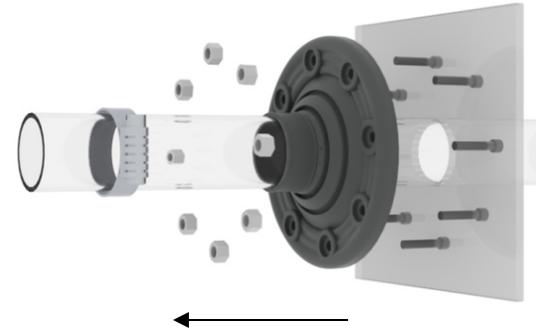


Icon Repair Instruction for Filled Encapsulation Design Fittings “IRF (M-XXL)*.*” Split Repair Part Numbers – Direct Replacement Option

STEP 1

Identify the damaged fitting and select the proper Icon repair fitting based upon the fitting design and the pipe OD. Icon technical support can assist in the fitting specification. Please provide pictures and other information to assist in this process. It is important to prepare the surface where the fitting will be placed. Remove existing fitting if applicable, and remove any existing residual gasket sealant that may be in the way. Clean the surface with Acetone or Isopropyl Alcohol to remove any contaminant that would prevent a flush seal by the repair fitting. Save the nuts and metal compression ring for possible re-use.



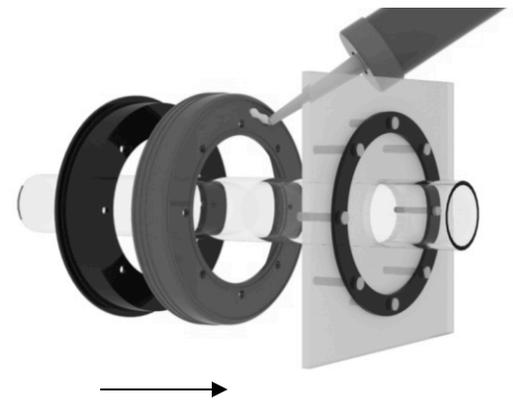
STEP 2

Assemble the repair fitting parts over the pipe to determine the sequence of installation based upon the space you have to work with. All flexible split fitting parts except the rigid nylon ring must be bonded together with FastFuse solvent. This is done by first ensuring that the split surfaces are clean and dry. Apply a liberal amount of FastFuse to both surfaces, and then hold the seam closed securely for four (4) minutes without movement until it is bonded sufficiently to let go. It may be helpful to use the band clamps to loosely hold the seams together during the additional curing period. The FastFuse bond will be fully cured in 40 minutes. This is called the rule of “4 & 40” in our training.



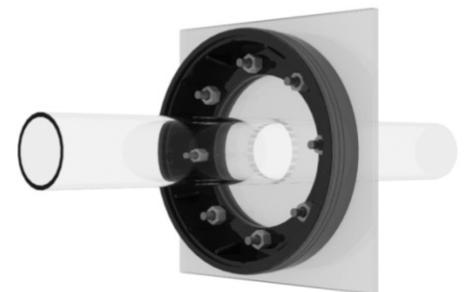
STEP 3

Once all Icon approved split components are bonded and cured, apply a bead of gasket sealant to the backside of the gasket or to the sump wall. Sikaflex 1a or Icon PetrolSeal are the authorized sealants for this step (part #'s: IAC Sika10 and IAC PSeal200). This will help fill in any defect in the surface of the sump wall or around pipe, and assure a tight seal when the fitting is compressed. In every “Encapsulation” design fitting kit, Icon supplies a “flat” and “curved” wall gasket. Make sure you are using the correct gasket for the sump type. Rotate the “curved” gasket, as applicable, so that it fits the studs and general curvature of the sump wall. Insert the nylon ring into the gasket and position the ring onto the existing studs and against the sump wall.



STEP 4

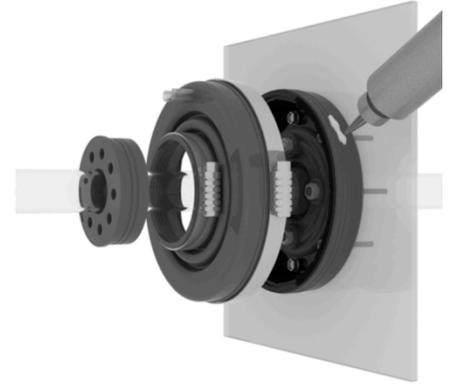
Reinstall nuts if usable, and tighten them in a star pattern for an even and flush fit on the sump wall.



Icon Repair Instruction for Encapsulation Design Fittings “IRF (M-XXL)*.*” Split Repair Part Numbers – Direct Replacement Option

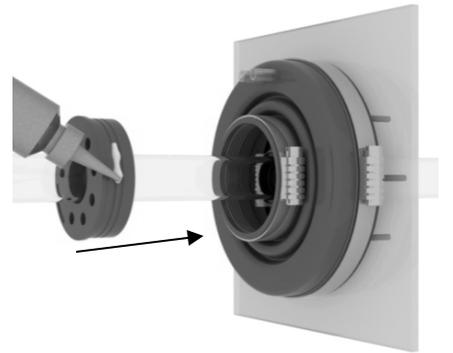
STEP 5

Apply a liberal amount of FastFuse along the gasket side wall and install the outer fitting boot onto the gasket. Make sure that you rotate the boot vent tubes at the 12:00 position as much as possible to facilitate a better fill process. Install and tighten the band clamp securely around the boot to get a seal between boot and gasket. You do not need to wait for any cure time to continue the next steps. FastFuse will permanently bond the boot to the gasket during the remainder of the process.



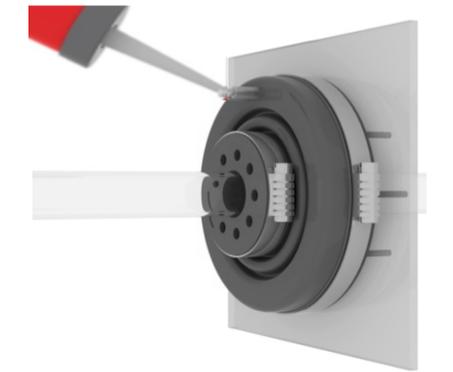
STEP 6

As applicable, apply FastFuse to the inside of the boot mouth and around the side of the insert, if one has been supplied. Push it into the boot mouth. Install and tighten the band clamp securely around the boot mouth for a tight seal around the pipe. You do not need to wait for any cure time to continue the next step. FastFuse will permanently bond the boot to the insert during the remainder of the process.



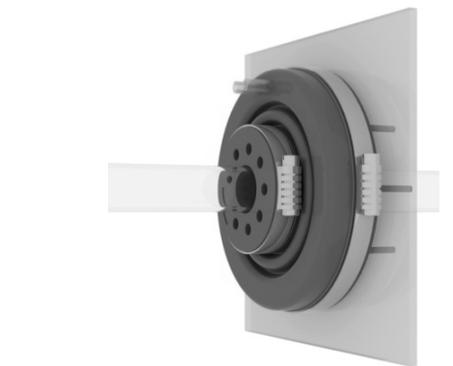
STEP 7

The Encapsulation design fittings are equipped with two tubes, one to fill through and the other to vent air out. Fill the fitting with Icon approved “FastFill” filler (part #: IAC FastFill) through one of the tubes that has been aligned at the 12:00 position. Fill until the entire cavity of the boot is full and the material is beginning to come out the vent tube. FastFill is a two-part, very low viscosity rubber compound that sets up quickly. In 15 minutes or so it will have gelled sufficiently to move to the next step. FastFill is dispensed with a 20oz Cartridge dispensing gun, part #: IAC MGun20.



STEP 8

When completed, you may start testing to confirm a successful repair. The fill and sealant may not yet be completely cured, but there is sufficient cure and seal when completed with the installation that testing may start.



NOTE

If you have several fittings in a sump to repair, it is best to rotate the more significant repair steps in a sequence from fitting to fitting rather than try to complete the entire process with each individual fitting before moving on to the next. A rotation procedure will greatly decrease the time involved in a multiple fitting repair.

