Starting at one end, unroll and lay fabric down, working it into the resin. Using a paint brush, or squeegee, work out all the bubbles and wrinkles. Good saturation is when the fibreglass cloth or mat appears to disappear. **NOTE:** For best adhesion, fibreglass cloth should be saturated with resin prior to application to repair area. However, on single layer applications, fibreglass cloth may be laid onto the surface before saturating with resin.

### REPAIRING HOLES:

1. Clean and remove paint, varnish or any other foreign matter surrounding the damaged area. Surface must be free of damage debris. Bevel outside edge of hole at an approximate 20° angle. Rough sand and wipe clean and dry area. Repeat this step on the reverse side of the repair if accessible.
2. Cut two pieces of fibreglass cloth or mat, large enough so that the patches will extend past the edges of the hole by at least 2". Mix and apply resin mixture to the back side of the repair then lay the fibreglass patch over the repair, working it into the resin.
3. Once the backing patch has hardened, sand the exposed area on the face of the repair. Mix and apply resin mixture to the front side of the repair. Lay fibreglass patch over the repair, working it into the resin and allow to cure. Note: Build up the layer to equal the original thickness.
4. Sand the repair to contour and fill the low area with Pro Form Filler.

### MIX RESIN AND HARDENER USING THE CHART BELOW:

Air Temp	Recommended Resin/Hardener Mixture		
	Per oz.	Quart	Gallon
15°C - 21°C (60°C - 70°F)	18 drops	0.57 fl oz (17 cc)	2.30 fl oz (68 cc)
22°C - 32°C (71°C - 90°F)	12 drops	0.37 fl oz (11 cc)	1.35 fl oz (40 cc)
33°C and above (91°F +)	10 drops	0.30 fl oz (9 cc)	1.22 fl oz (36 cc)

### FINISHING TIPS:

- To prevent the cloth pattern from showing through, a surface layer of fibreglass mat should be applied.
- Once the resin is cured, it should be sanded to the desired smoothness before painting or top coating.
- For outdoor applications where it is exposed to the ultra violet rays of the sun, a protective top coat is recommended.

### TECHNICAL DATA:

	<b>PF 320</b> 236 ml (8 fl oz) Resin
<b>Physical State</b>	Liquid
<b>Color:</b>	Red
<b>Odour:</b>	Aromatic
<b>Solubility :</b>	Slightly soluble in water

<b>Flash point:</b>	31°C (87.8°F)
<b>Auto ignition temperature:</b>	490°C (914°F)
<b>VOC</b>	94.66 g/L • 0.79 lbs/gal

### **PRECAUTIONARY INFORMATION**

Refer to product label and Safety Data Sheet for health and safety information before using this product.

### **SAFETY CONSIDERATION**

Safety Data Sheets are available at [www.proformproducts.com](http://www.proformproducts.com) or upon request at [info@proformproducts.com](mailto:info@proformproducts.com). These are provided to help our customers satisfy their own handling, safety and disposal needs, and those required by local applicable health and safety regulations. Our Safety data sheets are updated regularly, therefore, please review the most current Safety Data Sheet before handling or using any product.

### **TECHNICAL INFORMATION**

The technical information, recommendations and other statements contained in this document are based upon tests or experience that Pro Form believes are reliable, but the accuracy or completeness of such information is not guaranteed.

### **PRODUCT USE**

Many factors beyond Pro Form's control and uniquely within user's knowledge and control can affect the use and performance of a Pro Form product in a particular application. Given the variety of factors that can affect the use and performance of a Pro Form product, user is solely responsible for evaluating the Pro Form product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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