

RAILBLAZA RIBPort fitting instructions using 3M VHB (Very High Bond) self adhesive pad.

The **RAILBLAZA RIBPort** can be mounted to any surface with no gluing or drilling required. Simply prepare the area as per the following instructions then peel the backing paper and stick it.

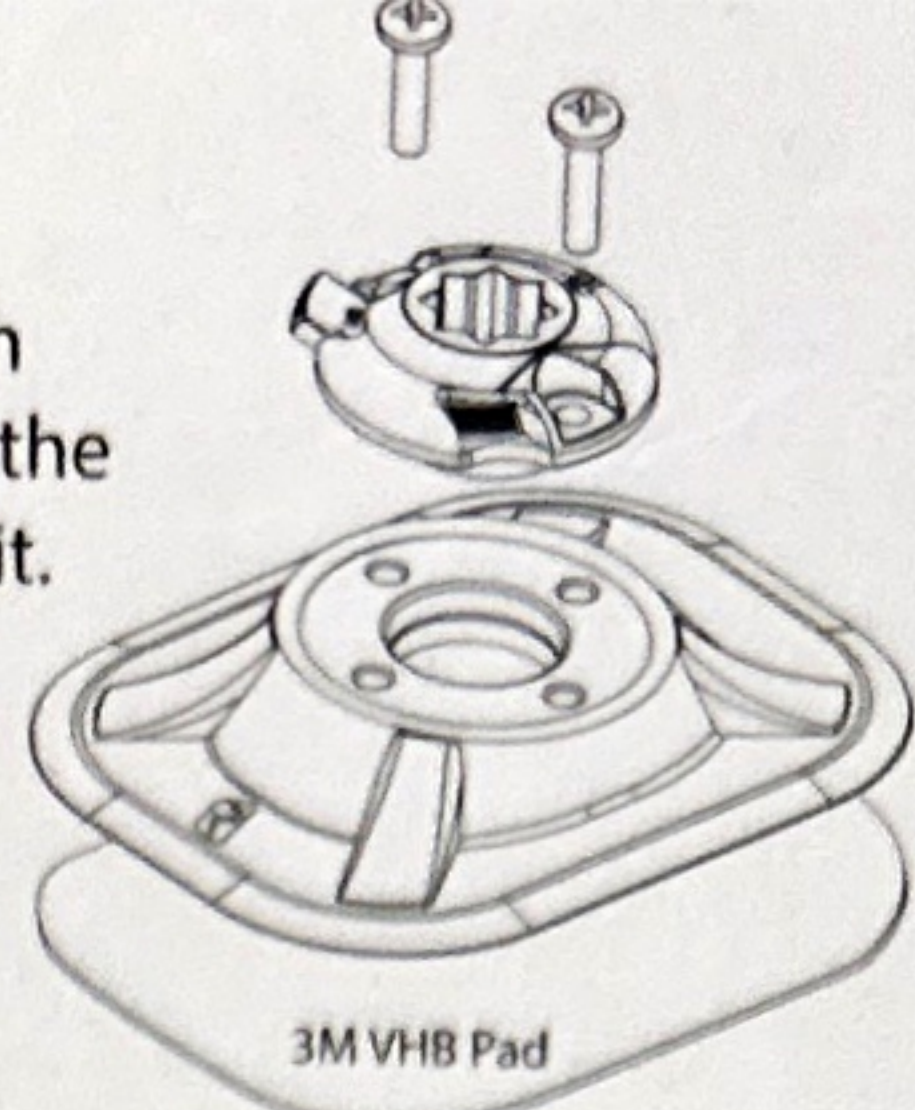
Tools required:

• Pencil or masking tape • Heat gun (or hair dryer) • Sharp scissors

Please note:

The following instructions must be followed carefully to ensure you get the best possible bond from the 3M VHB adhesive.

NOTE: The Vessel must be fully inflated before installing RIBPort. If the surface is not absolutely clean or if it has had silicon applied. We recommend you use 3M Primer 94 for best results.



1. Mark the surface where you want to mount the **RIBPort** using a pencil or masking tape.
2. Using the abrasive pad supplied scrub the surface where the **RIBPort** is to be mounted.

3. Using the alcohol swabs supplied carefully clean the surface where the **RIBPort** is to be mounted and the surface of the **RIBPort**. If silicon has been anywhere near this surface we recommend you use 3M Primer 94.

4. Leave until both surfaces are dry.

5. Carefully peel the backing paper off one side of the VHB pad and stick the pad to the **RIBPort** ensuring the **RIBPort** is within the edges of the VHB pad.

6. Moving from the centre to the outside, Smooth the full surface with your fingers for at least 45 seconds to ensure a good bond.

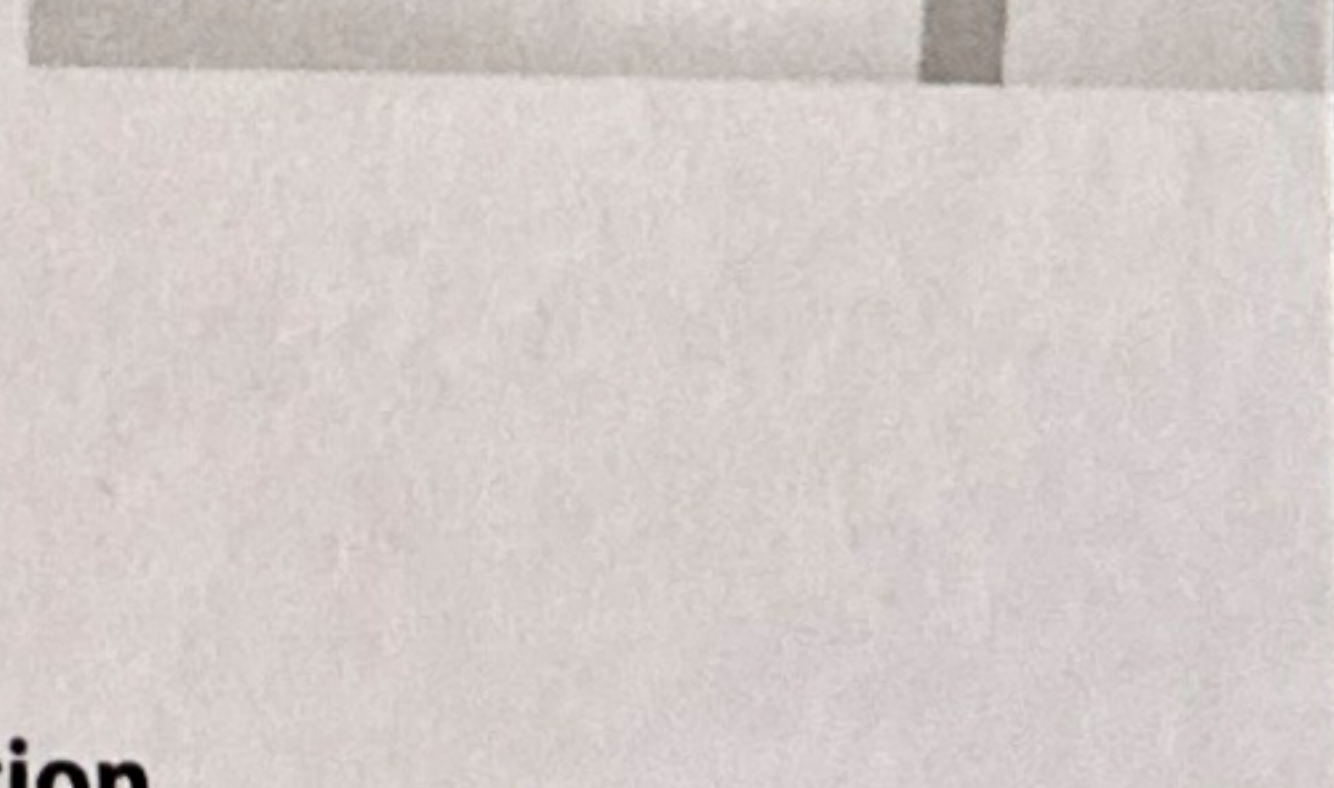
7. Using a pair of sharp scissors (scissors are better for this application than a knife) trim around the edge of the **RIBPort** so the VHB is flush with the edge of the **RIBPort**.

8. With a heat gun on low setting, gently heat around the StarPort side of the **RIBPort** until the edges become malleable. Please avoid directing the heat gun onto the VHB pad, and avoid overheating as this may damage the plastic.

9. Peel the last layer of backing paper from the VHB and apply the **RIBPort** to the surface ensuring it is lined up with your marks. **(Very important to get it correctly positioned on the marks "first time" as it will be very difficult to remove & reposition).**

10. Push the centre of the **RIBPort** firmly to ensure the whole surface underneath is adhered, and any air bubbles are pressed out. Then smooth the surface around the edges of the **RIBPort** with your fingers. Make sure firm pressure is applied for at least 45 seconds.

11. We recommend applying a weight to the top of the **RIBPort** and leaving it for up to 12 hrs.



Product information

CURING TIMES:

The bond will be strong almost immediately and should not move.

The 3M tape will take about 72 hours to totally cure.

75% bond strength is achieved within the first 24 hours.

90% of bond strength is achieved within the first 48 hours.

Full strength is achieved after 72 hours.

Your **RIBPort** is now ready to receive **RAILBLAZA** accessories.

Go forth and spread the word. **RAILBLAZA** is awesomestuff.