



Kirby Morgan Dive Systems, Inc.®

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Part #525-725, 525-726 and 525-727 KMB Molded Face Seal Replacement Kit

Kit Number	Part Number	Description	Qty
525-725	510-810	KMB 18/28 Face Seal (Small)	1
525-726	510-811	KMB 18/28 Face Seal (Medium)	1
525-727	510-812	KMB 18/28 Face Seal (Large)	1

NOTE: It is necessary to read the entire instructions and to have a complete understanding of the following procedures before attempting to replace and install a molded Band Mask® face seal.

Tools Required:

- Neoprene Cement
- Aquaseal® or Equivalent
- 4" × 4" Sand Paper 120 grit
- Isopropyl Alcohol (Rubbing Alcohol)
- (1) Glue Brush
- (1) Aquaseal® Brush or Equivalent
- Paper Towels

Removing a Band Mask® Molded Face Seal

1. Remove the head harness
2. Remove the top and bottom band keepers
3. Loosen the band adjustment screws and take the hood off the mask frame.
4. Remove the earphones from the pockets in the hood and completely separate the hood from the mask frame.
5. Remove the band adjustment screws from the bands and remove the bands from the hood.
6. Open the zipper all the way.

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7. Turn the Band Mask® hood inside out until the inside edge, where the molded rubber material meets the neoprene hood, is visible.

NOTE: Delamination is a result of nylon or neoprene layers peeling apart from one another. Step 8 should be done in a slow and steady manner to avoid delaminating or tearing the nylon away from the neoprene, especially around the seams on the hood. Work your way around the hood, peeling in a downward motion towards the front edge of the face seal to complete separation.

8. Begin pulling the face seal away from the hood starting at one of the ear pockets. Peel the face seal in a downward motion towards the front of the face seal, until you break through the last layer of Aquaseal® adhesive.



9. Remove any leftover bits and pieces of face seal or Aquaseal® left behind.

NOTE: Keep delamination to a minimum. Small delaminations, should be repaired before setting in the new face seal by re-gluing the seams closed, using two coats of neoprene cement adhesive.

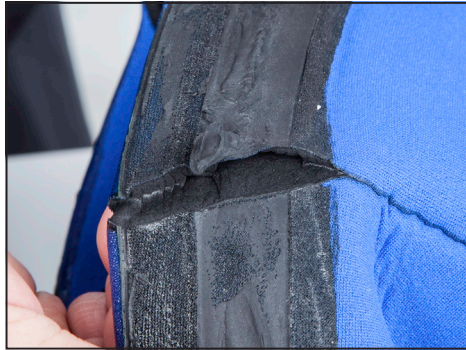


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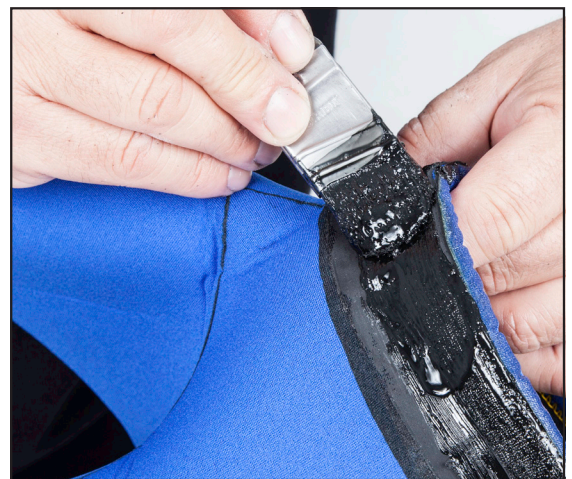
Preparing the New Molded Face Seal for Installation



1. Using 120 grit sandpaper, sand a 1 ¼ inch (3.175 cm) wide strip all the way around the outside edge of the face seal. This 1 ¼ inch (3.175 cm) strip will be the mating surface for the neoprene hood

2. Clean up the surface of any residue with alcohol and a paper towel.
3. Apply a pre-coat of neoprene cement to the sanded area of the face seal and let it dry 20–30 minutes.

4. Apply a pre-coat of neoprene cement to the hood. Follow the original glueline left behind after removing the face seal. Make sure the edges of the glueline are well defined as you apply an even coat of neoprene cement. Let it dry for 20–30 minutes.





Installing a New Molded Face Seal

HELPFUL HINT- As you work, always pull out on the hood material and avoid pulling in on the molded face seal. Also follow any creases left behind from the old faceseal to help line it up correctly.

NOTE: There are short upraised center lines (bottom & top) on the inside of the face seal to assist you in correctly lining up the hood and face seal.



1. Once the face seal and the hood have dried, right side out the hood. Fold the edge of the hood over so it is rolled onto itself around the face opening (inside out—about three inches (7.62 cm)) you will be able to see the previous glue line around the entire hood.

2. Apply a second coat of neoprene cement to both the face seal and the hood. Wait approximately 10–15 minutes to let the glue get tacky, before attempting to put them together.
3. Begin fitting together the two parts, starting at the chin. Carefully line up the bottom center of the face seal to the seam on the hood. Concentrate on lining up the front edge of the face seal to the front edge of the hood.



NOTE: Unlike the standard Band Mask® face seal, the molded face seal's outer edge will need to be flush with the outer edge of the neoprene hood.



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4. Continue by putting in one side of the face seal, from the chin to the bottom of the ear pocket. Then work in the other side of the face seal from the chin to the bottom of the other ear pocket.



5. Once the bottom portion of the work is done, tuck the ear pockets on the face seal towards the center and finish the top portion. Start at the center and pull outward on the hood material as you fit one side in at a time as you did with the bottom portion.

NOTE: The hood and face seal combination will naturally right itself and roll out to the correct orientation of being right side out as you join the two materials. Make sure the front edge is in place all around the front of the hood before applying pressure to the edge of the face seal.



6. Use the palm of your hand or a roller against a table top and carefully work your way around the inside of the face seal and toward the neoprene hood.

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7. Turn the hood inside out and make sure the seal is all the way around the face seal and there are no creases or air bubbles in the face seal. Right side out the hood and let it dry overnight.



NOTE: If you add the Aquaseal® too soon before the neoprene cement completely cures, the glue will reactivate and open up.

THE NEXT DAY:



8. Apply a coat of Aquaseal® to the front of the hood and face seal combination, along the front edge of the face seal. Spread the Aquaseal® evenly, making sure it overlaps, from the edge of the face seal onto the hood by about ¼ inch (6.35 mm).

9. Let the Aquaseal® completely dry and cure overnight.

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