

## Repairing a tear, gouge or rip in an industrial tire – NOT a Puncture

Gouges in the side wall of industrial tires can dramatically reduce the working life of the tire. The rubber is the protective layer that prevents side wall punctures caused by sharp objects commonly found in industrial sites. Operating heavy machinery with this type of tire damage is often an OSA or MSHA violation and they will insist the tire is replaced or sent for repair. Eli-Flex should only be used to repair slow moving off road tires. Consult your tire expert if you are unsure.

<p>1 Deep gouges to the side of a large off road tire are often an OSA or MSHA violation.</p>	<p>2 The steel radials are exposed to moisture which causes them to corrode, dramatically reducing the working life of the tire</p>	<p>3 Skive out the rubber around the rip or tear. Be careful not to damage the steel radial of the tire with the blade</p>
<p>4 Grind the damaged area using a rubber grinding disk like the Rubber Exterminator. It is imperative you get a rough texture to allow for good adhesion.</p>	<p>5 Paint the damaged area with Eli-Bond FR704 adhesion promoter. Allow to dry until it is very "finger tacky". Don't apply FR909 to soon. You will trap solvents which will reduce the bonding strength</p>	<p>6 Open Eli-Flex FR909 kit, remove the spine and mix the two components together for 2-3 minutes or until warm. See "Six Easy Steps to Belt Repair" for more detailed instructions.</p>
<p>7 Cut open a corner of the bag and apply a liberal amount to the center of the gouge. You have 20-30 minutes of working time.</p>	<p>8 Use your spatula to force the Eli-Flex into the gaps by working from the center outwards. This will help reduce air entrapment and bubbles forming.</p>	<p>9 Allow 8 hours for Eli-Flex to cure. Buff as needed. See Tech Specifications for curing time at varying temperatures</p>