

## Plastic Boat Repair Instructions for building up skids and thin areas.



Basic tools needed for repair.



Using a clean paint scraper, scrape the boat surface that will be welded. This will remove oxidized plastic on the surface.



Select a plastic welding rod that matches the plastic and the color of the boat. The rod must be made out of the same material as the boat. Using a clean paint scraper, scrape the welding rod surface that will be welded to the boat. This will remove oxidized plastic on the welding rod.



Set the heat gun to the pre-programmed setting for welding, in this case HD-PE plastic. Boat thermoplastic varies between manufacturers.



Once the heat gun has reached set temperature, tack weld the welding rod in place. Push down on the rod as it heats up. The heat gun should be moved up and down so that you heat the rod and the boat at the same time.



In the above photo the welding rod has started to bend because it has been heated up. Continue pushing down on the rod in order for it to create the tack weld.



Insert the heat gun between the rod and the boat as shown. Using the hand roller firmly press down as you push the roller towards the heat gun. Slowly move the heat gun backwards while pushing down on the roller and moving it towards the heat gun.



590 Fish Road, Tiverton, RI 02878

800-289-7505

www.malcomheatguns.com

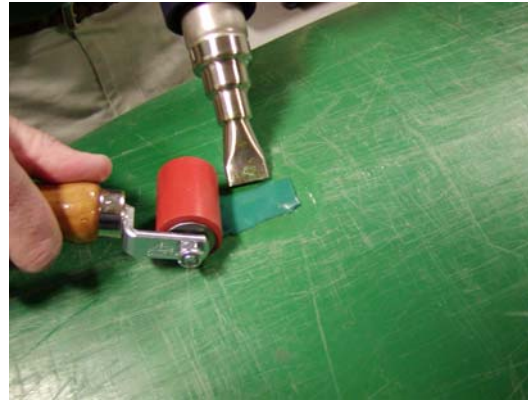


Firmly press down on the hand roller working it back and forth making sure to work the edges. Look for squeeze out along the edges. This action creates the weld. Pressure is very important when welding.



A proper weld will show a melted bead or plastic on both sides of the welding rod. If you move too slow you will burn the plastic, if you move too fast you will not see the bead and you will have a less than ideal weld. Work the roller along the edge of the weld area while heating it up to smooth out the edges.

When you have finished welding, using the cutters, cut the welding rod as close as you can to the surface.



Work the roller along the edge of the weld area while heating it up to smooth out the edges and fare it into the surface.



When completed you can either leave it as it is or scrape and grind it down further as desired.



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### Welding Rod Colors Available

Material is precut in 48 Inch Lengths

22MM X 2 MM Price Per Pound = \$40.00

8MM X 2 MM \*Special Order/Minimum Order is 5lbs = \$200.00

Approx. Feet Per Pound = 22MM X 2 MM = 36 feet

8MM X 2 MM = 120 feet

**HDPE Red**  
 PWC1 22MM X 2 MM  
 \*PWC1-8 8MM X 2 MM\*



**HDPE Beige**  
 PWC2 22MM X 2 MM  
 \*PWC2-8 8MM X 2 MM\*



**HDPE Blue**  
 PWC3 22MM X 2 MM  
 \*PWC3-8 8MM X 2 MM\*



**HDPE Green/Emerald**  
 PWC5 22MM X 2 MM  
 \*PWC5-8 8MM X 2 MM\*



**HDPE Green/Blue**  
 PWC6 22MM X 2 MM  
 \*PWC6-8 8MM X 2 MM\*



**HDPE Yellow**  
 PWC4 22MM X 2 MM  
 \*PWC4-8 8MM X 2 MM\*

