



NECK GASKET REPAIRS **WITHOUT** KOKATAT'S NECK GASKET REPLACEMENT TOOL KIT

*There are two sets of instructions: One for replacing the neck gasket **WITH** Kokatat's Neck Gasket Replacement Tool Kit, and one **WITHOUT**. Neck Gasket Replacement Tool Kits may be purchased through any Kokatat dealer.*

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 WITH GASKET REPAIR KIT (AVAILABLE FROM KOKATAT DEALERS)

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

ADDITIONAL REQUIRED ITEMS (NOT INCLUDED)

- Cardboard (enough to create two 10 1/2" and one 8" diameter disc and one ring with a 9 1/2" outside and 6 1/2" inner diameter)
- Compass, ruler or tape measure
- Pencil or pen
- Box knife, Xacto knife or heavy scissors
- Denatured alcohol or acetone
- Wax paper or plastic wrap
- Double sided tape (available at most hardware stores)
- Popsicle stick or plastic butter knife (to apply AquaSeal®)
- Heavy, flat weight (large books work well)

OPTIONAL ITEMS

- Seam ripper (if removal of an existing sewn-in gasket is necessary, this will help)
- Latex gloves (to protect fingers and keep clean) & work gloves
- Iron

GETTING STARTED

1. The simplest, safest and most effective 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 see step 4.

2. On work surface, measure and trace two 10 1/2" and one 8" diameter cardboard discs and one cardboard ring with a 9 1/2" outside and 6 1/2" inner diameter. Cut out and set aside.

3. With drytop or drysuit right side out, turn outer collar down so entire gasket is exposed. Note whether the original gasket is attached on the inside or the outside of the suit. 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.

4. 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. If the gasket has been stitched on, use a seam ripper to break the threads on the gasket side before removing.

GORE-TEX® FABRIC

Using a typical home iron set at medium, heat either the gasket or the fabric (either inside or outside) until hot to the touch, and carefully pull the gasket off. 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 gloves.

URETEK (COATED NYLON) FABRIC

Warning: Excessive heat will melt the urethane coating causing the fabric to leak. 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. Heat the gasket until hot to the touch, and carefully pull the gasket off. 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 gloves.

Removal of gaskets usually creates some fraying of the fabric around the edge of the neck 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.

5. *If the original gasket was on the interior of the suit, the replacement gasket could be glued on either the interior or the exterior. These instructions detail an exterior gasket application.* Place 10 1/2" cardboard discs back to back and attach using tape, then cover completely with wax paper or plastic wrap. Place 6-8 strips of double sided tape around the perimeter of one side of the disc. Insert 10 1/2" disc into the garment, and center in the neck hole. Press about 1" of the fabric flat against the tape around the perimeter of the repair board so that it is as flat as possible. It will take some manipulation and patience to get the fabric flat, so take your time. Some small wrinkles are okay.

6. Pull the outer collar around and under the shape of the disc so that it's completely out of the way. With a razor blade, cut and remove any repair materials projecting past fabric edge. This prevents glue from drying on sticky tape and/or waxed paper or plastic wrap. (Careful not to cut the fabric!)

GLUING

1. Clean the gluing area on the old latex with alcohol or acetone before sanding. Then sand the old latex. Prepare the new gasket similarly. (Sanding before cleaning can rub contaminants in 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.

2. Cover 8" cardboard disc with wax paper or plastic wrap and insert into bellows (wide spot) of the new gasket.

3. Cut 6 – 8 strips of double-sided tape and space evenly around one side of your 9 1/2" cardboard ring. Insert base of new gasket through cardboard ring and fold back so that outside of base lays flat against tape strips on the cardboard ring. Slowly work your way around gasket, pressing out any ripples. Set the gasket down, centered over the opening and trace the outside perimeter of the gasket onto the fabric. Leave the cardboard forms in the gasket, and set aside.

4. Apply a moderate bead of AquaSeal® onto the fabric and spread it from fabric edge to the traced line.

5. Set the neck gasket on the wet glue. Manipulate it so that the edge of the neck gasket extends to the edge of the wet glue. Press with fingers to remove any air bubbles and to ensure the surfaces are in good contact.

6. Taking extreme caution not to allow glued surfaces to shift, place your large flat weight (covered with wax paper or plastic wrap if it's a favorite or borrowed book) on top of gasket so pressure is evenly distributed all the way around the edge.

7. Eight hours (or so) later, remove weight and all cardboard. (Take 10 1/2" disc and 8" disc out through the waist, not the neck!)

8. Inspect quality of glued area, touching up from the inside with AquaSeal® if necessary. While the bond may be strong enough for use by this point, a 24-hour cure time is recommended for best results.

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