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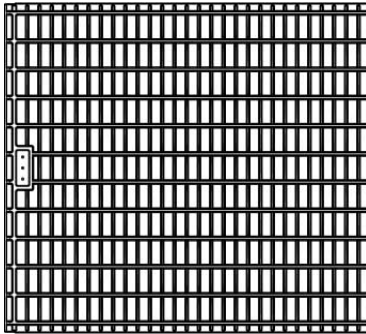
Tray Assembly
Guide



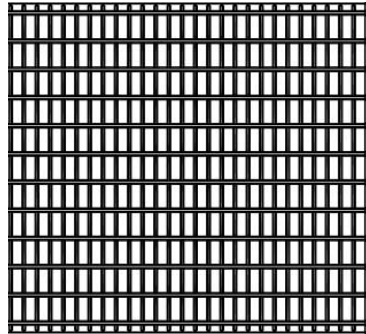
Adhering & Sealing Tray Section Process

These instructions pertain to all Hydrotek tray sections

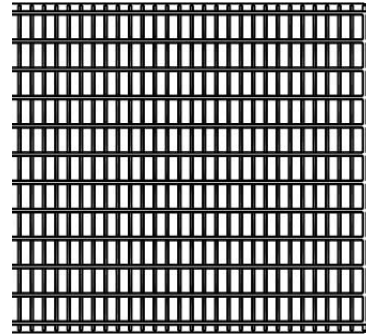
End Tray with Gutter



Center Tray



End Tray



Requirements

A Caulking Gun



B Silicone



C Nitrile Gloves



D Plastic Scraper



E Precision Utility Knife



F Heat Gun (Preferred, Optional)
or
180 Grit Sandpaper

G Isopropyl Alcohol



Directions for use

Installation

It is recommended to wear nitrile gloves throughout the installation.

- 1 Prepare the surfaces to be bonded by:
 - a. Using a heat gun, warm the surfaces to be connected together. This creates a slight chemical change in the ABS, preparing it to bond with the silicone, and is the recommended method of installation.

OR

- b. Lightly sanding the connecting joints with 180 grit sandpaper and then cleaning with isopropyl alcohol. Allow the isopropyl alcohol 15 minutes to dry and evaporate.

- 2 Bonding of the trays should be performed with the bench trays placed in the bench frame and positioned so the connecting joint is accessible. This will help ensure the integrity of the seal and avoids additional handling of the newly bonded trays. Excessive handling or unsupported raising of the bench tray could damage the sealed joint, creating leaks.

Once the bench trays are correctly positioned in the bench frame, use the caulking gun to apply the silicone onto the connecting joint groove. Apply a silicone bead 3/8" to 1/4" wide.

Note: Applying excessive sealant will prevent the trays from sealing properly and create an uneven surface.

- 3 Move the adhesive-free tray section into position above the connecting joint, leaving a 1/8" horizontal gap between the two trays. Apply pressure along the joint to close the seal and ensure the silicone bonds to each surface.

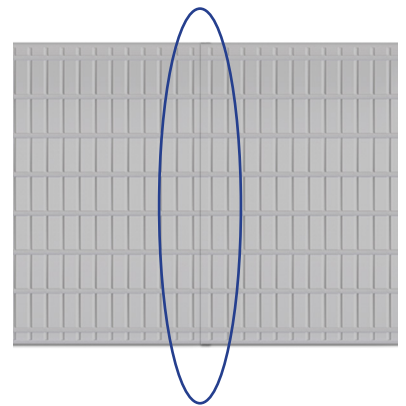
Install the joint clips on the trays outer rim, one on each side, spanning the joint.

Using your gloved finger, smooth the bead into the seam and remove any excess silicone. The silicone joint should be smooth and flush with the surrounding surface.

A weight should be used to maintain pressure on the seal as it cures.

- 4 The silicone will cure completely in **7 days at approximately 20° Celcius**. It is important the temperature be kept constant during curing.

Once the curing time has passed, fill the trays with a small amount of water and check for leakage. If any leaks are detected, drain and dry the table and, using the method detailed above, apply a small amount of silicone to the area where the leak was detected.





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