

LEXAN FIXED PORT REPLACEMENT PROCEDURE

Required Tools:

- Screw driver
- Utility Knife & Blades
- Pencil
- Scissors
- Putty Knife
- GE Silpruf Pre-cast White 4 Tubes
- GE Silpruf Black 4 Tubes
- Caulking Gun
- Plastic Spatula or Bondo Spreader

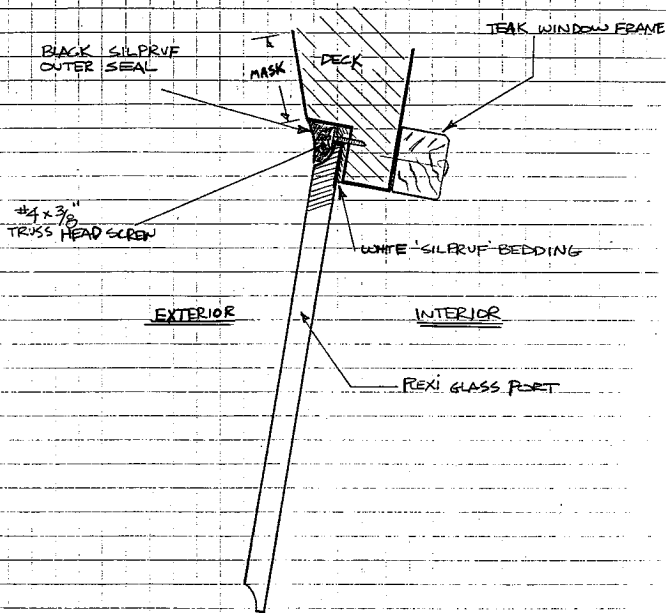
A) Review attached illustration showing section of installed port and read instructions before beginning.

B) Remove Damaged Port:

1. Using putty knife or similar tool, remove black silpruf on outside of port and discard.
2. Remove #4 3/8" truss head screws. Save screws, as they will be used to install new ports. Remove wooden frame from inside cabin.
3. Using utility knife, break seal of sealant on inside edge of port. Remove old port from opening by peeling it away.
4. Remove all remaining sealant from deck surface and clean deck before attempting to begin installation of new port.

C) Install Replacement Port:

1. Remove the paper from inside edge of port only; **DON'T TAKE PAPER OFF FROM OUTSIDE OF PORT.** You can identify the outside of the port by the cove that is routed on the edge of the port. The cove side faces out, like the old port was.
2. Loosely install the bottom truss head screws for the port to set on. With the caulking gun apply a generous bead of the pre-cast white sealant to the inside of the port around the entire perimeter.
3. Set the port in place, resting on the screws, and making sure that the port is centered fore and aft. Gently push the port against the flange to set the sealant, enough so that you can start the top truss head screws. With all of the screws started, evenly go around and tighten each screw. **NOTE: Do not overtighten the screws. You will cause waves or ripples in the glass. The screws should be snugged up just enough for some sealant to squeeze out around the entire inside perimeter.**
4. Excess sealant should be cleaned off from the inside edge as soon as possible. Spray the excess sealant with a cleaner such as Now, 409, Fantastic, etc.. Then take a scraper, we use bondo spreaders, and scrape the excess sealant off the



FOR THESE MODELS ONLY:

30 III, 34 II, 36, 362, 38 II, 386, 402, 42, 426,
425 + 452

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FIXED PORT
SECTION.

SCALE

DATE

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BY
SED

APPVD.

DWG. NO.

surface. Spraying the sealant makes it less sticky. When you have scrapped away as much as you can spray again and wipe with a clean white rag. When cleaning the excess, be careful not to apply too much pressure to the port, as this can cause voids in the sealant.

5. A 12-hour curing time should be allowed before the black is applied to the outside. If excess squeezes out on the outside during installation it is okay to leave it at this time.
6. After curing time, remove any hardened sealant on the outside with a utility knife so that it won't interfere with the black sealant. Mask off the deck on the edge where the black sealant will be. This will make a nice clean edge for the sealant, and protect the deck.
7. Apply adequate amounts of black sealant to outer perimeter of port. Using a spatula or thumb spread the sealant around the entire perimeter in a continuous motion. It may be necessary to add more sealant if you have voids. Spraying this surface with the cleaners mentioned earlier will help in spreading the sealant. After you have achieved a seal, remove excess off from deck and port being careful not to disturb the seal.
8. Carefully remove the masking tape from the deck. If the ports aren't going to be exposed to direct sunlight it is advisable to leave the paper on the port for 24 hours. If you need to remove the paper right away, just be careful not to disturb the seal.
9. Mission Accomplished!