



CREST INDUSTRIES, INC.
1337 King Road, Trenton, Michigan 48183
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Automotive Specialty Chemicals

GENERAL INSTRUCTIONS

Stock No. CE-RL, RED LINE

Work Time: 7 minutes
Sand / Paint Time: 30 minutes

**Two-component, rigid, multi-task repair epoxy
specially formulated for SMC, fiberglass and
other rigid plastic repair and sealing**

Preparation of GF-21 Applicator Gun and Cartridge

1. GF-21 plunger rods should be fully retracted. To release rods, hold gun by back handle, press thumb lever and pull back on knob.
2. Prepare cartridge for loading by removing cover from nozzle side of cartridge and snapping off end cap.
3. Load cartridge into gun. Make sure tab at front of cartridge is properly inserted in slot at front of gun. Prior to attaching static mixer nozzle, dispense a small amount of product to be sure both sides flow evenly. To stop dispensing, release pressure by pressing thumb lever.
4. Install static mixer. Dispense a short bead until color is uniform. Dispose of this bead. Product is now ready for application.
5. When application is complete, leave mixer nozzle installed on cartridge and hang (nozzle-down) on Stock No. WAWR – Adhesive Wall Rack. Use a new nozzle for next application.
6. Never attempt to force material through a blocked cartridge opening or a used nozzle.

**STORE CARTRIDGES AT 65°F TO 95°F (18°C TO 35°C).
SUBSTRATE TO BE REPAIRED SHOULD BE 70°F (21°C) OR ABOVE.**

*** SEE REVERSE SIDE FOR DETAILED PLASTIC REPAIR PROCEDURE ***

**RED LINE RIGID
PLASTIC (SMC, FRP, FIBERGLASS)
REPAIR PROCEDURE**

1. Clean front and back side of damaged area thoroughly with BCS – Car Wash Soap. After drying, clean with ASX / BSX – Super Solv (take care to avoid exposing damaged edges / open pores of fiber-reinforced plastics to solvents).
2. Using a 36 grit grinding disc, enlarge / bevel and soften edges on front side of area to be repaired to increase bonding surface area.
3. Scuff repair area and surrounding surface with 80 grit sandpaper.
4. Blow off area with clean, compressed air. **Use no solvent.**
5. On cosmetic repairs, it may be necessary to install 2" paper tape (RPT) on the back of repair to act as a temporary dam. Major repairs may require a backer panel, which may be bonded to the backside of the repair area with Red Line Epoxy.
6. Prepare Red Line for dispensing per "GENERAL INSTRUCTIONS."
7. For major repairs requiring a backer panel, sand backside of repair area (where backer panel is to be bonded) with 80 grit sandpaper. Blow off with clean, compressed air. Bond backer panel to backside with Red Line and allow to cure for 30 minutes before proceeding to step 8. Cosmetic repairs do not require a backer panel and should proceed directly to step 8.
8. Fill front side of repair area until slightly overfilled to provide material for sanding.
9. After 30 minutes, sand to contour with 80 grit on DA sander. Finish sand with 150 or finer grit. Crest Skim Coat (BSC) may be used as a final surfacing coat if required for minor imperfections.
10. Prime with 2 coats Crest Ure Prime (Stock No. BUP), two-part urethane primer catalyzed with Crest Urethane Primer Activator (Stock No. BUPA). Follow directions on primer / activator labels. After sanding, if any SMC or repair material is exposed, re-apply primer or apply a coat of sealer prior to basecoat application. Follow paint manufacturer recommendations.
11. Top coat per paint manufacturer's instructions.

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TYPICAL PHYSICAL PROPERTIES

Adheres to plastic, metal, aluminum, SMC and fiberglass.

Work Time: 7 minutes

Sand / Paint Time: 30 minutes

Tensile Strength: 2,527 psi

*** Lap Shear: 838 psi**

*** Aluminum to aluminum**