



SERVICE BULLETIN

Document No.: 3/ Issue: 1 / Date: December 1, 2013

Instruction Details for Installing Glass with Factory Applied Edge Seal

Area Affected: Marine Laminated Flat and Curved Glass with a factory applied edge seal around the perimeter edge of the laminated construction.

Dates Effected: Installations performed using laminated glass with a factory applied edge seal

Description: ProCurve Glass offers a factory applied edge seal to its customers as an option, at the request of its customers or when customer supplied installation details raise concerns that an edge seal is desired. The purpose of the edge seal is to further protect laminated glass from moisture penetration and/or surface contamination issues that may arise when it is exposed to the harsh marine environment. Sealants that are applied to the laminated glass edge in the field are exposed to the risk of contaminants that, if not properly attended to, can reduce shear and adhesive strength of the sealant system. The edge seal also aids in blocking the migration of moisture/humidity or water from reaching the otherwise fully exposed laminated glass edge which will cause future concerns. Having the edge seal applied at the factory ensures that the sealant has been applied when the glass is in its most pristine condition and that laminated interlayer has not been exposed to any threatening elements. Please note that whether glass comes with an edge seal or the laminated glass is sealed during installation, maintenance and periodic inspection of the sealant bond to the glass edge is required to address cracking and separation that will occur over time.

Pre-Tip Out Instruction: There are two methods by which glass with a factory applied edge seal can be prepared for the tip out process, by means of either cutting or abrading the existing edge seal. Instructions for either method of properly conditioning the edge seal can be found below. These instructions outline the processes which need to be completed on the factory applied edge seal before the laminated glass can be tipped out.

Re-apply Tip Out: Once the factory applied edge seal has been properly prepared by using one of the two listed methods, the installer is able to proceed with the tip out process. The final tip out should contain a thick "lip" of sealant which overlaps onto the face of the glass. The "lip" will further ensure that the glass edge is completely protected from the marine environment. A thicker "lip" will not be able to be removed as easily as a thinner "lip" through standard means of wear and tear such as washing the vessel. If you have any questions regarding the tip out process, please contact ProCurve Glass.

METHOD 1 – CUTTING

1. Remove outer edge of edge seal sealant from edge of glass using a razor blade. This will provide a “fresh” sealant surface that the newly applied sealant will be able to adhere very well to.

2. (Optional) Remove lip of sealant from the face of the glass using a razor blade so that there is no residual sealant left on glass surface.

NOTE - If installer is not going to remove the sealant lip from the face of the glass, the surface of the lip **MUST** be abraded and cleaned before applying additional sealant on top of the lip (see abrading instructions below).

3. If the “rejuvenated” edge seal has been left for over 30 minutes before applying the tip out, or has accumulated dirt between the time of cutting back the sealant to the point when the installer is ready to apply the tip out, the installer must clean-wipe the surface of the edge sealant using Isopropyl Alcohol and a clean rag to remove any particulates from the sealants surface. Any dirt, dust or particulates left on the surface of the sealant will hinder the ability of the newly applied tip out sealant to bond to the existing edge seal.

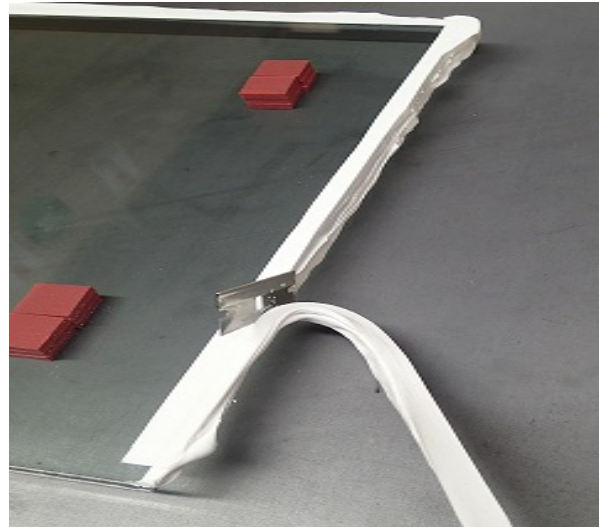


Image 1 – Removal of factory edge seal surface

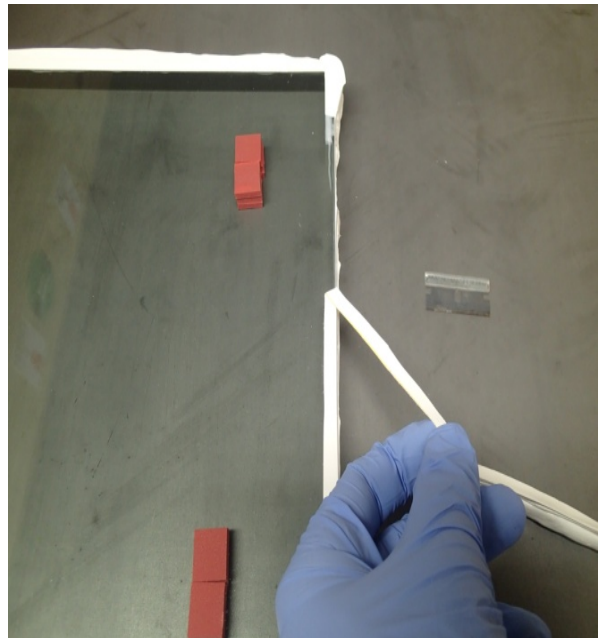


Image 2 – Removal of factory edge seal surface lip

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METHOD 2 – ABRADING

1. Using an abrasive technique such as sandpaper or a scuff pad, scuff the factory applied edge sealant to remove surface of the sealant. Make sure to scuff all surfaces in which new sealant will be directly applied.

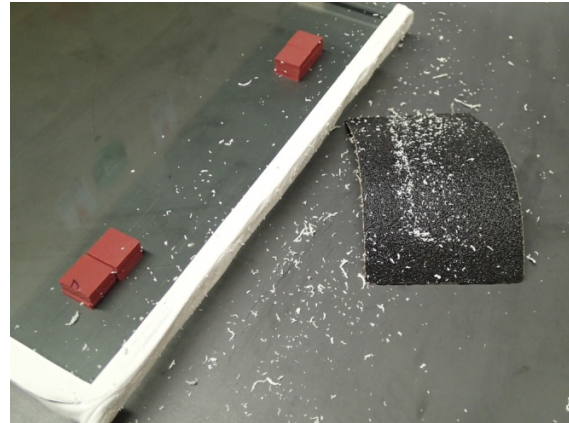


Image 1 – Abrading factory edge seal surface

2. Using Isopropyl Alcohol (IPA) and a clean rag, clean-wipe the newly scuffed surface of the edge sealant to remove any type of grit that may have been a resultant of the sandpaper or scuff pad.



Image 2 – Applying IPA clean-wipe to abraded sealant surface

3. Wait approximately 10 minutes before installing or tipping out the glass so that any residual IPA completely evaporated. The installer must be certain that the IPA has completely flashed off before applying the tip out sealant. If any IPA is left behind the ability of the newly applied tip out sealant to bond to the existing edge sealant will be hindered.

**Please note that when supplying edge sealed glass to customers, ProCurve Glass uses a black edge seal product. The white product used for the instructions below was only used for photographic purposes.*



Image 3 – Abraded and cleaned edge seal surface