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EAST COAST SEALING SYSTEMS, INC.

A.W. **CHESTERTON**® DISTRIBUTORS

April 14, 1987

Morris Humphrey
Utilities Branch
Base Maintenance Division
Bldg. #1700 Outside Steam Distribution
Camp Lejeune, N.C. 28542

Dear Morris,

Per our phone conversation, by using this substitute (silicon based lubricant) all repairs using Chesterton's NR 835 Underwater Metal Repair will fail. It is stipulated in the Metal Repair booklet enclosed in each box, that the surface coated must be grease free. Using a silicon base lubricant will not provide a grease free surface. Enclosed is a section of our Metal Repair System Manual about degreasing. It points out that even some of our own solvent based cleaners are unacceptable and should not be substituted for NR 261 Safety Solvent.

I trust this information to be helpful in providing you with the best possible procedure for surface preparation, to assure a successful repair using Chesterton's NR 835 Underwater Metal Repair.

Sincerely,

Bill Betts
Bill Betts /clb

BB/clb

Enclosures

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DEGREASING

Oily surfaces can result from incidental or accidental contact with oily substances, from immersion in oil, or from the use of metal working lubricants. The degreasing of surfaces immersed in oil are usually the most difficult to accomplish.

A hydraulic ram is an example of a part that would be immersed in oil and surfaces which are machined prior to the application of the METAL REPAIR products would be contaminated with metal working lubricants.

None of the METAL REPAIR products will adhere to an oily surface. It is essential that all surfaces to which these products are to be applied are thoroughly degreased.

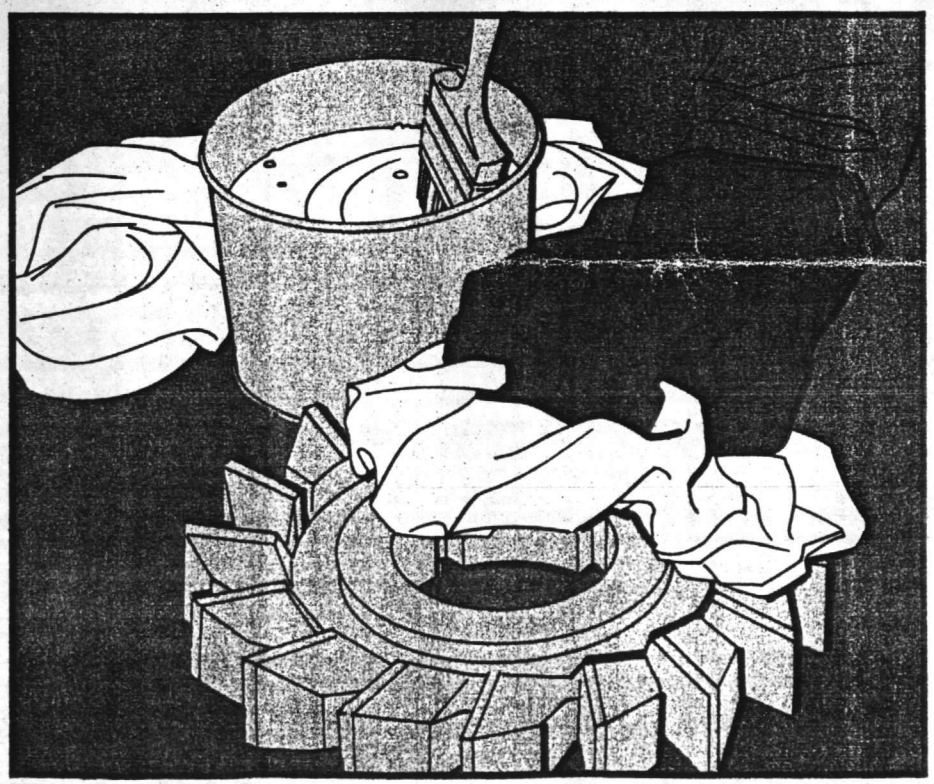
Unless otherwise specified, CHESTERTON® NR. 261 SAFETY SOLVENT CLEANER should be used for degreasing. The other Chesterton solvent cleaners evaporate too slowly to be used and competitive products of unknown composition should not be used.

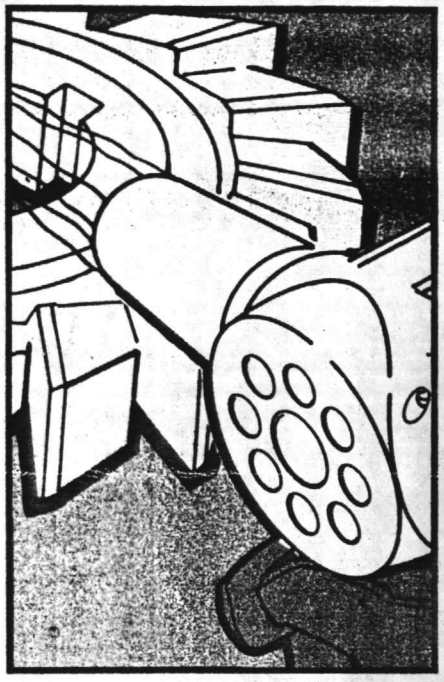
1. Apply Nr. 261 to the surface and wipe with a clean cloth.
Turn the cloth frequently and replace the cloth often to avoid recontamination of the surface.
Before applying Nr. 261 to plastic or painted surfaces, check for compatibility to insure the solvent does not attack the plastic or paint.

6. The last step in the cleaning process is always degreasing the surface with CHESTERTON® NR. 261 SAFETY SOLVENT CLEANER.
See the paragraph on Degreasing.

7. The repair should be made as soon as possible after the cleaning process has been completed to avoid the formation of flash rust or oxidation and the recontamination of the cleaned surfaces.

8. After cleaning, try to avoid handling the cleaned area to prevent recontamination.
If handling is unavoidable, wipe down the surface again with Nr. 261 just prior to the application of the product.



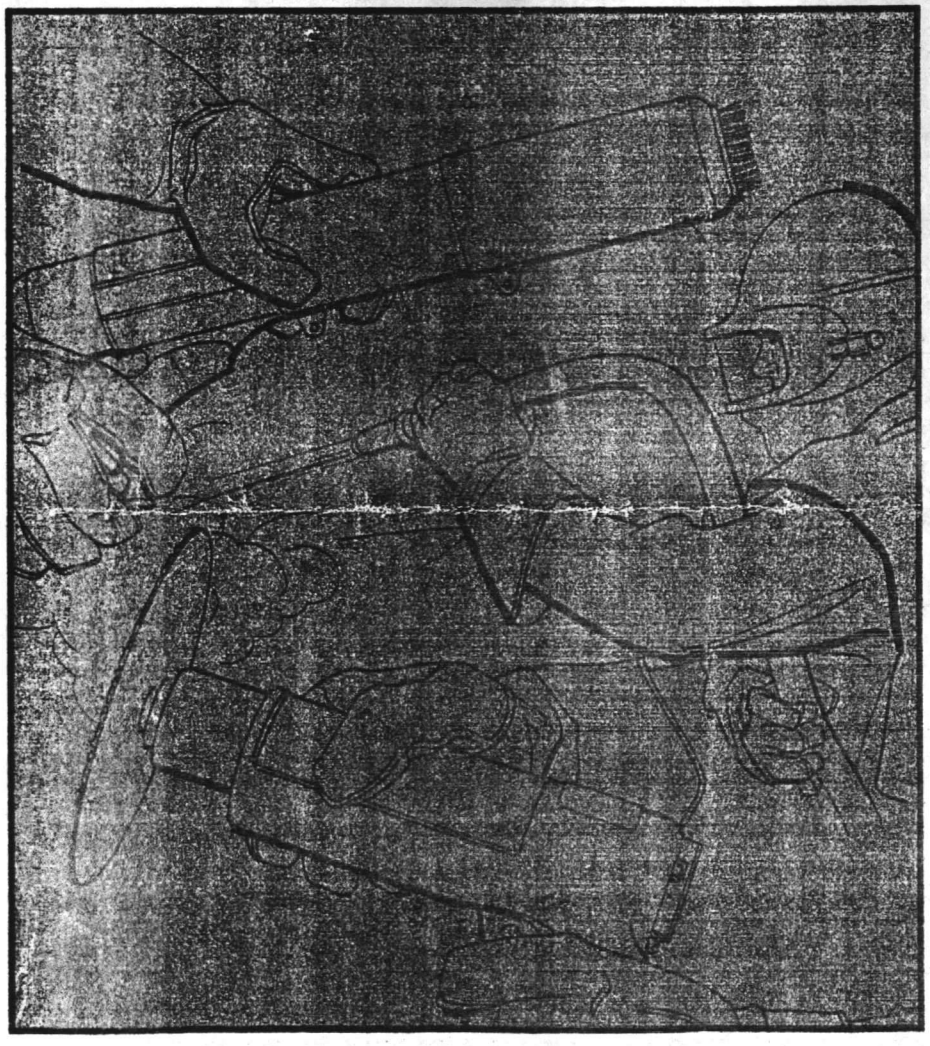


2. Absorbed oil from surfaces which have been immersed should be removed by heating. First, wipe off the excess oil with Nr. 261. Then heat the surface to force the oil out of the pores. The heating can be done in an oven or with an open flame or an electric heat gun.

Do not use an open flame on a surface which will be damaged by heat or is combustible nor in an area where there is a flammability or explosive potential.

2A. Allow the surface to cool and wipe it down again with Nr. 261. Repeat this procedure several times to insure that all of the oil has been removed.

3. Always degrease just prior to the application of the METAL REPAIR products.



SURFACE ROUGHENING

Roughening the surface increases the surface area and adhesion sites, resulting in better adhesion of the product to the surface.

1. If the surface was cleaned by abrasive blasting, grinding, or needle gun the surface should be sufficiently rough.

2. When the surface needs to be roughened, one of the above methods can be used. Otherwise, coarse abrasive paper or a rasp file could be used.