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RE: BONDING PROCEDURE – PTFE/FABRIC PAD

1. Wipe PTFE and fabric pad clean with acetone, or other solvent.
2. PTFE should be cut oversize, allowing 1/4" overhang on all sides.
3. Use 3 parts "A" (white) epoxy to 1 part "B" (black). Mix thoroughly to an even paste. Epoxy should be used within one half hour of mixing.
4. Spread epoxy evenly on the fabric pad or the PTFE, approximately 0.003" to 0.004" thick. Use the etched side of the PTFE for bonding.
5. Hot bond the PTFE to the pad in a press heated to 210° F. for 15 minutes at approximately 36 psi.
6. Remove the excess PTFE and epoxy from the sides of the bearing with either a band saw or a knife. Sand the edges with #36 grit belt or disc sander.
7. Wipe clean with acetone, or other solvent.
8. Polish with a vibrating sander using 100 to 120 grit emory cloth. Remove all dirt and high spots to a smooth even finish.

IS THE PTFE ETCHED ON ONE SIDE FOR BONDING?

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