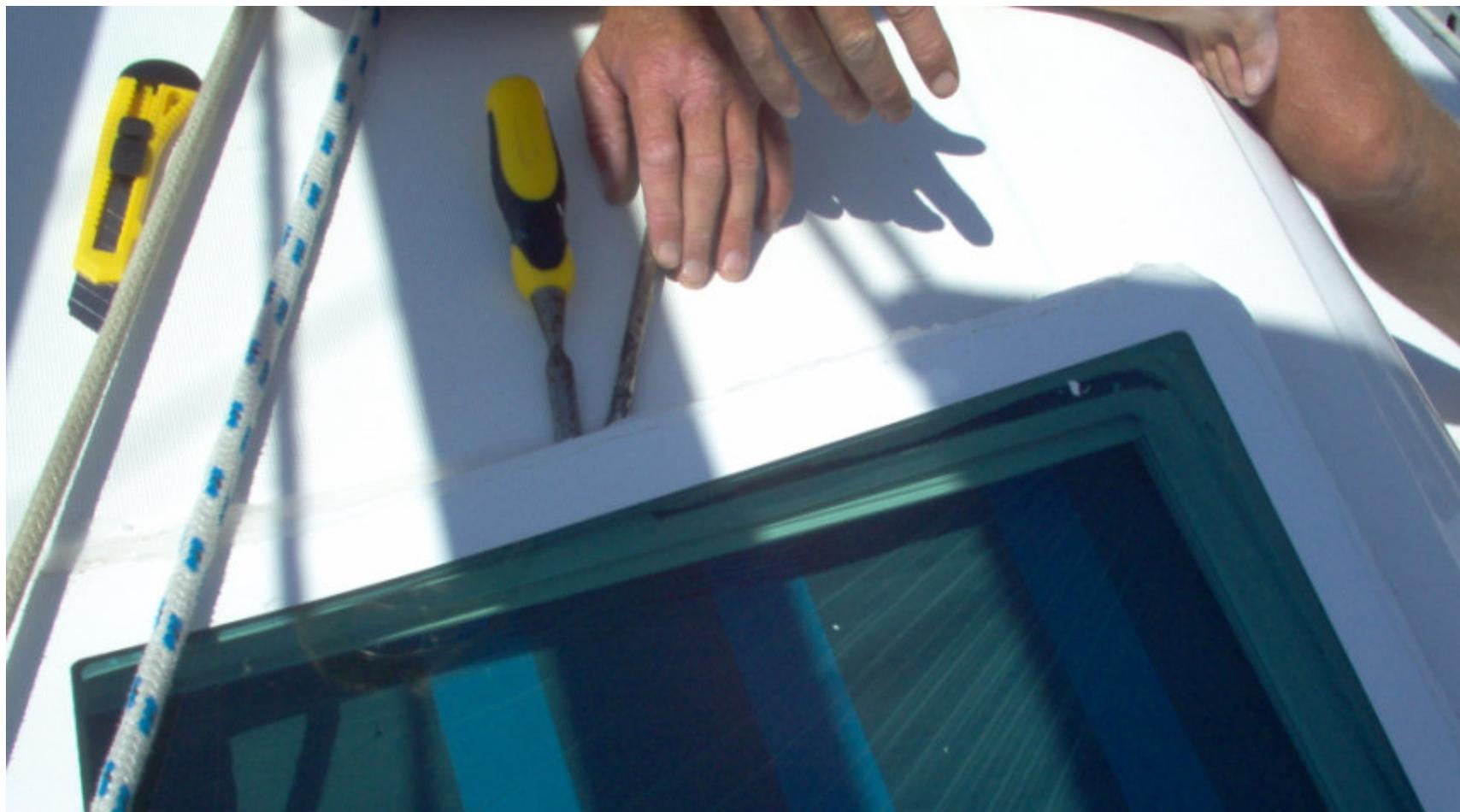


Cover the inside of the skylight with plastic. Make sure it is very secure.



Begin by removing the sealant in one of the corners. Alternating chisel and large screwdriver worked well.



It might be necessary in some locations to drive the chisel with a hammer.



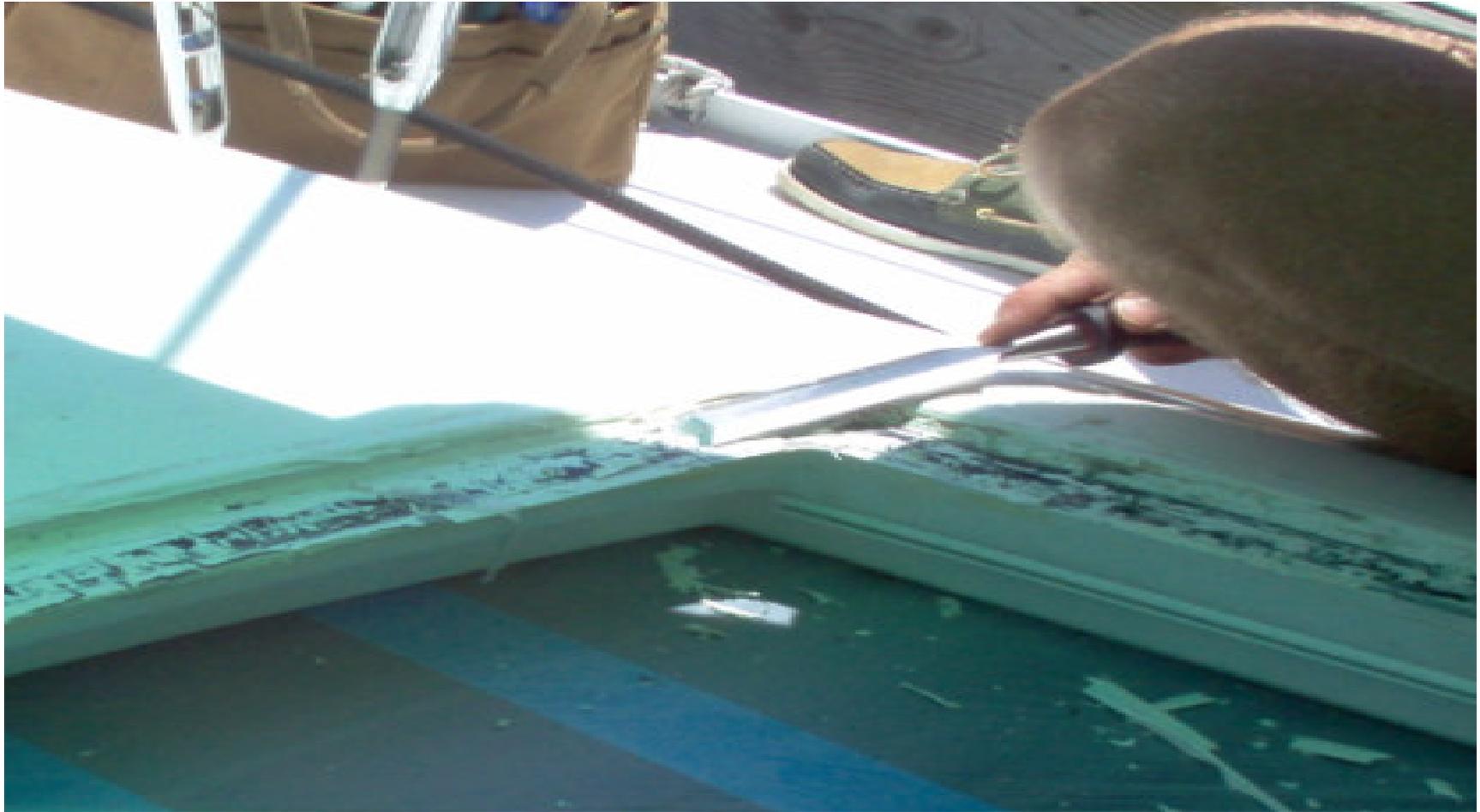
Continue to alternate chisels and large screw driver



Work the perimeter of the window



Remove any of the old adhesive



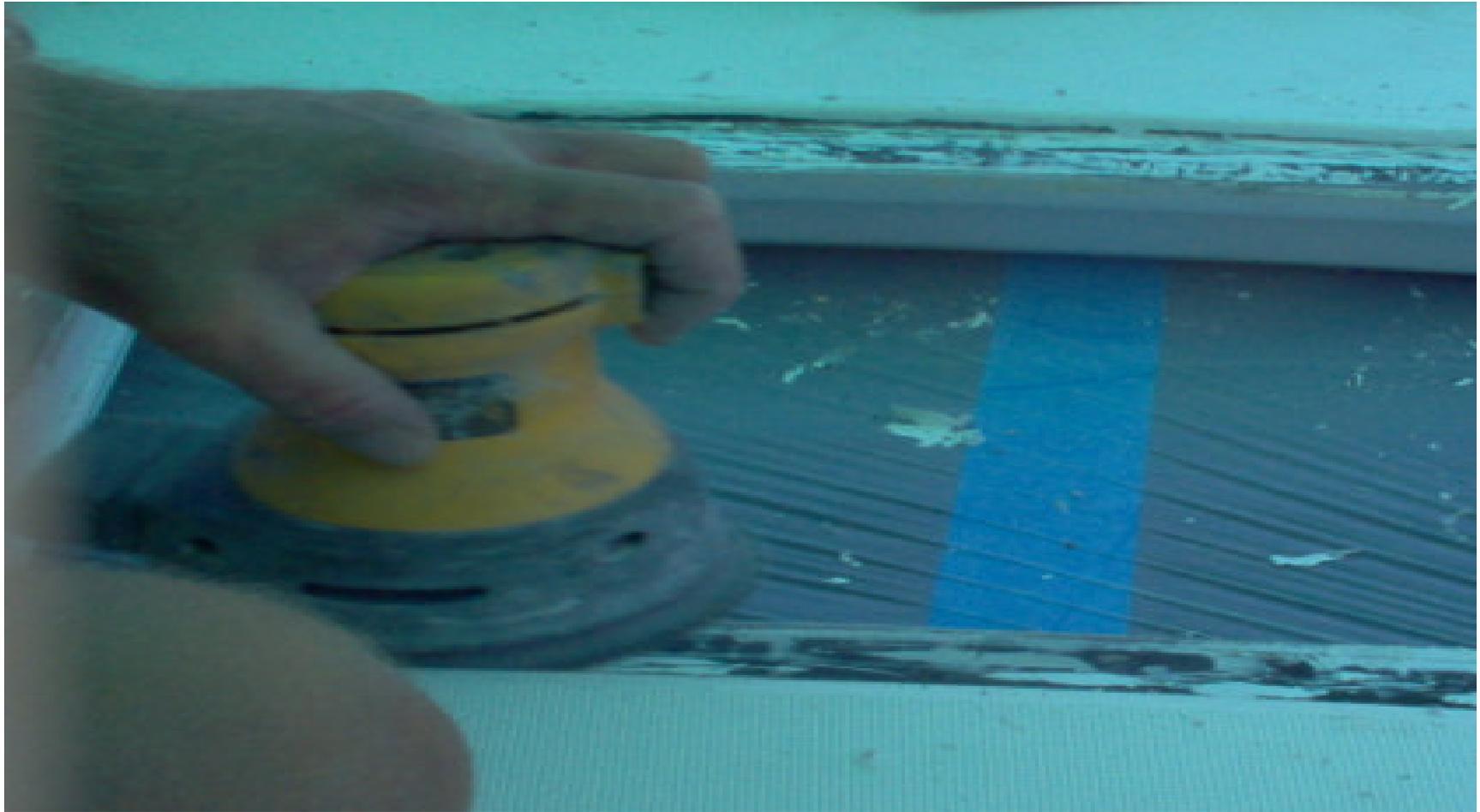
Identify and fill any voids



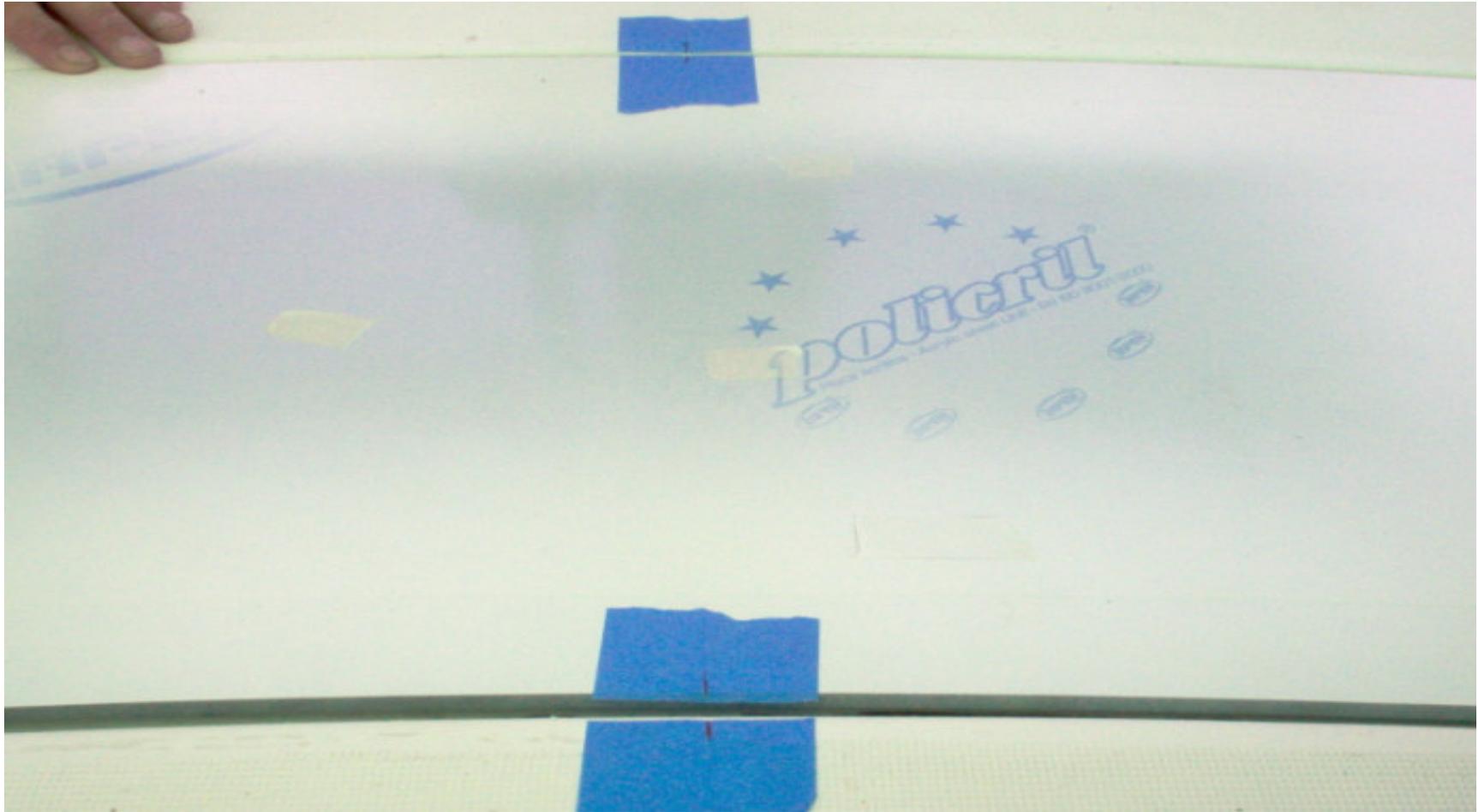
Sand the recess with 120 grit.



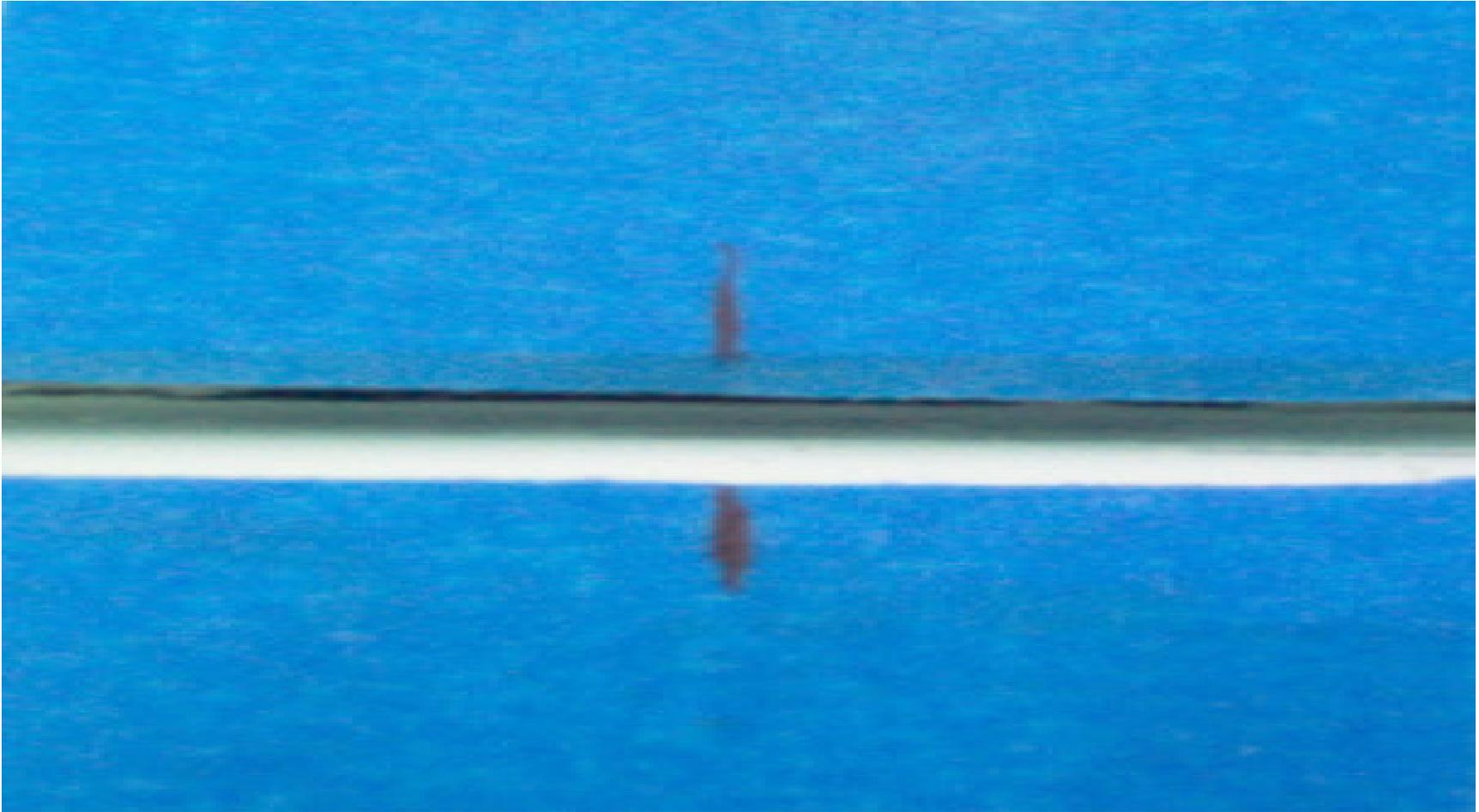
Remove the old adhesive. Vacuum and prepare for pre-fit



Align the window. Check the gap at the top and on both sides. Make them uniform. Put a piece of tape at the top and bottom of the middle of the window. Mark your center points.



Centering points



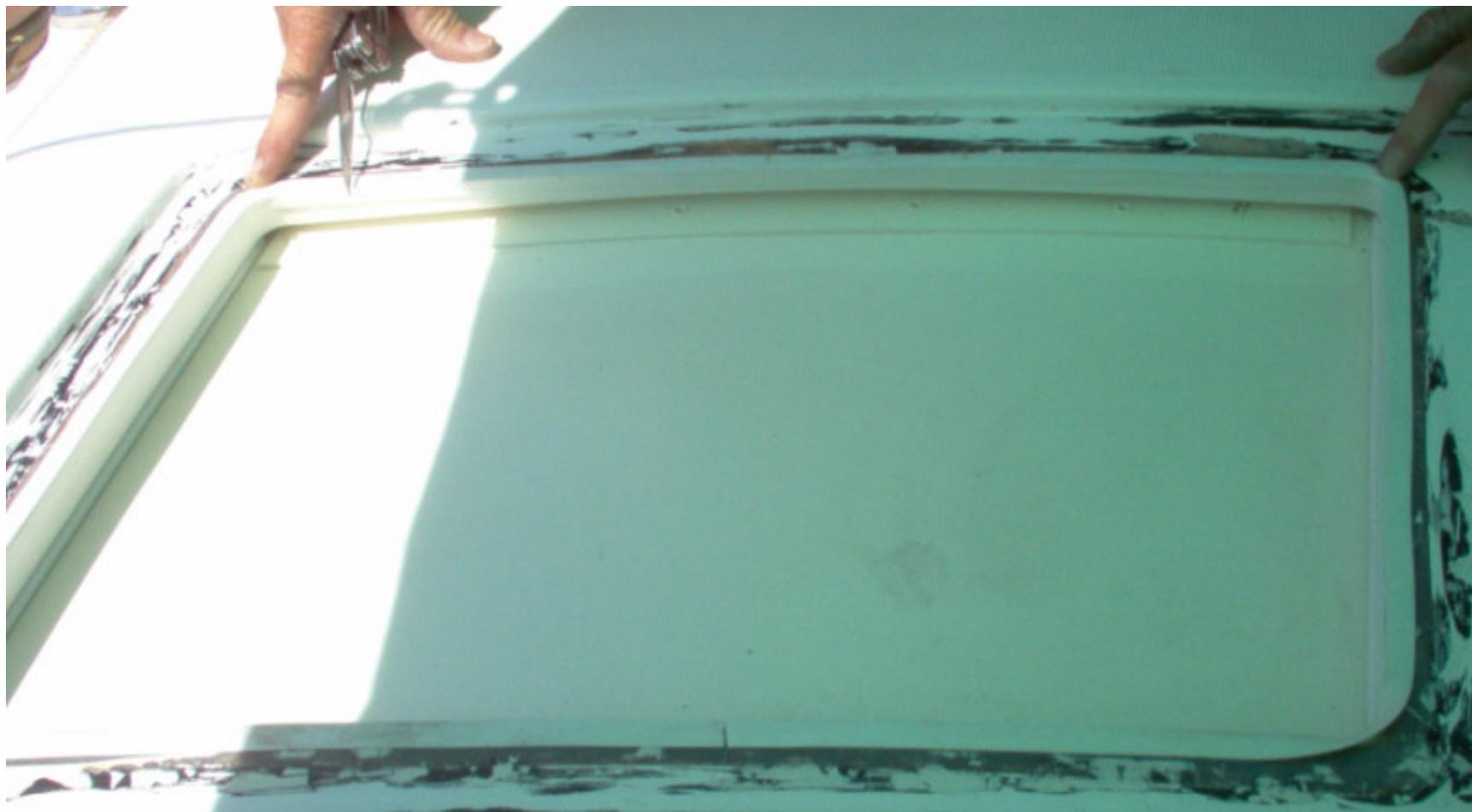
Cover to keep adhesive cooler, protect from elements.



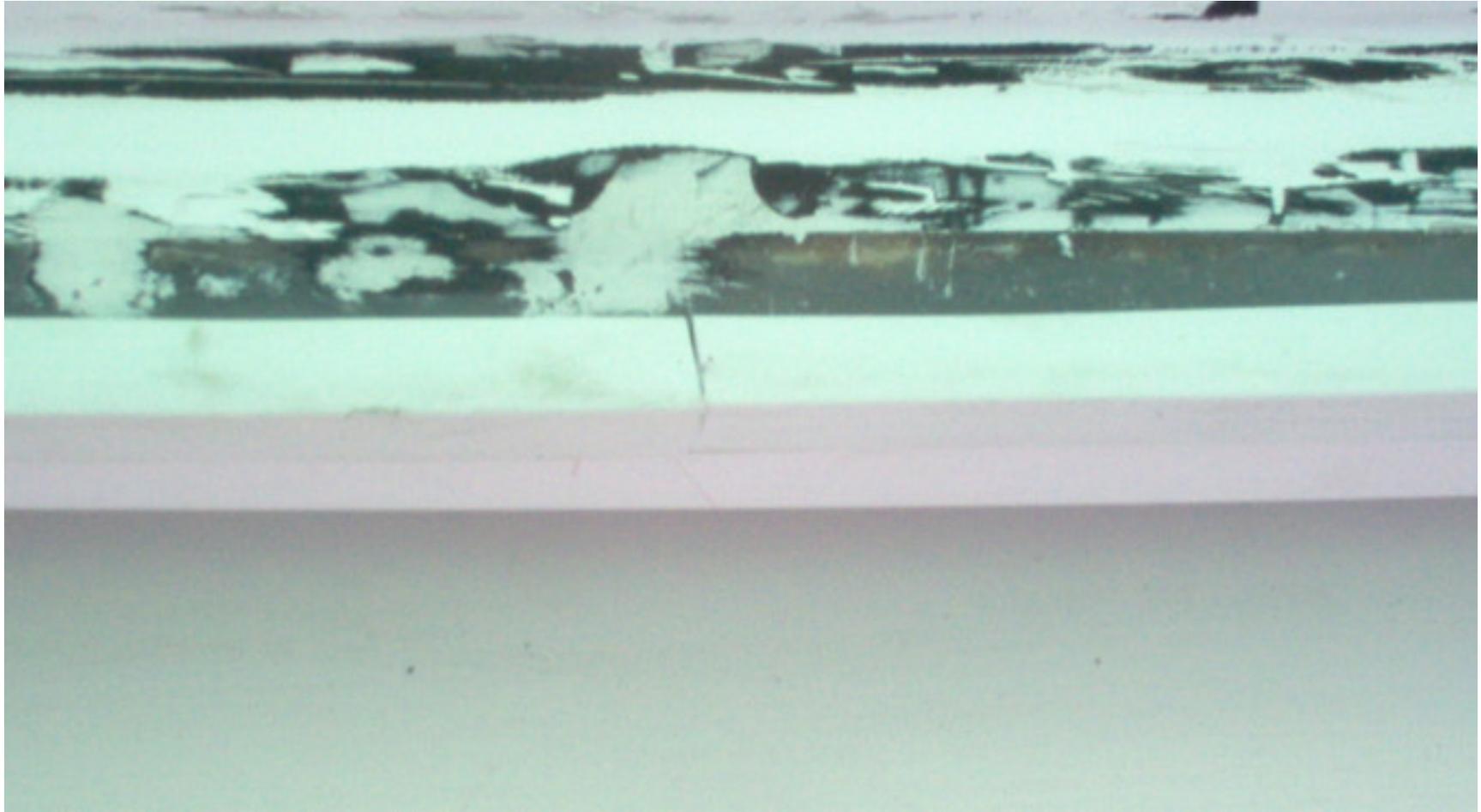
Clean well with acetone



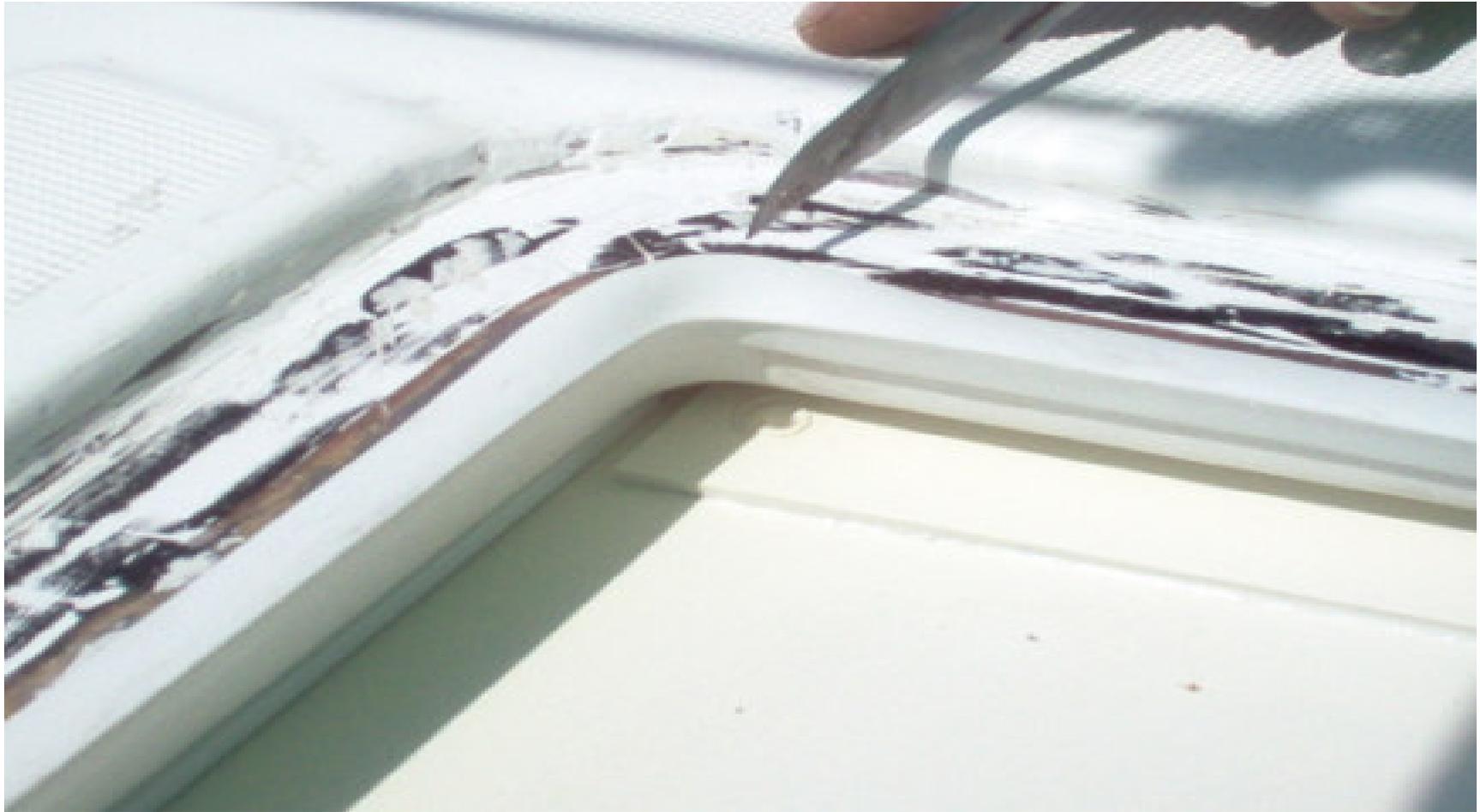
Apply the EPDM weather-stripping trim. Make sure to have your seam at the top of the window. It is less visible from inside the boat.



Seam at top of window



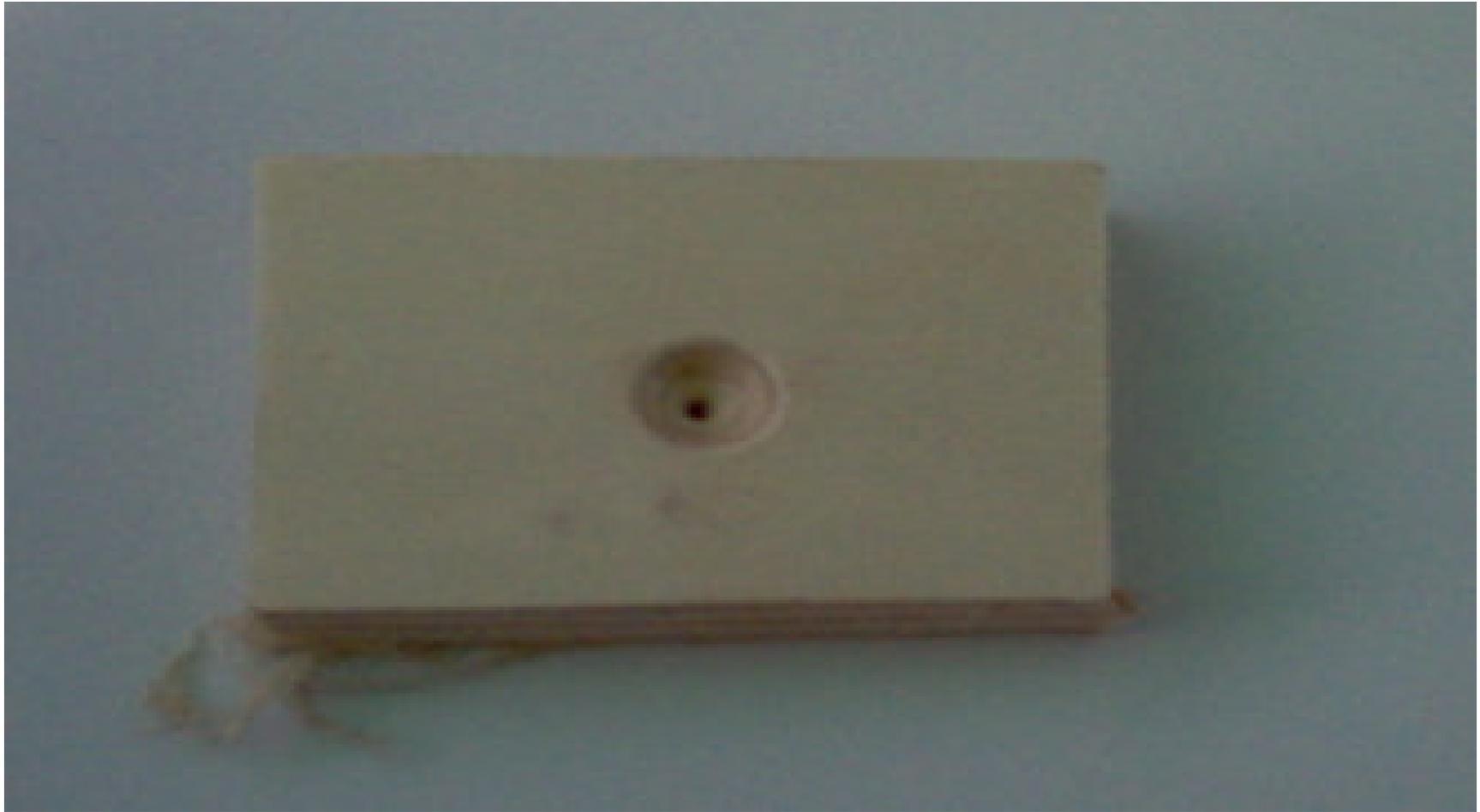
Note the corners tend to lift.



Super glue the corners



3x3 inch pre-drilled block of wood used as cleat

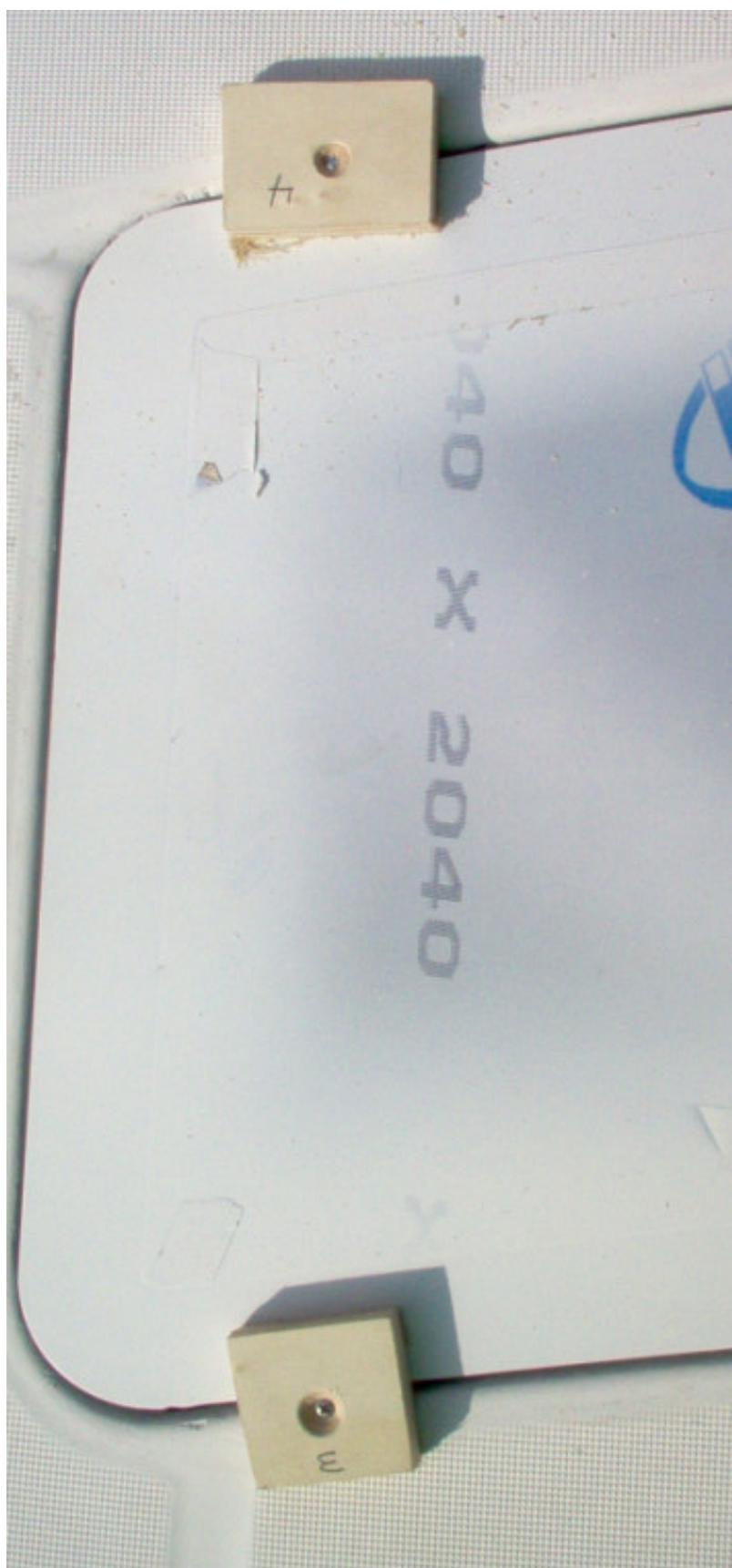
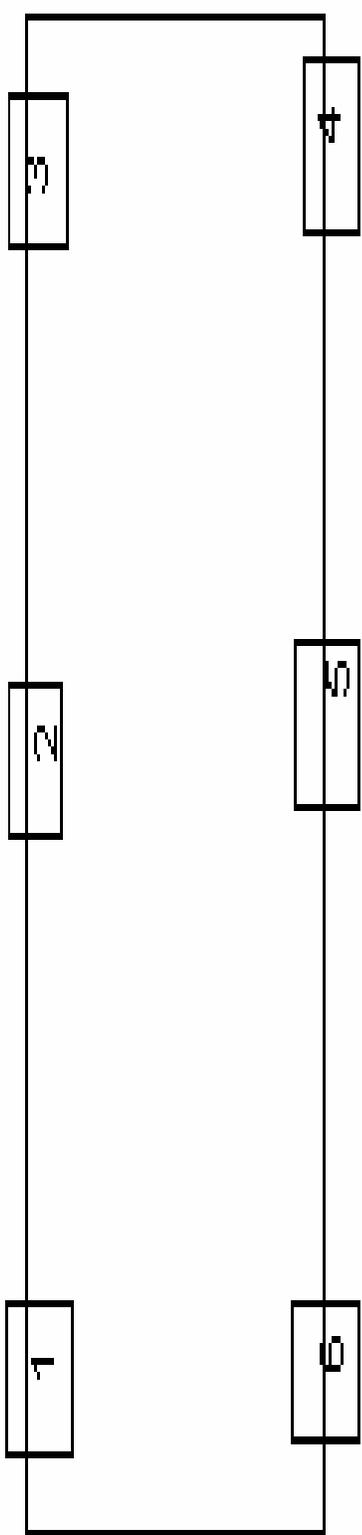


Pre-fit the cleats. Put them on all 4 corners. Also, put 2 cleats center of the window, top and bottom. Note the numbers on the cleats.



Middle cleats

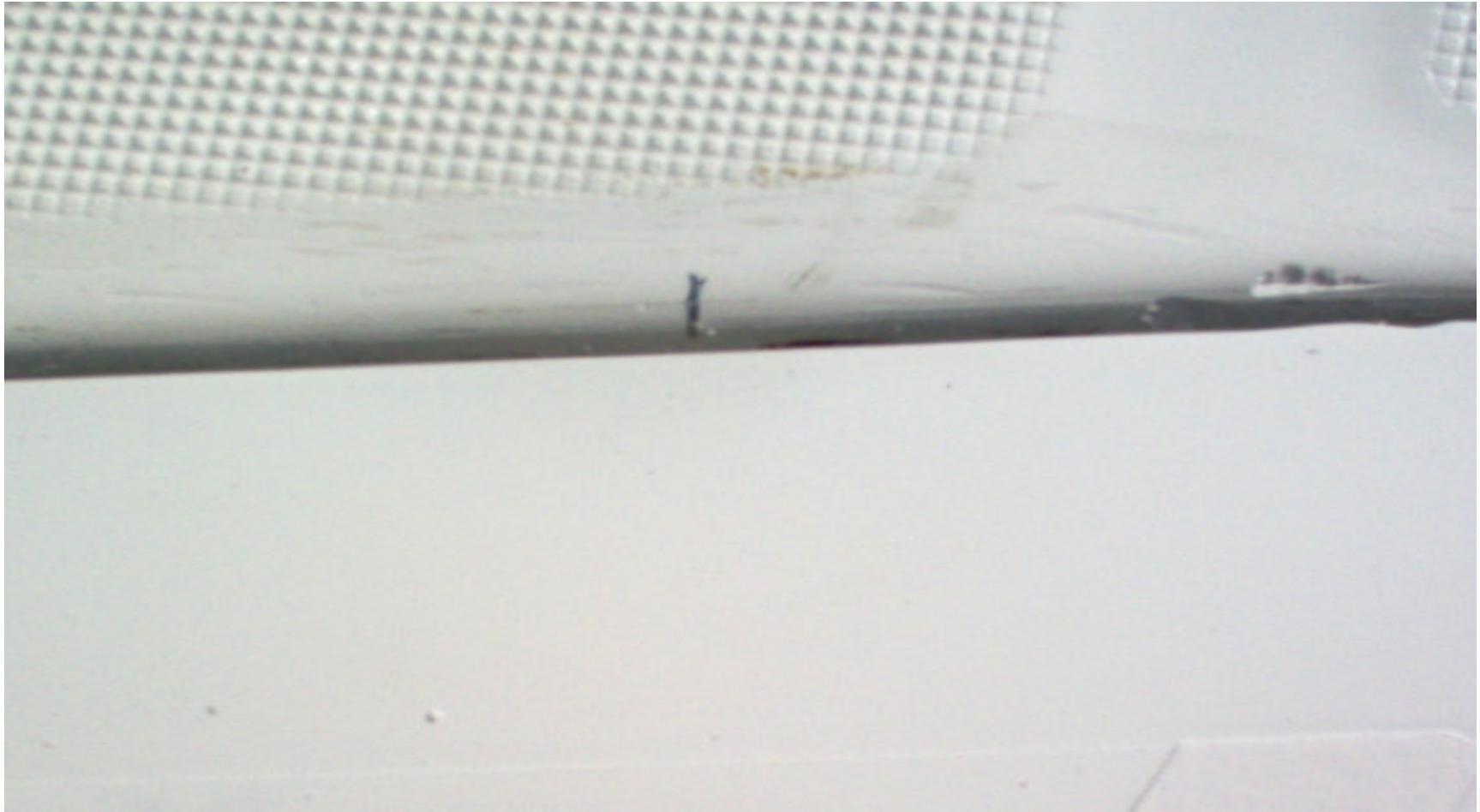




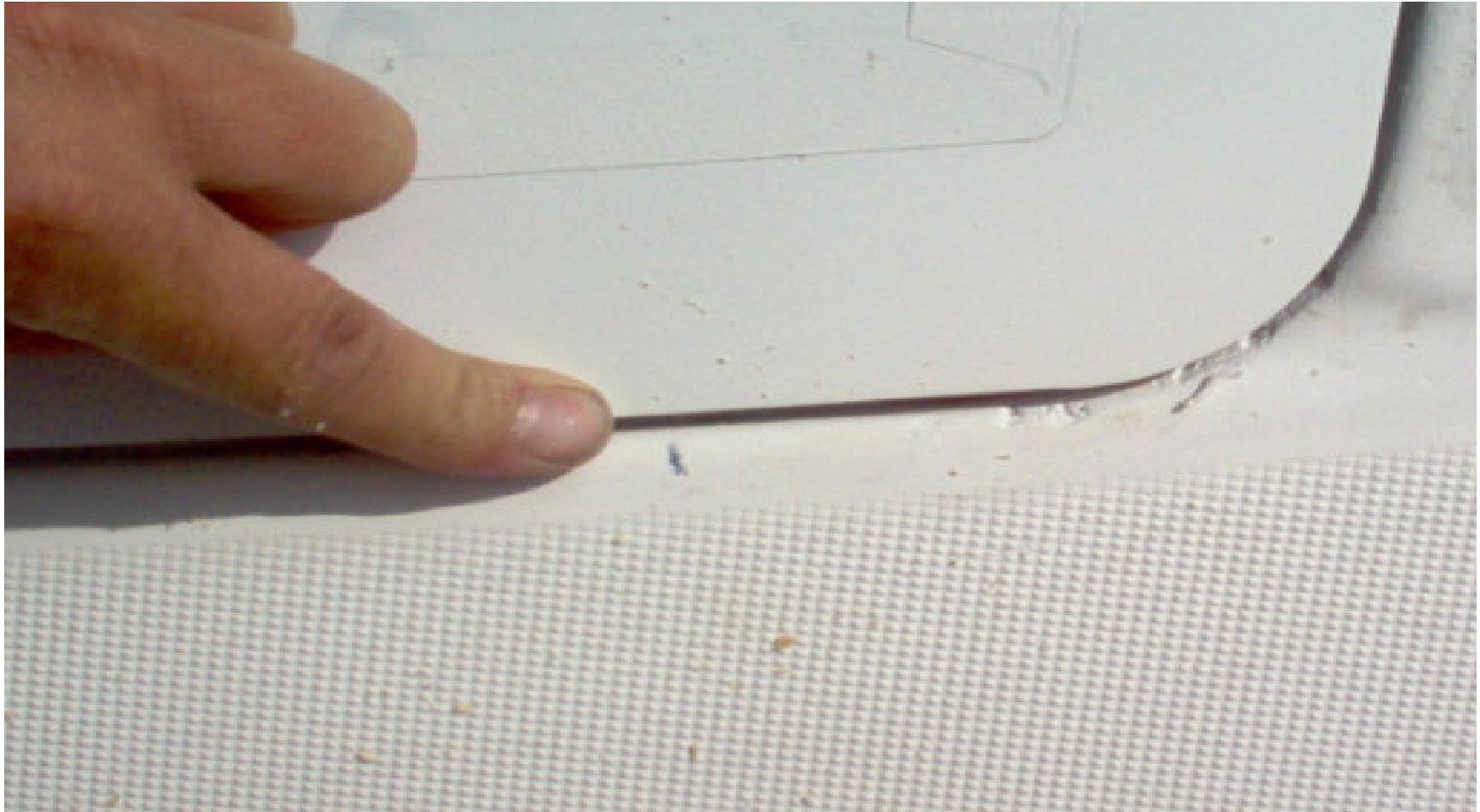
Secure the cleats. Make sure to mark the cleats. See previous slide.



After removing the cleats, mark the screw hole.



Location of screw



Tape the perimeter of the window.



Newborn caulk gun accommodates the sausage tubes. These are very handy tool. They can be purchased at <http://www.loghelp.com/tools/apeqquip.html>



Carefully sand the window groove with 120 grit. Clean the window.



Brush on primer. Careful to cover all of the surface area



Apply primer to window



Make sure to primer center of window



Cut the tube in a “V” shape.



Apply a continuous bead of adhesive. Minimum height of the bead should be 10mm. Our field repair was more like 12mm.



Remember to apply adhesive to the middle of the window



Field repair was done at 94 degrees in the shade. It took approximately 5 minutes to apply the adhesive. We noted no skim on the adhesive



Notes

- Center the window. This requires two people on port and starboard side of window. Apply pressure with knees to sides of window. Secure the two middle cleats. Secure the sides of the window. Make sure to pull the window down flush.
- Careful not to get any adhesive on your shoes or pants. It can make a big mess.

Notes

Check on the inside of the boat for any adhesive.

The adhesive is easier to clean after it has cured.

It tends to smear and makes more of a mess.

Remove cover from over window.

- It needs 24 hours to cure.
- Remove the cleats and tape.

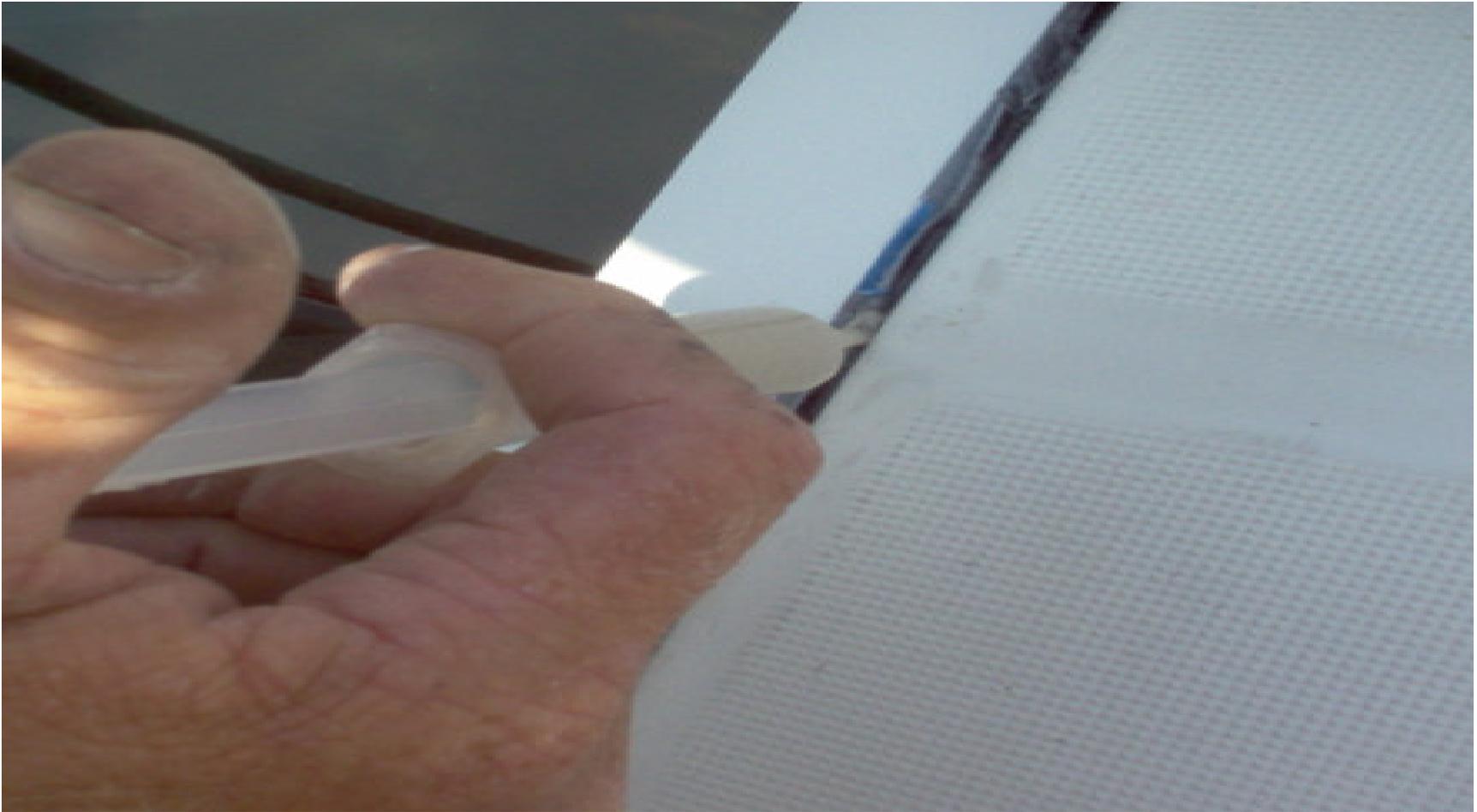
Check the seam with a plastic spatula. Drag the spatula around the perimeter of the window checking for high spots. You will need to trim any area where the spatula touches the adhesive. This is in preparation for the sealant.



Carefully remove the protection



Fill the screw holes with epoxy. We marked on the deck the location of each screw hole. Actually, they were quite easy to find.



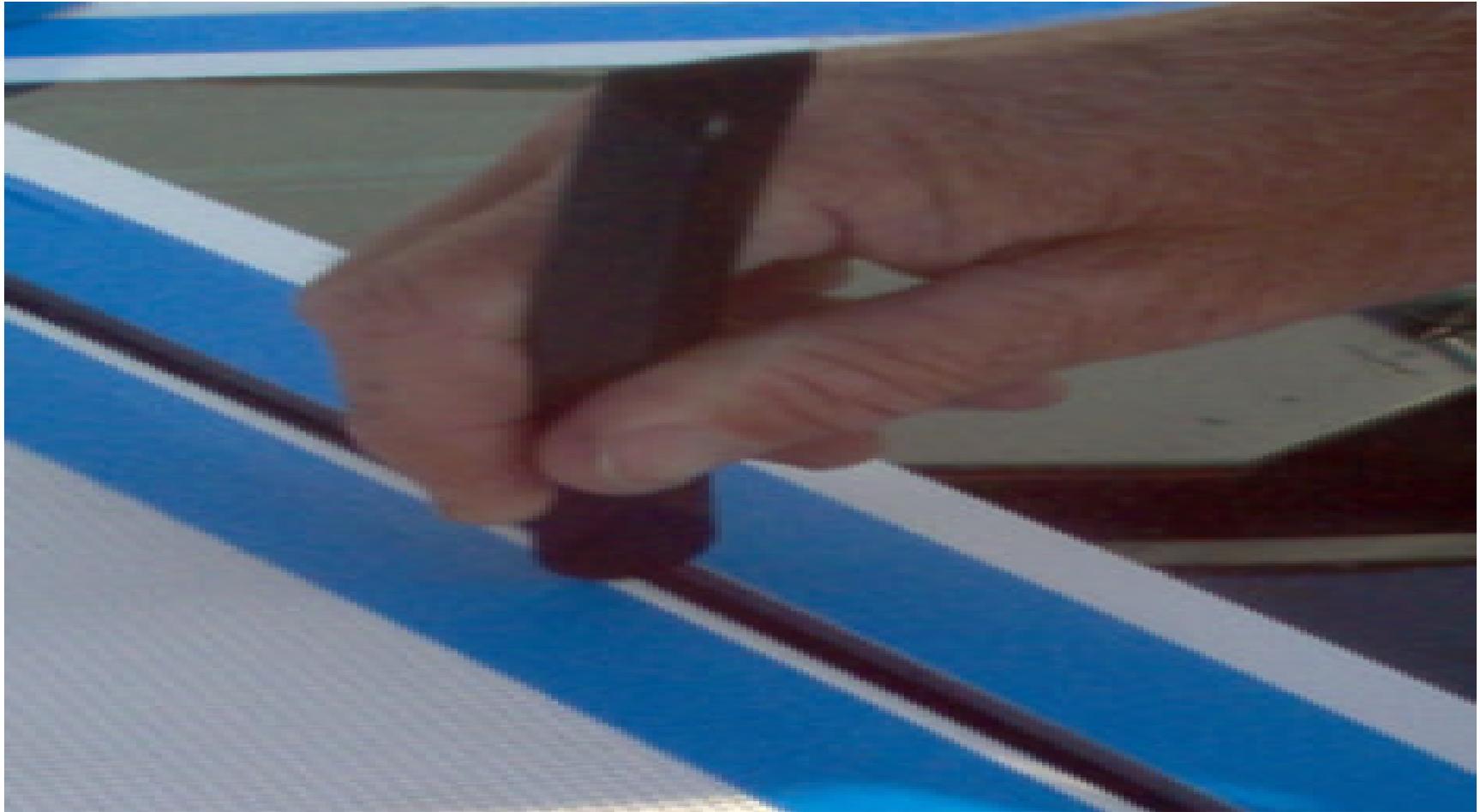
Check for leaks

- After the epoxy has hardened.
- Run water over the window. No need to spray directly on the seam. Just lay the hose on the top side of the window.
- Allow generous flow for at least 5 minutes.
- Check for any leaks.

Tape the window. You need about the width of the spatula between the two pieces.



Check the gap with your spatula.



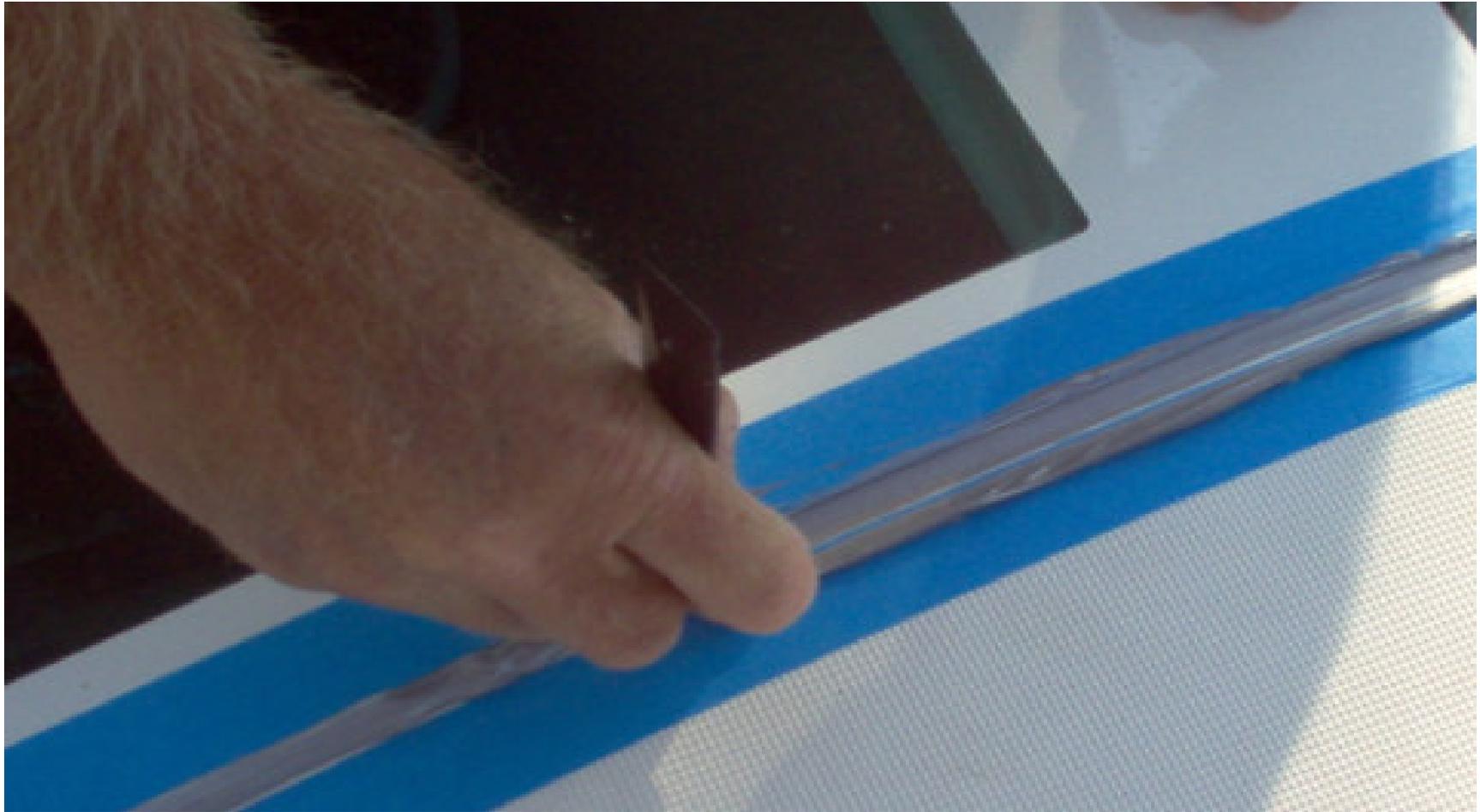
Taped window. Makes for much easier clean up.



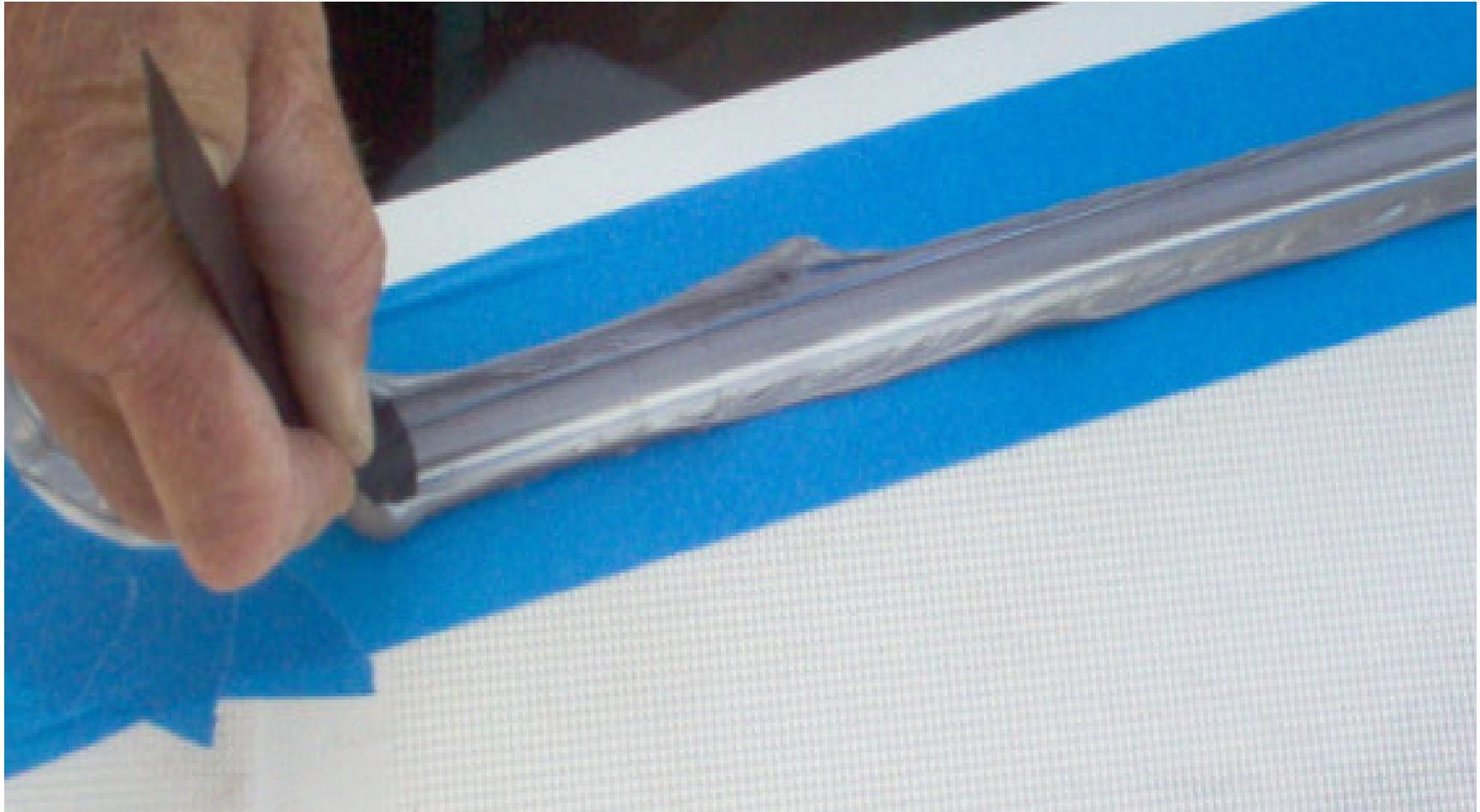
Apply Silicone



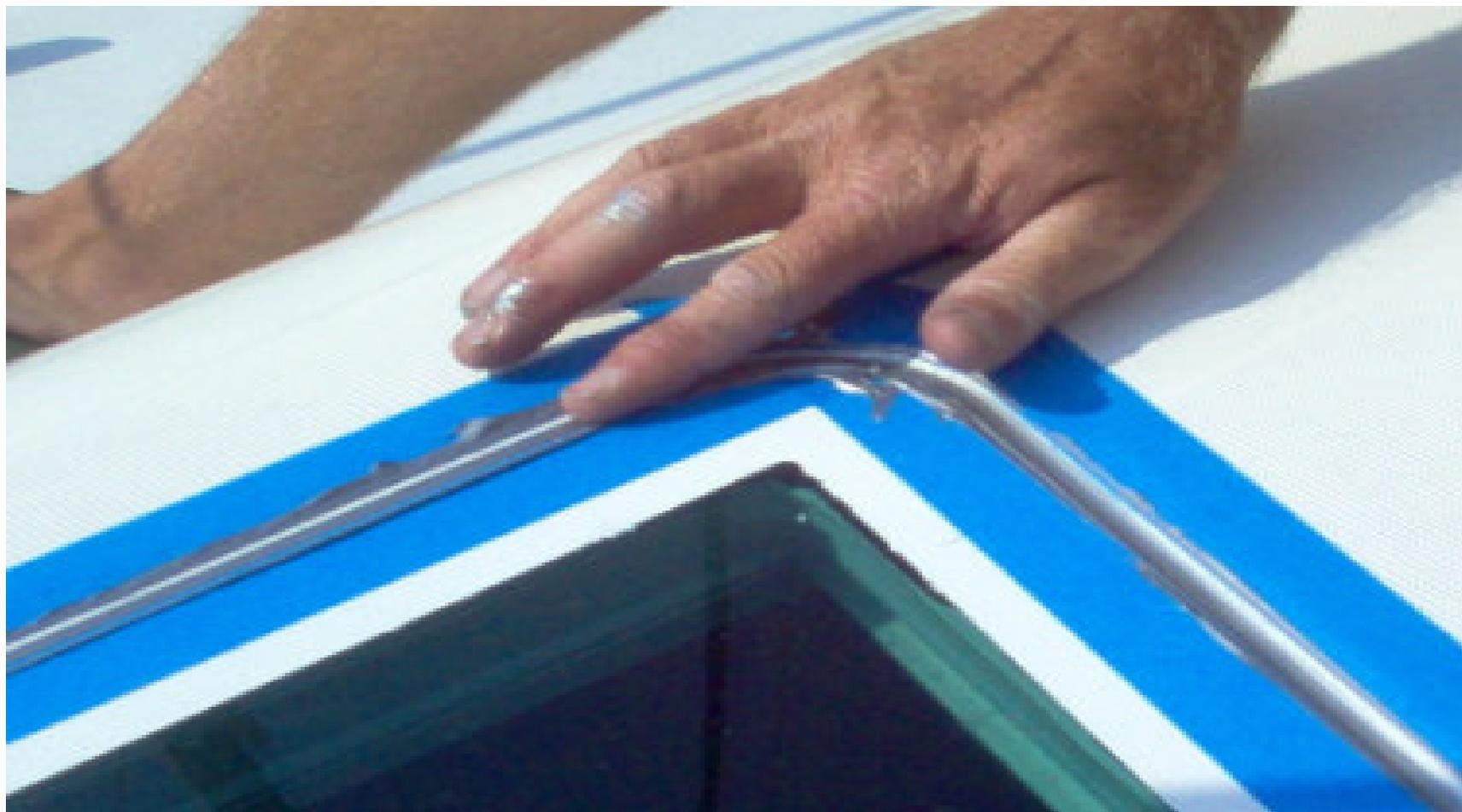
Smooth the silicone with a plastic spatula. Make sure you have a cup of water handy to dip the spatula.



Applying sealant



You can smooth the seam with your finger. Make sure you have a cup of water.



Remove any sealant not in the seam. There is normally a very small bead that needs to be removed.



Remove excess sealant



Notes

- Allow sealant to cure.
- Carefully remove the tape.
- Clean up