FLEX-MOLD

NON-SKID PATTERNS & RE-DECK

FLEX-MOLD...

20 years of application and over 60 patterns used successfully to help tool and production mold builders for Marine, Industrial, Aerospace, Transportation and Recreation.

BOAT YARDS...

make near-perfect repairs to molded-in, non-skid patterns. No more sanding out smooth areas or trying to cover it up with carpet or some other item.

MOLD BUILDERS...

add non-skid patterns to plugs and molds, repair production molds and parts accidentally damaged during construction.

"ONE OFF BUILDERS"...

now have a choice of patterns more attractive than sprayed or rolled-on sand grit surface.

gibcoflexmold.com

Notes

A message from the Founder...

Dear Friend:

Thank you for your interest in our products!

FLEX-MOLD is dedicated to developing products and methods for help in solving some of the problems associated with the tooling, production and repair of non-skid deck areas of boats.

As you know, the deck area is some of the most exposed and used areas of a boat. This is the surface that your customers see, touch and care about for appearance and function.

Consideration for your choice of non-skid patterns should include some of the following:

1. Ability to function as a “limited slip”surface
2. Appearance
3. Cleanability for customer
4. Feel on bare feet
5. Repairability in factory and in field
6. Wax buildup in mold in patterns with sharp points or little pits as with sand or roll on patterns
7. Mold maintenance and repair
8. Ease of application to tooling
9. Will patterns appearance be consistent from part to part and from boat to boat? A spray or roll on application will change with personnel change.

FLEX-MOLD has successfully produced over 60 patterns that mold makers have been using for the last 20 years. These patterns are produced for repair as well. The flat top design helps prevent wax buildup. Spacing is such that a scrub brush will clean them easily. Our designs incorporate ample draft to provide for easy release of parts and the “limited slip” characteristics are good with shoes or bare feet.

FLEX-MOLD will assist your personnel in tooling application, in factory repairs and your dealers with warranty repairs.

Your company’s main objective is to “Sell” boats. Production of those boats is a necessary hardship, at its best. Our objective is to help you solve some of your production problems.

We have more new patterns and products under development for your benefit.

We look forward to working with you.

Thanks again,

Gibbs Slaughter Jr.

This catalog is dedicated to the memory of Gibbs Slaughter 1939 -2013

FLEX-MOLD
NON-SKID PATTERNS & RE-DECK

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U.S. Patent #'s
5246642, 5462702, 5626802

Table of Contents

RE-DECK©

GIBCO FLEX-MOLD

Empowered by PATRICK

The award winning permanent non-skid repair solution

IBEX 2021 INNOVATION AWARDS WINNER

Our new peel & stick solution for repair and custom applications is now available!

What is Re-Deck?

Re-Deck peel & stick solution is a polyester resin-based flexible sheet, using our most popular male 100 series patterns. The sheet is about 1/16th to 1/8th of an inch thick. This sheet can be cut to shape with quality shears or a CNC machine.

This non-skid can be applied using our optional pressure-sensitive adhesive or by using your favorite epoxy for a permanent, true bond.

- Use on large and small repair applications
- Great for customizing a new deck
- Perfect for prototypes
- User can color match by spraying with gelcoat or paint
- Available in sizes 1'x1' to 4'x12'

Flex-Mold Re-Deck Tutorial Videos

Scan The QR Code For Links To Our Tutorial Videos

Making Re-Deck a Permanent Solution

True bond technology makes G4 a permanent solution for deck repair.
Apply polyester-based Re-Deck to any composite surface with epoxy, to create a permanent bond.

This material has the same properties as a molded non-skid and is more durable than an EVA foam non-skid solution.

Peel and Stick adhesive is not technically permanent. This solution is only permanent when adhered using epoxy resin. In order to get a permanent peel and stick solution using our adhesive, you must seal the edges with a polyurethane or gelcoat putty.

Customization

Sizing: Available in sizes 1'x1' up to 4' x12' depending upon pattern and builders' requirements.

Colors: Re-Deck can match your deck by applying a coat of paint or gelcoat to the surface after application.

Personalize: Customizable patterns are available upon request; send us your pattern, we'll make you a repeatable one.

Two options are available:
- **With the adhesive:** We have a high-quality adhesive that can be applied in-house.
- **Without adhesive:** For customers who prefer to apply adhesive or epoxy to the Flexmold.

FLEX-MOLD
NON-SKID PATTERNS & RE-DECK

G-4 Series

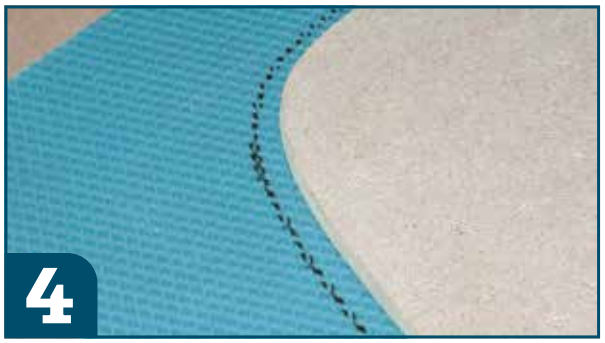
Premier Patterns for Application to Plugs When Multiple Pulls are Required

The G-4 Series is designed and manufactured with more robust material for plug applications where multiple pulls are desired.
The recent color change makes it easier for the mold makers to distinguish between the pattern on the plug and the tooling gelcoat being used to make the molds.

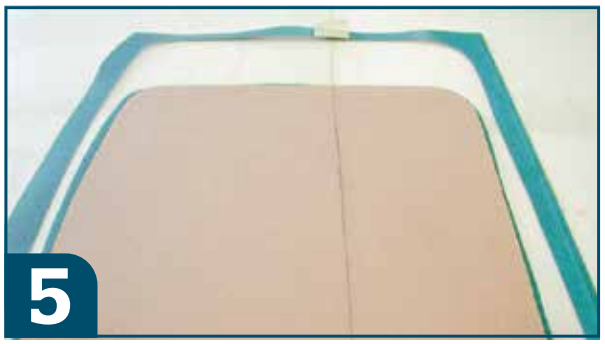
Cut a plywood or fiberboard pattern to exact size and shape required.

Apply double sided foam rubber tape around perimeter of pattern board.

Determine correct direction that the texture should run. Draw a line on pattern board and align with pre-determined mark on FLEX-MOLD. Place pattern board on FLEX-MOLD and press down to adhere.



Mark a border about 1 inch (25mm) larger than pattern board.



Cut FLEX-MOLD with scissors.

Apply clear packaging tape around border.

The reason for applying the clear tape is to prevent accidentally peeling up the backing paper at the joints which can contaminate the adhesive on the FLEX-MOLD.

Use a Flush Laminator Trim bit similar to this in your trim router.

Use router to trim FLEX-MOLD to precise size and shape of pattern board.

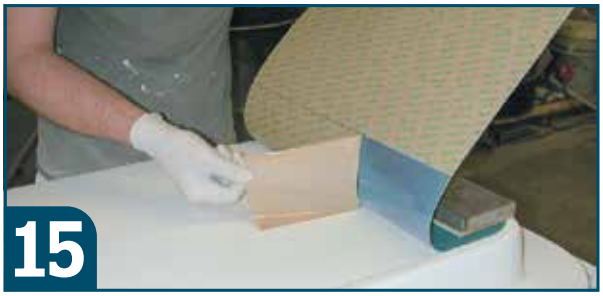
Use 80-100 grit sandpaper on a block to clean up edges.

Peel FLEX-MOLD from pattern board.

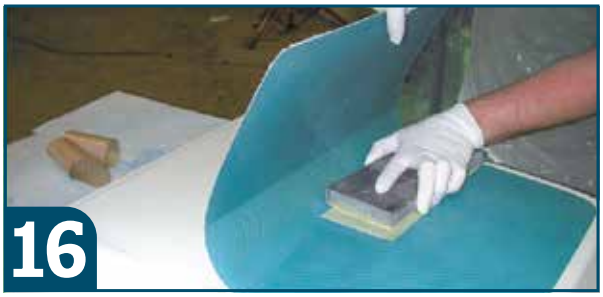
Pre-mark proper position of FLEX-MOLD with a pencil. Apply adhesive promoter (like 3M 94 Tape Promoter) to the plug and allow to flash off.

Be sure to clean any debris out of the spaces between the paper stripping. Position FLEX-MOLD on the plug and tape securely in place, leaving one end free. Lift free end and pull off one or two paper strips.

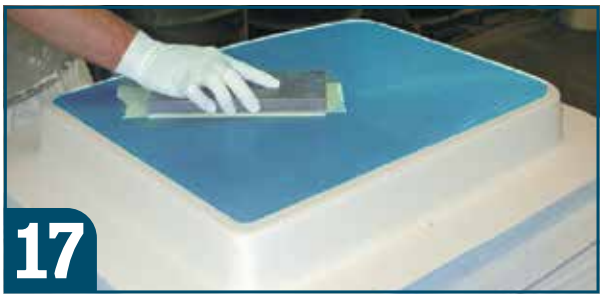
Use a heavy piece of steel with a thin foam padding glued to the bottom. Push and pull back and forth as you move forward being careful not to trap any air bubbles beneath the FLEX-MOLD. Using block instead of your fingers or hand will help avoid trapping air bubbles.



Remove masking tape used to hold FLEX-MOLD in position. Lift FLEX-MOLD and remove additional stripping.

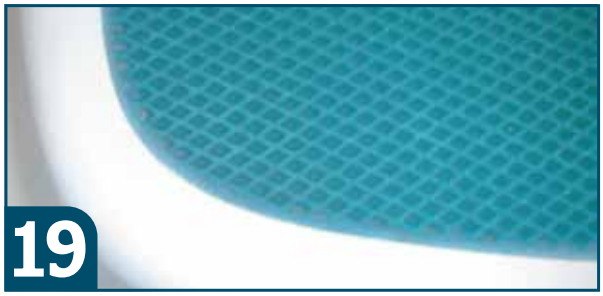


Make sure plug surface is clean and free of debris as you continue pressing FLEX-MOLD down. A piece of discarded paper stripping under weight will reduce friction.

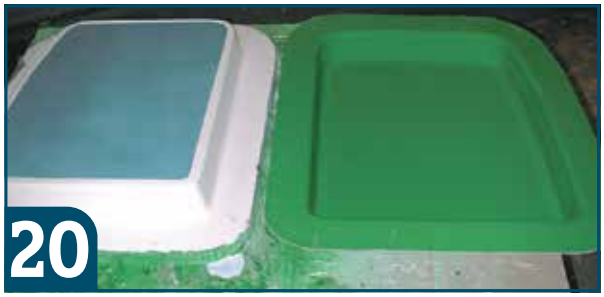


After FLEX-MOLD is completely down, pass block back and forth over it several times to aid adhesion.

One option to produce a finished edge is to use FLEX-MOLD Edge Tools. Wet sand using the FLEX-MOLD coarse grit edge tool with 80/100 grit.



Sand enough to produce a nicely tapered edge.



After applying a mold release system, lay up mold and separate from plug.

Finish wet sand edge in mold using FLEX-MOLD edge tool. Begin with 80/100 grit followed by 170/200 and 270/325 grit.

FLEX-MOLD Edge Tools

30° - 80/100 grit TLF 30
30° - 170/200 grit TLC 30
30° - 270/325 grit TLA 30
45° - 80/100 grit TLE 45
45° - 170/200 grit TLC 45
45° - 270/325 grit TLA 45

FLEXMOLD Edge tools are designed to create the transition between the smooth gelcoat and non skid areas. Available in 30° and 45° angles & 3 different grits.

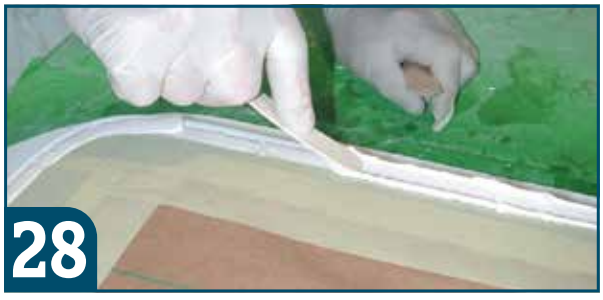
Clean mold and mask off non-skid area. Compound and polish edge and mold. Remove masking tape, clean, and apply proper release system.

Edge produced on part using FLEX-MOLD Edge Tools.

Another option for making a finished edge is to mask off the FLEX-MOLD and apply a filler material. First, mix filler compound and pour into a plastic bag.

Squeeze material into one corner of bag and cut corner off.

Squeeze bag and lay a bead of filler along edge.



Use a tongue depressor or similar tool to spread filler along edge.

After the filler has hardened a little but while still “green”, remove excess filler and clean up with acetone or other solvent.

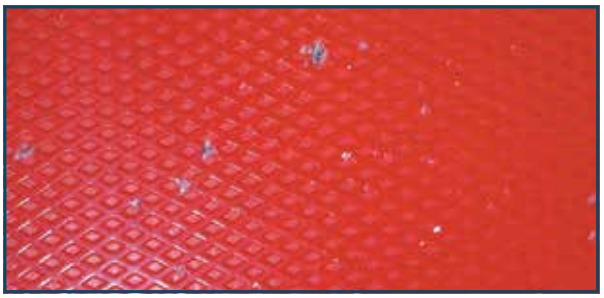
After a full cure, sand smooth with about 240 grit paper.

Finished appearance of edge of plug.

Appearance of edge on final part.

Important Information

To help prevent premature failure and chipping out on small part molds, be careful when applying the tooling gelcoat. If the first coat is applied too thick and recoated before air bubbles are allowed to gas out, the bubbles can lie just under the surface of a thin coating of gelcoat and may break through, cause a hook and pull chunks out of the mold.



Upon receiving FLEX-MOLD, remove from shipping container, unroll and lay on a flat surface. Weigh down with plywood to flatten out. If temperature is below 70°, allow FLEX-MOLD to warm before unrolling. **Any presumed factory imperfections must be reported within 24 hours of receipt of the FLEX-MOLD.**

AN Series

Non-skid and Textured Patterns for Plugs and Molds

Quick and Easy Apply Sheets

Adhesive Pre-Applied

Friendly to Environment

Available in sizes 1' x 1' up to 4' x 12' depending upon pattern and builders requirements.

General Information

Plug surface can have 220 grit scratch to a polished wax free surface for good adhesion. Bare wood must be sealed.

A water based release agent has been applied to the FLEX-MOLD. Its purpose is to provide some lubrication to aid smoothing down during application and offer added release protection. We recommend that you apply your own release over the entire surface.

Some vinylester gelcoats can affect the white rubber in our FLEX-MOLDS. An application of a PVA release system can help solve this problem.

We recommend that you pre-test your brand of gelcoat and release system.
We will not warranty FLEX-MOLD used with Vinylester gelcoats.

One pull is all that can generally be expected. Some have reported more. We believe because of the softness of the rubber and the fact that gelcoat shrinks down tightly, it will form thousands of little suction cups. If the FLEX-MOLD comes out with mold, it is easily peeled out. If mold seems more difficult than usual to separate from plug, use steady pressure and give the adhesive time to release.

Important Information

Bottom edge of FLEX-MOLD should be radiused into plug surface with any fillet material of your choice or you can sand a radius once the female mold is made.

WARNING!!! It is important to smooth edges or the result will be poor appearance of the part and chipping out of the mold.

AN Series Application Procedures

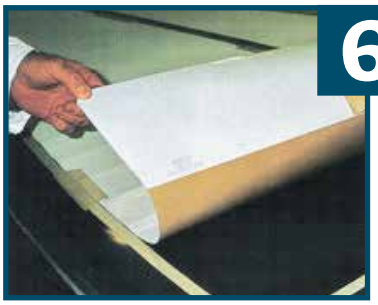
1 For a good degree of accuracy, cut FLEX-MOLD pattern from a plywood template.

2 After FLEX-MOLD pattern is cut, place on top of template or other appropriate fixture. Using no courser than 220 grit sand paper, block sand a taper or radius edge on FLEX-MOLD or use FLEX-MOLD edge tool. If you cut too much, fiber of the reinforcing material will show.

3 After sanding edge, clean sanding debris from FLEX- MOLD. Dampen cloth with acetone and wipe edge to help smooth rubber.

4 Turn FLEX-MOLD over and clean back side. Make sure gap between tape stripes are not contaminated with sawdust or other debris. Use no solvent.

5 On a clean and wax free plug surface, apply adhesive promoter like 3M 94 Tape promoter as directed. Let flash off.

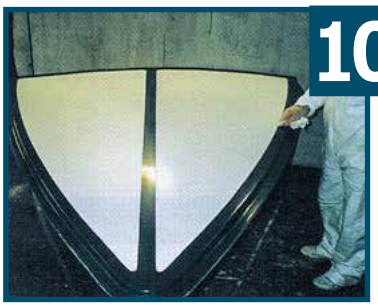


6 Place FLEX-MOLD into position and secure in place with tape. Lift one end and remove one or two strips of the release paper.

7 Smooth down FLEX-MOLD from inside toward outer edge in a manner as to not trap air.

8 Lift other end of FLEX-MOLD. Continue to peel off paper strips two or three at a time.

9 Smooth down FLEX-MOLD as you proceed. DO NOT PULL OR STRETCH FLEX-MOLD. This will hamper spot repair procedures of part or mold, should it ever be necessary.



10 Once FLEX-MOLD is in place, clean plug surface around edge with acetone to remove excess adhesive promoter.

Repattern/Repair Large Areas

1. Make necessary substructure repairs.

2. Sand off all existing texture (40 to 80 grit surface scratch). Mask off sanded area. Make sure border tape is wide enough to allow a 1/2” to 3/4” (12-19mm) overlap of the FLEX-MOLD to lay flat.

3. Make pattern of area and transfer to back side of FLEX-MOLD. Cut to shape, making sure to leave 1/2”-3/4” (12-19mm) border.

4. The background color of the area to be textured must be of like and even color. To achieve this, gelcoat should be thinned with appropriate thinner or styrene and sprayed on thick enough to give an even color. Let cure thoroughly.

*If *surfacing agent is used in your gelcoat, it must be removed by sanding, along with solvent wipe to assure a proper bond with textured coat.*

**A surfacing agent is a solution containing paraffin wax. When added to gelcoat or polyester resin, it will rise to the surface during cure cycle to seal off air. Exposure to air will prevent a complete surface cure. If no surfacing agent is used, the surface will remain slightly tacky in the shade and extremely sticky in the sun. Avoid exposure to sun during next step.*

5. Lay FLEX-MOLD in place to check fit, secure determined starting edge with tape. Check fit and make sure overlapping border lays down flat and is not held up by wrinkles in the tape or other objects. A seal must be formed around edge that will not allow air to bleed gelcoat down before it can cure.

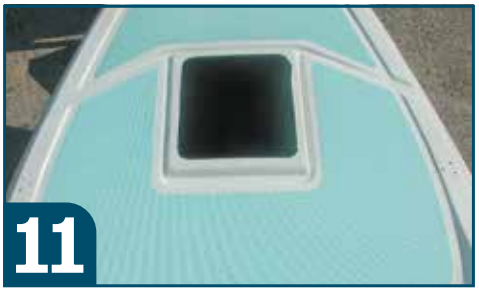
Note:
The FLEX-MOLD is coated with green polyvinyl alcohol (PVA) to serve as a release agent as well as a barrier coat that prevents a chemical reaction that will occur between the FLEX-MOLD and gelcoat, resulting in a distorted pattern.

6. Lightly sprinkle backside of FLEX-MOLD with talcum powder for a lubricant. Remove excess.

7. Prepare gelcoat by checking viscosity with a viscosity measuring cup. Gelcoat should run through a Zahn Cup #2 in 60-65 seconds and Ford Cup #4 in 40-45 seconds. Be sure to clean cup between each test.
Gelcoat may be thinned with some of the following products with varied results: Duratech Clear, Patch Boost, Patch Aid. DO NOT USE ACETONE. The gelcoat must be fluid enough to flow into the cavities of the non-skid pattern to avoid air entrapment. Also, thick gelcoat makes it difficult to squeegee FLEX-MOLD down level over large areas. Catalyze gelcoat cool enough to allow sufficient cure time to complete procedure.

8a. Hold FLEX-MOLD up and pull back to secure end. Pour enough gelcoat to start a wave in front of and across entire width of FLEX-MOLD as not to leave any air bubbles trapped. Use a stick as illustrated in spot repair #9 to push gelcoat up under FLEX-MOLD if necessary.

8bcd. Use a proper tool (squeegee, board, paint roller) to push along behind the FLEX-MOLD in a manner that will move a wave of gelcoat before the face of the FLEX-MOLD as it is lowered into the wave. Add gelcoat as needed and continue process across entire area.



9ab. Once FLEX-MOLD is down, start in the middle and push, with a squeegee, excess gelcoat out from under FLEX-MOLD. Squeegee across in all directions. Run hand over surface to feel out any high spots that will need to be squeegeed out. Use some of excess gelcoat to lubricate the squeegee it will slide easily. You may use acetone sparingly to wipe back of FLEXMOLD clean if you intend to reuse. Squeegee should be of adequate size for size of application, stiffened up to help apply even pressure across width of squeegee.

10ab. Let gelcoat cure and peel off FLEX-MOLD. Remove masking from around border. Sand and polish edges using graduated grit. Starting with 100, 220, 320, 500, then compound and polish.

11. Finished product.

The FLEX-MOLD can be used repeatedly as long as the PVA coating is intact. Once PVA has begun to come off the FLEXMOLD, wash remaining PVA off with water. Let FLEX-MOLD dry and reapply PVA with a spray gun by misting on about six coats, let dry thoroughly between each coat.

APPLICATION TIP

When practical, roll FLEX-MOLD on a tube and then unroll slowly to push wave of gelcoat along. Then Squeegee out.

Painted Non-Skid Surfaces

Polyurethane Paints

1. FLEX-MOLDS come with PVA already sprayed on them, an additional mold release such as Frekote applied on top of the PVA will be needed. This will keep the paints from sticking to the PVA.

2. Cut your patterns from the FLEX-MOLD, spray a heavy coat of polyurethane on to fill all the cavities. Allow to cure to about 80% (or until you can handle the FLEX-MOLD).

3. You are going to secondary bond the FLEX-MOLD to your deck. Put the FLEX-MOLD in place and tape down at the beginning point. Hold FLEX-MOLD up and pour enough polyurethane on surface to start a wave in front of FLEX-MOLD face. Use a proper tool (squeegee) to push along behind the FLEX-MOLD in a manner that will move a wave of polyurethane before the face of the FLEX-MOLD as it is lowered into the wave. Continue process across entire area.

4. Once FLEX-MOLD is down, start in the middle and push, with a squeegee, excess polyurethane out from under FLEX-MOLD. Squeegee across in all directions. Run your hand over surface to feel out any high spots that still need to be squeegeed out.

5. Let polyurethane cure and peel off FLEX-MOLD. Remove masking from around border. Sand and polish edges using graduated grit, starting with 100, 220, 320, 500, then compound and polish.

Epoxy

Use of epoxy is much the same as using gelcoat. If you are going to paint your epoxy, it is suggested that you use an epoxy close to the color of the paint that you will be using. This will allow for a longer lasting surface as the paint wears off, the underlying epoxy will be a close color match and it will not be as noticeable.

Endurance Technologies custom epoxy formulations for mold application achieve excellent impact resistance and little or no shrinkage. Endurance epoxies are compatible with all of the latest fabrics and cores. By using epoxy tooling systems you will have more durable tools with excellent thermal stability allowing for more parts out of the same mold.

Spot Repairs

This method can be used for repairing existing non-skid surfaces.

For Success:

- Apply Wax
- Apply Wax
- Apply Wax

Before You Start

1a. Apply wax in and around damaged area. Extend out several inches so excess gelcoat doesn't stick to surrounding surface.

1b. Buff out with a brush.

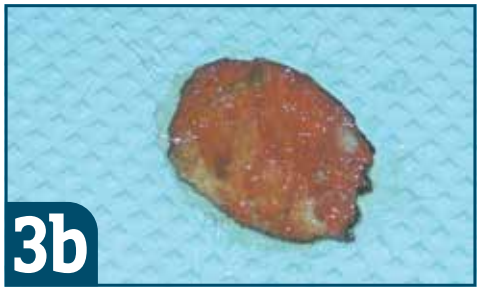
1c. Polish with a rag.
Note: A thorough and effective release is imperative.

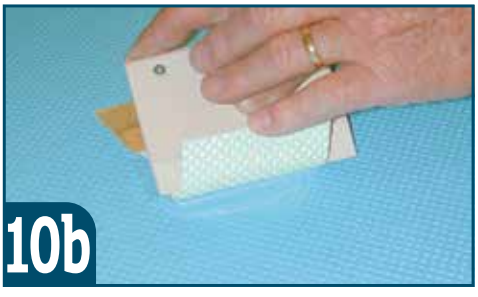
2. Rout out damaged area to solid material.

3ab. Fill area with appropriate filler and let cure.

4. Rout out again just below base of pattern to allow a second fill with color matched gelcoat.

5. Fill with color match and let cure.





6. With router cut raised portion of pattern down to its base around the outside perimeter. This will give you a depth gauge by which to rout and sand out the center of the damaged area.

7. Use a small block and 100 to 80 grit sandpaper to level out and cut proper depth of the damaged area.

8. Cut FLEX-MOLD large enough to leave at least 1” (25mm) or better overlap of repair area. Place over repair area and move around until you feel it mesh into existing patterns. When FLEX-MOLD is properly placed and depth of area is correct, you should be able to run your hand over FLEX-MOLD and it will feel flat and level, not being able to detect cut out area.

9. With FLEX-MOLD in place, tape down one edge to hold firmly in position. Place squeegee into position. Pull FLEX-MOLD back and pour gelcoat against FLEX-MOLD and with stick push it under and across full width as not to trap any air bubbles. Gelcoat may need to be thinned for proper repair.

10abc. Use moderate pressure on squeegee and push wave of gelcoat across and into repair area. Hold FLEX-MOLD up high enough as you proceed as to not cup any air in cavities of pattern.

11. Once FLEX-MOLD is down, drag squeegee over it, two or three times with firm pressure.

12. Let cure and remove FLEX-MOLD.

13ab. Use a piece of Formica, Plexiglas, hardwood stick and or blow gun to remove excess gelcoat from the prewaxed surface around the repair area.

14. If done properly, color match is good and the pattern blends itself to a good match up, a near perfect repair will result.

Epoxy and other two-part chemically cured materials can be used.

Many types of liquid wax or polymer release agents will work. Some waxes will yellow and should be removed with an appropriate solvent after repair is complete.

ANOTHER METHOD

When a section may not have a good straight edge, you can secure the FLEX-MOLD and start process in a more suitable place.

Press FLEX-MOLD down with a squeegee, apply gelcoat and start process.

After initial squeegee out, press squeegee down to hold a seal as you pull off the tape.

Start process again on remainder and finish.

Go back over and carefully squeegee entire area.

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The FLEX-MOLD can be used repeatedly as long as the PVA coating is intact. Once PVA has begun to come off the FLEX-MOLD, wash remaining PVA off with water. Let FLEX-MOLD dry and reapply PVA with a spray gun by misting on about six coats.

New tech foam patterns are not lasting and are not repairable.

Non-Skid Patterns

Your Pattern Source for Tooling and Repairs

Check with us before you do that new tooling repair. We are continually adding more patterns.

Negative/Positive Patterns

GF
Negative (female) produces **positive** pattern to repair or re-pattern existing deck.
Example: GFD 102 (negative or female part)

GF-N
Positive (male) produces **negative** pattern for new tooling or mold repair or re-patterning.
Example: GFD 102N (positive or male part)

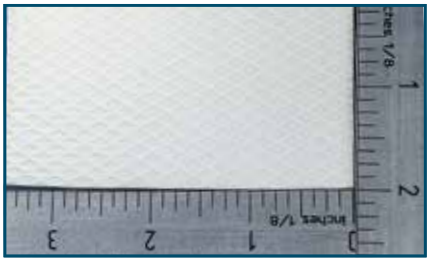
GF-A
Pre-applied adhesive (peel & stick) for surface application.
Example: GFD 102AN (male part with adhesive)

Spot repair will turn out well, provided FLEX-MOLD is applied properly.

Patterns:
102, 103, 106, 110, 115, 118, 313, 315 and 324

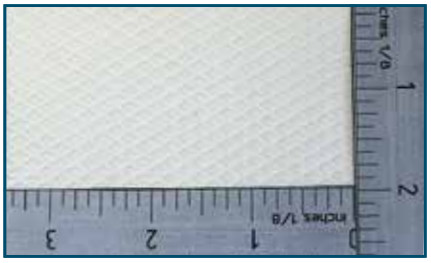
Due to inherent imperfections in all other patterns not developed by FLEX-MOLD, we will only warranty the 100 series patterns against defects in craftsmanship.

New patterns are being added all the time. Check our website for the latest additions!

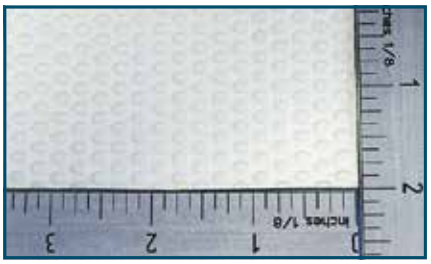


Part Number:
GFD 102 ®
GFD 102N ®
Max. Available Size:
4' x 12'

102 is the ONLY UL listed non-skid surface for marine applications



Part Number:
GFD 103 ®
GFD 103N ®
Max. Available Size:
4' x 12'



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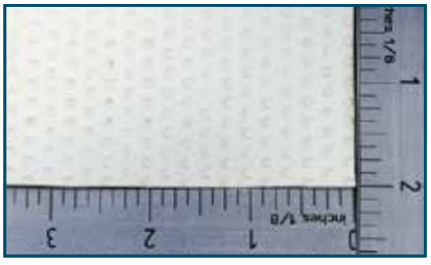
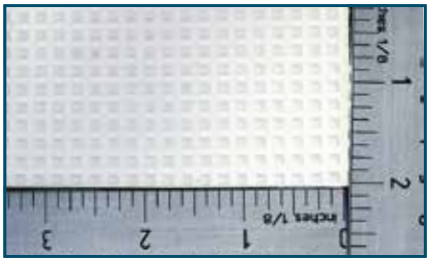
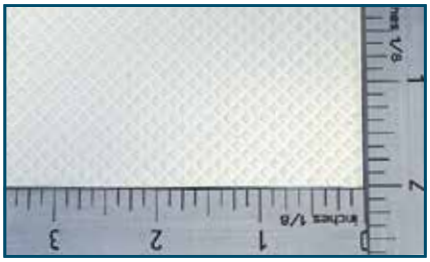
GFO 106 ®
GFO 106N ®
Max. Available Size:
4' x 12'



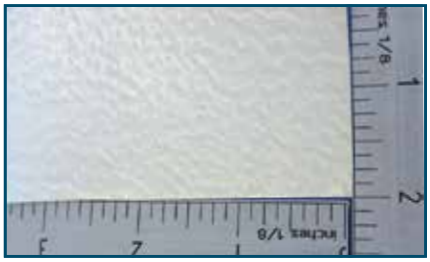
Part Number:
GFR 110 ®
GFR 110N ®
Max. Available Size:
4' x 12'



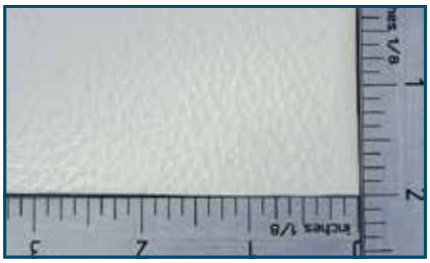
Part Number:
GFS 115 ®
GFS 115N ®
Max. Available Size:
4' x 12'



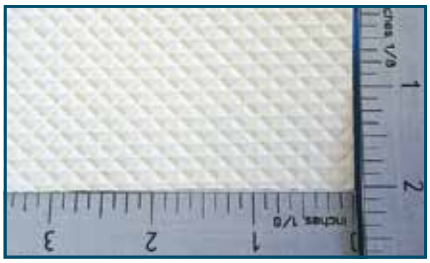
Part Number:
GFDS 118 ®
GFDS 118N ®
Max. Available Size:
4’ x 12’



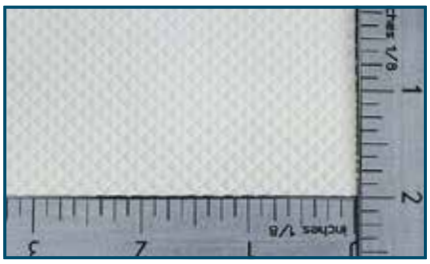
Part Number:
GFSR 305
GFSR 305N
Max. Available Size:
4’ x 12’



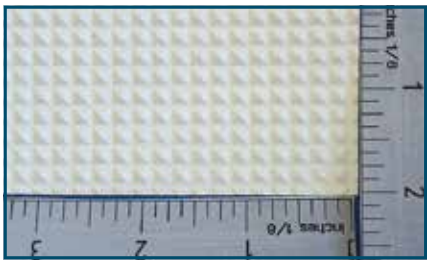
Part Number:
GFCD 202
GFCD 202N
Max. Available Size:
4’ x 8’



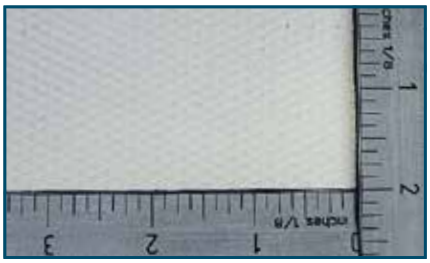
Part Number:
GFP 306
GFP 306N
Max. Available Size:
4’ x 11’11”



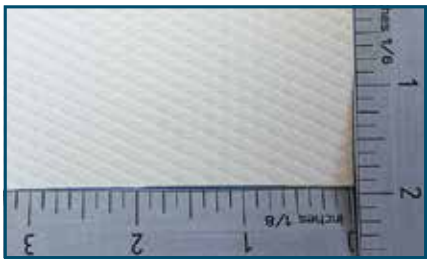
Part Number:
GFP 301
GFP 301N
Max. Available Size:
4’ x 12’



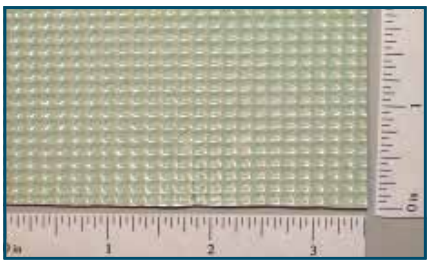
Part Number:
GFP 307
GFP 307N
Max. Available Size:
3’ x 12’



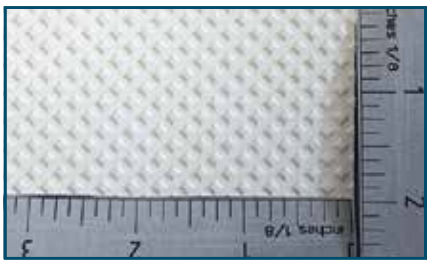
Part Number:
GFD 302
GFD 302N
Max. Available Size:
4’ x 12’



Part Number:
GFBLD 308
GFBLD 308N
Max. Available Size:
4’ x 12’

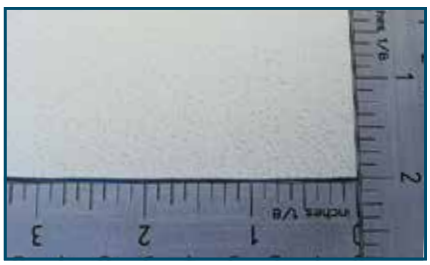


Part Number:
GFR 303
Max. Available Size:
45” x 7’9”

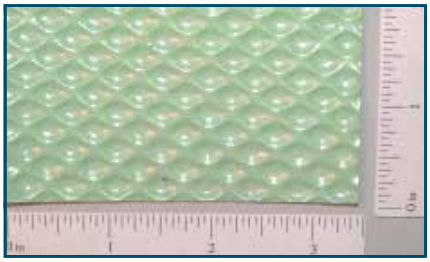


Part Number:
GFBLA 309
GFBLA 309N
Max. Available Size:
3’11” x 9’10”

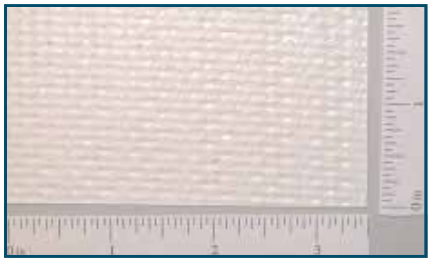
Part Number:
GFD 304
GFD 304N
Max. Available Size:
3’10” x 11’11”



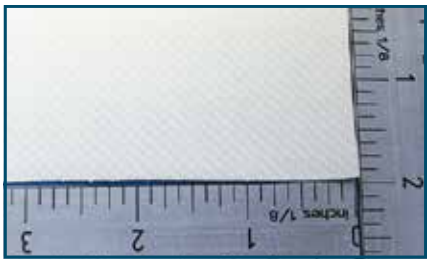
Part Number:
GFSS 310
GFSS 310N
Max. Available Size:
3’10” X 7’10”



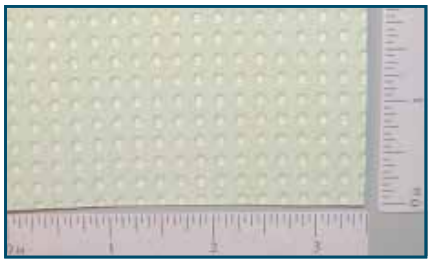
Part Number:
GFH 311
Max. Available Size:
4’ x 12’



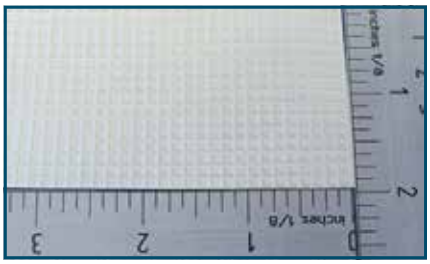
Part Number:
GFCW 317
Max. Available Size:
3’ x 12’



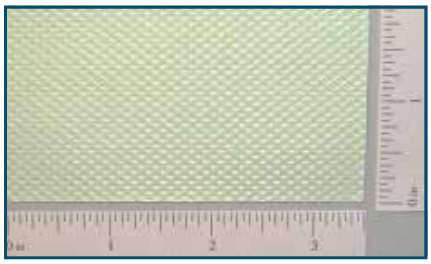
Part Number:
GFBW 312
GFBW 312N
Max. Available Size:
3’8” x 11’



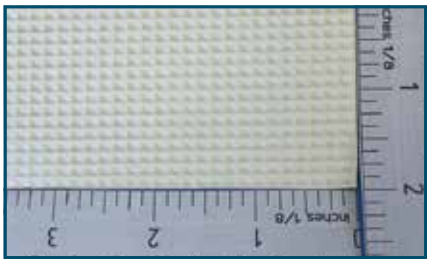
Part Number:
GFBTD 318
Male also
available
Max. Available Size:
41” x 41”



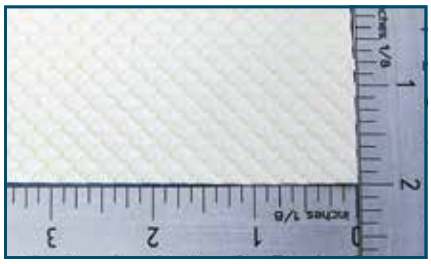
Part Number:
GFS 313
GFS 313N
Max. Available Size:
3’11” x 7’11”



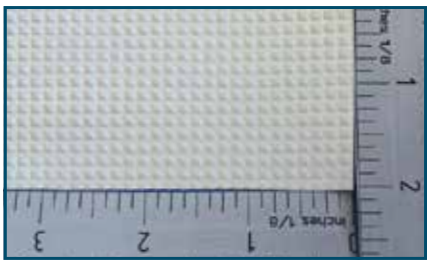
Part Number:
GFR 319
Max. Available Size:
13” x 65”



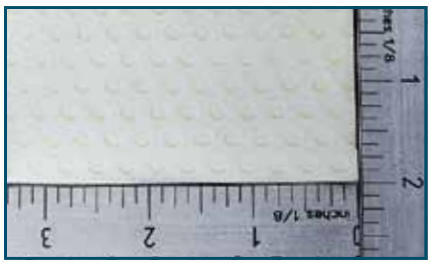
Part Number:
GFE 314
GFE 314N
Max. Available Size:
4’ x 8’



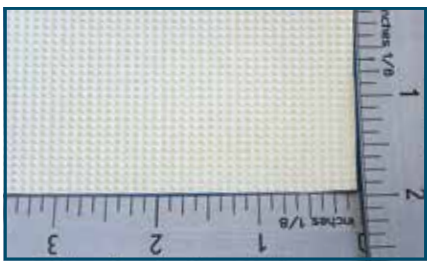
Part Number:
GFSC 320
GFSC 320N
Max. Available Size:
4’ x 4’



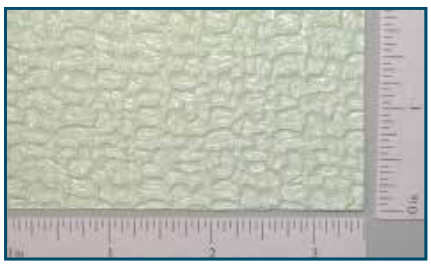
Part Number:
GFTF 315
GFTF 315N
Max. Available Size:
3’11 x 7’10”



Part Number:
GFD 321
GFD 321N
Max. Available Size:
4’ x 10’

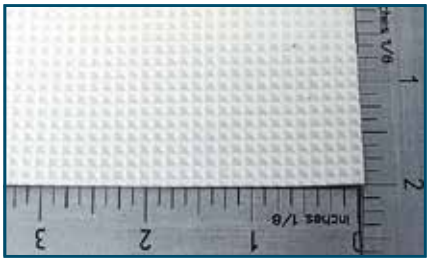


Part Number:
GFBTP 316
GFBTP 316N
Max. Available Size:
3’9” x 6’3”

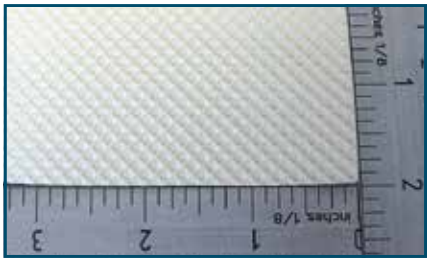


Part Number:
GFS 323
Max. Available Size:
4’ x 8’

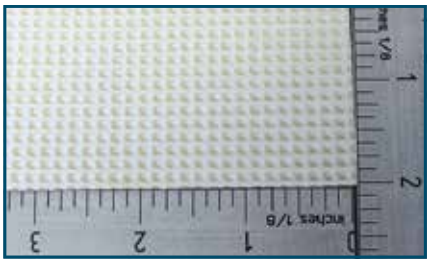
FLEX-MOLD
NON-SKID PATTERNS & RE-DECK



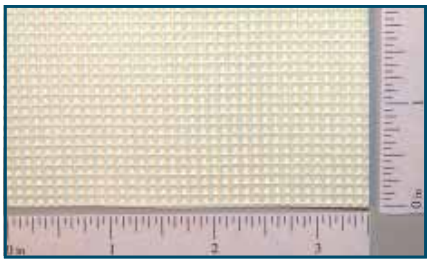
Part Number:
GFEP 324
GFEP 324N
Max. Available Size:
4’ x 7’11”



Part Number:
GFSC 402
GFSC 402N
Max. Available Size:
45” x 46”

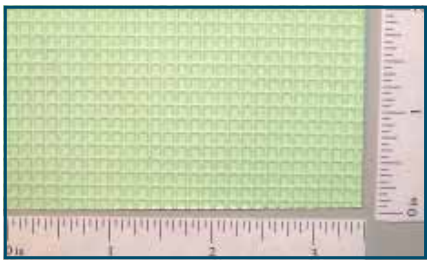


Part Number:
GFPP 325
GFPP 325N
Max. Available Size:
4’ x 8’

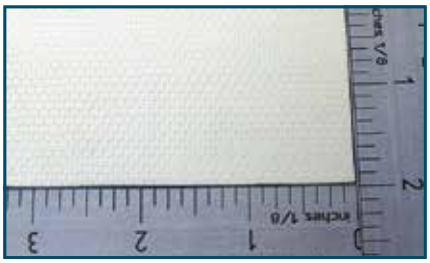


Part Number:
GFJ 404
Max. Available Size:
4’ x 8’8”
2 - 4’ x 4’4” Panels

Part Number:
GFPL 326
GFPL 326N
Max. Available Size:
4’ x 8’

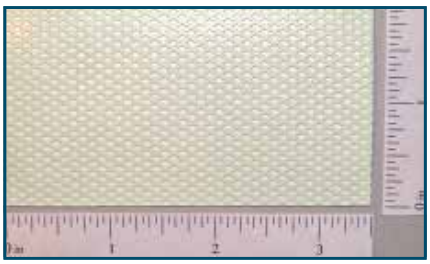


Part Number:
GFEW 405
Max. Available Size:
1’ x 46”

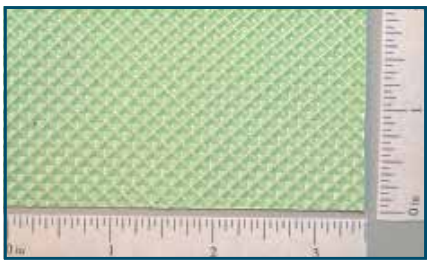


Part Number:
GFBW 327
GFBW 327N
Max. Available Size:
4’ x 12’
2 - 4’ x 6’ Panels

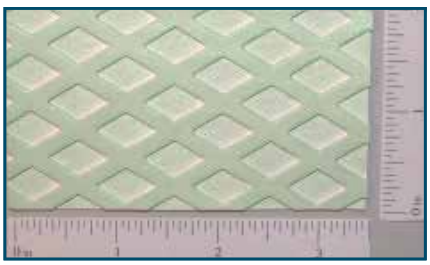
Part Number:
GFCC 406
GFCC 406N
Max. Available Size:
4’ x 10’



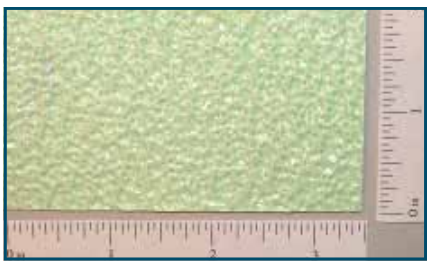
Part Number:
GFBW 332
Max. Available Size:
4’ x 11’9”



Part Number:
GFTP 407
Max. Available Size:
10” x 16.5”

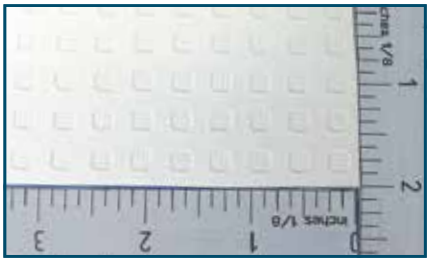


Part Number:
GFTM 401
Max. Available Size:
2’ x 2’

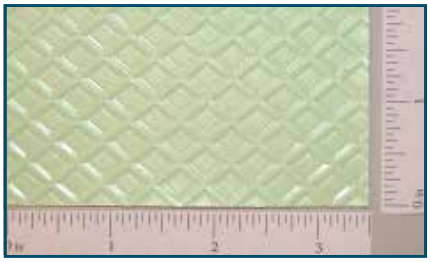


Part Number:
GFC 408
Max. Available Size:
19” x 25”

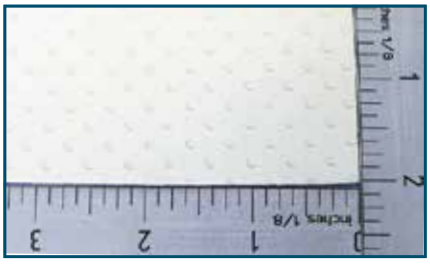
1-817-236-5021



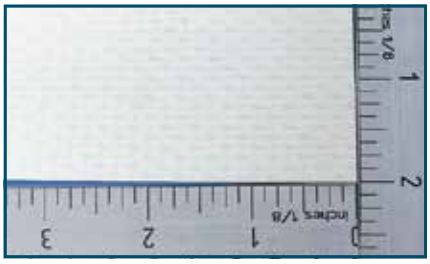
Part Number:
GFYO 409
GFYO 409N
Max. Available Size:
4' x 7'2"



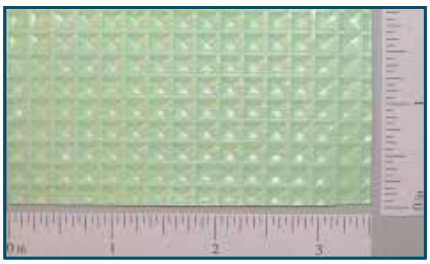
Part Number:
GFH 414
Max. Available Size:
2' x 2'



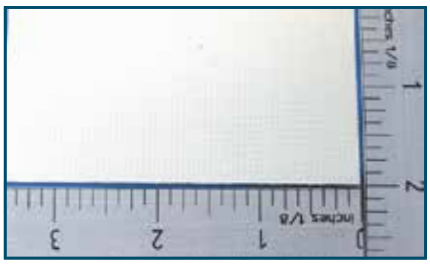
Part Number:
GFYD 410
GFTD 410N
Max. Available Size:
34" x 4'10"



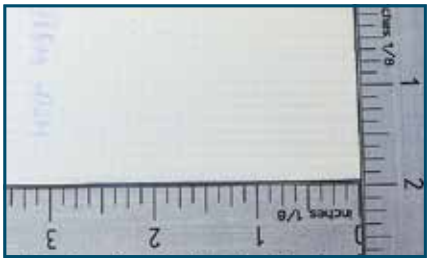
Part Number:
GFC 416
GFC 416N
Max. Available Size:
2' x 2'



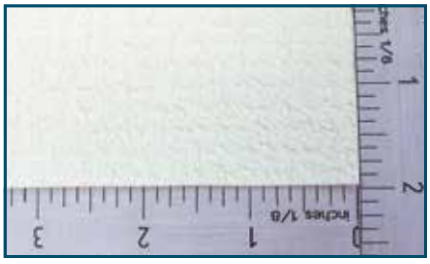
Part Number:
GFS 411
Max. Available Size:
33" x 12"



Part Number:
GFLB 417
GFLB 417N
Max. Available Size:
4' x 5'



Part Number:
GFBW 412
GFBW 412N
Max. Available Size:
27" x 7'2"'
21" x 7'2"



Part Number:
GFR 422
Max. Available Size:
4' x 12'

Accessories

Rubber Squeegees

You can purchase rubber squeegees from FLEX-MOLD. Available sizes are: 6", 12", 18" and 24".

Edge Tools

FLEX-MOLD patented diamond edge tool are designed to create the transition between the smooth gelcoat and non skid areas. Available in 30˚ and 45˚ angles & 3 different grits.

30˚ - 80/100 grit TLF 30
30˚ - 170/200 grit TLC 30
30˚ - 270/325 grit TLA 30
45˚ - 80/100 grit TLE 45
45˚ - 170/200 grit TLE 45
45˚ - 270/325 grit TLA 45

Viscosity Measuring Cup

This cup is a viscosity measurement device widely used in the paint industry. It is commonly a stainless steel or plastic cup with a tiny hole drilled in the center of the bottom of the cup. There is also a long handle attached to the sides. We recommend a Zahn Cup #2 or a Ford Cup #4.

To determine the viscosity of a liquid, the cup is dipped and completely filled with the substance. After lifting the cup out of the substance the user measures the time until the liquid streaming out of it breaks up. To be the most effective, the gelcoat must completely run out of the Zahn #2 cup in 60-65 seconds and the Ford #4 cup in 40-45 seconds.

Frequently Asked Questions

1. **What solvent should I use to prepare the surface before applying the FLEX-MOLD repair?**
   Standard Solvent, Bio Solv, MEK, Acetone.

2. **What wax can I use to prepare the surface before laying down the FLEX-MOLD repair?**
   Most paste wax or mold release will work.

3. **What temperature does FLEX-MOLD need to be to achieve the best results?**
   The FLEX-MOLD recommends applying the piece when temperatures are above 70˚ to maintain the flexibility and lay down properly. It must be at 70˚ or above when you unroll the piece.

4. **Is FLEX-MOLD reusable for repairs?**
   Yes, as long as the PVA is intact.

5. **What if my PVA starts to come off?**
   The FLEX-MOLD can be used repeatedly as long as the PVA coating is intact. Once PVA has begun to come off the FLEX-MOLD, wash remaining PVA off with water. Let FLEX-MOLD dry and reapply PVA with a spray gun by misting on about six coats.

6. **What's the difference between a male or female pattern?**
   Predominantly, female patterns are needed for repair and the male is used to make the plug. If your repair area has a pronounced design that sticks out (convex) then it is likely a male deck and you would need a female pattern to repair it. If it is hard to tell, call the office 877-938-8130 or email us at info@gibcoflexmold.com and we'll be glad to help you out.

7. **Why did the FLEX-MOLD repair stick to the deck?**
   It is extremely important to wax the damaged area and surrounding area BEFORE you begin. You can also tape off areas to keep the area limited. Wax, wax and wax again.

8. **What viscosity does the gelcoat need to be at to be successful?**
   Using a #2 Zahn Cup or viscosity cup the gelcoat should run through the cup at 60-65 seconds; if using a Ford #4 cup speed should be 40-45 seconds (page 9, #7).

9. **What can be used to thin the gelcoat?**
   Patch Aid, Patch Boost, Duratech Clear or whatever is recommended by the gelcoat manufacturer. DO NOT use Acetone as it may cause pinholes, discoloration and cracking.

10. **Can I use the FLEX-MOLD or other applications besides molds or repairs?**
    Absolutely! It can be used for as many applications as your imagination can devise!

11. **How Do I prevent air bubbles from forming in the repair?**
    Make sure you "create the wave " when applying the FLEX-MOLD and push the gelcoat forward. Once it is all the way down, start squeeging from the middle out in all directions.

Notes

FLEX-MOLD

NON-SKID PATTERNS & RE-DECK

Waterparks

Tubs & Showers

Industrial

Transportation

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U.S. Patent #'s 5246642, 5462702, 5626802

817-236-5021 (t) ♦ 817-236-5020 (f)