

TECHNICAL BULLETIN - #A302
SUBJECT: PROLO HATCH ADHESIVE GASKET
INSTALLATION INSTRUCTIONS

Effective Date: 2/7/03 Revised Date: 8/18/05

INSTALLATION INSTRUCTIONS FOR ADHESIVE MOUNT GASKETS FOR PROLO HATCHES

1. The hatch hole that the gasket will be applied to must be cut 23.5" x 23.5" x 4" R. corners. Slight variation of these dimensions may be allowable (such as 23.688" x 23.688" x 4.438" R. corners) provided that the perimeter of the hole is the same (87.13"). An accurate hole cut is required for the pre-spliced endless loop gasket to fit properly.
2. The top surface of the hole (minimum 7/8" outward from the edge of the hole) should be clean, dry, free of fasteners or sheet metal overlaps, and 60°F or warmer.
3. If sheet metal overlaps exist on the top surface, a 5/8" long bead of exterior adhesive may be applied from the edge of the hole outward along the gap between the sheets. (Using a bead length slightly less than the width of the gasket keeps the adhesive underneath the gasket and provides a clean appearance.) This should be done just prior to gasket installation. If this is not desirable, sealer may be applied to this gap after the hatch has been completely installed.
4. Beginning at the rear center of the hatch hole, start with the splice and remove six to twelve inches of the release liner from the weather-strip adhesive. Using the down facing flap as a guide, touch this flap to the cut edge of the hole first and then press down to engage the adhesive to the top surface of the bus. The bulb of the gasket should be positioned on the top surface of the bus. Continue to remove release liner about 12 inches at a time, positioning the gasket using the downward flap against the sheet metal edge, and using finger pressure to attach the adhesive.
5. Once the gasket loop is fully positioned, visually check that the gasket has been positioned correctly. At this point, you may pick up and reposition if needed. Once in place, use a small hand roller to wet-out the adhesive by using firm even pressure one time around the gasket. This step is important to maintaining ultimate leak protection and must not be skipped. If for some reason, the gasket must be repositioned after rolling, it should be discarded and a new gasket should be used.
6. The ProLo hatch may now be installed.
7. 3M recommends keeping the surface and gasket temperature above 60°F for at least two hours after installation. Full cured strength typically occurs in 72 hours.

Notes: These installation notes are based on 3M's official installation instructions, which are available by calling the number below. These instructions may be conservative in that slightly lower installation temperatures may be acceptable, but should be verified by the customer in their process before use on production units.

Please contact Specialty Manufacturing with any questions. (1-800-951-7867 x3036)