




	Part Name / Description: Clear Silicone: Platinum, XCM, P10	Instruction #: OP100020	Page 1 of 4
	Operation Instruction Title: Platinum Silicone Application	Revision Date: 04/30/2018	Revised By: V. Frail
		Revision No. 1	Approved By: S. Ditner


Step (picture)	Step (Instructions)	Step (Tools Required)	Step (Safety & PPE)
	<p><i>Where should silicone be applied?</i></p> <ul style="list-style-type: none"> • Inside wall and base extrusions • On the joint between each panel and extrusion, inside and outside the cabinet • Along the manufacturing joint in the console • Around the temperature probe and back-up alarm insulation • Around installed dampers and fans, both inside and outside the cabinet • Between ECU supports and the wall • Around the edges of the ECU supports • Around each liquid tight 		
OP100020 Step 1	<p><i>Prepare the surface:</i></p> <p>Extrusions and panels:</p> <ul style="list-style-type: none"> • Dust all surfaces of loose debris • wipe all surfaces with a 50% solution of isopropyl alcohol and water <p>Concrete:</p> <ul style="list-style-type: none"> • blow all dust and dirt off concrete • wipe with a 50% solution of isopropyl alcohol and water • dry with a separate, clean cloth <p>Note: lint-free absorbent cloths must be used</p> <p>Note: do not use acetone-based cleaners. This will degrade the panels.</p>		<p>Throughout:</p> <p>Safety Shoes</p> <p>Safety Glasses</p> <p>Hearing protection as required</p> <p>Additional equipment as required by the site</p>
OP100020 Step 2	<p>Optional: Apply masking or painters tape to the adjacent areas to protect from silicone application.</p>		

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Step (picture)	Step (Instructions)	Step (Tools Required)	Step (Safety & PPE)
<p>OP100020 Step 3</p> 	<p><i>For internal joints:</i></p> <ol style="list-style-type: none"> 1. Apply silicone to one of the prepared surfaces in a continuous operation. Use positive pressure and push the sealant ahead of the application nozzle. 2. Quickly cover with the other surface to be bonded 3. Make any adjustments for square of machine immediately and secure. 		
<p>OP100020 Step 4</p> 	<p><i>For exposed application:</i></p> <ol style="list-style-type: none"> 1. Apply the silicone to the joint in a continuous movement. 2. Use positive pressure by pushing the sealant ahead of the application nozzle. 3. Maintain a steady rate of application to fully fill the cavity to be sealed. <p>Note: The tip supplied with the silicone is small enough for the application, and should not be trimmed.</p>	<p>Caulking gun</p>	

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Step (picture)	Step (Instructions)	Step (Tools Required)	Step (Safety & PPE)
<p>OP100020 Step 5</p> 	<p>Tool the silicone by using a finger to drag down the line of silicone, forcing it into the joint.</p> <p>Remove excess silicone from the finger frequently using a clean rag to ensure a clean application.</p> <p>Note: work in small areas at one time. Caulk one line and tool before continuing.</p>		
<p>OP100020 Step 6</p>	<p>Remove the masking or painter's tape once the silicone has been tooled.</p>		

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Step (picture)	Step (Instructions)	Step (Tools Required)	Step (Safety & PPE)
<p>OP100020 Step 7 <i>Unacceptable Silicone</i></p> 	<p>Inspect all silicone. It should barely be visible but completely cover the joints.</p> <p>There should be no globs or raised areas of silicone.</p> <p>Inadequate applications should be removed and re-applied.</p>		

Additional references:

- <https://www.youtube.com/watch?v=a9H0sTTgAOQ>
- http://www.paintpro.net/articles/pp706/pp706_caulking_tips.cfm