Elevator Equipment Corporation CB-024

Procedure for Applying Marine-Tex® to Piston Joints

Ensure you have all the equipment required to apply Marine-Tex^{*}.

Items included in this kit:

- 1 2 oz. Kit of Marine-Tex[®]
- 1 Marine-Tex[®] MSDS Data Sheet

"Simplicity in Motion"

- 1 4 oz. Simple Green[®] Spray Cleaner
- 1 1 1/2" Plastic Putty Knife

- 1 4 oz. Plastic Cup with Lid
- 1 2" x 6' 80 Grit Emery Cloth
- 1 2" x 6' 400 Grit Emery Cloth

Read instructions completely prior to mixing. Marine-Tex[®] has a working time of only 15 minutes. For questions or assistance with this procedure contact customer service.

- 1. Use **Simple Green**[°] **Spray Cleaner** to clean the two mating surfaces of the piston and the exposed thread.
- 2. Extract the entire Kit of Marine-Tex[®] resin and hardener tubes into Plastic Cup. Mix quickly and thoroughly.

Note: If temperatures are below 40° F use an approved heating deviceto bring the work area and components to a temperature above 40° Fahrenheit.

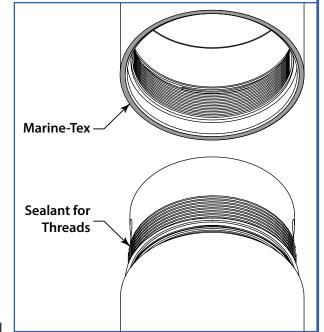
3. Apply the mixed Marine-Tex[°] material liberally to the **<u>bottom</u>** <u>**face**</u> of the joint using **Plastic Putty Knife**.

Note: Do not apply to threads! Marine-Tex^{*} *has a working time of only 15 minutes.*

- 4. Screw the two sections together as tight as possible.
- **5.** Let the Marine-Tex[°] stand and cure for one hour (1 hr) at 75[°] Fahrenheit. If the work area temperature is less than 75[°], allow for more curing or standing time.

Note: If temperatures are below 40° Fahrenheit use an approved heating device to bring the work area and components to a temperature above 40° Fahrenheit.

6. Ensure the Marine-Tex[®] has cured to a hardened state prior to sanding. Use **80 Grit Emery Cloth** to sand off all excessive dried material from the piston joint. Sand or dress the joint area approximately three inches (3") on each side of the joint for a total of six inches (6").



- 7. Sand the joint until the joint cannot be felt using your thumbnail as a gauge.
- 8. Use the 400 Grit Emery Cloth to polish the joint to the desired smoothness.*Note:* This surface should be as smooth as the rest of the piston.

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