

## Usage Instructions for Ceramic Pourable Compound (CPC)



**WARNING:** Remember to wear safety glasses and gloves when using resin compounds. Also, remember to wear a dust mask if sanding fiberglass. These instructions are intended for skilled professionals who routinely perform marine repairs.

### STEP 1 of 3: Prepping Transom for Arjay 6011

1. Access transom core in order to remove wood.
2. Remove all existing wood core from transom, **whether rotten or dry**, leaving an empty cavity.  
**Note: Any remaining wood will eventually rot, leaving voids in the transom after pouring.**
3. Remove all remaining attached wood by sanding down to bare fiberglass.
4. Use air to blow out the cavity and remove dust produced from sanding.
5. Wipe transom skins down with isopropyl alcohol or other solvent; this removes any oils or remaining dust.
6. Plug all holes leading into the transom cavity to prevent leakage of Arjay 6011 when poured.  
**Note: You may choose to leave engine-mounting bolts in place or other pass through fasteners in place during pour. These may be areas of leakage though if spacing is not appropriate. Plug gaps accordingly.**
7. Depending on transom skin fiberglass thickness, it may be necessary to support transom skins so that an even thickness is achieved throughout.

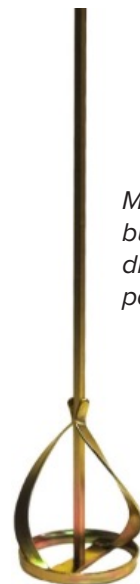
### STEP 2 of 3: Mixing Arjay 6011 with MEKP Catalyst

1. Using the table below, add the correct amount of catalyst (MEKP) necessary for the current pouring temperature of the material.

Catalyst	Lupersol DDM-9 (MEKP)

The chart shows the recommended catalyst addition for a working time of approximately **18 to 20 minutes**.

Material Temperature	% by weight	gm/gal	gm/5gal	cc/gal	cc/5gal	30ml shots
60-65° F	2.00	66	323	63	310	
65-70° F	1.80	59	290	57	279	
70-75° F	1.60	53	258	51	248	
75-80° F	1.50	49	242	47	232	
80-85° F	1.20	39	194	38	186	
85-90° F	1.00	33	161	32	155	
90-95° F	0.80	26	129	25	124	



Mix in bucket with drill operated paint mixer

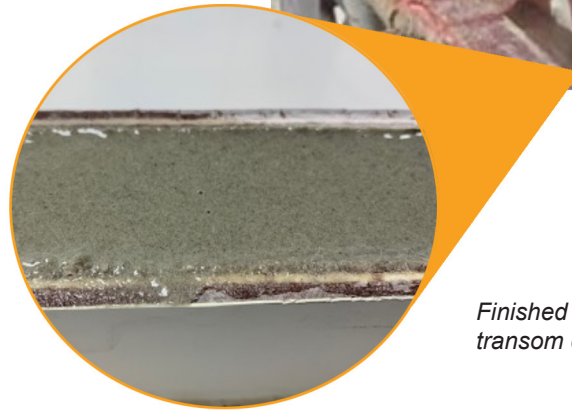
2. Mix catalyst in thoroughly for 1-2 minutes using a drill operated paint mixer (see above). Be sure to mix corners of buckets well.

### STEP 3 of 3: Pouring Arjay 6011 into Transom Cavity

1. Once mixed, pour buckets of Arjay 6011 into transom cavity, allowing the material to self-level. Fill to the top and scrape flat across top of transom.

**Note: Pour the whole transom in one pour to eliminate “weld lines” or seams that will occur between a cured pour and fresh pour. A weld line or seam between two pours can be a weak spot in the transom.**

2. Allow Arjay 6011 to cure for 24 hours before drilling holes or mounting an engine to the transom.



*Finished pour in transom cavity*

**SHELF LIFE & STORAGE CONDITIONS:** The shelf life of this compound (Arjay 6011) in unopened containers is six (6) months from the date of shipment to you from IPS Adhesives unless otherwise explicitly stated. Shelf life is based on a continuous, steady state storage temperature of between 60°F (18°C) and 80°F (27°C). Exposure to temperatures above 80°F (27°C) will rapidly reduce the stated shelf life of the product. Exposure to temperatures below 60°F (18°C) or above 95°F (27°C) will impact the product performance and viscosity.

**PRODUCT APPLICATION & USE:** To ensure consistent performance, product temperatures must be held reasonably constant between 60°F (18°C) and 80°F (27°C). Substrate preparation, adhesive/activator ratio, application temperature, humidity and a variety of other environmental and end user application factors are beyond the control of IPS Adhesives; therefore, the end user is solely responsible for determining whether the product is fit for a specific purpose and suitable for the user's product, design and final application requirements.

**NOTE:** This product is intended for use by skilled individuals at their own risk. Recommendations contained herein are based on information we believe to be reliable. The compressive strength has been documented by an independent testing laboratory to be several times that of plywood and 8 to 10 times that of PVC foam. In addition, its ability to conform to very complex geometry make it an excellent choice for critical applications such as coring transoms on power boat hulls, and repairing damaged or rotting

wood cored transoms. The properties and strength values presented are intended to be used only as a guide for selection for end-use evaluation. The ultimate suitability for any intended application must be verified by the end user under anticipated test conditions. Since specific use, materials and product handling are not controlled by IPSA, our warranty is limited to the replacement of defective IPSA products.

**Limited Warranty:** Seller warrants to the original Buyer of the goods that all new Seller goods shall be free from defects in material and workmanship for the published shelf life of the good. If any Seller good fails to conform to this Limited Warranty under normal use and storage conditions, and if the original Buyer complies with the terms of this Limited Warranty, then Seller will, without charge to Buyer, replace the nonconforming good.

This Limited Warranty shall not extend to, nor shall Seller be responsible for, damages or loss resulting from accident, misuse, negligent use, improper storage, or improper application.

THIS LIMITED WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES. SELLER MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, EITHER IN FACT OR BY OPERATION OF LAW, STATUTORY OR OTHERWISE, AND EXPRESSLY DISCLAIMS ANY WARRANTIES OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, ARISING FROM A COURSE OF DEALINGS, AND/OR FROM USAGE OF TRADE. SELLER SHALL NOT BE LIABLE IN CONTRACT, IN TORT (INCLUDING NEGLIGENCE OR STRICT LIABILITY) OR OTHERWISE FOR ANY SPECIAL, INDIRECT, INCIDENTAL, PUNITIVE OR CONSEQUENTIAL DAMAGES.