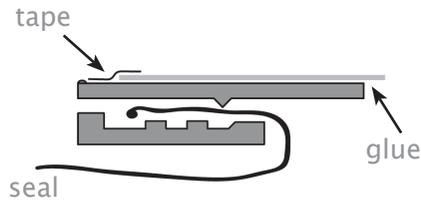


Allow at least 5 mm (1/4") for sealing tape to overlap the sleeve edge.



Note! The Wrist Ring must be glued about 2 cm (3/4") above the wrist (with arm hanging down). This means, in most cases, that the suit sleeve must be shortened.



These are recommendations only. Follow the glue manufacturers instructions. Make a leakage test before diving.

QCS OVAL – GLUING INSTRUCTIONS

Preparations before gluing

Measure and adjust the sleeve length wearing the suit and the normal underwear garment. The installation may make the sleeve longer. When attached to the sleeve, the outer end of the Wrist Ring should not exceed the wrist when stretching the arms forward. As most sleeves are tapering, ensure that the sleeve circumference matches the wrist ring before length adjustment. (If the sleeve is too short, use a suit material extension.)

Buff all non fabric surfaces that are to be glued. Ensure proper ventilation when working with glue. Glue mixed with hardener has a limited pot life. Do not mix too much each time.

Be extra careful to even out all sharp edges in joints and seams on the suit with sand paper (not with glue).

Wash all surfaces to be glued (with acetone or toluene unless otherwise is stated by the glue manufacturer), prior to applying the first coat of glue. The PU-material in Wrist Ring will be more receptive to the glue if swollen with solvent or pre-heated with a hot airgun (60–80 degrees C/140–180 F).

A pre-glued heat activated PU-tape is supplied with the QCS Oval set. Apply glue on the suit and Wrist Ring, but not on the tape. Let dry thoroughly. To activate; heat the tape and glue on sleeve and Wrist Ring, 5 cm (2") at a time, with a hot air gun or hair dryer and stretch the tape gently when applying.

A small roller can be used to apply pressure to all glued surfaces and force the remaining air in seams and air pockets toward the edges.

Allow the work to cool under pressure or tension. Use of a heat activated PU-glue (for which the following instructions are intended) will avoid mismatches as you can match the two surfaces when dry. An inside support such as a short piece of PVC or ABS pipe that fills the sleeve end is a valuable help when fitting the glued surfaces. Use a hot air gun to melt the glue until good bonding is achieved. Heat one segment at a time in all four corners. Apply pressure and work on the remaining surfaces.

Make sure that the glue is thoroughly hot and bonding well.

Important issues about glue and gluing

Polyurethane (PU) based glue is recommended for the attachment of the Wrist Ring to the suit. Neoprene glue is not recommended since it may permanently swollen the material.

To achieve the best bonding and saturation of all materials, including natural rubber, the first (and possibly second) coat of PU-glue must be thinned. PU-glue can normally be thinned with acetone or toluene (follow the glue manufacturers recommendations.)

Apply 2-3 thin coats of glue (mixed with hardener if recommended by the glue manufacturer) on all surfaces, make sure that all seams are well covered. Thinning the glue will ensure saturation into the material or fabric to be glued. Allow each coat to dry completely.

Gluing instructions for Wrist Ring

The Wrist Ring must be glued to the inside of the sleeve. If the Wrist Ring don't match your sleeve you may have to consider removing or inserting a wedge into the suit sleeve.



Circumference (Inch measurements are rounded.)

323 mm (12 3/4")

320 mm (12 9/16")



Internal 302 mm (11 7/8")

X On the inside of the sleeve.

(On neoprene suits; cut the edge perpendicular and apply glue on exposed neoprene and the perpendicular surface of the Wrist Ring.)

If you use a heat activated glue; insert the Wrist Ring into the sleeve when the last layer of glue is dry. Place the glued surfaces together.

Heat activate the glue, apply pressure and let dry.

Reinforce the seams with tape to seal the edge. Apply pressure to all glued surfaces and allow to dry.

