

**Description:** This procedure describes the replacement of the fender gasket material with a silicon foam rubber gasket material (CiDRA P/N 52305-04) adhered to the fender with RTV adhesive (CiDRA P/N 52118-01). The gasket material called out in Table 1 (Gasket Kit length by Pipe Diameter) is for (1) fender section, (4) fender sections are used per cover. One tube of RTV will be supplied for up to (4) fender sections.

**Procedure:** Refer to Figure 1

1. If necessary, remove existing Gasket material from the Fender. Ensure surface is clean.
2. Cut piece of gasket material to just beyond the inner diameter length.
3. Apply 1/8" bead of RTV 108 onto entire length of INNER DIAMETER. Apply bead approximately 3/16" from edge.
4. Install the Gasket onto the RTV. Leave extra length on both ends, ends will be trimmed later.
5. Cut a piece of Gasket material approx. 6" long.
6. Apply 1/8" bead of RTV 108 approx. 6" long centered on the OUTER DIAMETER. Apply bead approx. 3/16" from edge.
7. Install 6" long gasket onto the RTV.
8. Allow to dry for 12 hrs.
9. Cut INNER DIAMETER gasket flush with fender edge.

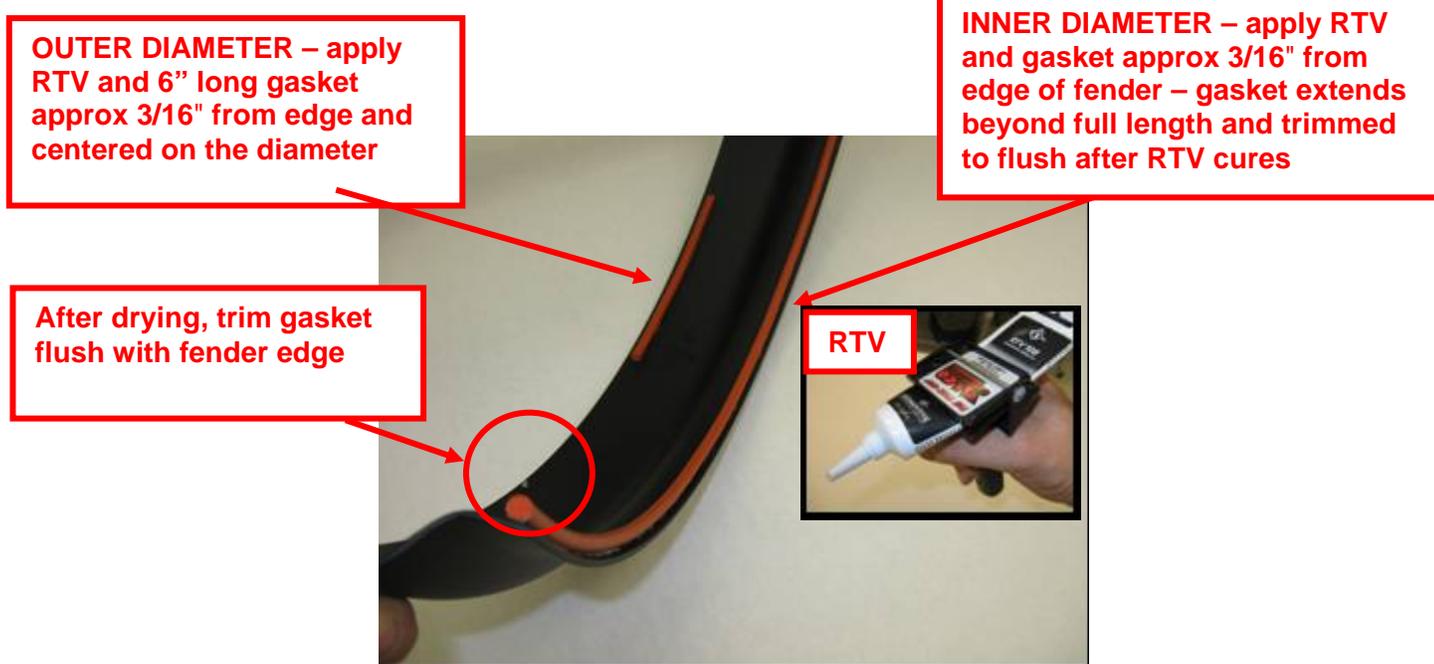


Figure 1 Fender Rework



# SONARtrac<sup>®</sup> Rework Instruction

**Subject: Rework Fender  
Assembly Gasket Material**

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**Table 1 – Gasket Kit length by Pipe Diameter**  
(Includes enough material for one outer and inner diameter gasket)

Pipe Size	Gasket Length (For 1 fender)	Gasket Length (For 4 fenders)
18 inch	3.00 feet	12.00 feet
20 inch	3.25 feet	13.00 feet
22 inch	3.50 feet	14.00 feet
24 inch	3.75 feet	15.00 feet
26 inch	4.00 feet	16.00 feet
28 inch	4.25 feet	17.00 feet
30 inch	4.50 feet	18.00 feet
32 inch	4.75 feet	19.00 feet
36 inch	5.25 feet	21.00 feet

NOTE: One tube of RTV will be supplied for up to (4) fender sections

## Document Change History

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