

Please use these
Helpful Suggestions
for a secure application

Installation of Rubber-Seals

Follow these simple recommendations to accurately
secure your rubber seals

Severe installation conditions, such as elevated temperatures and tight radius applications may require additional measures to provide a secure application. (Temperature and radius guidelines vary by individual part)

RECOMMENDATIONS:

1 CLEAN SURFACE THOROUGHLY.

Must be clean, dry, and free of oil & grease.

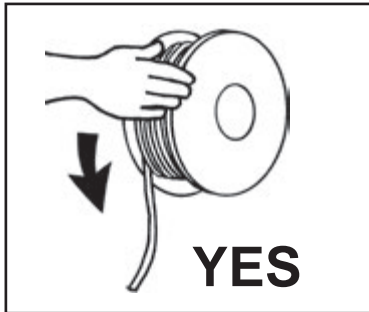
Regardless of what bonding surface you apply the gasket to, it must be clean and free of surface contaminants such as oils, grease, mold release and dirt or dust in general. Most bonding failures are not due to the adhesive failing, but instead, the failure to properly clean the surfaces. Prior to applying any adhesives, clean the surface with IPA Alcohol/H₂O, Safety solvent, or TSP. For your particular use, it is advised to test all material to ensure the effectiveness of the product.



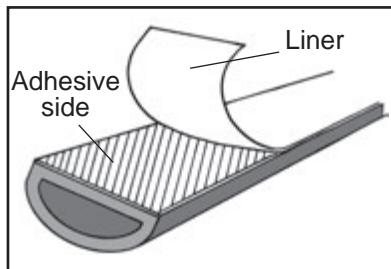
- Use clean, lint-free wiping cloths or disposable wipes, and change at least every hour or when visually soiled.
- Reprocessed rags should not be used as they may contain waxes, residual solvent or other contaminants.
- Care should be taken, especially with automatic wiping, that the cleaning cloth does not rub against tires or any other surface that might contaminate the body surface.
- Use 50/50 isopropanol and water mixture should not be less than 50% isopropanol, but may have a higher concentration as long as the body surface is properly cleaned before the mixture flashes off.
- If possible, avoid applying the trim component after a water test operation. This operation often involves surfactants and dirty water that adversely affect adhesion.

2 DO NOT STRETCH THE RUBBER SEAL FROM THE REEL.

Dispense product by turning the reel.



3 AVOID GETTING ADHESIVE DIRTY.

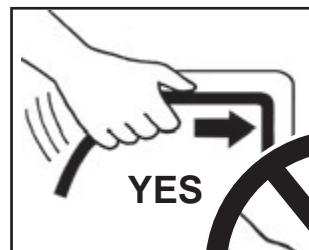


Peel Liner just prior to application.

NOTE:
Various adhesive tape grades available.
Contact your representative for details.

4 "STUFF" NOT STRETCH AROUND RADIUS

Install the rubber seal around radius by 'stuffing', not stretching.



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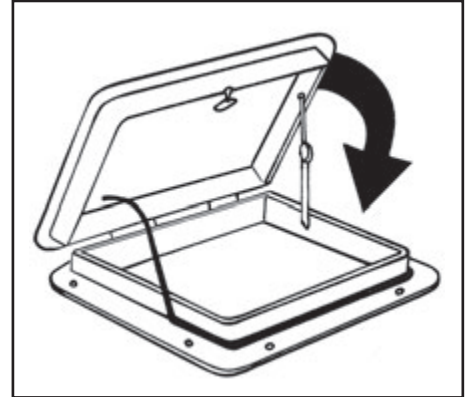
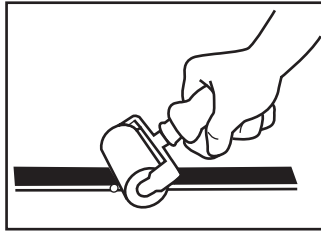
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5 WITH A HAND ROLLER:

Apply Pressure against the seal to get good wet out of the adhesive to the surface. **This is a very important step in the application procedure to ensure long-term durability of the tape-attached weatherstrip.**

Apply Clamping Pressure
 (If possible) Immediately after application close unit, (i.e.: hatch, door)



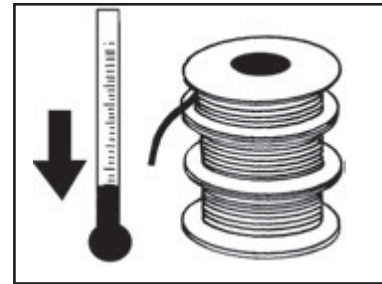
WITH AUTOMATIC ROLLER:

The roller should be made of a dense urethane rubber. Roll down force should be about 30 pounds per 1" of tape width at the tape surface.

Allow 24 Hours for complete wet out of tape adhesive.

6 STORAGE:

Always store on original reels and store in cool, dry & dust-free location.



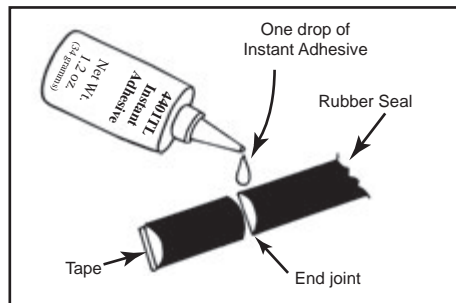
To ensure optimum performance, several important requirements should be noted prior to the installation of any Pressure Sensitive Adhesive (PSA) taped product. Be sure to store this product at 72°F (22°C) and 50% relative humidity. **DO NOT** apply when temperatures are below 60°F nor above 100°F, as this may affect the performance of the tape.

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HELPFUL HINT:

To bond or splice rubber seal ends together. use:
'Instant Adhesive'
 (Item# 4401TL)

Contact your representative to order.



PLEASE NOTE: Due to a constant effort to update Rubber Seal products, specifications are subject to change without notice, and without incurring obligation. Because the manufacturer can not anticipate or control the many different conditions which this information and their products may be used, they do not guarantee the applicability, accuracy or suitability of each product for their particular application. The products described here are sold without warranty, either expressed or implied. The buyer assumes all responsibility for loss and/or damage arising from the handling and use of these products. **PROPER CARE:** Do not paint over or clean with solvents.