



SERVICE MANUAL FOR VIKING IMMERSION SUITS		
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SERVICE MANUAL for VIKING Immersion Suits

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Prepared by: Henny Andersen



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INTRODUCTION

Service inspection of VIKING immersion suits is to be carried out only by servicing stations authorised by VIKING LIFE-SAVING EQUIPMENT A/S.

The purpose of this service manual is to ensure that the suit is serviced and repaired in such a way that it is in order and functional.

If any doubts should occur in connection with the servicing of suits, please contact the service manager of VIKING LIFE-SAVING EQUIPMENT A/S.

Where modifications of existing VIKING immersion suits are to be implemented, the modification instructions will be inserted in Section 12 of the service manual.

Where information relative to existing VIKING immersion suits is given, the information will be introduced in Section 13 of the service manual.

RESTRICTIONS ON REPAIRS

VIKING recommends that the suits be sent to Esbjerg, Denmark, for replacement of collars and front zippers.

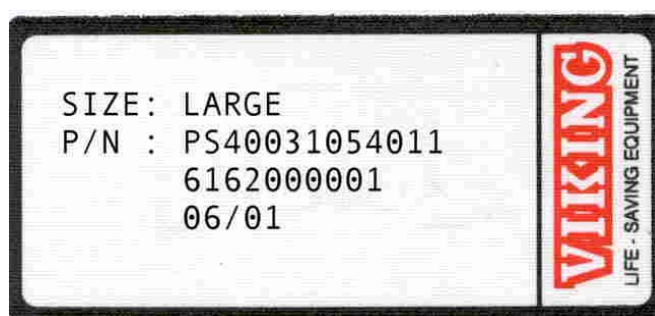
A SEAM-SEALING MACHINE IS REQUIRED FOR THE SERVICING STATION TO REPLACE FRONT ZIPPERS, SEWED IN CUFFS AND COLLARS.

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2 IDENTIFICATION AND MARKING

All suits are reverse the suit provided with an identification mark.
The identification mark contains information of article No., size and suit No. and date of production.

Example:



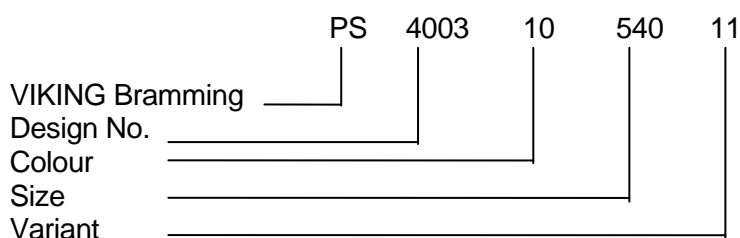
or



It is important to know the article number in order to identify the correct spare parts and repair methods.

Article numbers are created as stated below

Article No.:





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3. SERVICE INSPECTION

3.1 SERVICE INTERVAL

Immersion suit should be inspected at suitable intervals.

VIKING LIFE-SAVING EQUIPMENT A/S recommend following intervals:

- Suits used regularly should be inspected annually.
- Aribbononment suit should be inspected at least every 3rd. year.

Beware of national authorities may have special requirements.

3.2 INSPECTION OF SUITS

The suits are to be inspected in accordance with the applicable points below.

(Please notice inspection form is available in section 11)

1. Leakage test.
2. Check the outer material for holes and tears.
3. Check pockets.
4. Check boots for defects, tears and holes.
5. Check socks.
6. Check rubber wrist seals for cracks and scratches; check glueing, ribbons and mounting.
7. Check collar/hood for cracks and scratches; check glueing, ribbons and mounting.
8. Check gloves for cracks; check GLUEING and mounting.
9. Check reflective tape for mounting and condition.
10. Check front zipper and grease it with the grease stick.
11. Check lifting Becket.
12. Check bodyline.
13. Check buoyancy foam for condition.
14. Check miscellaneous, like webbing and buckle.
15. Check light function and expire date.
16. Check whistle.
17. Check the knife
18. Check the lining – notice the zipper for mounting.
19. Check labelling.

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4. WASHING INSTRUCTIONS

4.1 **LINING**

Dismount buoyancy foam from Inner lining.

Wash the inner lining at 40°C.

An ordinary detergent without bleaching preparation may be used, but the following is recommended:

Main wash:	1 part of Tensid	Part No. 705-0017 / new 1013167
	1 part of Alkali	Part No. 705-0016 / new 1013166

Softener:	1 part of Skyl	Part No. 705-0019 / new 1013182
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The mentioned detergent necessitate a washing machine with automatic dispenser.

The inner liner must only be spin-dried by low speed.

The inner liner must only be tumble-dried by low temperature.



When the inner lining is dry, mount the buoyancy.

4.2 **SUITS WITHOUT INNER LINING OR DETACHABLE LINER.**

(Wash the inner lining as 4.1)

Dismount all loose parts such as gloves, hood, light, whistle, knife etc.

Wash the suits at 40°C.

An ordinary detergent without bleaching preparation may be used, but the following is recommended:

Prewash:	1 part of Tensid	Part No. 705-0017 / new 1013167
	1 part of Alkali	Part No. 705-0016 / new 1013166

Main wash:	1 part of Tensid	Part No. 705-0017 / new 1013167
	1 part of Alkali	Part No. 705-0016 / new 1013166
	1 part of Triplex plus	Part No. 705-0015 / new 1013163

The mentioned detergents necessitate a washing machine with automatic dispenser.

The suits are not to be spin-dried.

The suits are not to be tumble-dried.



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4.3 IMMERSION SUITS WITH ATTACHED LINER (DESIGN 5002, 5003, 5004)

Dismount all loose parts such as buoyancy foam from Inner lining, light, whistle etc.

Wash the suits at 40°C.

An ordinary detergent without bleaching preparation may be used, but the following is recommended:

Main wash: 1 part of Tensid
1 part of Alkali

Part No. 705-0017 / new 1013167
Part No. 705-0016 / new 1013166

The mentioned detergent necessitates a washing machine with automatic dispenser.



When the suit is dry, mount the buoyancy foam in inner lining.



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5.1 CONDEMNATION RULES

A suit must be condemned if it is deemed that repair will not make the suit fully functional or that the expenses in connection with the repair will be too high. (Ordinarily 50% of purchase price) - Contact the customer, if necessary.

If the customer wants to have the condemned suit returned, clearly mark the suit with label 1003396 "Discarded for life-saving" welded reverse the suit and mount the label 1003591 "Discarded" on front zipper.

If the customer does not wish to have the condemned suit returned, cut up the suit with scissors.



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5.2. RULES FOR EXPIRY DATE ON LIGHT

Expire date on light must be checked in connection with servicing of Immersion Suits.

- SOLAS approved Immersion suits - At the time of servicing the light must have a lifetime of min. 5 months.
- SOLAS approved Immersion suits, If the SOLAS suit is vacuum packed the light must have a lifetime of minimum 3 years
- Next servicing and replacement of light, has to follow the next service date.
- Not approved SOLAS Immersion suits – the light must have a lifetime of minimum 1 year.



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6 LEAKAGE TEST OF SUITS

1. LEAKAGE TEST WITH COMPRESSED AIR.

Suits are to be tested with compressed air.

Suits with reinforcement on the outside are to be tested reverse out.

The detection of leakage can either be with soapy water solution or immersion of the whole suit in a water vessel.

Soapy water solution:

- Mount the sealing clamps 1011092 at wrists seals
- Mount the sealing tool 1002802 in face opening.
- Connect the inflation station and inflate the suit to a pressure of 20 mbar ± 1 .
- Cover the whole suit with soapy water solution (1/3 detergent for dish wash without perfume and 2/3 water) with a sponge 1011091.
- The suit is to be tested on each side.
- Mark any leakage with a special pen, 1018471 (mark leakage in a FORM FOR MARKING OF LEAKING, page 11.1)
- Rinse the suit with clear water
- Dry the suit

Water vessel

- Mount the sealing clamps 1011092 at wrists seals
- Mount the sealing tool 1002802 in face opening.
- Place the suit in the vessel and close the lattice cover.
- Connect the inflation station and inflate the suit to a pressure of 20 mbar ± 1 .
- Inspect the suit on front side
- Turn the suit and inspect the rear side.
- Mark any leakage with a special pen, 1018471 (mark leakage in a FORM FOR MARKING OF LEAKING, page 11.1)
- Dry the suit

2. TEST WITH WATER PRESSURE.

Suits made from Gore-Tex and neoprene coated nylon are to be tested with water pressure in a special test bench. All tests are to be done with the reverse out of the suit.

- Mount the sealing clamps at the neck seal.
- Mount the connectors at the wrist seals.
- Close the lattice.
- Place the lattice in the tilted position and start the pump,
- Adjust the pressure to 25 mbar ± 1 .
- Inspect the suit on both sides and mark any leakage with a special pen, No. 1018471.

<i>Type of fabric</i>	<i>Pressure</i>
Gore-tex	25-30 mbar ± 1
PU coated nylon	20 mbar ± 1
Neoprene coated nylon	20 mbar ± 1
Neoprene	20 mbar ± 1



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7. LIST OF TOOLS AND EQUIPMENT

DESCRIPTION	PART NO.
TEST BENCH type 73 WST.	1017956
CROSSOVER	1001581
WRIST SEAL RINGS	1000040
SHIELD FOR COLLAR MOUNTING PS4177	1018634
SHIELD FOR COLLAR MOUNTING	1003247
SHIELD FOR COLLAR MOUNTING PS4003-12	1017952
SHIELD RING FOR COLLAR MOUNTING PS4003-12	1017953
FABRIC CLAMP	1001674
FOLDING STICK 20 CM	1000450
STITCH UNPICKER	1001661
SCISSORS	1001659
BALLOON FOR WRIST SEAL MOUNTING	1014606
BALLOON FOR BOOT MOUNTING	1014605
BALLOON FOR MOUNTING OF GLOVES	1012468
HEATING GUN	1017954
INDUSTRIAL WASHING MACHINE	1017955
SEWING MACHINE	
PUNCH PLIERS	
PIPE WRENCH	
STEEL HAND ROLLER, 10 MM	1004963
TOOL SET FOR IMMERSION SUIT Containing: Sealing tool for face opening Sealing clamp for wrist Inflation unit for immersion suit Balloon for wrist seal mounting Balloon for boot mounting Sponge for soapy water Marking pen Edding 950, no. 49, white Folding stick 20 cm Ring/fork wrench 9/16"	1011089 1002802 1011092 1011090 1014606 1014605 1011091 1018471 1000450 1006535
SEALING TOOL FOR FACE OPENING	1002802
INFLATION UNIT FOR IMMERSION SUIT	1011090
SEALING CLAMP FOR WRIST	1011092
MARKING PEN	1018471
SPONGE	1011091
RING/FORK WRENCH 9/16"	1006535



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8 STANDARD FOR GLUE MIXING

1. Glue and hardener is acclimatized for 12 hours before use.
2. Glue marked with an*, according to list below, must be shaken before use.
Must be applied a maximum 72 hours after the glue has been shaken.
3. The "Expiry-date" which must appear from the packaging, must not be exceeded.
Any extension of the expiry date Quality Department in Viking DK must be contacted.
4. Following solvents do not require expiry-date printed on the package:
1012436 MEK, BB thinner 694
1005112 Heptane solvent
5. Glue must be mixed according to the following:

*1013243 Bostik NE 486	7 – 9 % 1001918 hardener 2206
1001642 Fast Bond 30:	No hardener
*1012545 GXGQ:	7 – 9 % 1001918 hardener 2206
1032514 Bostik Vinycol 1520	5% 1024195 hardener Desmodur

The amount of hardener is calculated as a percentage of the weight. The weighing must be done on a calibrated scale.

Mixed glue has a pot-life of max. 3 hours

NOTE
MIXED GLUES ARE TO BE STORED COVERED
DO NOT USE THE SAME BRUSH OR TOOLS IN DIFFERENT KINDS OF GLUE
VESSELS AND TOOLS ARE TO BE CLEANED OF DIRT/RESIDUE
THE WORKPLACE IS TO BE KEPT CLEAR AND TIDY



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8 STANDARD FOR GLUEING WITH CONTACT GLUE

This standard does NOT apply to the GLUEING of neoprene (gloves, hood etc.)

1. Work instructions must be present before the operation.
2. Glue has to be applied in a uniform layer and the given opening and stand until opening time has been reached (the glue is a bit sticky)
If glue has to be applied twice, the second layer can be applied in the opening time or at later time.
3. The glued surfaces cannot be touched and brush hair or other impurities are not to be found on the surface either. Otherwise leakage could occur. (However, opening time must be controlled)
4. The materials are assembled and knuckled together with the knuckle stick or rolled with "the roller".
5. Outside the glued parts, there must be a visible edge of approx. 1-5mm, except where it is glued all the way out to the edge.
6. Activating of glue with a moisten cotton rag with toluene, not fluid and dripping. The glue surface must be moistened by dabbing.



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9. REPAIR INDEX

On the following pages the repair instructions are described for each design number.

Using the table below the repair instruction used for the specific design numbers is identified.



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	1		2	3	4	5	6	7	8	9	10	11	12
PS3764	14		3								2		1
PS4001	14		2	7	1			-			1		
PS4002	14		2		1	-	-		-	-	1		
PS4003.10	11		2	18	-	3	1	-	-	-	1	-	1
PS4003	14	14	2	18	1	-	1	-	-	-	1	-	1
PS4004	14	14	2	7	1			-	-	-	1	-	-
PS4005	19		2	7	1						1		1
PS4006	1		2	-	-	3	-	-	-	-	1	-	1
PS4010	1		2	12	1	-	-		-	-	1	1	-
PS4010.10	1		2	12	1	-	-		-	-	1	1	-
PS4013	11		2	26	1		1	-	-	-	1	-	1
PS4014	14		2	7	1	-	-		-	-	1	-	-
PS4017	14		2	7	1	-		-	-	-	1		
PS4018	1		2	5	1	-	-		-	-	1	-	-
PS4019	14		2	7	1	-	-		-	-	1	-	-
PS4020	14		2	7	1	-	-		-	-	1	-	-
PS4021	11		2	6	-	1	-	-	-	-	1	-	1
PS4022													
PS4026	1		2	4	1						1	1	1
PS4026.10	1		2	4							1	1	1
PS4027	1		2	3	-	1	-		-	-	1	1	-
PS4027.10	1		2	3	-	1	-		-	-	1	1	-
PS4027.11	1		2	3	-	1	-		-	-	1	1	-
PS4027.12	1		2	4	-	1	-		-	-	1	1	-
PS4027.13	1		2	3	1	-	-		-	-	1	1	-



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Design No.	Replacement of wrist seals (gluing)	Replacement of wrist seals (sewing)	Replacement of tape	Replacement of collar	Replacement of socks	Replacement of boots	Replacement of front zipper	Replacement of PU front zipper	Replacement of hood	Replacement of gloves	Repair of tears and holes	Intake of collar	Replacement of reflective tape
	1		2	3	4	5	6	7	8	9	10	11	12
PS4029	1		2	5	-	1	-	-	-	-	1	1	-
PS4029.11	1		2	1	-	1	-	-	-	-	1	1	-
PS4030	1		2	1	-	-	-	-	-	-	1	1	-
PS4031.10	10		2	1	-	8	-	-	-	-	1	1	-
PS4032	14		2	7	1	-	-	-	-	-	1	-	-
PS4033	14		2	7	1	-	-	-	-	-	1	-	-
PS4034	1		2	1	-	1	-	-	-	-	1	1	-
PS4035		4	2	26	1	-	-	-	-	-	1	-	-
PS4037	10		2	3	-	8	-	-	-	-	1	1	1
PS4061	1		2	-	-	-	-	-	-	-	1	-	-
PS4070	4		2	-	1	-	-	-	-	-	1	1	-
PS4072.10	1		2	23	1	-	2	-	-	-	1	-	-
PS4077	1		2	-	1	-	-	-	-	-	1	-	-
PS4103		14	2	6	1	-	-	-	-	-	1	-	1
PS4110		9	2	-	-	4	-	-	-	-	1	-	1
PS4130	9	9	2	5	1	3	-	-	-	-	1	-	-
PS4162	14		2	-	-	3	-	-	-	-	1	-	-
PS4162.10	1		2	-	-	3	-	-	-	-	1	-	1
PS4163.10	1		2	27	-	7	-	-	-	-	1	1	1
PS4163.11	10		2	27	-	2	-	-	-	-	1	1	1
PS4164	2		2	24	-	2	-	-	-	-	1	-	1
PS4167	17		2	24	-	2	-	-	-	-	1	-	1
PS4172	9	9	2	5/21		4						1	-
PS4177	4	4	2	26	1	-	-	-	-	-	1	-	-
PS5004	3		3	-	-	5	-	1	-	-	2	-	1
PS5004.10	3		3	-	-	5	-	1	-	-	2	-	1
PS5005	-		3	-	-	5	-	1	-	1	2	-	1



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	1	2	3	4	5	6	7	8	9	10	11	12	
PS5008	5		1	21	-	2 or 4	4		-	-	3	1	1
PS5008.10	5		1	21	-	2 or 4	4		-	-	3	1	1
PS5008.11	5		1	21	-	4	4	-	-	-	3	1	1
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PS5012	5	9	1	21/5	-	4	-		-	-	3	1	1
PS5013.10	5		1	21	-	4	-		-	-	3	1	1
PS5014	5		1	21	-	4	-		-	-	3	1	1
PS5015	5		1	21	-	4	-		-	-	3	1	1
PS5028	5		1	24		4					3		1
PS5030	6		1	4	-	6	-		-	-	3	1	-
PS5030.10	6		1	4	2		-		-	-	3	1	-
PS5030.11	8		1	4	-	6	-		-	-	3	1	-
PS5044	5		1	25	2		3				3		1
PS5060	8 or 15		1	7	-	6	-		-	-	3	-	-
PS5060.10	8		1	7	-	6	-		-	-	3	-	-
PS5063	13		3	-	-	-	-		-	-	2	-	1
PS5065	7		3	-	-	-	-		-	-	2	-	1
PS5065.10	7		3	-	-	-	-		-	-	2	-	1
PS5076.10			1	-	-	-	-		-	-	2	1	1



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10.1 REPAIR REGULATIONS

1 Replacement of sleeve wrist seal.

Replacement of Codan wrist seals, 1014953 on Gore-tex immersion suits without zip fastener for inner lining.

<p>External ribbon is heated on Crossover for 5-10 sec. and removed using a folding stick. The sleeve is reverse. Internal ribbon is heated on Crossover for 5-10 sec. and removed using a folding stick. The seam between sleeve and wrist seal is heated on Crossover for 5-10 sec. and separated using a folding stick.</p> <p>The sleeve is reverse, the edge is cut and the suit is provided with ring. Edge of sleeve in the middle of the ring. The wrist seal is cleaned and put on the ring reverse side out. 1½ cm is tucked in.</p> <p>GLUEING: Gore-tex reverse / wrist seal face side Wrist seal is averted over the sleeve.</p> <p>Gore-tex reverse Wrist seal reverse Indian tape 1003058</p> <p>The suit is turned and provided with a balloon. NB - Do not inflate to the extent that the wrist seal becomes wider than the sleeve.</p> <p>Gore-tex face side Wrist seal face side Indian tape 1003058 (face side: rubber glue).</p> <p>Overlap 3-4 cm The lap joint must be at front sleeve seam. Disassemble balloon.</p> <p>Glue mixture according to VIKING norm 8.1. Glueing is carried out according to VIKING norm 8.2.</p>	<p>Heptane 1005112</p> <p>C</p> <p>C</p> <p>C C</p>	<p>Bestik NE 486 1013243 +7-9% hardener 1001918</p> <p>1xG</p> <p>1xG 2xG 1xG</p> <p>1xG 1xG 1xG</p>
<p>C = clean G = glue X = number H = hardener</p>		



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10.1 REPAIR REGULATIONS

2 Replacement of sleeve wrist seal.

Replacement of Dipco wrist seals article no. 1003710 on immersion suits made of Neoprene coated Nylon.

	Heptane 1005112	Bestik NE 486 1013243 +7-9% hardener 1001918
External ribbon is heated on Crossover for 5-10 sec. and removed using a folding stick. The sleeve is reverse. Internal ribbon is heated on Crossover for 5-10 sec. and removed using a folding stick. The seam between sleeve and wrist seal is heated on Crossover for 5-10 sec. and separated using a folding stick. The sleeve is reversed and provided with ring. The Dipco wrist seal 1003710 is grind and cleaned. Put on the wrist seal ring reverse out. 1½ cm is tucked in.	C	
<u>GLUEING:</u> Neoprene reverse/wrist seal face side Wrist seal is averted over the sleeve. Neoprene reverse Wrist seal reverse Neoprene tape 1001312	C	1xG 1xG 1xG 1xG
The suit is turned and provided with a balloon. NB - Do not inflate to the extent that the wrist seal becomes wider Than the sleeve. Neoprene face side Wrist seal face side Neoprene tape 1001312	C	1xG 1xG 1xG
Overlap 3-4 cm The lap joint must be at front sleeve seam. Disassemble balloon. Glue mixture according to VIKING norm 8.1. Glueing is carried out according to VIKING norm 8.2.		
C = clean	G = glue	X = number
		H = hardener



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10.1 REPAIR REGULATIONS

3 Replacement of sleeve wrist seal.

Replacement of Codan wrist seals no. 1014953 for immersion suits made of PU coated nylon.

<p>Cut off the wrist seal, 5 cm from edge of outer fabric. Sew on (part 1008151) lengthen the sleeve and tape the sewing in cross-over. Tape no. 1003570.</p> <p><u>Be careful not to destroy the inner lining.</u></p> <p>Unstitch wrist seal from inner lining.</p> <p>Sew on a new wrist seal to the inner lining with a seam width of 10 mm.</p> <p>Fold the edge of the sleeve 2½ - 3 cm. Place the edge of the wrist seal so that it follows the fold of the sleeve all the way around. The seam of the outer fabric and the inner lining is to be in the same place.</p> <p>Insert balloon in the sleeve and inflate it.</p> <p style="padding-left: 40px;">Clean and glue the wrist seal. Clean and glue the reverse of the sleeve</p> <p>Force the fold over the wrist seal so the edge of the sleeve is 1½ - 2 cm over the seam of the wrist seal and roll or knuckle it.</p> <p style="padding-left: 40px;">Clean and glue the Neoprene ribbon 25 mm, 1001313</p> <p>Mount Neoprene ribbon at assembling at reverse side. Overlap 3-4 cm and knuckle it.</p> <p>The balloon shall remain in the sleeve for at least 16 hours.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	Heptane 1005112	MEK 1012436	Bostik NE486 1013243 + 7-9% Hardener 1001918
		C C	2xG 1xG
	C		2xG
<p>C = clean G = glue X = time H = hardener</p>			



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10.1 REPAIR REGULATIONS

5 Replacement of sleeve wrist seal.

Replacement of Neoprene wrist seals S-450012450xxL/S-450012450xxR and S-450016250xxL/S-450016250xxR with zip and elastic for immersion suits made of Neoprene coated Nylon, with inner lining.

	Heptane 1005112	Bostik NE486 1013243 + 7-9% Hardener 1001918
<p>Heat up external ribbon with a heat gun and removed using a folding stick. The sleeve is reverse. Heat up the wrist seal with a heat gun and removed using a folding stick.</p> <p>Turn reverse out of the sleeve. Cut the edge straight and insert rings in the suit. Edge of sleeve along edge of ring. Wrist seal S-45001245050L / S-45001245050R sizes XS-S Wrist seal S-45001245058L / S-45001245058R sizes M-L-XL-XXL-XPL</p> <p>Clean and glue reverse sleeve edge Glue wrist seal face side</p> <p>Mount wrist seal on sleeve such that the wrist seal zipper is placed by the sleeve seam. – Notice, wrist seal right – sleeve right / wrist seal left – sleeve left.</p> <p>Overlap of 2 cm. Press down the edge.</p> <p>Fold the wrist seal edge over the ring, such that the seam is to be covered. Knuckle the Neoprene edge.</p> <p>Remove the ring and turn the sleeve at face side.</p> <p>Insert balloon in sleeve.</p> <p>Neoprene ribbon 1001312 Glue face side sleeve/wrist seal</p> <p>Mount Neoprene ribbon at assembling at external sleeve and wrist seal. Assembling at front sleeve seam. Overlap 3 - 4 cm.</p> <p>Disassemble balloon.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	C	1xG 1xG
	C	1xG 1xG
C = clean G = glue X = number H = hardener		



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10.1 REPAIR REGULATIONS

6 Replacement of sleeve wrist seal.

Replacement of Codan rubber wrist seals 1014953 for immersion suits made of Neoprene coated nylon.

	MEK 1012436	Bostik NE 486 1013243 + 7-9% hardener 1001918
External ribbon is heated on Crossover for 5-10 sec. And removed using a folding stick. The sleeve is reverse. Internal ribbon is heated on Crossover for 5-10 sec. and removed using a folding stick. The seam between sleeve and wrist seal is heated on Crossover for 5-10 sec. and separated using a folding stick.		
The sleeve is reverse, the edge is cut and the suit is provided with rings. Edge of sleeve in the middle of the ring. The wrist seal 4500136/ new no. 1014953 is cleaned and put on the ring reverse out. 1½ cm is tucked in.	C	
GLUEING: Fabric reverse/wrist seal face side Wrist seal is averted over the sleeve.	C	1xG
Gore-tex reverse Wrist seal face side Indian tape 1003058 Overlap 3 – 4 cm.	C	1xG 2xG 1xG
The suit is turned and provided with a balloon. NB - Do not inflate to the extent that the wrist seal becomes wider than the sleeve.		
Gore-tex face side Wrist seal Indian tape 1003058	C	1xG 1xG 1xG
Overlap 3-4 cm The lap joint must be at front sleeve seam. Disassemble balloon.		
Glue mixture according to VIKING norm 8.1. Glueing is carried out according to VIKING norm 8.2.		
C = clean	G = glue	X = number
		H = hardener



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10.1 REPAIR REGULATIONS

7 Replacement of sleeve wrist seal.

Replacement of Codan wrist seals with knit, fabric no.1014953 for immersion suit made of PU-fabric.

<p>Internal ribbon is heated on Crossover for 5-10 sec. and removed using a folding stick. The seam between sleeve and wrist seal is heated on Crossover for 5-10 sec. And separated using a folding stick.</p> <p>The sleeve is reverse, the suit is provided with rings. Edge of sleeve in the middle of the ring.</p> <p style="text-align: center;">Fabric reverse Wrist seal face side</p> <p>Put on the wrist seal ring reverse out. 1½-2 cm is tucked in. Place the edge of wrist seal so that it follows the fold of the sleeve all the way around.</p> <p>GLUEING: Fabric reverse Wrist seal face side</p> <p>Force the fold over the wrist seal so the edge of the sleeve is 1½ - 2 cm over the seam of the wrist seal and roll or knuckle it.</p> <p>The balloon shall remain in the sleeve for at least 16 hours.</p> <p>Glue mixture according to VIKING norm 8.1. Glueing is carried out according to VIKING norm 8.2.</p>	MEK 1012436	Bostik NE 486 1013243 + 7-9% Hardener 1001918
	C C	1xG 1xG
<p>C = clean G = glue X = number H = hardener</p>		



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10.1 REPAIR REGULATIONS

8 Replacement of sleeve wrist seal.

Replacement of Neoprene wrist seals, S-450013050xxL / S-450013050xxR for immersion suits made of Neoprene coated nylon.

	Heptane 1005112	Bostik NE486 1013243 +7-9% Hardener 1001918
<p>Heat up external ribbon on Crossover for 5-10 sec. and removed using a folding stick. Turn the reverse of the sleeve out. Heat up the internal ribbon on Crossover for 5-10 sec. and removed using a folding stick. Heat up the joint between sleeve and wrist seal on Crossover for 5-10 sec. and removed using a folding stick.</p> <p>Turn the reverse of the sleeve out. Cut the edge straight and insert rings in the suit. Edge of sleeve along edge of ring. Wrist seal S-45001305050L / S-45001305050R (is pre glued) sizes 42K, 46K, 42, 46, 42L, 46L. Wrist seal S-45001305058L / S-45001305058R (is pre glued) all other sizes. GLUEING: fabric reverse Wrist seal face side</p> <p>Mount wrist seal on sleeve such that the sleeve seam places the sewed-on elastic. - Remember an overlap of 1½ cm. Press down the Neoprene edge.</p> <p>Mount ribbon internally. Fabric reverse Wrist seal reverse Neoprene ribbon 1001312 Overlap 3-4 cm.</p> <p>Turn sleeve and insert balloon. Mount ribbon externally. Fabric face side Wrist seal face side Neoprene ribbon 1001312</p> <p>Overlap 3-4 cm. Joint at front most sleeve seam.</p> <p>Glue mixture according to VIKING norm 8.1. Glueing is carried out according to VIKING norm 8.2.</p>	C	1xG 1xG
	C	1xG 1xG 1xG
	C	1xG 1xG 1xG
C = clean	G = glue	X = number
		H = hardener



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10.1 REPAIR REGULATIONS

9 Replacement of sleeve wrist seal.

Replacement of Neoprene wrist seals for immersion suits made of Pazifik or Neoprene coated nylon.

<p>Turn the reverse out of the suit. Heat up the ribbon with a heat gun or in crossover 5-10 sec. and remove it using a folding stick. Dismantle the stitching or cut by the stitching.</p> <p>MOUNTING OF WRIST SEAL BY GLUEING: Turn reverse out of the sleeve. Cut the edge straight and insert rings in sleeve. Edge of sleeve along edge of ring. Clean and glue reverse sleeve edge Glue wrist seal face side</p> <p>Mount wrist seal on sleeve such that the wrist seal zipper is placed by the sleeve seam. – Notice, wrist seal right – sleeve right / wrist seal left – sleeve left.</p> <p>Overlap of 2 cm. Press down the edge and knuckle it.</p> <p>Fold the wrist seal edge over the ring, such that the seam is to be covered. Knuckle the Neoprene edge. Remove the ring and turn the sleeve at face side.</p> <p>Insert balloon in sleeve.</p> <p>Neoprene ribbon 25 mm, 1001313 Clean and glue face side sleeve/wrist seal</p> <p>Mount Neoprene ribbon at assembling at reverse side of sleeve and wrist. Assembling at front sleeve seam. Overlap 3-4 cm and knuckle it. Disassemble balloon.</p> <p>REPLACEMENT OF WRIST SEAL BY SEWING. Turn reverse out of the sleeve. Cut the edge straight Clean and glue reverse sleeve edge</p> <p>Put the wrist seal in the sleeve – right side vs. right side – and sew it approximately 3 mm from the edge.</p> <p>Glue the sleeve and wrist seal reverse Neoprene ribbon 25 mm, 1001313</p> <p>Mount Neoprene ribbon at assembling at reverse side of sleeve and wrist Overlap 3-4 cm and knuckle it.</p> <p>Carry out Glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	<p>Heptane 1005112</p>	<p>Bostik NE486 1013243 +7-9% Hardener 1001918</p>
	<p>C</p>	<p>1xG 2xG</p>
<p>C C</p>	<p>1xG 1xG</p>	
<p>C</p>	<p>1xG</p>	
<p>C</p>	<p>1xG 1xG</p>	
<p>C = clean G = glue X = number H = hardener</p>		



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10.1 REPAIR REGULATIONS

10 Replacement of sleeve wrist seal.

Replacement of Codan wrist seals 1001499, with zip for inner lining, for immersion suits made of Gore-tex.

	Heptane 1005112	Bostik NE486 1013243 +7- 9% Hardener 1001918
<p>External ribbon is heated on Crossover for 5-10 sec. and removed using a folding stick. The sleeve is reverse. Internal ribbon is heated on Crossover for 5-10 sec. and removed using a folding stick.</p> <p>The sleeve is reverse, the edge is cut and the suit is provided with rings. Edge of sleeve in the middle of the ring. The wrist seal is cleaned and put on the ring reverse side out. 1½ cm is tucked in.</p> <p>GLUEING: Gore-tex reverse/wrist seal face side. Wrist seal is averted over the sleeve.</p> <p>Reverse zip must be at front sleeve seam. Wrist seal right – sleeve right / wrist seal left – sleeve left. Overlap 2 cm. Disassemble balloon.</p> <p>The suit is turned and provided with a balloon. NB - Do not inflate to the extent that the wrist seal becomes wider than the sleeve.</p> <p>Gore-tex face side Wrist seal face side Indian tape 1003058</p> <p>Overlap 3-4 cm The lap joint must be at front sleeve seam. Disassemble balloon.</p> <p>Glue mixture according to VIKING norm 8.1. Glueing is carried out according to VIKING norm 8.2.</p>	C	1xG
	C	1xG 1xG 1xG
<p>C = clean G = glue X = number H = hardener</p>		



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10.1 REPAIR REGULATIONS

11 Replacement of sleeve wrist seal.

Replacement of Neoprene wrist seals for immersion suits made of Gore-tex.

REPLACEMENT OF WRIST SEALS BY SEWING.

- Turn the reverse out of the suit.
- Heat up the ribbon with a heat gun or in crossover 5-10 sec. and removed using a folding stick. Dismantle the stitching.
- Put the wrist seal in the sleeve – right side vs. right side – and sew it approximately 3 mm from the edge.
- Seam sealing tape over the stitches (Gore-Tex tape 22 mm 1007492).

THE SEAM SEALING TAPE MUST BE APPLIED BY MEANS OF SEALING MACHINE

	Heptane 1005112	Bostik NE486 1013243 +7-9% Hardener 1001918
Heat the external tape in the Crossover for 5-10 sec. and remove it with the folding stick. Reverse the sleeve. Heat the internal tape in the Crossover for 5-10 sec. and remove the tape and the wrist seal.		
Sleeve wrist seal left side Sleeve wrist seal right side		
Mount sleeve pieces on metal rings with the reverse out. <u>GLUEING:</u> Gore-tex reverse Wrist seal face side		1xG 1xG
Mount the wrist seal on the sleeve, so that the elastic is sewed on at the front seam. Remember an overlap of 1,5 centimetres. Press down the Neoprene edge.		
Mount Neoprene tape on the reverse. <u>GLUEING:</u> Gore-tex reverse Wrist seal reverse Neoprene tape 1001312 Overlap, 3 to 4 cm. Roll or use a folding stick.	C	1xG 1xG 1xG
Turn sleeve and insert balloon. Mount Neoprene tape on the face side. <u>GLUEING:</u> Gore-tex face side Wrist seal right side Neoprene tape 1001312	C	2xG 1xG 1xG
Overlap, 3 to 4 cm. roll or use a folding stick. The lap joint is to be at the front sleeve seam.		
Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2		
C = clean	G = glue	X = times
		H = hardener



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10.1 REPAIR REGULATIONS

12 Replacement of sleeve wrist seal.

Replacement of Neoprene wrist seals with elastic and loop / Hook, 1003980/1003981 and S-450013250xxL / S-450013250xxR for immersion suits made of Neoprene coated Nylon.

Heat up the external ribbon with a heat gun and removed using a folding stick. Reverse the sleeve. Heat up the wrist seal with a heat gun and remove it.	Heptane 1005112	Bostik NE486 1013243 + 7-9% Hardener 1001918
Reverse the sleeve. Cut the edge straight and insert rings in the suit. Edge of sleeve along edge of ring. Sleeve wrist seal S-450013250xxL left side Sleeve wrist seal S-450013250xxR right side Mount sleeve pieces on metal rings with the reverse out. Clean and glue the sleeve edge reverse Wrist seal face side	C	1xG 1xG
Mount the wrist seal on the sleeve, so that external strap is at the front seam. Remember an overlap of 2 cm. Press down the neoprene edge. Disassemble the ring. Wrist seal right – sleeve right / wrist seal left – sleeve left. Press down overlap 2 cm. Mount Neoprene tape on the reverse. Clean and glue fabric and wrist seal reverse Neoprene tape 1001312 Overlap, 3 to 4 cm. Roll or use a folding stick.	C C	1xG 1xG
Turn sleeve and insert balloon. Mount Neoprene tape on the face side. Clean and glue fabric and wrist seal face side Neoprene tape 1001312 Overlap, 3 to 4 cm. Roll or use a folding stick. Disassemble balloon. Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2	C C	1xG 1xG
C = clean G = glue X = times H = hardener		



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10.1 REPAIR REGULATIONS

13 Replacement of sleeve wrist seal.

Replacement of Codan rubber wrist seals, 1015038 for immersion suits made of PU fabric.

	MEK 1012436	Bostik NE 486 1013243 +7-9% hardener 1001918
<p>Heat between sleeve and wrist seal in crossover for 5-10 sec. and remove it with the folding stick.</p> <p>Mount sleeve pieces on metal rings with the reverse out. Edge of sleeve in the middle of the ring.</p> <p style="padding-left: 40px;">Sleeve edge/reverse Clean the wrist seal 101538</p> <p>Mount the wrist seal on the ring, reverse out and fold the edge 1½-2 cm. Place the fold of the wrist seal so that it follows the sleeve all the way around.</p> <p><u>GLUEING:</u> Sleeve/reverse Wrist seal/face side</p> <p>Force the fold of wrist seal 1½-2 cm over the edge of sleeve and roll or knuckle it.</p> <p>Disassemble ring.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	C C	1xG 1xG
<p>C = clean G = glue X = times H = hardener</p>		



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10.1 REPAIR REGULATIONS

14 Replacement of sleeve wrist seal.

Replacement of rubber wrist seals, for immersion suits made of Gore-tex.

<p>REPLACEMENT OF WRIST SEAL BY GLUEING</p> <p>Heat the external tape in the Crossover for 5-10 sec. and remove it with the folding stick. Reverse the sleeve. Heat the internal tape in the Crossover for 5-10 sec. and remove tape and wrist seal or cut off the wrist seal close to stitches.</p> <p>Mount sleeve pieces on metal rings with the reverse out.</p> <p>Mount the grinded and cleaned wrist seal on the ring with the reverse out, and fold down 1½ cm. The fold must follow the edge of the sleeve all the way round.</p> <p><u>GLUEING:</u> Gore-tex reverse Wrist seal face side Force the wrist seal over the sleeve and knuckle it.</p> <p><u>GLUEING:</u> Gore-tex reverse / wrist seal reverse Neoprene ribbon 25 mm, 1001312 Glue down overlap, 3-4 cm. Knuckle with a folding stick.</p> <p>Turn sleeve and insert balloon. NOTE: Do not inflate so much that the wrist seal becomes wider than the sleeve.</p> <p><u>GLUEING:</u> Gore-tex face side Neoprene ribbon 25 mm, 1001312</p> <p>Glue down overlap, 3-4 cm, knuckle with a folding stick. The lap joint is to be at the front sleeve seam.</p> <p>REPLACEMENT OF WRIST SEALS BY SEWING</p> <p><u>GLUEING:</u> grind, clean and glue wrist seals 2 cm all way round. Gore-tex reverse Put the wrist seal in the sleeve - right side vs. right side - and sew it approximately 3 mm from the edge.</p> <p><u>GLUEING:</u> Glue Wrist seal and Gore-tex reverse Clean and glue the Neoprene ribbon 25 mm, 1001313</p> <p>Insert balloon in sleeve. Mount Neoprene ribbon at assembling at reverse side. Overlap 3-4 cm and knuckle with a folding stick.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	<p>Bostik NE 486 1013243 + 25% Heptane 1005112</p>	<p>MEK 1012436</p>	<p>Bostik NE 486 1013243 + 7-9% hardener 1001918</p>
	<p>1xG</p>	<p>C</p>	<p>1xG</p>
<p>1xG</p>	<p>C</p>	<p>1xG 2xG</p>	
<p>1xG</p>	<p>C</p>	<p>1xG 2xG</p>	
<p>1xG</p>	<p>C</p>	<p>1xG</p>	
<p>1xG</p>	<p>C Heptane 1001645</p>	<p>1xG 2xG</p>	
<p>C = clean G = glue X = times H = hardener</p>			



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10.1 REPAIR REGULATIONS

15 Replacement of sleeve wrist seal.

Replacement of rubber wrist seals 1022242 for immersion suits made of Neoprene coated nylon.

	MEK 1012436	Bostik NE 486 1013243 +7-9% hardener 1001918
<p>External ribbon is heated on Crossover for 5-10 sec. and removed using a folding stick. The sleeve is reversed. Internal ribbon is heated on Crossover for 5-10 sec. and removed using a folding stick. The seam between sleeve and wrist seal is heated on Crossover for 5-10 sec. and separated using a folding stick.</p> <p>The sleeve is reversed, the edge is cut and the suit is provided with rings. Edge of sleeve in the middle of the ring. The wrist seal 1022242 is cleaned and put on the ring reverse out. 1½ cm is tucked in.</p> <p>GLUEING: Fabric reverse/wrist seal face side Wrist seal is averted over the sleeve.</p> <p>Gore-tex reverse Wrist seal face side Neoprene ribbon 1001312 Overlap 3 – 4 cm.</p> <p>The suit is turned and provided with a balloon. NB - Do not inflate to the extent that the wrist seal becomes wider than the sleeve.</p> <p>Gore-tex face side Wrist seal Neoprene ribbon 1001312</p> <p>Overlap 3-4 cm The lap joint must be at front sleeve seam. Disassemble balloon.</p> <p>Glue mixture according to VIKING norm 8.1. Glueing is carried out according to VIKING norm 8.2.</p>	C	
	C	1xG
	C	1xG 2xG 1xG
	C	1xG 1xG 1xG
<p>C = clean G = glue X = number H = hardener</p>		



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10.1 REPAIR REGULATIONS

17 Replacement of sleeve wrist seal.

Replacement of Neoprene wrist seals S-450012450xxL/ S-450012450xxR with zip and elastic for immersion suits made of Gotland Gore Tex, with inner lining.

	Heptane 1005112	Bostik NE486 1013243 +7-9% Hardener 1001918
<p>Heat up external ribbon with a heat gun and removed using a folding stick. The sleeve is reverse. Heat up the wrist seal with a heat gun and removed using a folding stick.</p> <p>Turn reverse out of the sleeve. Cut the edge straight and insert rings in the suit. Edge of sleeve along edge of ring. Wrist seal S-45001245050L / S-45001245050R sizes XS-S Wrist seal S-45001245058L / S-45001245058R sizes M-L-XL-XXL-XPL</p> <p style="text-align: center;">Glue wrist seal face side</p> <p>Mount wrist seal on sleeve such that the wrist seal zipper is placed by the sleeve seam. – Notice, wrist seal right – sleeve right / wrist seal left – sleeve left.</p> <p>Overlap of 2 cm. Press down the edge.</p> <p>Fold the wrist seal edge over the ring, such that the seam is to be covered. Knuckle the Neoprene edge.</p> <p>Remove the ring and turn the sleeve at face side.</p> <p>Insert balloon in sleeve.</p> <p style="text-align: center;">Neoprene ribbon 1001312 Clean and glue face side wrist seal</p> <p>Mount Neoprene ribbon at assembling at external sleeve and wrist seal. Assembling at front sleeve seam. Overlap 3 - 4 cm.</p> <p>Disassemble balloon.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>		1xG
	C C	1xG 1xG
C = clean G = glue X = number H = hardener		

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10.1 REPAIR REGULATIONS

19 Replacement of sleeve wrist seal.

Replacement of rubber wrist seals, article no. 1022242 for immersion suits made of Gore-tex.

REPLACEMENT OF WRIST SEALS BY SEWING

- Cut off the wrist seal close to stitches
- Heat the external tape in the crossover, for 5-10 sec. and remove it with the folding stick.
- Prepare Sleeve wrist seal, 1022242 for GLUEING reverse.



- Clean (MEK, BB thinner 694, 1012436) and glue (Bostik 1013243 + 7–9 % hardener 2206, 1001918) 2½ cm all way round.
- Put the wrist seal 1022242 in the sleeve and sew it approximately 3 mm from the edge.
- Seam sealing tape over the stitches (Gore-tex 1007492).
The seam sealing tape must be applied by means of sealing machine.



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10.2 REPAIR REGULATIONS

1 Replacement of tape.

Replacement of tape for immersion suits made of Neoprene coated Nylon.

- Place the tape to be replaced in the crossover and heat it for 4 sec. at 180°C, or use a heating gun and pull it off with a folding stick. Remove all tape to be replaced in one operation.
- May also be removed using MEK article no. 1012436.
- Place the new tape, 1003570 over the seam and heat it for 4-6 sec. at 180°C in the crossover.
- Then pressed and smoothed with a folding stick. Remember to press and smooth surrounding tape that has been heated.



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10.2 REPAIR REGULATIONS

2 Replacement of tape.

Replacement of tape for immersion suits made of Gore-Tex.

- Place the tape to be replaced in the crossover and heat it for 5 to 10 sec. at 180°C or use a heating gun and pull it off with a folding stick. Remove all tape to be replaced in one operation.

- Place the new tape:

1007492 grey
1001307 black
1001303 white
1001305 green

in the Crossover and heat it for 25 to 30 sec. at 180°C. Upon heating, press and smooth the tape with a folding stick.

- Finish all tape finishes with patches.
Gore-tex patch 1014600 is to be applied by means of heat.
- in Crossover heat it for 25 to 30 sec. at 180°C. Upon heating, press and smooth the tape with a folding stick.



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10.2 REPAIR REGULATIONS

3 Replacement of seam sealing tape.

Replacement of tape for immersion suits made of PU-coated Nylon.

- Place the seam sealing tape to be replaced in crossover, heat it for 4 sec. at 180°C and pull it off with a folding stick. Remove all tape to be replaced in one operation.

DO NOT USE THE CROSSOVER

- Mount the new seam sealing tape 1003570, - it must be applied by means of seam-sealing machine.



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10.3 REPAIR REGULATIONS

1 Replacement of collar

Replacement of rubber collar for immersion suits made of Gore-tex material with inner lining.

Heat front zipper in Crossover 5-10 sec. and remove it with a folding stick. (Don't use heating gun the fabric delaminates)	1005112 Heptane	1013243 Bostik NE 486 +7-9% 1001918 hardener
Internal ribbon between suit and collar is heated in Crossover 5-10 sec. Remove the ribbon with a folding stick. External ribbon is heated in Crossover 5-10 sec. – Remove ribbon and collar with a folding stick.		
The suit is put on the table with bag up and face side out. The shoulders are turning to reverse out. The suit is setting on shield. Clean undershot, zipper and collar	C	
Mark 2,5 cm in on under collar (left side) and mark out the point. Glue the neck edge 2 cm width, 1½ cm from zipper. Glue collar on skin side from mark out 2½ cm.		1xG 1xG
Cut undershot on bias (2cm) Glue undershot on edge (bias)		1xG
Mount the collar with 2cm deliberation all way round. Mount undershot. Clean, glue and mount Neoprene ribbon 1001313, 2½ cm Mark the suit for lining zipper (template 400) Zipper for lining S-5900580, is glued reverse in collar. Collar reverse / zipper	C	1xG 2xG
Turn suit and put on shield. Clean the neoprene ribbon 1001312 Glue the suit Glue and mount the Neoprene ribbon.	C	1xG 2xG
Disassemble shield Glue undershot down. Turn suit with bag up.		1xG
Continued....		
C=clean G = Glue X = Times H = Hardener		



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10.3 REPAIR REGULATIONS

1 Replacement of collar

Replacement of rubber collar for immersion suits made of Gore-tex material with inner lining.

	1005112 Heptane	1013243 Bostik NE 486 +7-9% hardener 1001918
ZIPPER IS GLUED. 2 cm neoprene ribbon 1001312 is cleaned and glued on left side, down over undershot, under zipper.	C	1xG
2½ x 5 cm Indian tape is glued on collars right side. 2½ cm on face side.		1xG
Glue zipper on collar.		1xG
Indian tape and neoprene ribbon is glued for fold on back of collar and undershot.		2xG
Cut collar on bias in surface.		
Collar and zipper is stitched together at the assembling – left side, all collar width – right side only, the top half of collar.		
Suit is laid with back up.		
The sewed on zipper and collar edge is cleaned and glued on face side.	C	1xG
Neoprene ribbon 1001312 is cleaned and glued.	C	1xG
Put on ribbon as cover ribbon over sewing on face side. Collar edge is glued 2½ cm from top edge on face side. Folded ca. 1 cm to face side.		1xG
Hook squares 2 pieces 1014602 marked up in relations to loop straps down along zipper.		
Hook squares and collar is cleaned, glued and put on.	C	1xG
Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2		
C = clean	G = glue	X = times
		H = hardener



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10.3 REPAIR REGULATIONS

3 Replacement of collar

Replacement of neoprene collar for immersion suits made of Gore-tex, with inner lining.

	1005112 Heptane	1013243 Bostik NE 486 +7-9% 1001918 hardener
Heat front zipper in Crossover 5-10 sec. and remove it with a folding stick. (Don't use heating gun the fabric delaminate)		
Internal ribbon between suit and collar is heated in Crossover 5-10 sec. (Don't use heating gun the fabric delaminate) Remove the ribbon with a folding stick. External ribbon is heated in Crossover 5-10 sec. – Remove ribbon and collar with a folding stick.		
MOUNTING OF COLLAR The suit is put on the table with bag up and face side out. The shoulders are turning to reverse out. The suit is setting on shield.		
Clean collar and zipper Glue the neck edge 2 cm width, 1½ cm from zipper. Glue collar on skin side 2½ cm width.	C	1xG 1xG
Mount the collar with 2 cm overlap all way round.		
Clean, glue Neoprene ribbon 1001313, 2½ cm Mount the ribbon reverse.	C	1xG
Zipper for lining S-5900580, is glued reverse the collar. Collar reverse / zipper ribbon		2xG
MOUNT RIBBON FACE SIDE Turn suit and put on shield. Clean and glue Neoprene ribbon 1001312 (2 cm). Glue the suit Mount the Neoprene ribbon.	C	1xG 2xG
Disassemble shield Turn suit with bag up.		
Continued....		
C = clean G = glue X = times H = hardener		



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10.3 REPAIR REGULATIONS

3 Replacement of collar

Replacement of neoprene collar for immersion suits made of Gore-tex, with inner lining.

	1005112 Heptane	1013243 Bostik NE 486 +7-9% 1001918 hardener
<p>ZIPPER IS GLUED ON COLLAR.</p> <p>2½ x 5 cm Indian tape is glued on collars right side. 2½ cm on face side.</p> <p>Glue zipper on collar.</p> <p>Indian tape and neoprene ribbon is glued for fold on back of Collar.</p> <p>Cut the top edge of collar on bias.</p> <p>Collar and zipper is stitched together at the assembling – left side, all collar width – right side only, the top half of collar.</p> <p>Suit is laid with back up.</p> <p>The sewed on zipper and collar edge is cleaned and glued on face side.</p> <p>Neoprene ribbon 1001312 (2cm) is cleaned and glued.</p> <p>Mount the ribbon as cover ribbon over sewing.</p> <p>Collar edge is glued 2½ cm from top edge on face of skin side.</p> <p>Folded ca. 1 cm to face side.</p> <p>Hook square 1 piece 1014602, marked up in relations to loop strap down along left side of zipper.</p> <p>Clean, glue and mount Hook square</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>		<p>1xG</p> <p>1xG</p> <p>2xG</p> <p>1xG</p> <p>1xG</p> <p>1xG</p> <p>1xG</p>
<p>C = clean G = glue X = times H = hardener</p>		



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10.3 REPAIR REGULATIONS

4 Replacement of collar

Replacement of neoprene collar for immersion suits made of Neoprene coated Nylon and Gore-tex, without lining.

	1005112 Heptane	1013243 Bostik NE 486 +7-9% 1001918 hardener
Heat front zipper in Crossover 5-10 sec. and remove it with a folding stick. (Don't use heating gun the fabric delaminate)		
Internal ribbon between suit and collar is heated in Crossover 5-10 sec. Remove the ribbon with a folding stick. External ribbon is heated in Crossover 5-10 sec. – Remove ribbon and collar with a folding stick.		
MOUNTING OF COLLAR The suit is put on the table with bag up and face side out. The shoulders are turning to reverse out. The suit is setting on shield.		
Clean collar and zipper reverse. Glue the neck edge 2 cm width, 1½ cm from zipper. Glue collar on skin side 2½ cm width.	C	1xG 1xG
Mount the collar with 2 cm overlap all way round.		
Clean, glue Neoprene ribbon 1015192 (2½ cm) Mount the ribbon reverse.	C	1xG
MOUNT RIBBON FACE SIDE Turn suit and put on shield. Clean and glue Neoprene ribbon 1001312 (2 cm) Glue the suit Mount the Neoprene ribbon.	C	1xG 2xG
Disassemble shield Turn suit with bag up.		
Continued....		
C = clean G = glue X = times H = hardener		



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10.3 REPAIR REGULATIONS

4 Replacement of collar

Replacement of neoprene collar for immersion suits made of Neoprene coated Nylon and Gore-tex, without lining.

	1005112 Heptane	1013243 Bostik NE 486 +7-9% 1001918 hardener
<p>ZIPPER IS GLUED ON COLLAR. 2½ x 5 cm Indian tape is glued on collars right side. 2½ cm on face side. Glue zipper on collar. Indian tape and neoprene ribbon is glued for fold on back of Collar. Cut the top edge of collar on bias. Collar and zipper is stitched together at the assembling – left side, all collar width – right side only, the top half of collar. Suit is laid with back up. The sewed on zipper and collar edge is cleaned and glued. Neoprene ribbon 1001312 (2cm) is cleaned and glued. Mount the ribbon as cover ribbon over sewing. Collar edge is glued 2½ cm from top edge on skin side. Folded ca. 1 cm to face side. Hook square, 1 piece 1014602, marked up in relations to loop strap down along left side of zipper. Clean, glue and mount Hook square</p>		<p>1xG 1xG 2xG</p>
	C C	1xG 1xG
	C	1xG
<p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>		
C = clean G = glue X = times H = hardener		


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10.3 REPAIR REGULATIONS

5 Replacement of collar

Replacement of neoprene collar S-4500096xx, for immersion suits made of Gore-tex Turn the reverse out of the suit.

- Heat tape with zipper for lining in crossover 5-10 sec. and remove it with a folding stick.
- Dismantle the stitching by under shot and front zipper and heat and remove tape by front zipper with the folding stick.
- Heat the tape between suit and collar in crossover 5-10 sec. or with a heating gun and remove it with the folding stick.
- Dismantle the stitching between suit and collar.
- Sew on the new collar right side vs. right side - and sew it approximately 3 mm from the edge.
- Clean and glue Neoprene ribbon 25 mm, 1001313 (Heptane 1005112 and Bostik NE486 1013243 + Hardener 1001918)
- Glue Gore-tex and collar reverse
- Mount Neoprene ribbon at assembling at reverse of collar and seam. Overlap 3-4 cm and knuckle with a folding stick.
- If lining is mounted, mount zipper for lining (see spare part list) in crossover reverse the suit.
- Glue the underlap (Bostik NE486 1013243 + Hardener 1001918), mount and knuckle with a folding stick.

<p>Turn face side out. Preglue the collar 2 cm all way round the edge. Mark up the hook square No. 1014602, in relation to loop strap down along left side of zipper. Preglue the collar for the hook square piece.</p>  <p>Preglue the hook square. The glued edge is folded up 1 cm. Mount the hook square piece.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	Bostik NE486 1013243 +7-9% Hardener 1001918
	2xG
	2xG
	1xG
C = clean G = glue X = times H = hardener	



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10.3 REPAIR REGULATIONS

6. Replacement of collar

Replacement of neoprene collar, for immersion suits made of Gore-tex without zipper for lining.

<p>Heat up external ribbon between suit and collar in crossover 5-10 sec. or with a heating gun and pull it off with a folding stick. Turn the reverse of the suit out. Heat up internal ribbon between suit and collar in crossover 5-10 sec. or with a heating gun and pull it off with a folding stick.</p>	<p>Bostik NE 486 1013243 + 25% Heptane 1005112</p>	<p>Heptane 1005112</p>	<p>Bostik NE486 1013243 + 7-9 % Hardener 1001918</p>
<p>Heat up the joint between sleeve and wrist seal with a heat gun and separate it with a folding stick. If sewed then Dismantle the stitching between suit and collar or cut off the collar close to stitches.</p>			
<p>MOUNTING OF WRIST SEAL BY SEWING:</p>			
<p>Turn the reverse out of the suit. Clean and glue Gore-tex and collar on both sides</p>	<p>1xG</p>	<p>C</p>	
<p>Sew on the new collar right side vs. right side - and sew it approximately 3 mm from the edge.</p>			
<p>Clean and glue Neoprene ribbon 25 mm, 1001313 Glue Gore-tex and collar reverse</p>		<p>C</p>	<p>1xG 1xG</p>
<p>Mount Neoprene ribbon at assembling at reverse of collar and seam. Overlap 3-4 cm and knuckle with a folding stick.</p>			
<p>or</p>			
<p>Mount seam-sealing tape, over the seam on back side (Gore-tex 1007492).</p>			
<p>THE SEAM SEALING TAPE MUST BE APPLIED BY MEANS OF SEALING MACHINE.</p>			
<p></p>			
<p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>			
<p>C = clean</p>	<p>G = glue</p>	<p>X = number</p>	<p>H = hardener</p>



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10.3 REPAIR REGULATIONS

7 Replacement of collar

Replacement of Dipco collar, 1006735 for immersion suits.

- Turn the reverse out of the suit.
- Heat the tape between suit and collar in crossover 5-10 sec. or with a heating gun and remove it with the folding stick.
- Dismantle the stitching.
- The collar 1006735 is to be cleaned (MEK 1012436) and covered with glue (Bostik NE 486 1013243 + 7–9 % hardener 2206 1001918) 3 cm wide at the bottom.

***NOTICE:** - If the defect collar was sewn with 3 mm seam, the new collar must be sewn on with 3 mm seam.*

- If the defect collar was sewn with 6 mm seam and a stitching, then the new collar must be sewn on with 6 mm seam and a stitching from right side.

- Put the collar 1006735 - right side vs. right side - and sew it approximately 3 mm or 6 mm from the edge.
- Glue Wrist seal and Gore-tex reverse (Bostik NE 486 1013243 + 7–9 % hardener 2206 1001918)
The Neoprene ribbon 25 mm, 1001313 is to be cleaned (MEK 1012436) and glued (Bostik NE 486 1013243 + 7–9 % hardener 2206 1001918)
- Mount Neoprene ribbon at assembling at reverse side.
Overlap 3-4 cm and knuckle with a folding stick.

or

- Mount 2 x seam-sealing tape, with overlap, over the seam on back side (Gore-tex 1007492).

The seam sealing tape must be applied by means of sealing machine.



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10.3 REPAIR REGULATIONS

11 Replacement of collar

Replacement of Dipco collar 1006735, for immersion suits made of Neoprene coated Nylon without lining.

	MEK 1012436	Bostik NE 486 1013243 + 7-9% hardener 1001918
<p>External ribbon is heated in Crossover 5-10 sec. Remove ribbon with a folding stick. Turn the suit reverse out. Internal ribbon on collar is heated in Crossover 5-10 sec. Remove the ribbon with a folding stick Heat collar in Crossover 5-10 sec. and remove it with a folding stick.</p> <p>The suit is put on the table with reverse out. The suit is setting on shield.</p> <p>PREPERE THE COLLAR Grind surface of the glue. Clean surface of the glue on both sides.</p> <p>Mount the collar – reverse: Fabric reverse Collar 1006735 face side Mount the collar with 2 cm overlap all way round. Avoid pucker and folds.</p> <p>Mount the ribbon - reverse: Fabric and collar reverse Neoprene ribbon 1001312 Mount the Ribbon with 3-4 cm overlap avoid pucker and folds.</p> <p>Turn the suit face side out. Put it on shield.</p> <p>Mount the ribbon – face side: Glue the fabric, face side Glue the collar, face side Clean and glue neoprene ribbon 1001312 Mount the Ribbon with 3-4 cm overlap avoid pucker and folds.</p> <p>Roll and knuckle after each assembling of glue.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	C	1xG 1xG
	C	1xG 1xG
	C	1xG 1xG
C = clean G = glue X = times H = hardener		



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10.3 REPAIR REGULATIONS

12 Replacement of collar

Replacement of Neoprene collar S-4500121xx, for immersion suits made of Gore-tex.

	1005112 Heptane	1013243 Bostik NE 486 +7-9% 1001918 hardener
Heat front zipper in Crossover 5-10 sec. and remove it with a folding stick. (Don't use heating gun the fabric delaminate)		
Internal ribbon between suit and collar is heated in Crossover 5-10 sec. Remove the ribbon with a folding stick. External ribbon is heated in Crossover 5-10 sec. – Remove ribbon and collar with a folding stick.		
MOUNTING OF COLLAR The suit is put on the table with bag up and face side out. The shoulders are turning to reverse out. The suit is setting on shield.		
Clean collar and zipper Glue the neck edge 2 cm width, 1½ cm from the teeth of zipper on booth sides. Glue collar on skin side 2½ cm width, omit the last 4 cm on left side of collar.	C	1xG 1xG
Mount the collar with 2 cm overlap. Right side: The edge of the collar finish 1½ cm from the teeth of the Zipper. Left side: The collar passes the teeth of the zipper 2½ cm, finish GLUEING 1½ cm at the teeth of the zipper.		
Clean, glue Neoprene ribbon 1001313 Mount the ribbon reverse.	C	1xG
MOUNT RIBBON FACE SIDE Turn suit and put on shield. Clean and glue Neoprene ribbon 1001312 Glue the suit Mount the Neoprene ribbon.	C	1xG 2xG
Disassemble shield Turn suit with bag up.		
Continued....		
C = clean	G = glue	X = times
		H = hardener



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10.3 REPAIR REGULATIONS

12 Replacement of collar

Replacement of Neoprene collar S-4500121xx, for immersion suits made of Gore-tex.

	1005112 Heptane	1013243 Bostik NE 486 +7-9% 1001918 hardener
ZIPPER IS GLUED ON COLLAR. 2½ x 5 cm Indian tape is glued on collars right side. 2½ cm on face side. Glue zipper on collar. Indian tape is glued for fold on back of collar.		1xG 1xG 1xG
Collar and zipper is stitched together at the assembling.		
Suit is laid with back up.		
The sewed on zipper and collar edge is cleaned and glued. Neoprene ribbon 1001312 is cleaned and glued.	C C	1xG 1xG
Mount the ribbon as cover ribbon over sewing.		
Hook square 1 piece 1014602, marked up in relations to loop strap down along left side of zipper.		
Clean, glue the collar face side Clean, glue and mount Hook square	C C	1xG 1xG
Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2		
C = clean G = glue X = times H = hardener		



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10.3 REPAIR REGULATIONS

18 Replacement of Dipco collar 1006735 for immersion suits made of Gore-tex.

	Heptane 1005112	Bostik NE 486 1013243 +7-9% hardener 1001918
<p>Turn the reverse out of the suit. Heat the internal tape with a heating gun and remove it with the folding stick. Heat the collar and remove it with the folding stick.</p> <p>* Grind 2 cm of the collar 1006735 on both sides. Mount the suit on the shield with the reverse out.</p> <p>Prepare the collar (ground), 1006735, for GLUEING on both sides.</p> <p>GLUEING: Gore-Tex / zip reverse 2 cm Collar face side</p> <p>Mount the collar with 1½ cm overlap, without tucking and puckered. Roll or use a folding stick.</p> <p>Mounting of tape: Gore-Tex / zip reverse / collar reverse. Neoprene tape 1001312</p> <p>Mount the tape. Glue down an overlap of 3 to 4 cm; roll or use a folding stick.</p> <p>Turn the face side out of the suit and mount it on the shield.</p> <p>Mounting of outside tape: Preglue Gore-Tex fabric Gore-Tex / zipper face side Collar face side Neoprene tape 1001312</p> <p>Mount the tape. Glue down an overlap of 2 to 4 cm; roll or use a folding stick.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	C	1xG 1xG
	C	1xG 1xG
	C	1xG 1xG 1xG
C = clean G = glue X = times H = hardener		



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10.3 REPAIR REGULATIONS

21 Replacement of collar

Replacement of collar S-4500119xx for immersion suits made of Neoprene coated Nylon.

	Heptane 1005112	1013243 Bostik NE 486 +7-9% 1001918 hardener
External ribbon and zipper is heated in Crossover 5-10 sec. Remove it with a folding stick.		
Turn the suit reverse out. Internal ribbon on collar is heated in Crossover 5-10 sec. Remove the ribbon with a folding stick Heat collar in Crossover 5-10 sec. and remove it with a folding stick.		
The suit is put on the table with bag up and face side out. The shoulders are turning to reverse out. The suit is setting on shield.		
Clean back cloth, zipper, collar and neck edge.	C	
Mark 2,5 cm in on under collar (left side) and mark out the point.		
Glue the neck edge 2 cm width, 1½ cm from zipper. Glue collar on skin side from mark out 2½ cm width.		1xG 1xG
Cut back cloth on bias (2 cm) Glue back cloth on edge (bias)		1xG
Mount the collar with 2 cm overlap all way round. Mount back cloth.		
Clean, glue and mount Neoprene ribbon 1001313 Mark the collar for lining zipper (template 400) Glue the collar to zipper for lining, 2½ cm width	C	1xG 2xG
Zipper for lining S-5900580, is glued reverse in collar. Collar reverse / zipper		2xL
MOUNT RIBBON FACE SIDE Turn suit and put on shield. Clean and glue Neoprene ribbon 1001312 Glue the suit Mount the Neoprene ribbon.	C	1xG 1xG
Disassemble shield Glue back cloth down. Turn suit with bag up.		1xG
continued		
C = clean G = glue X = times H = hardener		



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10.3 REPAIR REGULATIONS

21 Replacement of collar

Replacement of collar S-4500119xx, for immersion suits made of Neoprene coated Nylon.

	Heptane 1005112	1013243 Bostik NE 486 +7-9% 1001918 hardener
<p>ZIPPER IS GLUED ON COLLAR Neoprene ribbon 1001312 is cleaned and glued on left side, down over back cloth, under zipper.</p> <p>2½ x 5 cm Indian tape is glued on collars right side. 2½ cm on face side. Glue zipper on collar. Indian tape and neoprene ribbon is glued for fold on back of collar and back cloth.</p> <p>Cut collar on bias in surface.</p> <p>FINISH THE COLLAR Suit is laid with back up.</p> <p>The sewed on zipper and collar edge is cleaned and glued on face side. Neoprene ribbon 1001312 is cleaned and glued.</p> <p>Put on ribbon as cover ribbon over sewing on face side. Collar edge is glued 2½ cm from top edge on face side. Folded ca. 1 cm to face side.</p> <p>Hook square 1014602 marked up in relations to loop straps down along zipper.</p> <p>Hook square and collar is cleaned, glued and put on.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	<p>C</p> <p>C</p> <p>C</p> <p>C</p>	<p>1xG</p> <p>1xG</p> <p>1xG 2xG</p> <p>1xG</p> <p>1xG</p> <p>1xG</p>
<p>C = clean G = glue X = times H = hardener</p>		



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10.3 REPAIR REGULATIONS

23 Replacement of collar

Replacement of rubber collar (1013945 delivered from FMV) for immersion suits made of Gore-tex.

REPLACEMENT OF COLLAR	Heptane 1005112	Bostik NE 486 1013243 +7-9% Hardener 1001918
Heat the external tape with a heating gun or in Crossover for 5-10 Sec. and remove it with the folding stick. Heat the collar and Reverse.		
Clean the collar.	C	
Mark out in the middle of front and bag of the collar.		
<u>GLUEING:</u> Collar on front Gore-Tex reverse 2 cm all way round		1 x G 1 x G
Mount the collar, roll and knuckle		
<u>GLUEING:</u> Collar and fabric right side Clean and glue neoprene ribbon 1001312	C	2 x G 1 x G
Mount the Neoprene ribbon, roll and knuckle		
Glue down overlap, 3-4 cm, in the same way; roll or knuckle.		1 x G
Glue mixture according to VIKING standard 8.1 Carry out glueing according to VIKING standard 8.2		
C = clean G = glue X = times H = hardener		



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10.3 REPAIR REGULATIONS

24 Replacement of collar

Replacement of collar S-4500151xx, for immersion suit made of Neoprene coated Nylon.

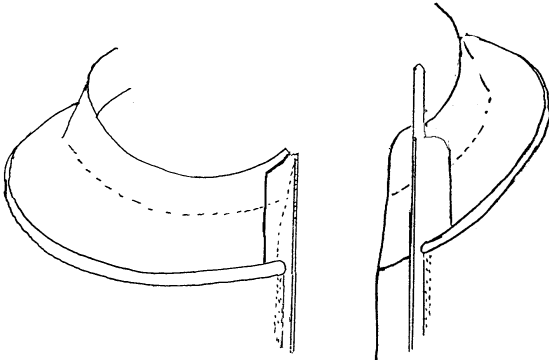
Heat the back cloth and the internal zip off collar with a heating gun and remove with the folding stick. Heat the tape and remove it with the folding stick.	1032514 Bostik Vinylcol+5% 1024195 hardener Desmodur	Heptane 1005112	1013243 Bostik NE 486 +7-9% 1001918 hardener
The suit is put on the table face out. The shoulders are turned reverse out. The neck opening is cut clean	1xG	C	
The loose end of zipper is ground reverse and outside. Put the suit on shield.			
Back cloth, neck edge and zipper are cleaned. Zipper is surfaced.			
Make a mark 2,5 cm in from left side of collar			
A 2 cm width of the neck edge is glued, 1½ cm from zipper. Collar face side is glued, from mark 2½ cm width. Back cloth is glued on edge Mount the collar with 2 cm overlap, all the way round. Mount back cloth.			1xG 1xG 1xG
Clean, glue and mount Neoprene ribbon, 1001313, 2½ cm width. Make a mark for lining zipper (template no. 591.1 + 591.2) Collar is glued from point, 2½ cm width. Zipper ribbon is glued - mount the zipper.		C	1xG 2xG 2xG
MOUNT RIBBON ON OUTSIDE The suit is put on the table reverse out. Put it on shield. 2 cm Neoprene ribbon 1001312 is cleaned Suit and collar are glued. Neoprene ribbon is glued and mounted		C	2xG 1xG
Disassemble shield. Glue back cloth down. Turn suit back up.			1xG
Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2			
C = clean G = glue X = times H = hardener			

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10.3 REPAIR REGULATIONS

24 Replacement of collar

Replacement of collar S-4500151xx, for immersion suit made of Neoprene coated Nylon.

	1032514 Bostik Vinycol+5% 1024195 hardener Desmodur	Heptane 1005112	1013243 Bostik NE 486 +7-9% 1001918 hardener
<p>MOUNT ZIPPER ON COLLAR Collar and back cloth are glued <u>Left side:</u> Neoprene ribbon, 1001312, is cleaned and glued. Mount neoprene ribbon over back cloth, under the zipper. <u>Right side:</u> 2½x5 cm Indian tape is glued reverse of collar. 2½ cm is glued on collar face side.</p> <p>Glue the zipper on collar - until teeth. Indian tape and Neoprene ribbon are glued to the fold down on back of collar and back cloth.</p> 	1xG	C	1xG
	1xG		1xG 1xG 2xG
<p>FINISH THE COLLAR Suit is laid with back up.</p> <p>The sewed on zipper and collar edge is cleaned and glued on face side. Neoprene ribbon 1001312 is cleaned and glued.</p> <p>Put on ribbon as cover ribbon over sewing on face side.</p> <p>1 Hook square 1014602 marked up in relations to loop straps down along zipper.</p> <p>Hook square and collar is cleaned, glued and put on.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>		C	1xG
		C	1xG
		C	1xG
C = clean G = glue X = times H = hardener			



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10.3 REPAIR REGULATIONS

25 Replacement of collar

Replacement of collar S-4500151xx, for immersion suit made of Neoprene coated Nylon.

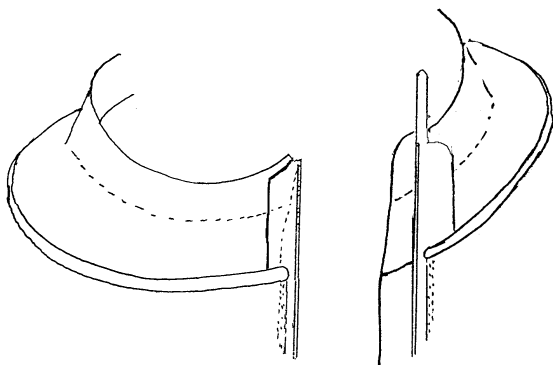
	Heptane 1005112	1013243 Bostik NE 486 +7-9% 1001918 hardener
Heat the back cloth and the internal zip off collar with a heating gun and remove with the folding stick. Heat the tape and remove it with the folding stick. The suit is put on the table face out. The shoulders are turned reverse out. The neck opening is cut clean		
The loose end of zipper is ground reverse and outside. Put the suit on shield.		
Back cloth, neck edge and zipper are cleaned reverse. Make a mark 2,5 cm in from left side of collar	C	
A 2 cm width of the neck edge is glued, 1½ cm from zipper. Collar face side is glued, from mark 2½ cm width. Back cloth is glued on edge Mount the collar with 2 cm overlap, all the way round. Mount back cloth.		1xG 1xG 1xG
Clean, glue and mount Neoprene ribbon, 1001313, 2½ cm width. Make a mark for lining zipper (template no. 591.1 + 591.2) Collar is glued from point, 2½ cm width. Zipper ribbon is glued - mount the zipper.	C	1xG 2xG 2xG
MOUNT RIBBON ON OUTSIDE The suit is put on the table reverse out. Put it on shield. 2 cm Neoprene ribbon 1001312 is cleaned Suit and collar are glued. Neoprene ribbon is glued and mounted	C	2xG 1xG
Disassemble shield. Glue back cloth down. Turn suit back up.		1xG
Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2		
C = clean G = glue X = times H = hardener		

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10.3 REPAIR REGULATIONS

25 Replacement of collar

Replacement of collar S-4500151, for immersion suit made of Neoprene coated Nylon.

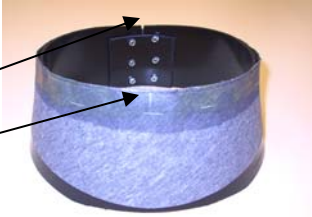



<p>SHORTING OF THE ZIPPER: Mark the collar edge (use template no. 406) Mark zipper from teeth, 1½ cm. Cut off the extra end of zipper to collar edge.</p>	<p>Heptane 1005112</p>	<p>1013243 Bostik NE 486 +7-9% 1001918 hardener</p>
<p>Count down 3 teeth from collar edge on zipper NOTE: move the zipper stopper down. Cut to strap – round off the rest. Right side: Count down 3 teeth from collar edge, Cut the zipper so that the top edge is bevelled. (According fig.)</p>		
<p>MOUNT ZIPPER ON COLLAR Collar and back cloth are glued <u>Left side:</u> Neoprene ribbon, 1001312, is cleaned and glued. Mount neoprene ribbon over back cloth, under the zipper. <u>Right side:</u> 2½x5 cm Indian tape is glued reverse of collar. 2½ cm is glued on collar face side.</p>	<p>C</p>	<p>1xG 1xG</p>
<p>Glue the zipper on collar - until teeth. Indian tape and Neoprene ribbon are glued to the fold down on back of collar and back cloth.</p>		<p>1xG 1xG</p>
		<p>2xG</p>
<p>The sewed on zipper and collar edge are cleaned. Neoprene ribbon, 1001312, is cleaned 2 cm.</p>		
<p>Zipper and ribbon are glued. Mount the ribbon as cover ribbon over sewing. 1 Hook square, marked up in relations to loop strap down along left side of zipper.</p>	<p>C C</p>	<p>1xG</p>
<p>Collar + strap are cleaned and glued Mount collar and strap</p>	<p>C</p>	<p>1xG</p>
<p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>		
<p>C = clean G = glue X = times H = hardener</p>		

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10.3 REPAIR REGULATIONS

26 Replacement of collar

Replacement of Neoprene collar for immersion suit made of Nomex Gore tex.

<p>Heat the external tape with a heating gun and remove it with a folding stick. Turn the reverse out of the suit. Heat the internal tape with a heating gun and remove it with the folding stick. Remove the collar with the folding stick.</p> <p>Turn the reverse out of the suit. Mount the shield (1018634) in Gore-tex Collar.</p>	<p>Bostik NE 486 1013243+25% Heptane 1005112</p>	<p>Heptane 1005112</p>	<p>1013243 Bostik NE 486 +7-9% 1001918 hardener</p>
<p>Mark Gore-tex collar in front and back</p> 	<p>1xG</p>		
<p>Preglue the Gore tex 2 cm wide.</p> <p>Mark the fabric straight in front and back. Glue the fabric 2 cm wide.</p>			<p>1xG</p>
<p>Collar The collar is cleaned reverse. Mark the collar straight in front and back, glue 2 cm face side. Mount the collar.</p>		<p>C</p>	<p>1xG</p>
 <p>Roll or use a folding</p>			
<p>stick.</p>			
<p><u>Neoprene tape reverse side</u> Clean and glue Neoprene tape 1001313</p>		<p>C</p>	<p>1xG</p>
<p>Use the auxiliary equipment (1017952)</p>  			<p>1xG</p>
<p>Glue collar and fabric. Mount the neoprene tape reverse. Glue down an overlap of 2 to 4 cm; use a folding stick.</p>			
<p><u>Neoprene tape face side</u> Glue collar and fabric Clean and glue Neoprene tape 1001313 Mount the neoprene tape face. Glue down an overlap of 2 to 4 cm; use a folding stick.</p>		<p>C</p>	<p>1xG 1xG</p>

C = clean G = glue X = times H = hardener

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10.3 REPAIR REGULATIONS

26 Replacement of collar

Replacement of Neoprene collar for immersion suit made of Goretex.

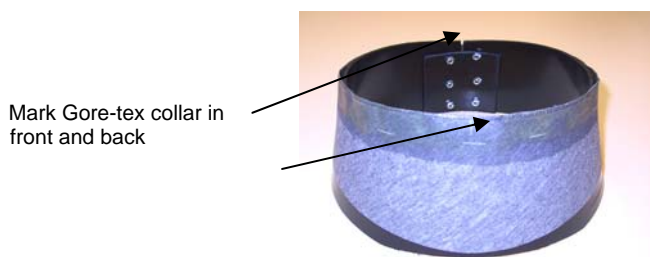
REPLACEMENT OF COLLAR BY SEWING

Cut of the collar by the stitches.

Heat the tape with a heating gun and remove it with a folding stick.

Turn the reverse out of the suit. Cut the edge straight.

Clean and glue reverse Goretex (Heptane 1005112 - glue Bostik NE 486 1013243+25% Heptane 1005112)



Put the neoprene collar in the fabric – right side vs. right side – and sew it approximately 3 mm from the edge.

Glue the collar and the fabric reverse (1013243 Bostik NE 486 +7-9% 1001918 hardener)

Neoprene tape reverse side

Clean and glue neoprene ribbon 25 mm, 1001313 (Heptane 1005112 – glue 1013243 Bostik NE 486 +7-9% 1001918 hardener)

Use the auxiliary equipment (1017952)



Mount neoprene ribbon at assembling at reverse side of collar and fabric. Overlap 3-4 cm and knuckle it.



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10.3 REPAIR REGULATIONS

27 Replacement of collar

Replacement of collar S-450015140, size 40, for immersion suit made of Gotland 3 layer.

	1032514 Bostik Vinycol+5% 1024195 hardener Desmodur	Heptane 1005112	1013243 Bostik NE 486 +7-9% 1001918 hardener
Heat the back cloth and the internal zip off collar with a heating gun and remove with the folding stick. Heat the tape and remove it with the folding stick. The suit is put on the table face out. The shoulders are turned reverse out. The neck opening is cut clean			
The loose end of zipper is ground reverse and outside. Put the suit on shield.			
Back cloth, neck edge and zipper are cleaned. Zipper is surfaced.	1xG	C	
Make a mark 2,5 cm in from left side of collar			
2 cm width of the neck edge is glued, 1½ cm from zipper. Collar face side is glued, from mark 2½ cm width. Back cloth is glued on edge Mount the collar with 2 cm overlap, all the way round. Mount back cloth.			1xG 1xG 1xG
Clean, glue and mount Neoprene ribbon, 1001313, 2½ cm width.		C	1xG
MOUNT RIBBON ON OUTSIDE The suit is put on the table reverse out. Put it on shield. 2 cm Neoprene ribbon 1001312 is cleaned Suit and collar are glued. Neoprene ribbon is glued and mounted		C	2xG 1xG
Disassemble shield. Glue back cloth down. Turn suit back up.			1xG
Carry out gluing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2			
C = clean G = glue X = times H = hardener			



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10.3 REPAIR REGULATIONS

27 Replacement of collar

Replacement of collar S-450015140, size 40, for immersion suit made of Gotland 3 layer.

	1032514 Bostik Vinycol+5 % 1024195 hardener Desmodur	Heptane 1005112	1013243 Bostik NE 486 +7-9% 1001918 hardener
<p>SHORTING OF THE ZIPPER: Mark the collar edge (use template no. 406) Mark zipper from teeth, 1½ cm. Cut off the extra end of zipper to collar edge.</p> <p>Count down 3 teeth from collar edge on zipper NOTE: move the zipper stopper down. Cut to strap – round off the rest. Right side: Count down 3 teeth from collar edge.</p> <p>MOUNT ZIPPER ON COLLAR Collar and back cloth are glued <u>Left side:</u> Neoprene ribbon, 1001312, is cleaned and glued. Mount it over back cloth, under the zipper.</p> <p><u>Right side:</u> 2½x5 cm Indian tape is glued reverse of collar. 2½ cm is glued on collar face side.</p> <p>Glue the zipper on collar - until teeth. Indian tape and Neoprene ribbon are glued to the fold down on back of collar and back cloth.</p> <p>The sewed on zipper and collar edge are cleaned. Neoprene ribbon, 1001312, is cleaned.</p> <p>Zipper and ribbon are glued. Mount the ribbon as cover ribbon over sewing. 1 Hook square, marked up in relations to loop strap down along left side of zipper.</p> <p>Collar + strap are cleaned and glued Mount strap</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	2xG	C	1xG
	1xG		1xG 1xG
		C C	2xG
			2xG
			1xG

C = clean G = glue X = times H = hardener



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10.4 REPAIR REGULATIONS

1 Replacement of socks

Replacement of socks for immersion suits made of Gore-Tex.

- Cut off the socks with scissors by the seam.
- Turn the suit reverse out. Heat the rest of tape in the Crossover for 5-10 sec. and remove it with the folding stick.
- Preglue the Gore-tex and sock reverse, Bostik NE 486 1013243+25% Heptane 1005112
- Sew the new socks onto the suit, right against right so that the seam width is 3 mm.
- Make sure that the socks mark forward.
- Sewing tread according to spare part list 1001544.
- The sock size depends on the suit size. (See spare-parts list)
- Place the suit with the reverse out, over the Crossover, apply the tape, 1007492, heat it for 25 to 30 sec. all the way round. Press and smooth the tape with a folding stick.
- Finish all tape finishes with patches.
- Gore-tex patch, 1014600, to be applied by crossover or means of heat, press and smooth the tape and patch with a folding stick.



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10.4 REPAIR REGULATIONS

2 Replacement of socks

Replacement of socks for immersion suits made of neoprene coated nylon.

Cut off the socks with scissors by the seam.

- Turn the suit reverse out. Heat the rest of tape in the Crossover for 5-10 sec. and remove it with the folding stick.
- Sew the new socks onto the suit, right against right so that the seam width is 3 mm. Make sure that the socks mark forward. Sewing tread according to spare part list
- The sock size depends on the suit size. (See spare-parts list)
- Sewing thread according to spare parts list.
- Make sure that the socks mark forward.
- Place the suit reverse out, put the trouser leg over the Crossover, apply the tape, article no. 1003570, heat it for 25 to 30 sec. all the way round. Press and smooth the tape with a folding stick.



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10.5 REPAIR REGULATIONS

1 Replacement of boots

Replacement of Bekina Thermolite and Harvik rubber boot, (se spare parts list) for immersion suits made of Gore-tex, without zipper for inner lining.

<p>Heat the tape with a heating gun and remove it. Heat the boot and the suit with a heating gun and separate them carefully. If the boots have not been replaced before they may be cut off at the boots' edge. Please note: the trouser legs will be 2.5 cm shorter.</p>	1012436 MEK	1013243 Bostik NE 486 + 7-9% 1001918 Hardener	1032514 Bostik Vinylcol +5% 1024195 hardener Desmodur
<p>Remove the outer layer of ribbon. Make the new boots have the same length as the boots to be replaced. Grind the top 4 cm of the boots.</p> <p>Glue and mount the zipper ribbon 2½ cm from edge. GLUEING: Zipper ribbon 1004602, for reverse of boot Inside the boot</p> <p>Mount the zipper ribbon as the line following the top edge of boot. The assembling is to be on the reverse leg/boot. Overlap of 3 to 4 cm.</p> <p>Place the suit on the table with the face side out. Mark the centre of trouser leg and fold the bottom 2-2½ cm of the trouser leg. Insert balloon in trouser leg and boot. Make sure that the centre markings are opposite each other. Inflate the balloon. Clean and preglue the boot PreGLUEING: Gore-tex reverse 5 cm</p> <p>Gore Tex reverse side Boot</p> <p>Force the fold onto zipper ribbon and the boot and knuckle. There is to be an overlap of 2-2½ cm on boot.</p> <p>Gore-tex face side Boot Indian tape 1001309</p>	C	2xG 2xG	1xG 1xG 1xG 1xG
<p>Cover the edge of the suit with Indian tape. The assembling (overlap of 3 to 4 cm) is to be on the outer leg, pointing backwards. Important: The GLUEING is to be knuckled with a folding stick</p> <p>Leave the balloon for min. 16 hours.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	C	2xG 1xG 1xG	1xG
<p>C = clean G = glue X = times H = hardener</p>			



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10.5 REPAIR REGULATIONS

2 Replacement of boots

Replacement of Harvik rubber boot article no. 1005663 (size 43 see spare parts list) for immersion suits made of Neoprene coated Nylon, with zipper for lining.

Heat the tape with a heating gun and remove it with a folding stick.	MEK 1012436	Fast Bond 1001642	1013243 Bostik NE 486 +7-9% 1001918 hardener
Heat the boot and the suit with a heating gun and separate them carefully.			
Cut the Compass boot, it is to be 27 cm reverse heel. Grind the top 4 cm of the boots. Glue the zipper ribbon 1014622, reverse side. Boot reverse side			2xG 2xG
Mount the ribbon as the line following the top edge of boot.			
The assembling is to be on the reverse leg/boot. Glue overlap of 3 to 4 cm.			
Place the suit on the table with the face side out. Mark the centre of trouser leg and fold the bottom 4½-5 cm of the trouser leg. Insert balloon in trouser leg and boot. Make sure that the centre markings are opposite each other. Inflate the balloon.			
Clean and preglue the boots Fabric reverse side (notice by tape 2xG) Boot	C	1xG	1xG 1xG
Force the fold onto zipper ribbon and the boot and knuckle. Edge of suit is to be 1½ - 2 cm under the top edge of boot. Fabric face side Boot Indian tape 1001309	C		1xG 1xG 1xG
Cover the edge of the suit with Indian tape. The assembling (overlap of 3 to 4 cm) is to be on the outer leg, pointing backwards.			
Leave the balloon for min. 16 hours.			
Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2			
C = clean G = glue X = times H = hardener			



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10.5 REPAIR REGULATIONS

3 Replacement of boots

Replacement of Bekina boot (se spare parts list) for immersion suits made of Gore-tex, without inside zipper for innerlining.

<p>Heat the tape with a heating gun and remove it. May also be removed using Mek 694 article no. 1012436 on a brush. Heat the boot and the suit with a heating gun and separate them carefully.</p>	MEK 1012436	1032514 Bostik Vinylcol +5% 1024195 hardener Desmodur	1013243 Bostik NE 486 +7-9% 1001918 hardener
<p>If the boots have not been replaced before they may be cut off at the boots edge. Please note: the trouser legs will be 2.5 cm shorter. Remove the outer layer of ribbon. Make the new boots have the same length as the boots to be replaced. Grind the top 4 cm of the boots.</p> <p>Place the suit on the table with the right side out. Mark the centre of trouser leg and boot and fold the bottom 2-2½ cm of the trouser leg. Insert balloon in trouser leg and boot. Make sure that the centre markings are opposite each other. Inflate the balloon.</p> <p>Clean and preglue the boots</p> <p>GLUEING: Gore-tex reverse side Outside of boot</p> <p>Force the fold onto the boot and knuckle. There is to be an overlap of 2 to 2½ cm on the boot.</p> <p>GLUEING: Gore-tex face side Boot Indian tape 1001309</p> <p>Cover the edge of the suit with Indian tape. The assembling (overlap of 3 to 4 cm) is to be on the outer leg, pointing backwards. Important: The GLUEING must be knuckled with a folding stick</p> <p>Leave the balloon for min. 16 hours.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	C	1xG	1xG 1xG 2xG 1xG 1xG
<p>C = clean G = glue X = times H = hardener</p>			



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10.5 REPAIR REGULATIONS

4 Replacement of boots

Replacement of Bikina safetyboot article no. 1004460 (see spare parts list) for immersion suits made of Neoprene coated nylon, with zipper for lining.

Heat the tape with a heating gun and remove it with a folding stick.	MEK 1012436	1032514 Bostik Vinylcol +5%	1013243 Bostik NE 486 +7-9%
Heat the boot and the suit with a heating gun and separate them carefully.		1024195 hardener Desmodur	1001918 Hardener
Make the new boots have the same length as the boots to be replaced. Grind the top 4 cm of the boots Glue Zipper ribbon 1014601 reverse side Clean and glue boot inside	C		2xG 2xG
Mount the zipper ribbon as the line following the top edge of boot. The assembling is to be on the inside leg/boot. Glue overlap of 3 to 4 cm.			
Place the suit on the table with the face side out. Mark the centre of trouser leg and fold the bottom 2-2½ cm of the trouser leg.			
Insert balloon in trouser leg and boot. Make sure that the centre markings are opposite each other. Inflate the balloon.			
Clean the boot and preglue Fabric reverse side Boot	C	1xG	1xG 1xG
Force the fold onto zipper ribbon and the boot and knuckle. Edge of suit is to be 1½ - 2 cm under the top edge of boot.			
GLUEING: Fabric face side Boot Indian tape 1001309	C		2xG 1xG 1xG
Cover the edge of the suit with Indian tape. The assembling (overlap of 3 to 4 cm) is to be on the outer leg, pointing backwards. Important: The GLUEING is to be knuckled with a folding stick			
Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2			
C = clean G = glue X = times H = hardener			



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10.5 REPAIR REGULATIONS

5 Replacement of boots

Replacement of boots 1015209 for immersion suits made of PU-coated nylon.

1. Dismount the buoyancy foam
Disconnect the outer fabric from the inner lining at the ribbons by the boot
Remove the inner lining through buoyancy zipper.
2. Cut the boot off with a pair of scissors. Cut in the middle of the seam between the suit and the boot.
3. Heat the remaining seam sealing tape in the crossover for 5 - 10 sec. and remove it with a folding stick. Also remove remaining sewing thread.
4. Turn the leg of the suit out through the buoyancy zipper so that the reverse of the fabric turns out.
Place new boots reverses the leg and sew it together with the face side to face side and a seam width of 3 mm

DO NOT USE THE CROSSOVER

5. The seam is to be applied with seam sealing tape, article no. 1003570.
The seam sealing tape must be applied by means of sealing machine.
6. Mount the inner lining in the boots and sew it together at the ribbons.
7. Turn the trouser leg back in the right position.
8. After repair, the suit must be retested.



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10.5 REPAIR REGULATIONS

7 Replacement of boots

Replacement of Compass rubber boots 1005664 (see spare parts list) for immersion suits made of Neoprene coated nylon and Gore-tex, without inside zipper ribbon.

	Heptane 1005112	1013243 Bostik NE 486 +7-9% 1001918 Hardener
Heat the tape with a heating gun and remove it with a folding stick. Heat the boot and the suit with a heating gun and separate them carefully.		
Cut the Compass boot, it is to be 27 cm reverse heel. Grind the top 4,5 cm of the boots.		
Place the suit on the table with the face side out. Mark the centre of trouser leg and fold the bottom 4½-5 cm of the trouser leg. Insert balloon in trouser leg and boot. Make sure that the centre markings are opposite each other. Inflate the balloon.		
Fabric reverse side (notice by tape 2xG) Boot	C	1xG 2xG
Force the fold onto zipper ribbon and the boot and knuckle. Edge of suit is to be 1½ - 2 cm under the top edge of boot.		
Fabric face side Boot Indian tape 1001309	C	1xG 1xG 1xG
Cover the edge of the suit with Indian tape. The assembling (overlap of 3 to 4 cm) is to be on the outer leg, pointing backwards.		
Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2		
C = clean G = glue X = times H = hardener		



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10.5 REPAIR REGULATIONS

8 Replacement of boots

Replacement of Harvik rubber boots (se spare parts list) for Immersion suits made of Gore-tex, with inside zipper ribbon for inner lining.


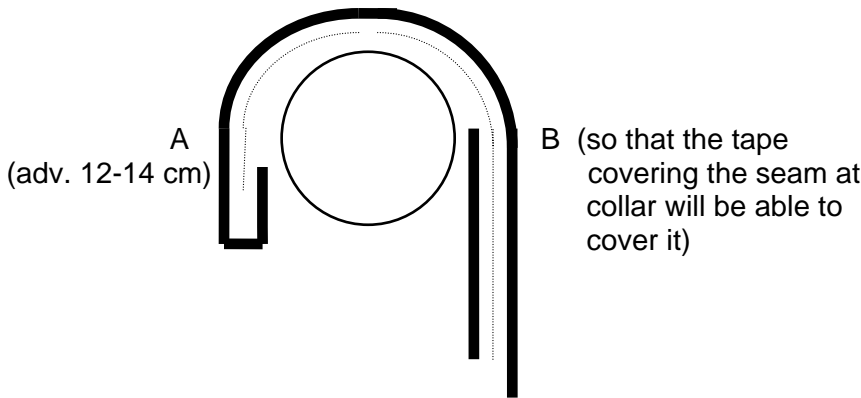
<p>Heat the tape with a heating gun and remove it with a folding stick. Heat the boot and the suit with a heating gun and separate them carefully.</p> <p>If the boots have not been replaced before they may be cut off at the boots' edge. Please note: the trouser legs will be 2.5 cm shorter.</p> <p>Remove the outer layer of zipper ribbon.</p> <p>Grind the top 4,5 cm of the boots. Mark zipper ribbon 2½ cm from edge. Place the suit on the table with the face side out. Mark the centre of trouser leg and boot and fold the bottom 2-2½ cm of the trouser leg. Insert balloon in trouser leg and boot. Make sure that the centre markings are opposite each other. Inflate the balloon.</p> <p>GLUEING: Zipper ribbon 1014601, for reverse of boot Inside the boot</p> <p>Mount the zipper ribbon as the line following the top edge of boot. The assembling is to be on the reverse leg/boot. Overlap of 3 to 4 cm.</p> <p>Place the suit on the table with the face side out. Mark the centre of trouser leg and fold the bottom 4½-5 cm of the trouser leg. Insert balloon in trouser leg and boot. Make sure that the centre markings are opposite each other. Inflate the balloon.</p> <p style="padding-left: 40px;">Gore-tex reverse side Boot</p> <p>Force the fold onto zipper ribbon and the boot and knuckle. There is to be an overlap of 1½-2 cm on the boot.</p> <p style="padding-left: 40px;">Gore-tex face side Boot Indian tape 1001309</p> <p>Cover the edge of the suit with Indian tape. The assembling (overlap of 3 to 4 cm) is to be on the outer leg, pointing backwards. Important: The glueing has to be knuckled with a folding stick</p> <p>Leave the balloon for min. 16 hours.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	<p>Heptane 1005112</p> <p>C</p>	<p>1013243 ostik NE 486 + 7-9% 1001918 hardener</p> <p>2xG 2xG</p> <p>1xG 1xG</p> <p>2xG 1xG 1xG</p>
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10.6 REPAIR REGULATIONS

1 Replacement of zipper

Replacement of zipper for immersion suits made of Gore-tex

<p>Heat up the tape at the collar with a heating gun and remove it carefully with the folding stick. Heat the collar and remove it carefully from the zipper with the folding stick. Unpick the stitches at the zipper and cut the neoprene tape along the zipper edge. (Don't heat the Gore-tex material as it will then delaminate) Sew in the zipper. Sew with Nomex 1001550 sewing thread. Place the suit on a table with the reverse out. Cut the zipper along the seam.</p> <p>GLUEING: Gore-tex reverse/ zipper. Neoprene tape 25 mm  1001313</p> <p>Mount the zipper in the left side to mark(A) Mount the zipper in the right side to mark(B)</p> <div data-bbox="239 1317 1104 1713" data-label="Diagram">  </div> <p>Mount the tape when the GLUEING are dry and use a folding stick thoroughly.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	<p>Heptane 1005112</p> <p>C C</p>	<p>1013243 Bostik NE 486 +7-9% 1001918 hardener</p> <p>1xG 1xG</p>
Continued		
<p>C = clean G = glue X = number H = hardener</p>		



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10.6 REPAIR REGULATIONS

1 Replacement of zipper

Replacement of zipper, for immersion suits made of Gore-tex

	1012436 MEK	1013243 Bostik NE 486 +7-9% 1001918 hardener
<p>* Grind 2 cm of the collar 1006735 on both sides. Mount the suit on the shield with the reverse out.</p> <p>Prepare the collar (ground), 1006735, for glueing on both sides.</p> <p>GLUEING: Gore-Tex / zip reverse 2 cm Collar face side</p> <p>Mount the collar with 1½ cm overlap, without tucking and puckered. Roll or use a folding stick.</p> <p>Mounting of tape: Gore-Tex / zip reverse / collar reverse. Neoprene tape 1001312</p> <p>Mount the tape. Glue down an overlap of 3 to 4 cm; roll or use a folding stick.</p> <p>Turn the right side out of the suit and mount it on the shield.</p> <p>Mounting of outside tape: Gore-Tex / zipper face side Collar face side Neoprene tape 1001312</p> <p>Mount the tape. Glue down an overlap of 2 to 4 cm; roll or use a folding stick.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	C	1xG 1xG
	C	1xG 1xG
	C	1xG 1xG 1xG
C = clean	G = glue	X = times
		H = hardener



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10.6 REPAIR REGULATIONS

2 Replacement of zipper

Replacement of zipper for immersion suits made of Gore-tex.

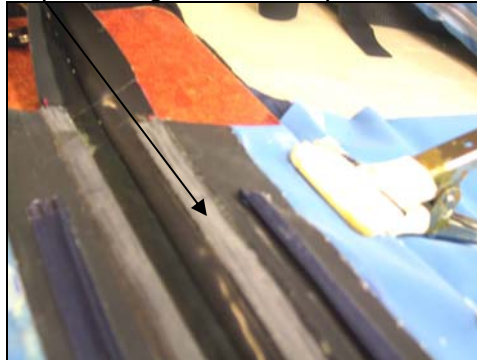
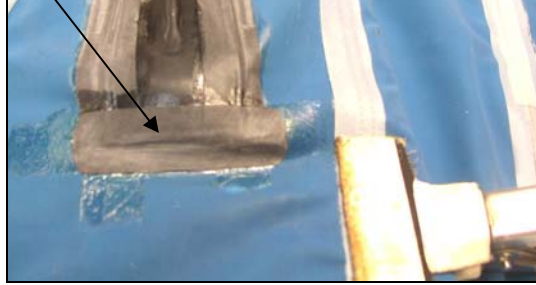
	Heptane 1005112	1013243 Bostik NE 486 +7-9% 1001918 hardener
Heat the external tape with a heating gun or in cross-over for 5-10 sec. and remove it with the folding stick. Unpick the sewing and remove the zipper		
The zipper is cleaned with a lint free cloth (cotton)	C	
Sew on the zipper with sewing by 2-needles.		
Turn the suit reverse out – the zipper must be open. Cut the rubber along the sewing all way round		
<u>GLUEING</u> : Gore-Tex reverse / zipper Neoprene ribbon 1001313	C	1 x G 1 x G
Mount the Neoprene ribbon, roll and knuckle.		
Mount neoprene ribbon at the end of zipper. Use the same procedure as above mentioned		
<u>GLUEING</u> : Velcro 1006696 Cut the Velcro along the sewing.		1 x G
Glue mixture according to VIKING standard 8.1 Carry out glueing according to VIKING standard 8.2		
C = clean	G = glue	X = times H = hardener

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10.6 REPAIR REGULATIONS

3 Replacement of zipper

Replacement of zipper for immersion suits made of Neoprene coated nylon.

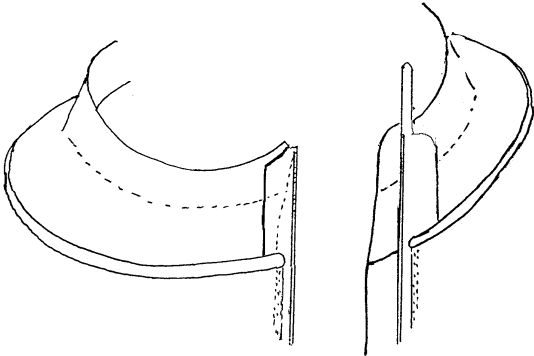
<p>Heat the back cloth and collar with a heating gun and remove it with the folding stick. Turn the suit with right side out and cut the zipper stitch. Turn the suit reverse out, cut through the Indian tape all along the zipper, and remove the front zipper.</p>	<p>Heptane 1005112</p>	<p>1013243 Bostik NE 486 +7-9% 1001918 hardener</p>
<p>Do not remove the zipper for lining. The zipper is clean with a non-fluffy cloth The front zipper is sewn in the suit (template no. 824)</p>	<p>C</p>	
<p>Put the suit on a table reverse out, close the front zipper.</p>		
<p>Mount Indian tape on front zipper reverse the suit: Clean and glue Neoprene coated nylon/front zipper, back side. Clean and glue Indian tape 1001309</p>	<p>C C</p>	<p>1xG 1xG</p>
		
<p>Mount Indian tape at the bottom of the front zipper.</p>		
		
<p>Glue mixture according to VIKING standard 8.1 Carry out glueing according to VIKING standard 8.2</p>		
<p>Continued</p>		
<p>C = clean G = glue X = times H = hardener</p>		

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10.6 REPAIR REGULATIONS

3 Replacement of zipper

Replacement of zipper for immersion suits made of Neoprene coated nylon.

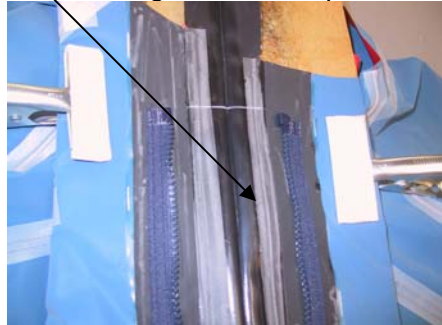
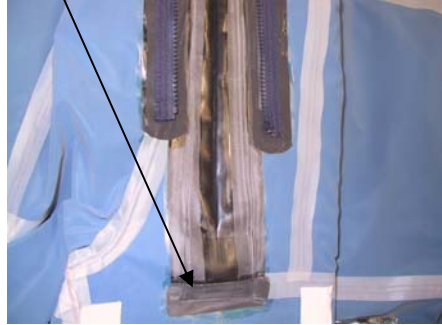
REPLACEMENT OF FRONT ZIPPER FOR IMMERSION SUIT PS5041 AND PS5042			
<p>SHORTING OF THE ZIPPER: Mark the collar edge (template no. 406) Mark zipper from teeth, 1½ cm. Cut off the extra end of zipper to collar edge.</p> <p>Count down 3 teeth from collar edge on zipper NOTE: move the zipper stopper down. Cut to strap – round off the rest. Right side: Count down 3 teeth from collar edge, Cut the zipper so that the top edge is bevelled. (According fig.)</p> 	Heptane 1005112	1013243 Bostik NE 486 +7-9% 1001918 hardener	
			1xG
		C C	1xG
		C	1xG
<p>MOUNT ZIPPER ON COLLAR The collar and zipper are glued</p> <p>The sewed on zipper and collar edge are cleaned. Neoprene ribbon, 1001312, is cleaned 2 cm.</p> <p>Zipper and neoprene ribbon are glued. Mount the ribbon as cover ribbon over sewing. 1 Hook square, marked up in relations to loop strap down along left side of zipper.</p> <p>Collar + strap are cleaned and glued Mount strap</p> <p>Glue mixture according to VIKING standard 8.1 Carry out glueing according to VIKING standard 8.2</p>			
<p>C = clean G = glue X = times H = hardener</p>			

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10.6 REPAIR REGULATIONS

4 Replacement of zipper PS5008

Replacement of zipper (4000932/new no. 1001493) for immersion suits made of Neoprene coated nylon with neoprene ribbon zipper.

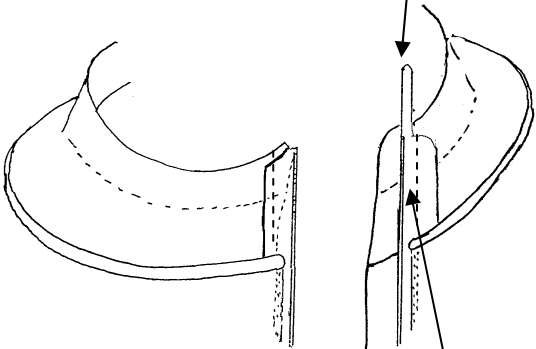
<p>Heat the back cloth and collar with a heating gun and remove it with the folding stick. Turn the suit with right side out and cut the zipper stitch. Turn the suit reverse out, cut through the indian tape all along the zipper, remove the front zipper.</p>	<p>Heptane 1005112</p>	<p>1013243 Bostik NE 486 +7-9% 1001918 hardener</p>
<p>Do not remove the zipper for lining. The zipper is clean with a non-fluffy cloth The front zipper is sewn in the suit (template no. 804)</p>	<p>C</p>	
<p>Put the suit on a table reverse out, close the front zipper. Mount Indian tape on front zipper reverse the suit: Clean and glue Neoprene coated nylon/front zipper, back side. Clean and glue Indian tape 1001309</p>	<p>C C</p>	<p>1xG 1xG</p>
		
<p>Mount Indian tape at the bottom of the front zipper.</p>		
		
<p>Glue mixture according to VIKING standard 8.1 Carry out glueing according to VIKING standard 8.2</p>		
<p>continued</p>		
<p>C = clean G = glue X = times H = hardener</p>		

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10.6 REPAIR REGULATIONS

4 Replacement of zipper for PS5008

Replacement of zipper (4000932/new 1001493) for immersion suits made of Neoprene coated nylon with neoprene ribbon zipper.

<p>SHORTING OF THE ZIPPER: Mark zipper, left side, from tooth, 1½ cm. Find the point, where marking on zipper meet the point on collar. Cut a hole with a punch pliers and cut off to top edge of zipper.</p> <p>(Se fig.) Place the zipper by the collar. Count down 3 teeth on zipper. Cut point and cut along teeth for point. Note: move the zipper stopper down. Cut the right side of zipper in same height.</p>  <p>MOUNT ZIPPER ON COLLAR Collar and zipper are glued and mounted. Suit is laid with back up.</p> <p>The sewed on zipper and collar edge is cleaned and glued on face side. Neoprene ribbon 1001312 is cleaned and glued.</p> <p>Put on ribbon as cover ribbon over sewing on face side. Collar edge is glued 2½ cm from top edge on face side. Folded ca. 1 cm to face side.</p> <p>Hook square 1014602 marked up in relations to loop straps down along zipper.</p> <p>Hook square and collar is cleaned, glued and put on.</p> <p>Glue mixture according to VIKING standard 8.1 Carry out GLUEING according to VIKING standard 8.2</p>	<p>Heptane 1005112</p> <p>C</p> <p>C</p> <p>C</p>	<p>1013243 Bostik NE 486 +7-9% 1001918 hardener</p> <p>1xG</p> <p>1xG</p> <p>1xG</p> <p>1xG</p>
<p>C = clean G = glue X = times H = hardener</p>		



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10.7 REPAIR REGULATIONS

1 Replacement of front zipper.

Replacement of front zipper for immersion suit made of PU-coated nylon.

<p>A seam-sealing machine is required for the servicing station to replace the front zippers.</p> <p>Heat the tape by the hood with a heat gun and dismount carefully. Heat the zipper and the hood and disconnect with a folding stick. Heat reverse at the joint between the zipper and the inner lining and disconnect with a folding stick.</p> <p><u>(Be careful not to damage the inner lining)</u></p> <p>Heat the seam sealing tape in the crossover or with a heat gun and remove the tape. Unstitch the seam by the zipper and remove the zipper.</p> <p>Thoroughly clean the ribbon and the teeth of the new zipper with a wet and clean cloth.</p> <p>Sew on the new zipper and cut the zipper ribbon by the seam with a pair of scissors so that the seam width is ½ cm.</p> <p>Seam seal the zipper on the seam-sealing machine with tape 2000311.</p> <p><u>DO NOT USE THE CROSSOVER</u></p> <p>Turn the suit reverse out and close the zipper. Mount the board with fabric clamps. Clean and glue: Inner lining Zipper/suit</p> <p>Mount the inner lining on the zipper and press and smooth it with a folding stick. See that the neck seam of the inner lining and the outer fabric are placed in the same position and that the edge of the inner lining must be 1½ - 2 cm from the teeth.</p> <p>Clean the zipper and glue it to the hood. Zipper Suit Hood Hook pad</p> <p>After repair, the suit must be retested.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	1012436 MEK	1013243 Bostik NE 486 +7-9% 1001918 hardener	1032514 Bostik Vinycol +5% 1024195 hardener Desmodur
	C		
	C C		1 x G 1 x G
	C	1 x G 1 x G 1 x G	1 x G 1 x G
	C	1 x G	
<p>C= Clean G = Glue X = Times H = Hardener</p>			



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10.8 REPAIR REGULATIONS

1 Replacement of hood

Replacement of Neoprene hood, No. 1015044 for immersion suits made of Neoprene Coated Nylon.

	1005112 Heptane	1013243 Bostik NE 486 +7-9% 1001918 hardener
Heat the front zip in the Crossover 5-10 sec. (Don't use a heat gun then the material delaminate)		
Heat the reverse ribbon between suit and hood in crossover 5-10 sec. and remove it with a folding stick.		
Heat the exterior ribbon in Crossover 5-10 sec. - and remove ribbon and hood with a folding stick.		
Hood 4500112, are cut bevel in edge by the neck. Mark the suit 2 cm down and 1½ cm from edge of zipper.		
<ul style="list-style-type: none"> Clean and glue the suit reverse. Glue the Neoprene hood 	C	1xG 1xG
Mount the hood 2 cm down the neck edge at the suit, and pres the neoprene edge down.		
<ul style="list-style-type: none"> Hood reverse Suit reverse Neoprene tape 1001313 	C	2xG 1xG 1xG
Glue the ribbon and knuckle it with a folding stick		
Glue the zipper S-5900580 for inner lining, reverse the hood (template 400)		2xG
Remove the suit from shield.		
Glue the front zipper on hood:		2xG
<ul style="list-style-type: none"> Hood face side Zipper reverse 		1xG
<ul style="list-style-type: none"> Clean and glue Indian tape 1014602 Glue the suit 	C	1xG 2xG
Put the suit on the shield face side out.		
<ul style="list-style-type: none"> Clean and glue Neoprene ribbon 1001312. Glue the suit and the hood reverse 	C	1xG 2xG
Mount Neoprene ribbon and knuckle it with a folding stick		
Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2		
C= Clean G = Glue X = Times H = Hardener		



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10.8 REPAIR REGULATIONS

2 Replacement of hood

Replacement of Neoprene hood article no.1015044, for immersion suits made of PU coated nylon



Heat the front zip in the Crossover 5-10 sec. (Don't use a heat gun then the material will delaminate)	1005112 Heptane	1013243 Bostik NE 486 +7-9% 1001918 hardener
Heat the reverse ribbon between suit and hood in crossover 5-10 sec. and remove it with a folding stick.		
Heat the external ribbon in Crossover 5-10 sec. - and remove ribbon and hood with a folding stick.		
Hood 1015044, are cut bevel in edge by the neck. Mark the suit 2 cm down and 1,5 cm from zip edge.		
<p>Clean and glue the suit reverse. Glue the Neoprene hood</p> <p>Mount the hood 2 cm down the neck edge at the suit, and pres the neoprene edge down.</p>	C	1xG 1xG
<p>Glue the hood reverse Glue the suit reverse Clean and glue the Neoprene tape 1001313</p> <p>Glue the ribbon and knuckle it with a folding stick</p>	C	2xG 1xG 1xG
Remove the suit from shield.		
<p>Glue the front zipper on hood: Hood face side Zipper reverse</p>		2xG 1xG
<p>Clean and glue Indian tape 1014602 Suit</p> <p>Put the suit on the shield face side out.</p>	C	1xG 2xG
<p>Neoprene ribbon 1001312. Suit / hood reverse</p> <p>Mount Neoprene ribbon and Knuckle it with a folding stick</p>	C	1xG 2xG
Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2		
C= Clean G = Glue X = Times H = Hardener		

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10.8 REPAIR REGULATIONS

3 Replacement of hood

Replacement of Neoprene hood, no. 1015044 for immersion suits made of Neoprene Coated Nylon.



<p>Heat the front zip in the Crossover 5-10 sec. (Don't use a heat gun then the material delaminate)</p> <p>Heat the reverse ribbon between suit and hood in crossover 5-10 sec. and remove it with a folding stick.</p> <p>Heat the exterior ribbon in Crossover 5-10 sec. - and remove ribbon and hood with a folding stick.</p> <p>Put the suit on the shield reverse out with open zipper. The Neoprene hood (1015044) is to be cutted bevel.</p>  <p>Mark the suit 3 cm from neck and 0,5 cm from zipper.</p> <p>The suit and reverse zipper are cleaned and glued</p>  <p>The Neoprene hood is glued. The suit is to be glued according to marking.</p> <p>Mount the hood on the suit.</p> <p style="text-align: right;">Continued</p>	<p>1013243 Bostik NE 486 +7-9% 1001918 hardener</p>	<p>1032514 Bostik Vinylcol +5% 1024195 hardener Desmodur</p> <p>1xG</p> <p>1xG 1xG</p>	<p>1005112 Heptane</p> <p>C</p>
<p>C = clean C = glue X = times H =hardener</p>			

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10.8 REPAIR REGULATIONS

3. Replacement of hood

Replacement of Neoprene hood, no. 1015044 for immersion suits made of Neoprene Coated Nylon.

<p>Suit is glued reverse The hood is glued reverse.</p> <p>Neoprene ribbon is to be cleaned and glued Mount the neoprene ribbon on the suit reverse.</p>  <p>Turn the suit, mark for GLUEING next side. Suit and zipper are glued</p>  <p>Mark for Velcro (S-5900580) with template no. 639 Indian tape is cleaned and glued Suit is cleaned Mount the Velcro on the suit</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	<p>1013243 Bostik NE 486 +7-9% 1001918 hardener</p> <p>1xG 2xG 1xG</p>	<p>1032514 Bostik Vinylcol +5% 1024195 hardener Desmodur</p> <p>1xG</p> <p>1xG</p>	<p>1005112 Heptane</p> <p>C</p> <p>C</p>
<p>C = clean C = glue X = times H =hardener</p>			

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10.8 REPAIR REGULATIONS

3. Replacement of hood

Replacement of Neoprene hood, no. 1015044 for immersion suits made of Neoprene Coated Nylon.

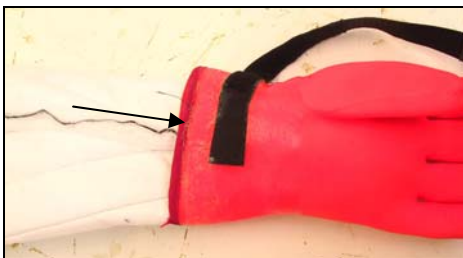
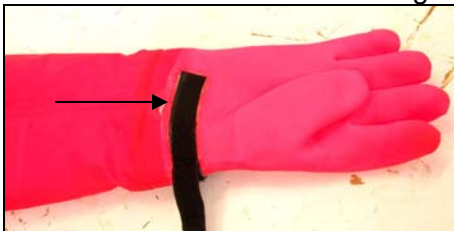
<p>Neoprene back cloth is to be cutted bevel. Mark the back cloth according to template no. 578 The back cloth (1013746) is glued</p> 	<p>1013243 Bostik NE 486 +7-9% 1001918 hardener</p>
<p>The hood is glued</p> 	<p>2xG</p>
<p>Mount the back cloth on the hood</p> 	<p>2xG</p>
<p>Mark and glue for mounting of reinforcement</p> 	<p>2xG</p>
<p>The reinforcement is glued Mount the reinforcement and roll.</p>	<p>1xG</p>
<p>C = clean C = glue X = times H =hardener</p>	

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10.9 REPAIR REGULATIONS

1 Replacement of gloves

Replacement of gloves no. 1012457, for immersion suits made of PU Coated Nylon.

	1012436 MEK	1032514 Bostik Vinylcol +5% 1024195 hardener Desmodur
<p>Cut of the glove, 5 cm from edge of outer fabric. Sew on (part 1008151) lengthen the sleeve and tape the sewing in cross-over. Tape no. 1003570.</p> <p><u>Be careful not to destroy the inner lining.</u></p> <p>Unstitch the glove from the inner lining. Place a new glove in the sleeve of the inner lining and sew it on with a seam width of 10 mm.</p>  <p>Fold the edge of the sleeve 2½ - 3 cm. Insert balloon in the sleeve and inflate it. Place the edge of the glove so that it follows the fold of the sleeve all the way around. The seam of the outer fabric and the inner lining shall be in the same place. Clean and glue the glove. Clean and glue the reverse of the sleeve</p> <p>Force the fold over the wrist seal so that the edge of the sleeve is 1½ - 2 cm over the seam of the glove and roll or knuckle it.</p>  <p>The Balloon shall remain in the sleeve for at least 16 hours. After repair, the suit must be retested.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	<p>C C</p>	<p>2 x G 1 x G</p>
<p>C = clean C = glue X = times H =hardener</p>		



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10.10 REPAIR REGULATIONS

1 Repair of tears and holes

Repair of tears and holes on Gore-tex immersion suits.

Spare parts (see spare-parts list)

Repair small tears, maximum 5 mm, and small holes, maximum 3 mm, by applying a patch using the crossover.

Place the patch on the reverse so that the hole is at the centre of the patch, and heat it for 25 to 30 sec. Then smooth and press with a folding stick.

If the tears and holes are bigger, sew on a patch of fabric over the tears or holes. Then cut the edge straight on the reverse so that the seam width is 3 to 4 mm.

Preglue the Gore-tex reverse with Bostik NE 486 1013243 + 25% Heptane 1005112

Gore-tex tape is applied to the seam using the crossover.

The tape is to be heated for 25 to 30 sec. and then smoothed and pressed with a folding stick.

All tape finishes must have a patch applied using the Crossover. These too, is be heated for 25 to 30 sec. and then pressed and smoothed with a folding stick. Remember to press and smooth surrounding tape that has been heated.



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10.10 REPAIR REGULATIONS

2 Repair of tears and holes

Repair of tears and holes for immersion suits made of PU-coated Nylon

<p>Spare parts (see spare parts list)</p> <p>Small tears, maximum 0.5 cm, and small holes, max 3 mm, by applying a patch of fabric 1001253 with glue on the reverse.</p> <p>Clean and glue the suit Clean and glue the patch</p> <p>Place the patch over the damaged area on reverse and knuckle with a folding stick</p> <p><u>DO NOT USE THE CROSSOVER</u></p> <p>If the tears and holes are bigger, sew on a patch of fabric over the tears or holes from the face side. Then cut the edge straight internally so that the seam width is 3-4 mm. Seam sealing tape is applied to the seam by means of seam-sealing machine.</p> <p>After repair, the suit must be retested.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	1012436 BB 694	1032514 Bostik Vynicol +5% 1024195 hardener Desmodur
	C C	2 x G 2 x G
<p>C = clean G = glue X = times H = hardener</p>		



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10.10 REPAIR REGULATIONS

3 Repair of tears and holes

Repair of tears and holes for immersion suits made of Neoprene coated Nylon

<p>Spare parts (see spare parts list)</p> <p>Small tears, maximum 0.5 cm, and small holes, max 3 mm, by applying a patch of Neoprene ribbon 1001329 with glue on the reverse.</p> <p>Clean and glue the suit Clean and glue the patch</p> <p>Place the patch over the damaged area on reverse and knuckle with a folding stick</p> <p>If tears and holes are bigger, sew on a patch of fabric over the tears or holes from the face side. Then cut the edge straight internally so that the seam width is 3-4 mm.</p> <p>Glue neoprene tape on the reverse of the suit</p> <p>Clean and glue the suit Clean and glue Neoprene ribbon</p> <p>When the open time has been reached, attaches the tape and then smoothed and pressed with a folding stick.</p> <p>After repair, the suit must be retested.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	<p>Heptane 1005112</p>	<p>1013243 Bostik NE 486 +7-9% 1001918 hardener</p>
	<p>C C</p>	<p>1xG 1xG</p>
	<p>C C</p>	<p>1xG 1xG</p>
<p>C = clean G = glue X = times H = hardener</p>		



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10.10 REPAIR REGULATIONS

4 Repair of tears and holes

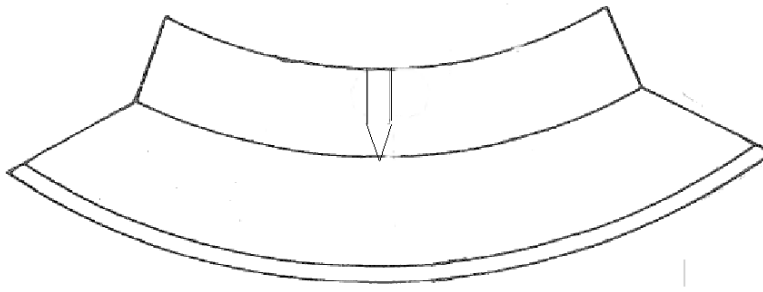
Repair of tears and holes for immersion suits made of Neoprene.

	Heptane 1005112	Bostik NE486 1013243 + 7-9% Hardener 1001918
<p>Small tears, maximum 0.5 cm, and small holes, max 3 mm, by applying a patch, 3½ cm, of Neoprene ribbon 1001329 with glue on the reverse.</p> <p>Glue the suit reverse Clean and glue the patch</p> <p>Place the patch over the damaged area on reverse and knuckle with a folding stick</p> <p>If tears are bigger, clean and glue the neoprene along tears. When the open time has been reached press the neoprene together.</p> <p>Mount ribbon on the reverse side of the suit</p> <p>Glue the suit reverse. Clean and glue Neoprene ribbon</p> <p>When the open time has been reached, attaches the neoprene ribbon and then smoothed and pressed with a folding stick.</p> <p>After repair, the suit must be retested.</p> <p>Carry out glueing according to VIKING standard 8.1 Glue mixture according to VIKING standard 8.2</p>	<p>C</p> <p>C</p> <p>C</p>	<p>2xG 2xG</p> <p>2xG</p> <p>2xG 2xG</p>
<p>C = clean G = glue X = times H = hardener</p>		

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10.11 REPAIR REGULATIONS

1 Intake of collar.

<p>Cut darts in the collar as shown in fig. If the collar has to be narrowed by more than 3 cm, two darts are required.</p> <p>Glue the edges together.</p> <p>Mount ribbon 1015778, above the assembling from outside to reverse in one go without dividing the ribbon in two.</p> <p>Then smooth and press with a folding stick.</p>  <p>Carry out glueing according to VIKING standard 6.1 Glue mixture according to VIKING standard 6.2</p>	<p>1013243 Bostik NE 486 +7-9% 1001918 hardener</p> <p>2xG</p> <p>2xG</p>
<p>C=clean P=primer G=glue X=number H=hardener</p>	



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10.12 REPAIR REGULATIONS

1 Replacement of reflective tape.

REFLECTIVE TAPE WITH GLUE 1012511

- IF THE TAPE IS SEWED ON
Carefully remove the stitches.
Do not damage the tape on backside.
- IF THE TAPE IS GLUED ON
Carefully heat the reflective tape with a heat gun and pull it off with a folding stick.

Glue the suit with Bostik NE 486 1013243 +7-9% hardener 1001918

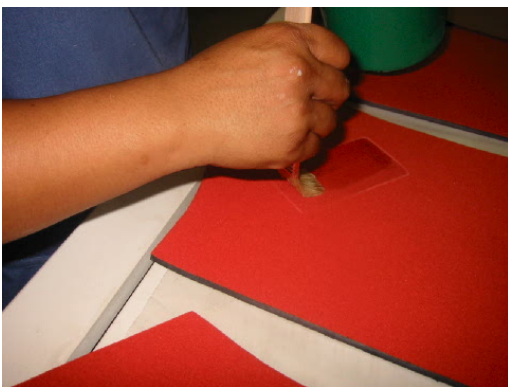
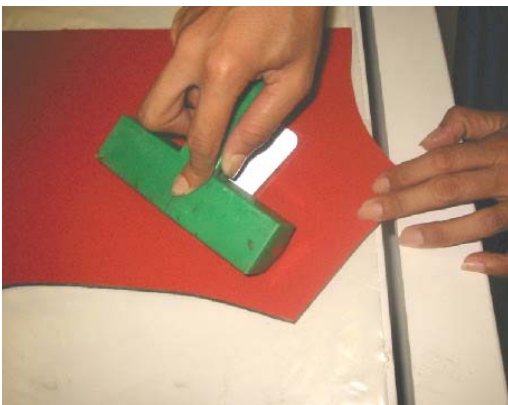
When the open time has been reached, remove the reverse of the retro-reflective tape, attach the tape and roll.

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10.12 REPAIR REGULATIONS

2 Replacement of reflective tape.

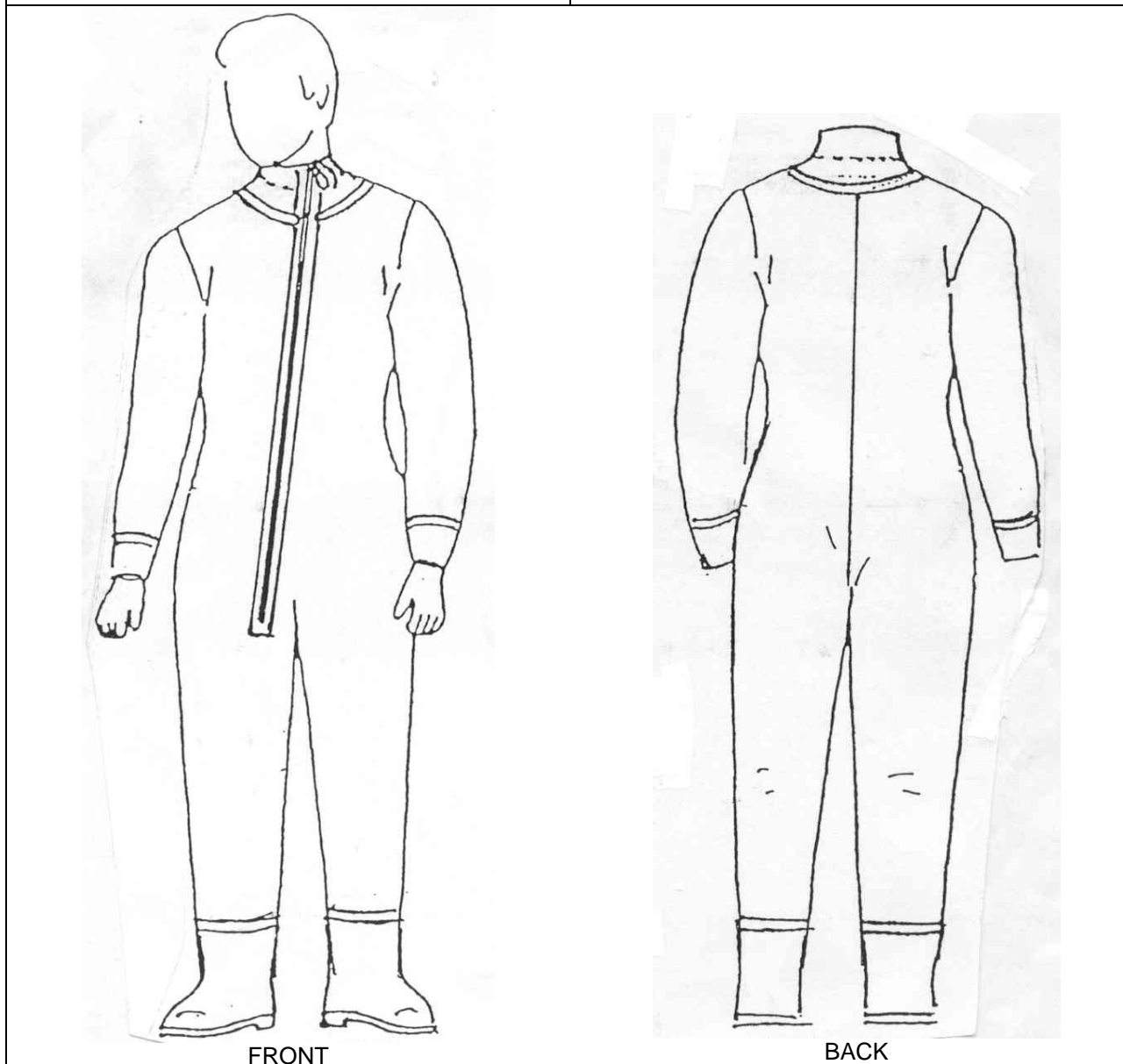
Replacement of reflective tape on immersion suit made of Neoprene.

		1013243 Bostik NE 486 +7-9% 1001918 hardener
<p>Pull of the damaged reflective tape Place the suit on a table.</p> <p><u>Apply glue</u> Apply glue on the marking area, in a smooth layer. 2 mm outside the marking.</p>		1xG
<p>When the open time is reached, attaches the reflective tape and then smoothed and roll hard.</p> <p>Carry out glueing according to VIKING standard 8.1</p> <p>Glue mixture according to VIKING standard 8.2</p>		
<p>C=clean G = Glue X = Times H = Hardener</p>		

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FORM FOR MARKING OF LEAKING

WORKING ORDER NO.:	SUIT NO.:
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DEFECTS REPAIRED:

Re-test
The suit must always be re-tested if there is uncertainty about whether the repairing has fixed the leaking.

Approved without Re-test
The suit should NOT be re-tested if the leaking is visible and the repairing with certainty has repaired the leaking.

Date _____ Repairer _____



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LEAKAGE TEST FORM

IF THE SUIT IS LEAKING / BROKEN MARK WITH X OR NUMBER IN PARTICULAR BOX									
DESSIN NO.:			ORDER NO.:				DATE:		
SUIT NO.:									
Zipper: Leaking									
Broken									
Hole in fabric - numbers									
Seam sealing at front zipper									
Seam sealing at legs									
Seam sealing at back									
Seam sealing at crutch									
Seam sealing at front									
Seam sealing at sleeves									
Collar									
Collar ribbon									
Boots									
Edge by boots									
Socks									
Edge by socks									
Wrist seals									
Edge by wrist seals									
REMARKS									
RE TEST									
APPROVED AFTER RE TEST									
APPROVED WITHOUT RE TEST									
THE SUIT IS OK									

THE SUITS MUST **NOT** BE RELEASED BEFORE ALL ARE OK OR SENT TO RE TEST.

PRESSURE TESTING: _____
SIGNATURE

THE SUIT IS OK: _____
SIGNATURE



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VIKING LIFE-SAVING EQUIPMENT A/S DISCARDINGREPORT FOR IMMERSION SUIT			
Working order no.:		Customer:	
Dessin:		Ref. person:	
Individual suit no.:		Address:	
Suit size.:		City:	
Boot/ sock size.:		Country:	
Neck size:		Phone no.:	
Year of manufacture		Fax no.:	
Ex. Name / No :			

Reason for discarding of suit	Code	(X)
Defect - reparation economical irresponsible	1	
In general worn out	2	
Frontzipper defect	4	
Zippers defect	5	
Reflex defect	6	
Seam / seam sealing defect	7	
Wrist seals defect	8	
Boots defect	9	
Socks defect	10	
Collar/hood defect	11	
Lining defect	12	
Holes in fabric	13	
Buoyancy foam defect	14	
Light defect	15	
Fabric decomposed	16	
Damaged by demonstration-/exercise use	17	
Strong effect of heat	18	
Demolished of mildew	19	
Others	20	

Fill in by sales department.:	Yes	No.	No.	No.	Discarding approved by:	Discarding made by:
Suit returned to customer		21		24		
Suit destroyed:		22		25		
New suit sold for customer:		23		26		
Order no.:						Date:
Remarks:						

SERVICE MANUAL FOR VIKING SOLAS IMMERSION SUITS		
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12. MODIFICATIONS

Replacement of light at PS4029 to article no. 1018938 McMurdo, manually light

McMurdo L5-M1 light is discontinued, therefore the article no. 1018938 L6 McMurdo, manually is applied.

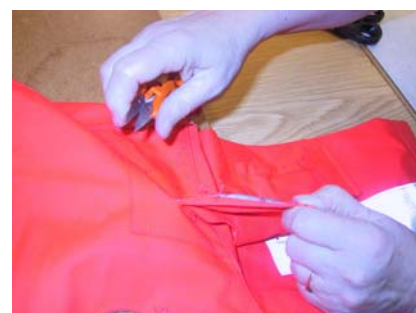
Modification at light pocket is needed for following style: PS4029



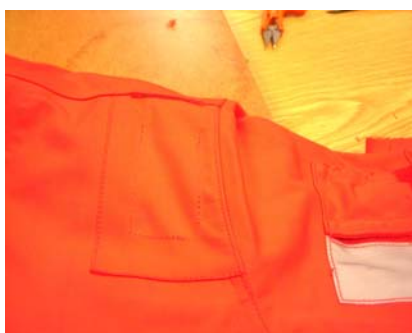
The existing light pocket.



Cut the pocket flap close by the seam.



Dismantle the stitching by light pocket and remove the pocket



New light pocket article No. 1021212 (include Patch)



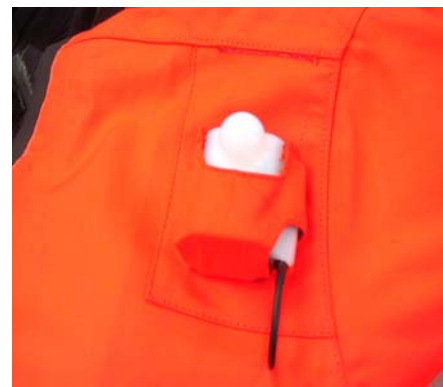
Sew on the pocket so that the stitch at the bottom is covered.



Heat on a patch, reverse the suit, in a cross-over. The patch must cover the stitching from the light pocket.



The patch is to be knuckled.



The light, article No. 1018938 L6 MCMURDO, MANUALLY is to be mounted.

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12. MODIFICATIONS

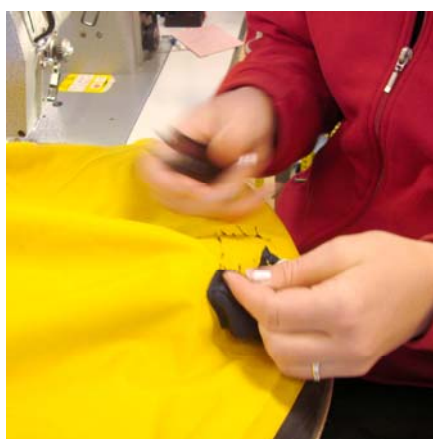
Replacement of light on PS5008, PS5041 and PS5042 to article no. 1018938 McMurdo, manually light

McMurdo L5-M1 light is discontinued, therefore the article no. 1018938 L6 McMurdo, manually, is applied.

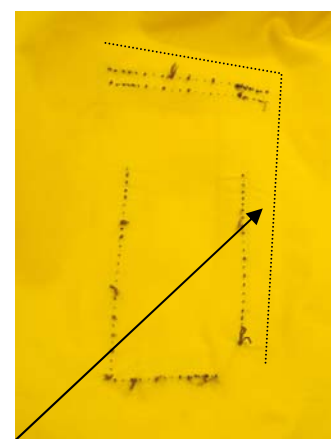
New light pocket article 1021494: 1021454 Light pocket
 1003570 Neoprene tape 22 mm
 1004530 Rasant thread 75, blue



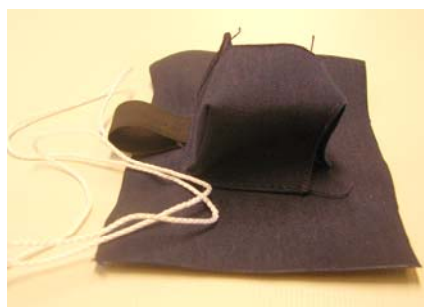
The existing light pocket.
 Cut off the whistle if mounted.



Dismantle the stitching by light pocket and remove the pocket and pocket flap if mounted.



Mark for new pocket approximately ½ cm around the stitches.



Light pocket article 1021494



Fold the edge 1 cm against the back side.



Sew on the pocket make sure that the old stitches are covered.

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12. MODIFICATIONS

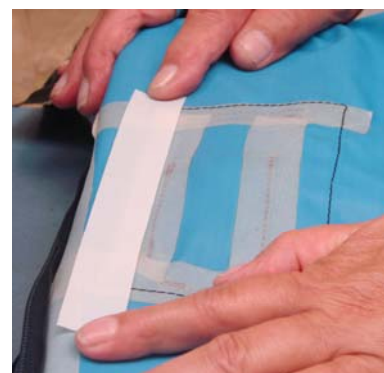
Replacement of light on PS5008, PS5041 and PS5042 to article no. 1018938 McMurdo, manually light



The pocket sewn on suit.



The stitches must be sealed on the reverse side with tape, article no. 1003570 in cross over.



Place the tape and heat in cross over 15 sec. by 160°C.
Beware do not heat on zippers, collar or trim.



All stitches must be covered.



The whistle and new light, article No. 1018938 L6 MCMURDO, MANUALLY is to be mounted.