

ANKLE/WRIST GASKET REPAIRS



WARNING: This repair can be difficult to perform. Please read and understand these detailed instructions completely before starting. It will be helpful to follow the instructions in a “dry run” without glue first. Make sure you have a well-ventilated, large flat surface to work on.

INCLUDED IN THE GASKET REPAIR KIT (AVAILABLE FROM ANY KOKATAT DEALER AND SOLD IN SINGLES OR PAIRS)*

- (1) or (2)* Latex gasket(s)
- (1) Tube AquaSeal® glue (0.5 oz)
- (1) Sandpaper
- (1) 303 Protectant™ sample

INCLUDED WITH ANKLE/WRIST GASKET REPLACEMENT TOOL KIT (AVAILABLE FROM ANY KOKATAT DEALER)

- (1) Large cylinder – for replacing ankles
- (1) Small cylinder – for replacing wrists
- (2) Short 1" pipe – used as a wedge when necessary

OPTIONAL/ADDITIONAL ITEMS

- Box knife, Xacto knife or heavy scissors
- Masking tape
- Popsicle stick or plastic butter knife (to apply AquaSeal®)
- Denatured alcohol or acetone or nail polish remover
- Clothing iron
- Wood clamps (spring)
- Latex or light work gloves (to protect fingers and keep clean)

If you will be doing a lot of repairs, a board with a slot about 3/4" wide by 6" long will be helpful for holding the cuff upright and keeping the rest of the garment out of the way. Clamp or attach the board to the edge of the workbench.

1. The simplest, safest and most effective universal method of dealing with deteriorated gaskets is to cut the old gasket off, leaving the base adhered to the fabric, then gluing the new gasket to the old gasket base. Kokatat strongly recommends this method, unless the gasket left on the garment is badly deteriorated (gummy) or there are already two or more layers of repairs. In this case, skip to step 3.

2. Open the Velcro® on the neoprene over-cuff and fold it back up the sleeve/leg out of the way. To cut the gasket off, you need to be able to see the edge of the fabric, so either leave the suit right side out or turn it inside out so that you can see the edge of the fabric. Then cut the old gasket off just at the fabric edge.

3. If you must remove the existing gasket, follow the procedure below. **WARNING: Pulling on a well adhered gasket can rip the fabric of the suit!** Rips in fabric will occur more easily in some directions, so even though it doesn't rip where you start to pull, it may

rip under the same stress at some other point in the circle. Go slowly, watch carefully and if the fabric starts to rip, stop and send the suit to Kokatat for repair.

REMOVING THE GASKET

Using a typical home iron set at medium, heat the gasket until hot to the touch, and carefully pull the gasket off. **Warning: Apply heat only to the latex gasket.** Do not allow the iron to touch the fabric anywhere. You can lay a thick piece of cloth (towel) on the fabric to protect it, but you still do not want to iron over the fabric. If the gasket doesn't come off fairly easily, apply more heat. Hot air guns are not recommended, and a regular hair dryer is typically not hot enough. Be aware that gasket glue and latex gets hot and stays hot, so you may want to wear protective gloves.

Removal of gaskets usually creates some fraying of the fabric around the edge of wrist/ankle hole. This is primarily a cosmetic issue because the new glue will bind the threads, but you may trim the threads with scissors or *carefully* singe them with a match or lighter.

4. Squeeze the cylinder form together and place into the end of the sleeve/leg, leaving about half the form exposed. Let go of the form, allowing it to expand and stretch the sleeve. Insert the wedge perpendicular to the form to tighten the form.

5. Put the sleeve/leg into the slot or your board if you are using one. Put tape around the fabric just below the old glued/welded area to make a neat glue line.

6. Clean the gluing area on the old latex well with alcohol or acetone before sanding. Then sand the old latex. Prepare the new gasket similarly. (Sanding before cleaning can rub contaminants into the rubber.) If you are gluing onto fabric and not the old latex, simply wipe the fabric with the cleaning agent and let it dry thoroughly.

7. Place the gasket over the form and pull it down to the masking tape line. Fold the edge of the gasket back onto itself until the folded edge is just above the edge of the fabric.

8. Apply a moderate bead of AquaSeal® onto the fabric (or old latex, if you cut the old gasket off), and spread evenly from the tape to the fabric edge. A little glue should actually go over the edge onto the form, and onto the masking tape.

9. Unfold the gasket over the glue and position it so the edge of the gasket is just above the masking tape. Using fingers or a clean tool, smooth the gasket towards the edges to remove trapped air bubbles. If there is a lot of excess glue, scrape it off. Remove the tape. Let dry overnight.

10. To remove the repair from the cuff, first remove the wedge. From the outside of the cuff, squeeze the form together and manipulate the fabric and the gasket to break the cuff away from the form (they will be glued together). You can also try to break the glue bond from inside the garment. Reach inside the garment and pull the form out of the sleeve/leg.

Treat all of your gaskets with 303 Protectant™ regularly.

Last update: 12/2004