

27 April 2016

Re: Gasket Repair Procedure for NP-172112

Below is the field procedure for replacing the side window gasket on NP-172112.

*NOTE: This procedure, when performed in the field, must be conducted with caution as damage to the acrylic can be induced during removal of the gasket. Procedure is to be completed at operator's own risk.

A. Equipment/Materials

- 1) Equipment
 - (a) Sharpened plastic scraper.
- 2) Materials
 - (a) Molded silicone gasket seal – PPG Part Number 22-3052
 - (b) DC 1200 primer (available through local PPG Application Support Center (ASC))
 - (c) 732 black sealant (commercial local distributors)
 - (d) Lint-free cloth (commercial local distributors)
 - (e) Isopropyl Alcohol, aka IPA (commercial local distributors).

NOTE: Use as a solution, mix of 50% IPA in 50% water.

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B. Procedure

- 1) Remove the damaged gasket seal and any remaining sealant with the sharpened plastic scrapper.

*NOTE: Acrylic surface must be inspected after removal of gasket for any damage that may have occurred during removal procedure.
- 2) Clean the seal area using the IPA solution and lint-free cloth.
- 3) Prime the surface of the window and gasket with DC 1200 adhesion promoter and allow to cure per manufacturer's instructions.
- 4) Apply 732 black sealant and smooth over surface.
- 5) Install gasket onto window, taking care to remove excess sealant from surrounding surfaces and holes of gasket. Ensure that gasket holes are aligned properly with holes on window. Smooth gasket using plastic scrapper.
- 6) Clean excess sealant from inside and outside of gasket. Continue process until gasket and surrounding areas are free of excess sealant.
- 7) Allow sealant to cure per manufacturer's instructions.

Please contact PPG Engineering with any further questions.

Best Regards,



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