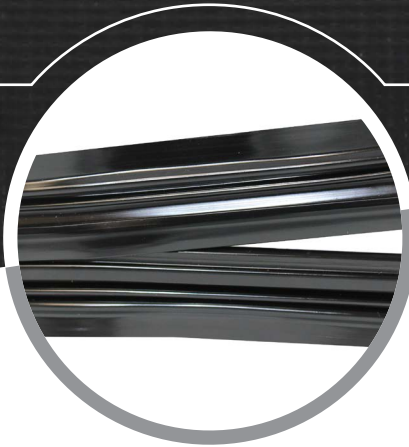


# Sealing Zippertubing Extruded Tracks

ALL ZIPPERTUBING TRACKS

pg.1

We  
Recommend  
Using our  
ZT-Tape Process,  
Click to Download



## ZTQ Sealer (**OBSOLETE PROCESS! NOT RECOMMENDED!**)

The ZTQ sealing process became obsolete in 1980's due to safety and environmental protection concerns. Many older military drawings still specify the use of the ZTQ Sealer procedure. If a drawing specifies the use of ZTQ Sealer, notify the responsible engineering authority and make them aware of this document and the recommendation to replace the ZTQ process with our ZT-Tape process prior to beginning any fabrication.

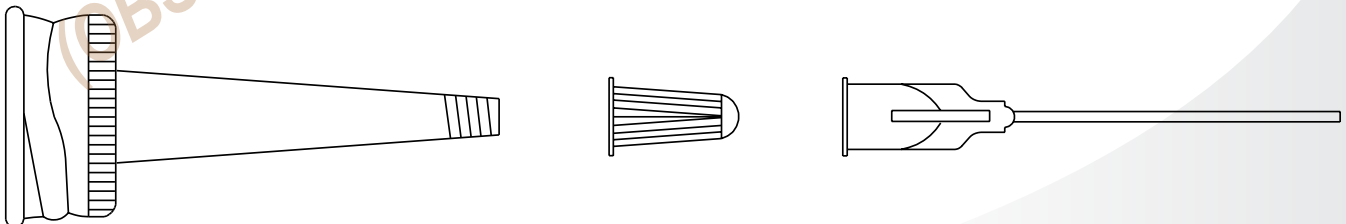
### Material:

There are two solvent materials that were used to chemically weld (seal) Zippertubing tracks together. Both of these materials are still available from commercial chemical supply houses by their chemical names. Always follow the material suppliers handling, safety precautions and shelf life recommendations.

These products are:

1. **Tetrahydrofuran (THF) – 1 to 3 minute cure time**
2. **Cyclohexanone - 4 to 6 hour cure time**

The solvent material must be transferred into small (6 oz. typical) metal containers prior to attempting to seal the Zippertubing jackets. The small containers should have a screw on metal cap and a screw on applicator tip. The applicator tip shall accept a screw on, hollow needle tip (#18 gage) to restrict the flow of the solvent. The applicator tip should have a screw on cap capable of replacing the needle and resealing the container when not in use.



SEALING ZIPPERTUBINGP EXTRUDED TRACKS ROCEEDURE

**01**

Close the Zippertubing jacket using any ZT tooling required.

**02**

Install the applicator tip and needle on dispensing container.

**03**

Lift one end of the installed Zippertubing assembly about 10-15 degrees.

**04**

Rotate the jacket so the track inter-lock joint faces up and the separation crack is slightly off the 12 o'clock position. This will allow gravity to cause the solvent to flow down into the joint.  
*(see on the following page)*

**05**

Position the applicator needle near the crack at the elevated end. Do not push the needle into the crack!

**06**

Begin application of the solvent by tipping the container up and allowing the solvent it to flow out the needle (do not squeeze the container). Move the needle down the track providing a smooth even flow. Note: Polyurethane (type PFR) jackets will not fuse as quickly as do PVC material tracks. It is recommended that the process be repeated (steps 3 to 6) when using the PFR material.

**07**

Continue the process over the entire assembly length.

**08**

Allow finished assemblies to cure for the minimum time period specified for the specific solvent type used. Do not bend or flex the assembly until it sealed joint is fully cured.

(ZTQ SEALER - OBSOLETE PROCESS! NOT RECOMMENDED!)



