

MANUAL - EN

HBC system®

System B1
**Leather, Plastic and
Vinyl Repair System**
Part no. 525



System name	B1 – Leather, Plastic & Vinyl Repair System
Part no.	525
Dimension	56x56x15 cm
Modification	Nov-20
Warranty	2 years
Power	220 V

Product description

System B1 is the complete solution for repairing plastic, leather and vinyl upholstery as well as other interior and exterior parts. HBC system B1 is a glue system designed for the repair of scratches and damages in plastic, leather and vinyl. It makes it possible to repair hard and flexible plastic, both interior and exterior parts, as well as leather and vinyl components. The system contains all the required tools and adhesive materials to complete the repair from start to finish.

System B1 contains a complete assortment of adhesives ranging from specially developed hotmelt with fine structure to soft, flexible, or hard chemically activated bumper-adhesive for dashboards and glass fibre boxes on caravans and lorries. Plastic, Leather, and Vinyl System B1 also contains cleaners, primers, and reinforcement material. Copy the structure to top off the repair for a perfect finish!

CONGRATULATIONS!

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Dear user,

we hope that you will achieve great pleasure out of your new HBC system. We recommend that you go through a course and study the manual thoroughly before you start using the system. When used properly the system enables you to carry out repairs of an extremely high quality.

We would like to hear about your experiences with the system. A few words concerning the things that has made an impression on you - positive or negative - would be of great help to us in our efforts to improve our products to an even higher standard. If you are in any kind of doubt or in need of additional products your distributor will assist you with further advice.

If you have any other types of questions we refer to our hotline +45 7022 7070.

Thank you.

HBC System B

Copying of Structure

Start by cleaning a small area of the object to be copied using Vinyl Prep. Remember to dry the area with a heat gun. Then Mouldmaker is applied directly to the object and spread to an evenly thin layer using the palette knife.

A heat gun may be used to accelerate the curing time of the copy.

After curing, the copy is carefully removed and the area is cleaned using Vinyl Prep. It is recommended to use some kind of powder on the surface as this allows the iron to glide more readily. It is a good idea to save the copy made as it may be reused several times.

As the copying leaves no marks, this technique can be used on all parts.

REMEMBER TO USE A SUITABLE RESPIRATORY PROTECTIVE DEVICE, GLOVES AND SAFETY GLASSES.
THE WORK AREA MUST BE PROPERLY VENTILATED.

Vinyl Repair (B1)**B1.1**

Clean the area to be repaired thoroughly using Vinyl Prep. Thanks to its special properties, Vinyl Prep both cleans/degreases and softens the vinyl, thereby preparing the area for the subsequent application of paint. Vinyl Prep is partly water-based. For that reason, the area cleaned must both be wiped off with a cloth and dried with a heat gun before painting.

The softening properties of Vinyl Prep make it an excellent agent for preparing those damaged parts on dashboards that can be heated back into position.

Fill the hole with B Compound. Avoid overfilling the hole. Carefully scrape away any excess material. The casting piece is placed on the area to be repaired. Apply the iron for 5 seconds at intervals of approx. 3 seconds.

Fix the casting piece by pressing it with the cooling block.

Check that the B Compound is properly cured. The compound is somewhat transparent when cured properly.

B1.2

When a satisfactory repair result has been achieved, the area is cleaned thoroughly using Vinyl Prep. The work is completed by spray painting the area with the right colour. See next page.

Stressed Vinyl**B1.3**

Clean the area to be repaired thoroughly using Vinyl Prep.

B1.4

Cut a piece of fibre glass mat somewhat larger than the area to be repaired.

B1.5

Use the tip of the iron to fix the mat. Then seal the mat along the edge of the hole.

B1.6

The area is filled with B Compound. Make sure to work the B Compound well into the mat. Be careful to scrape off any excess material before placing the casting piece on top. Use the iron with caution for curing. Fix the casting piece by pressing it with the cooling block.

B1.7

Clean the area using Vinyl Prep before colouring the area as described on next page.

Vinyl Colour

Use the colour chart to find the colour best matching the original. Mix the colour according to the formula manual. The formula manual contains two columns where the left column provides approx. 1 litre of paint. If less than 1 litre is required, the decimal point is moved one or two places to the left. The weight values in the formula manual are accumulated. This means that the scales should not to be reset for each colour.

If you are lucky, one of the spray can vinyl colours will match perfectly.

Mix the colours thoroughly and compare the resulting colour with the original by stippling/spraying a sample on the original. The colour must be allowed to dry before you can tell, as it changes when dry. Evaluate the colour carefully. Usually, the colour will have to be adjusted - sometimes more than once. Check also that the colour binds correctly. Allow it to dry well and then try to scratch it.

When the colour matches, the gloss may require some adjustment:

Low Lustre provides a mat finish

Satin Gloss provides a silky finish

High Gloss provides a glossy finish

The gloss adjusters can be mixed with the colour (up to 50 % - pay attention to covering capacity) or they can be used for subsequent finishing. Note: If the colour is to be very lustreless, numerous thin layers must be applied, allowing each layer to dry for a few seconds. Colour tends to become glossy if it is applied in one thick layer no matter how much Low Lustre added. The gloss adjusters can also be used to stretch the colour if you are running low.

Before application, the vinyl must be cleaned/softened using Vinyl Prep. Remember to dry the area with a heat gun as Vinyl Prep is partly water-based. If when applying colour the airbrush splutters, the paint should be diluted a bit with 1005 Thinner

(never use the type available from DIY markets).

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Leather

If possible, the leather's sensitivity to heat should always be tested in a non-visible place.

Reinforce the crack/hole by gluing a piece of fibre glass tissue or linen sheeting underneath the leather using A Stitch. Fill the hole with B compound before placing the casting piece on the area to be repaired and curing this with the iron. Fix the casting piece with the cooling block.

Mix the colour (vinyl colour, see page 5).

Clean the leather using Leather Prep. Note! Always carry out a test first in a non-visible place. Most leather types are treated with some kind of coating. Leather Prep removes this coating (the colour changes a bit too; it is therefore important to start by mixing the colour) and primes the leather for painting. Allow the leather to dry before painting.

The vinyl colour will not bind as homogeneously to leather as to vinyl, which means that there is a risk that vinyl colour will crack when used on leather, especially if a relatively thick layer is required. To avoid this, a "suitable" - as it says on the label - quantity of Leather Flex should be added to the vinyl colour.

10 % is the absolute maximum, but far less will do the trick. You should also be aware that when adding Leather Flex, the drying time for the colour increases significantly and makes the colour a bit sticky.

Once the colour is dry, it is important to remove any excess colour with Leather Conditioner, which also provides an excellent finish.

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Dashboard / Centre Console / Mobile telephone holes

B3.1

Fill the holes / the scratch with B Gel to surface level and activate the gel using the B Activator. When the gel is dry (the B gel becomes white on drying) the area is sanded with sandpaper (grain size P240) until the area repaired is level with the surface.

Note!

B3.1 is repeated if the repair result is not satisfactory at this stage. Any irregularities are filled, and the area repaired is then cleaned using Vinyl Prep and dried with a heat gun.

B3.2

Use texture spray - with the right touch - on the area repaired until the desired finish is achieved. Allow the area to dry or use a heat gun to speed up the process.

Note!

The texture spray finish can be improved by preheating the can.

B3.3

If necessary a couple of "leather lines" can be drawn in the area repaired with a suitable tool such as the end of a small brush shaft.

Sand the area carefully again with sandpaper if necessary (grain size at least P800).

Colour the area as described on page 5.

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Dashboard / Centre Console / Mobile telephone holes / B gel + Activator

B3.4

Make a copy of the structure in an undamaged area.

Spray B Activator on the area to be repaired and apply B gel to the holes. Place the copy over the B gel together with a cooling block for approx. 5 minutes.

Remove the copy carefully and sand the area with sandpaper (grain size P240/800) along the edge until the desired finish is achieved.

Note! B3.4 is repeated if the repair result is not satisfactory at this stage.
Any irregularities are filled, and the area repaired is then cleaned using Vinyl Prep and dried with a heat gun.

B3.5.

Colour the area as described on page 7.

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Repair of Plastic Bumpers · 2K plast Rigid

B4.1

The synthetic material is cleaned carefully using soapy water.
If the parts are distorted, they must be heated to eliminate any tension.

Note! Be careful not to overheat the parts.

B4.2

The place to be repaired is cleaned on both sides (if it is a hole) using Plastcleaner.

B4.3

The place to be repaired is sanded to provide the outside face of the hole with a wedge shape. Use sandpaper with grain size 60-80. A knife can be used with caution. Remember to sand the area (grain size 120).

Note! If the damage is a crack, a hole is drilled at the end of the crack.

B4.4

The place to be repaired is sanded on both sides with sandpaper (grain size 120). (Any dust must be removed).

B4.5

The place to be repaired is cleaned again on both sides using Plastcleaner. The area must be allowed to dry for approx. 10 minutes.

B4.6

Primer: A thin layer of plastic primer applied on both sides.
The area must be allowed to dry for approx. 10 minutes.

B4.7

2K Plastic Rigid is applied with a gun and mixing tube.
Can be levelled using a palette knife.
Large cracks and holes are reinforced with reinforcement plates or tissue.

B4.8

Allow the object to dry (the process may be accelerated by heating the object to 70-80° C. Care should be exercised!).

Keep an eye on the object when heating it, as it may distort.

B4.9

Once the object has cooled, it is ready for sanding. Sanding must be carefully done to achieve the right finish as any defects will show in the final result.

For the finishing sanding before priming, grain size 240/800 must be used.

B4.10

Priming is a two-step process. Start by heating the object until it is hand warm. Then apply a uniform layer of Primer, clear on a sufficiently large area and allow the primer to dry. Then reheat the object until it is hand warm and apply thin layers of Primer, sanding, reheating the object between each layer. This procedure is followed until the entire repair area is covered with Primer, sanding. Finally allow the object to dry until it is ready for sanding. An infrared lamp may be used with care!

B4.11

You can choose between 5 different Spray Textures. Each can be used on its own or be combined with other types.

If a fine, medium or coarse structure is selected, a uniform thick layer must be applied. Heating the object before application may improve the result. More layers may have to be applied to achieve the correct finish. The object is finally sanded lightly.

If a fine flat or coarse flat is selected, these types must be applied in thin layers, heat being applied between each layer. Heating the object before application may improve the result. When the desired finish has been achieved, very careful sanding may be required.

B4.12

After applying structure, the area should be painted. This can be done by using vinyl spray paint or using an airbrush, mixing the paint yourself.

Either way, the paint must be applied in thin layers, possibly heating the object in-between layers.

Repair of Plastic Bumpers · 2K Plast Flex

B4.1

The synthetic material is cleaned carefully using soapy water. If the parts are distorted, they must be heated to eliminate any tension.

Note! Be careful not to overheat the parts.

B4.2

The place to be repaired is cleaned on both sides (if it is a hole) using Plastcleaner.

B4.3

The place to be repaired is sanded to provide the outside face of the hole with a wedge shape. Use

sandpaper with grain size 60-80. A knife can be used with caution. Remember to sand the area afterwards (grain size 120).

Note! If the damage is a crack, a hole is drilled at the end of the crack.

B4.4

The place to be repaired is sanded on both sides with sandpaper (grain size 120). (Any dust must be removed).

B4.5

The place to be repaired is cleaned again on both sides using Plastcleaner.
The area must be allowed to dry for approx. 10 minutes.

B4.6

Primer: A thin layer of plastic primer applied on both sides.
The area must be allowed to dry for approx. 10 minutes.

B4.7

2K Plastic Flexible is applied with a gun and mixing tube.
Can be levelled using a palette knife.
Large cracks and holes are reinforced with reinforcement tin or film.

B4.8

Allow the object to dry (the process may be accelerated by heating the object to 70-80° C. Care should be exercised!).
Keep an eye on the object when heating it, as it may distort.

B4.9

After cooling off, the object is ready for sanding. Sanding must be carefully done to achieve the right finish as any defects will show in the final result.
For the finishing sanding before priming, grain size 240/800 must be used.

B4.10

Priming is a two-step process. Start by heating the object until it is hand warm. Then apply a uniform layer of Primer, clear on a sufficiently large area and allow the primer to dry. Then reheat the object until it is hand warm and apply thin layers of Primer, sanding, reheating the object between each layer.

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If a fine flat or coarse flat is selected, these types must be applied in thin layers, heat being applied between each layer. Heating the object before application may improve the result. When the desired finish has been achieved, very careful sanding may be required.

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After applying structure, the area should be painted. This can be done by using vinyl spray paint or using an airbrush, mixing the paint yourself.

Either way, the paint must be applied in thin layers, possibly heating the object in-between layers.

Contact information:

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SAFETY

REMEMBER!

Be aware of your own safety. Handle these products with caution. Do not let children near any of the products. Always use the included mask and plastic gloves and safety glasses when using these materials. Wash your hands and arms thoroughly before eating, going to the toilet and after work if you have been in contact with chemicals. Make sure that the work area is well ventilated. Avoid direct skin and eye contact. Avoid inhalation. The products must not be placed in the vicinity of flames or other heat-generating appliances. Provide effective fire-fighting equipment - Fires are best extinguished with a dry powder extinguisher. Do not use water when flammable liquids are on fire.

Emergency instructions

Fire - Call the fire department.

Provide the following information to the emergency call center:

The address of the fire.

The products/things on fire and the scope of the fire.

Call an ambulance in the event of personal injury.

State your name and telephone number.

Stay by the telephone until the alarm message has been understood.

Notify the safety officer and the management.

Never use water for fighting oil or organic compounds on fire. Use a dry powder extinguisher to kill the fire. Remove all sources of ignition in the area to the extent possible.

Please refer to the safety data sheets for safety measures on the individual products.