

***Seasava Plus, Plus X and Plus R liferafts — Container :
Introduction of improved container seal strip***

This Service Bulletin affects products from the brands that follow:



Survitec
Dunmurry - Belfast
Northern Ireland

This Service Bulletin has been technically approved by Survitec Design Authority.

Signed:



Tommy Scott (Jan 24, 2023 11:10 GMT)

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Head of Engineering
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Dated:

Jan 24, 2023

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1. Introduction

Seasava Plus, Seasava Plus X and Seasava Plus R liferafts are packed in a GRP container which is closed with a rubber seal strip. Survitec has found that water can get into the container through the current rubber seal strip.

This Service Bulletin tells service personnel how to install the new rubber seal strip.

2. Equipment affected

| Product group | Service Manual reference |
|-----------------------|--------------------------|
| Seasava Plus | M 150 |
| Seasava Plus X/R L/Rs | M 202 |

3. Embodiment date

Do this Service Bulletin at the next scheduled service.

4. Necessary parts

| Part number | Description |
|-------------|-------------------------------------|
| 04694128 | Toluene |
| 04528009 | Solvent MEK |
| 02596015 | 4 inch (100 mm) width sealing strip |
| 12595009 | Hinge strip tape |
| 04929009 | Glue (Polychloroprene Adhesive) |
| 04694083 | Transparent lacquer (cold dip) |

5. Necessary equipment and tools

| Description | Quantity |
|--|----------|
| ½ inch masking tape or equivalent (LS) | AR |
| 100 – 200 grade abrasive paper (LS) | AR |
| Clean, dry, lint-free cloths (LS) | AR |
| Ratchet straps (LS) | 2 |
| Spacers (LS) | 8 |
| Scissors | 1 |
| 2 inch paint brush or equivalent (LS) | 2 |
| Roller (LS) | 1 |
| Plastic sheet (LS) | AR |

AR (as required)

LS (locally sourced)

6. Tasks

A. Obey the correct service manual to remove and service the liferaft.

B. Remove the existing seal strip from the container:

WARNING: SOLVENTS ARE FLAMMABLE.
KEEP THEM AWAY FROM OPEN FLAMES.

WARNING: USE SOLVENTS ONLY IN A WELL-VENTILATED AREA.
DO NOT BREATHE THEIR FUMES.

WARNING: USE EYE PROTECTION. DO NOT SPLASH SOLVENTS
INTO YOUR EYES.

WARNING: USE A BARRIER CREAM ON YOUR HANDS AND PUT ON
RUBBER GLOVES. WASH YOUR HANDS AFTER YOU
USE SOLVENTS.

- (1) Use toluene to activate the glue on the existing seal strip. Remove excess toluene immediately with a clean, lint-free cloth.
- (2) Gently peel the existing seal strip away from the container.
- (3) Use a clean, lint-free cloth and toluene to remove the glue that remains on the container.

C. Prepare the container:

- (1) Use masking tape to make a mark on the upper and lower containers where the seal strip will be attached.

NOTE: This is the target area.

- (2) Use 100 – 200 grade abrasive paper to make the target area rough on the upper and lower containers.
- (3) Remove all dust and debris from the upper and lower containers.

CAUTION: DO NOT USE TOLUENE AND MEK ON THE SAME
CLOTH

- (4) Use a clean, lint-free cloth and MEK to clean the target areas on the upper and lower containers.

- D. Obey the correct service manual to pack the liferaft with the changes that follow.
- E. Close the container:
- (1) Put the upper container on top of the liferaft.
 - (2) Put two ratchet straps around the upper and lower containers.
 - (3) Put foam sheet between the ratchets and the container surface to prevent damage.
 - (4) Put a spacer between the ratchet strap and the container to make sure that you can get access to the target area of the seal strip.
Refer to **Figure 1**.
 - (5) Do step 6.E.(4) again to install seven more spacers under two ratchet straps.
 - (6) Use the ratchet handle on each ratchet strap to tighten the ratchet straps evenly and close the container.

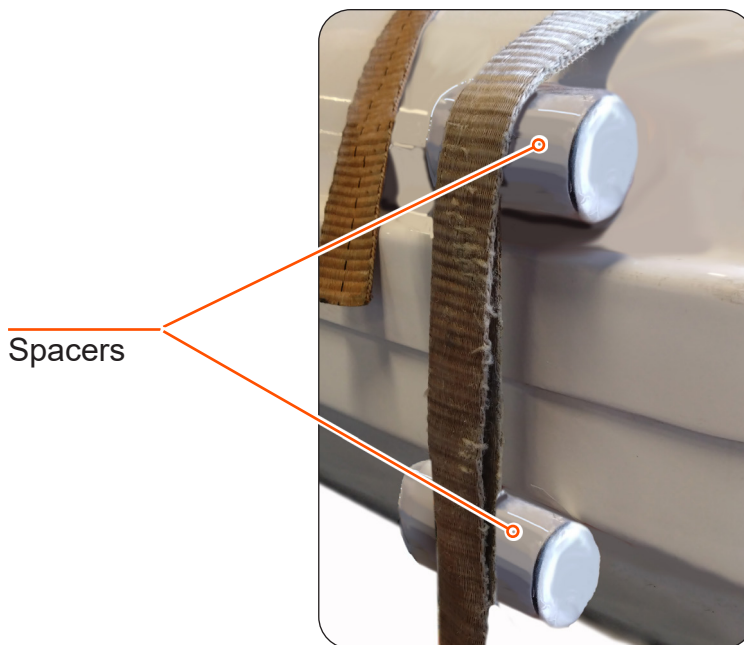


FIGURE 1
Closing the container

F. Cut the seal strip.

- (1) Put the seal strip around the target area on the container.
- (2) Use scissors to cut the seal strip with a 10 mm overlap at the ends.

NOTE: The 10 mm overlap on the seal strip will be trimmed at a later stage.

G. Install the hinge strip:

- (1) Use scissors to cut 180 mm length of hinge strip tape.
- (2) Use masking tape to make a mark at the target area. This must be 100 mm from the centre of the long side of the container, opposite from the firing line location. Use a paint brush to apply a layer of glue to the hinge strip location and mating surface of the hinge strip and let it dry.

NOTE: Dry is defined when a surface is touched it will feel smooth and will not grip the back of the hand.

- (3) Do step 6.G (3) again.
- (4) Use a paint brush to apply a layer of glue to the container and mating surface of the hinge strip and let it become tacky.

NOTE: Tacky is defined when a surface is touched with the back of the hand, it will grip and no glue is removed.

Wet is defined when a surface is touched glue will come off onto the back of the hand.

- (5) Put the hinge strip in position and use a roller to attach it to the container.

H. Prepare the seal strip:

- (1) Use ½ inch masking tape or equivalent to cover the full length of the central point on the seal strip.
- (2) Immediately before you apply the seal strip, use 100 – 200 grade abrasive paper to remove the shiny surface and make the flat side of the seal strip rough.
- (3) Use ½ inch masking tape or equivalent to replace any missing or damaged tape on the seal strip.
- (4) Use a clean, lint-free cloth to rub MEK on the full length of the seal strip until the cloth has black stains visible on it.
- (5) Use a paint brush to apply a layer of glue to the seal strip and allow it to dry.
- (6) Do step 6.H.(5) again two more times.
- (7) Remove the masking tape.
- (8) Put a polyurethane sheet over the seal strip to protect it from debris.

I. Align the seal strip:

- (1) Put the cut edge of the seal strip on the middle of the hinge strip and do a check to make sure that the upper external raised edge of the seal strip is aligned with the upper edge of the container. Refer to **Figure 2**.
- (2) Do a check to make sure there is clearance between the central break point of the seal strip and the container. Refer to **Figure 2**.

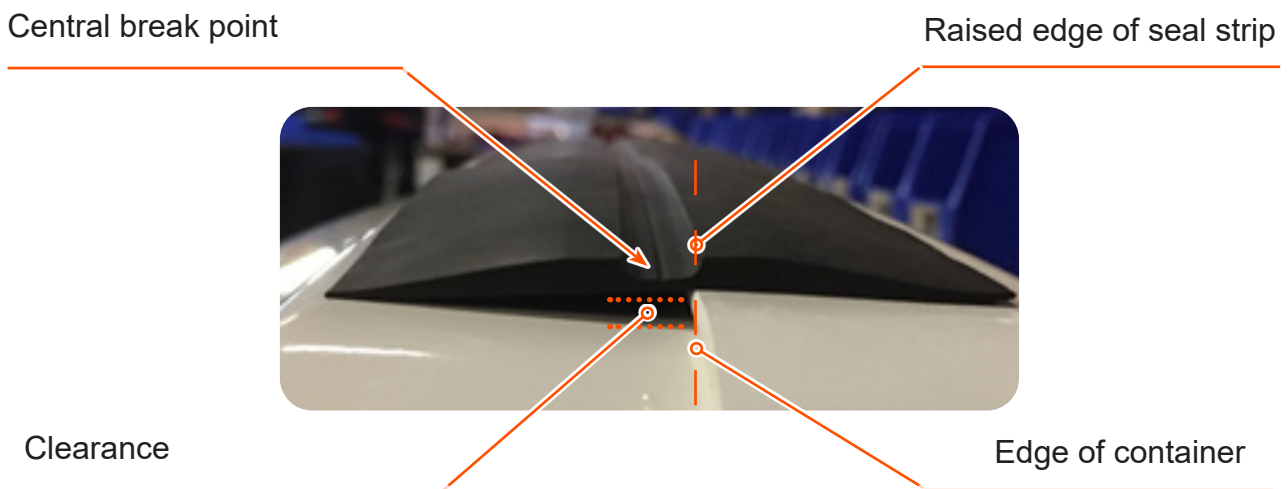


FIGURE 2
Align the seal strip on the container

J. Attach the seal strip:

- (1) Use a clean, lint-free cloth to apply MEK to the abraded surfaces of two containers immediately before the seal strip is attached.
- (2) Remove approximately 500 mm of polyurethane sheet from the seal strip.
- (3) Use toluene on a clean, lint-free cloth to activate the glue.
- (4) Use a roller to apply pressure to the seal strip to attach it to the container.
- (5) Pull the seal strip tight around each corner and use a roller to apply pressure to make sure there is good contact on two sides of the container.
- (6) Do steps 6.J.(2) thru 6.J.(5) until the seal strip is attached around the container and the edges meet at the hinge strip.
- (7) Use scissors to cut the seal strip and leave a maximum clearance of 4 mm between the ends.

K. Close the Hinge Strip:

- (1) Use 100 – 200 grade abrasive paper to make the seal strip rough where it overlaps the hinge strip.
- (2) Use a clean, lint-free cloth and MEK to clean the abraded surface.
- (3) Use a paint brush to apply a layer of glue to the abraded surface of the seal strip and the mating surface of the hinge strip and allow to dry.
- (4) Do step 6.K.(3) again.
- (5) Use a paint brush to apply a layer of glue and allow it to become tacky.
- (6) Fold the upper section of the hinge strip down to attach it to the seal strip. Refer to **Figure 3**.
- (7) Use scissors to cut the upper section of the hinge strip at the lower edge of the seal strip and use a roller to apply pressure to the hinge strip.
- (8) Do steps 6 K (3) thru 6 K (5) to apply glue to the mating surfaces of the hinge strip.

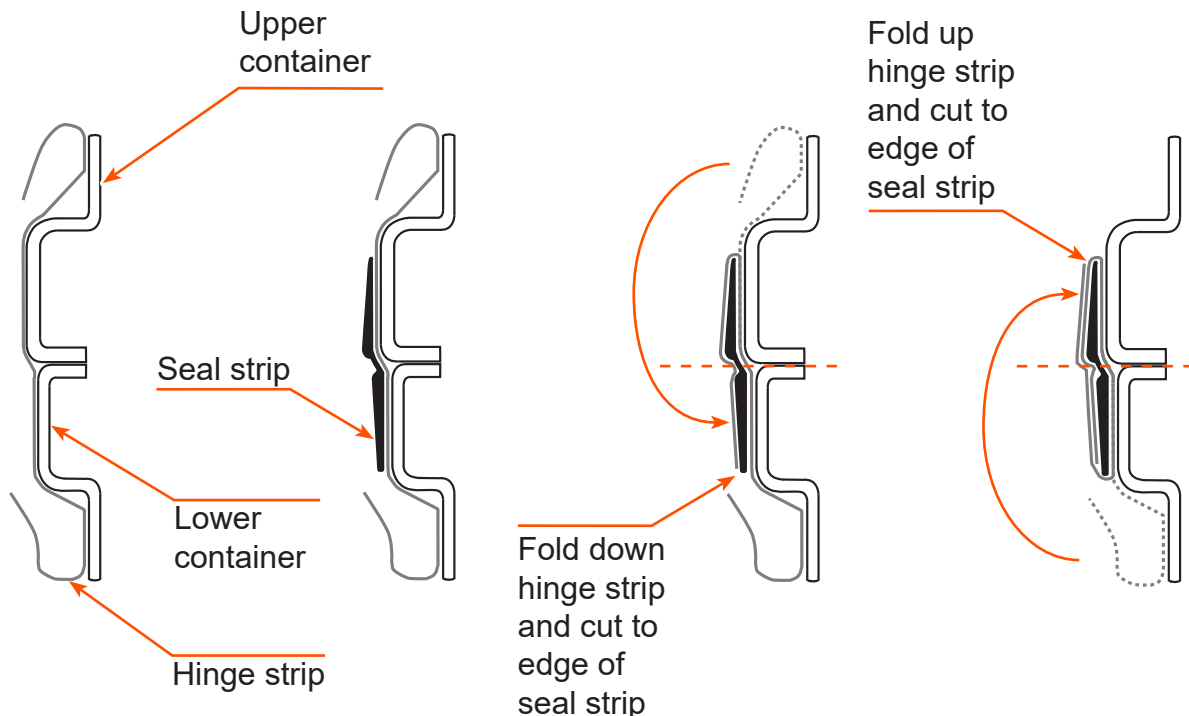


FIGURE 3
Complete the Hinge Strip

- (9) Fold the lower section of the hinge strip up to attach it to the recently glued section of the hinge strip. Refer to **Figure 3**.
- (10) Use scissors to cut the lower section of the hinge strip at the upper edge of the seal strip.
- (11) Use a roller to apply pressure to the hinge strip.
- (12) Let the glue dry for a minimum of 12 hours before you remove the ratchet straps.
- (13) Use a clean paint brush to apply a layer of transparent lacquer to the seal strip and let it dry.

7. Recording

- A. For each liferaft to which this Service Bulletin has been applied, complete the appropriate record card(s).
 - (1) Record details of the service onto the Service Record Card. In the appropriate field, write "SB 28/20 Ver.1 APPLIED".

8. Reporting

- A. None required.

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Service provider: _____

Associated Publications: **M 150 & M 202**

As part of Survitec procedures, each technician who is trained to service the equipment affected by this publication must read and fully understand this publication.

When each technician has read and fully understood the publication, they must complete and sign the table below.

Keep this table with this publication.

Each person named below has read and fully understood this publication:

| Signature | Name (<i>Print</i>) | Date |
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2820 Version 01 Marine Liferrafts Seal Strip

Final Audit Report

2023-01-24

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