

WATERTIGHT SEAL LUBRICATION

Subject: Relubrication of the Watertight Seal on Series 90-Coded/005 Pushbutton Switch Assemblies.

Purpose: To insure a watertight joint between the Pushbutton Seal and the Seal Retainer Collar when the Pushbutton has been removed from the Switch Assembly and is to be reinstalled.

Materials:

-Silicone Grease, Dow Corning EM-50L.

-Stiff bristled brush such as an acid brush.

*(Caution: Do not use Q-tips as the cotton fibers come loose and become embedded in the lubricant which could compromise the integrity of the seal.)*

-Finger cots recommended as silicone grease is difficult to wash off hands and fingers.

-A supply of wipes such as paper towels or lint-free tissues.

Procedure:

1) Inspect the area around the gland between the Seal and the Retainer Collar for contamination or foreign materials. The gland area of the Seal and the Collar must be clean.

2) Using a stiff bristled brush, apply a coating of EM-50L Silicone Grease in the groove of the Seal Retainer on all four sides and corners.

*(Caution: Be very careful not to get grease on the Face-plate of the Pushbutton as cleaning it off the textured surface will be very difficult if not impossible.*

3) With the skirt of the Seal turned upward and inside out, orient the Pushbutton correctly and install it in the Switch.

4) Roll the skirt of the Seal down over the Retainer Collar. Tuck the rubber ridge, inside the Seal, well into the groove of the Retainer Collar on all sides. Pinch the skirt of the Seal at one corner to allow trapped air to escape from the groove, then tuck that corner into the Collar also. It is very important to the integrity of the watertight seal to make sure that the ridge of the Seal is seated all the way home in the groove of the Collar on all sides.

5) Wipe away any excess grease as required for appearance.