

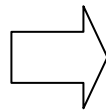


[Click to Website](#)

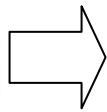
### SURFACE RENEWAL GUIDE - Applicable to models XO / XL / SL / GS



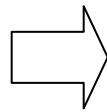
**Welding Kit Content**  
1) Welding gun  
2) Welding rod  
3) Scraper



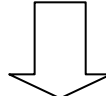
**STEP 1:**  
Welding Gun Settings  
Plastic Temp: 240-260°C  
Heat Temp: 250-280°C  
Injection Speed: 7 - 8



**STEP 2:**  
Clean damaged area.



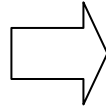
**STEP 3:**  
Pre-heat surface until it turns soft but not melt.  
Inject the melted plastic over the pre-heated area in consistent strokes at 3sec/50mm.



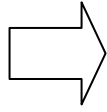
Heat from the welding gun should not be directed at the board at the same location continuously for more than 8 seconds to avoid any occurrence of de-lamination.



**STEP 4:**  
Leave it to cool for 3-5 seconds.



**STEP 5:**  
Scrap off excess with a metal scraper very quickly using a fast moving action.



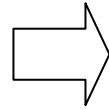
**STEP 6:**  
Surface is repaired with immaculate results.

[Click to Watch Video](#)

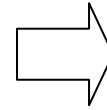
## HOLE REPAIR GUIDE - Applicable to models XP / XL / SL / GS



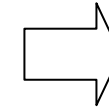
Step 1:  
Remove all debris  
before welding.



Step 2:  
Pre-heat area around  
hole and inject melted  
plastic into the hole.  
When melted plastic fills  
up the entire hole, apply  
pressure to flatten it.



Step 3:  
Leave to cool until  
melted plastic  
hardens and scrap  
off any excess  
material.

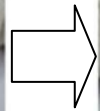


Repair is Complete!

## JOINING GUIDE - Applicable to models XL / SL / GS



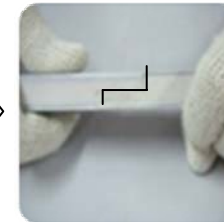
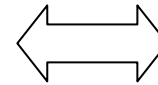
Step 1:  
Brush glue onto  
surfaces to be  
joined.



Step 2:  
Press both surfaces  
together firmly for 5  
seconds until an  
initial bond is  
obtained.

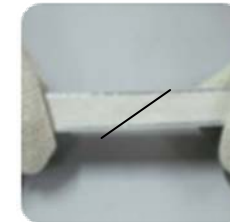


Step 3:  
Leave to cure  
undisturbed under room  
temperature for 12  
hours. Bond will be as  
strong as the core.



Option 1:  
Lap Joint

OR



Option 2:  
Diagonal Joint

[Click to Watch Video](#)

Note : Use TP Glue-WC for a watertight joint. Curing is necessary to achieve bond strength. Max Bending Stress at Joint for 17mm thk = 3.2mpa.