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# Instructions: NRS Shore Adhesive

## Repairs

- Pennel Orca® or other synthetic rubber patches
  - D-ring patches
  - Footcups
  - Handles
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## Materials Needed

- Shore Adhesive
  - Roller Rasp or Pro Roller
  - Patch material
  - 150-180 grit wet/dry sandpaper
  - Rubbing alcohol or Toluene for cleaning
  - Lint-free towel
  - Pencil
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## Recommended

- Work in a well ventilated area (garage or shady area works well)
  - Organic fume respirator
  - Chemical resistant gloves (i.e. Nitrile gloves)
  - Eye protection
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## Environmental Conditions

- Ideal ambient temperature for gluing: 75°F and below.
  - Humidity: Do not try to mix and apply glue if the humidity exceeds 70%.
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## Fabric Preparation

- All contact/gluing surfaces must be thoroughly buffed, using a sanding wheel, 150 or 180 grit sandpaper, or a roller rasp. Just buff the fabric shine off; don't rasp down to the threads.
- Cut patch to extend 2" beyond the damaged area, round the edges.
- Clean the buffed surfaces with rubbing alcohol or Toluene using a lint-free towel.

- Trace area of patch with a pencil.
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## Application of Glue

1. Both surfaces to be joined must be coated with adhesive.  
**Note:** The surfaces to be joined must be dry prior to applying adhesive.
2. Apply one thin, even coat of adhesive to each surface.
3. Wait until the first coat of adhesive is dry, approximately 10 to 30 minutes, depending on conditions. Use the "knuckle" test — touch your gloved finger to the glue. You should be able to feel adhesion without your knuckle sticking.
4. Apply a second thin, even coat to each surface. Wait until the second coat has an even, tacky finish (surfaces should not be visibly wet). Use the knuckle test again to gauge the optimum surface condition for joining the surfaces. Don't allow the layer to dry completely.
5. Immediately press both sides of the fabric together and apply pressure to the entire glued surface using a roller, rolling from the center out. This forces air bubbles out and meshes the two fabrics together. Use a lint-free towel to wipe up excess glue.
6. Complete curing time takes approximately 24 hours. If you must inflate a repaired chamber before that, it's best to minimize the pressure.
7. Be careful when rolling up a repaired boat for storage. Make sure drying is complete.

**Note:** Year-round use of 303 Protectant is recommended between uses, and before storage of your inflatable.