



# PROCALIBER<sup>TM</sup> PRODUCTS

Advanced, High-Tech Solutions for Surface Repair



## Plumbing Fixture Surface Repair Kit

Light-Curing Acrylic (LCA) Gel

### Directions for Use

#### Prepare the Damaged Surface for Repair

1. Tape off damaged area with masking tape.
2. Lightly sand the damaged area **ONLY**.
3. Clean the damaged area to remove any dust or loose material. Acetone (fingernail polish remover) and alcohol (purchased separately) are preferred cleaning agents (use appropriate gloves and eye protection). Surface must be completely dry and dust free before applying Acrylic Paste. For deeper chips, it may be necessary to use a hair dryer on the damaged area after cleaning to completely dry it.

#### Apply the Acrylic Gel

Remove syringe cap. Install applicator tip onto syringe by removing syringe cap and screwing on tip until secure. Check color of gel against your surface first by applying a small amount of gel onto wax paper or cardboard and use the curing light to dry it. Then compare to surface color around the area to be repaired to ensure a match.

4. Apply sufficient Acrylic Gel to completely fill damaged area. Do not overfill, as this will create additional sanding and time to complete repair. Do not allow air bubbles to form. If bubbles do appear, stir or pop bubbles until they disappear.

**Note:** If you have a deep repair (more than 1/16" deep), fill and cure the damaged area in shallow layers, one layer at-a-time. This will allow the light to penetrate the acrylic and cure it fully before it is completely filled. Test each layer for hardness before adding more material.

#### Apply Curing Strip

5. Apply clear Curing Strip (provided) to completely cover Acrylic Gel. This will help to limit the tackiness of the cured repair and can level the repair material before curing.

6. Use craft stick (provided) over top of Curing Strip and Acrylic Gel to level off the gel and help fill damaged area completely. This will help to provide a level surface and prevent too much overfill, decreasing sanding time as a result.

#### Cure the Repair Area

7. Turn on the LED Curing Light (included). Hold the beam 1/2" above repair surface for 3 minutes for small repairs (1/2" in diameter), and 3 to 5 minutes for larger repairs. Occasionally move beam around outer edges of repair until surface is completely hardened. Test for hardness by pushing down on curing strip with craft stick. If it sinks into the repair material, cure with the light until it has completely hardened.

**Note:** An incandescent, compact fluorescent or halogen desk lamp can also be used to help cure Acrylic gel. Place lamp head 2" directly over repair surface for 10 minutes.

It is normal for some sticky residue to remain on the surface after it has completely hardened. This should be removed with acetone, alcohol (purchased separately) or some of the Polish Paste included in the kit.

#### Sand

Remove Curing Strip (should come off easily - if it pulls up the gel, apply more light until fully cured)

8. **Lightly** sand the repair area using the sandpaper (provided). Do not use any other sandpaper or abrasives to sand repair. Repair area should be level with surrounding surface and smooth to the touch when completed. Be careful to **NOT** sand/scratch surrounding surface.

#### Polish

9. Use the Polish Block (included) and follow the 4 steps as printed on each side in order.

10. Apply polish paste (included) to acrylic repair area. Using the microfiber buffing cloth (included), rub the polish on the repair area. Polish to desired finish.

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