

# DC-10

## STRUCTURAL REPAIR MANUAL

### VOL. II

	Types of Resin System	Applicable Catalyst(s)	Parts by Weight Catalyst to Resin	Pot Life
R R R	Hetron 92 Coldset	Cobalt Drier 6% Cobalt Napthanate and DDM Catalyst	(0.17 to 100) (1 to 100)	20 to 30 minutes
	Hetron 92 Heat-Cured	Benzoil Peroxide Paste	2 to 100	6 to 8 hours
	Epon 828 Coldset	Hardener 956	8 to 100	20 to 30 minutes
R	Epon 828 Heat-Cured	Epolite 2323	17 to 100	6 to 8 hours
R	#156 Part A	Part B	6 to 100	30 minutes

Mixing of Resins  
Figure 2

#### 5. Pressure Application Methods

**NOTE:** Repair of reinforced plastic parts requires the application of pressure to repair area. Proper application of pressure assists in affecting a good bond and maintains the contour or alignment. Two methods of applying pressure are recommended.

##### A. Vacuum Bag Method

- (1) Place repaired part in vacuum bag.
- (2) Arrange bag so that as depressurization occurs the resultant external pressure will not bridge the bag.

**NOTE:** A minimum of 12-psi (24 inches of mercury) vacuum pressure is required to remove air from the bag.

- (3) Hand squeegee the bag and laminate to remove any excess resin or pockets of air.

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