



Silicone or EPDM Seal with Pressure Sensitive Adhesive

These instructions address either replacement or initial installation.

- Open blades. Use scraper to remove any existing seal or adhesive.
- Surface must be free from dust, dirt, oil and moisture. Clean blade edge with alcohol or similar solvents. Do not use mineral spirits or other petroleum based solvents that leave a residue.
- Install when blade surface is at 70°F or above.
- Cut seal material to exact blade length with release paper still on seal material.
- Blade seal will need to be applied to the closure strip at the top of the frame. Apply blade seal to the bottom of every blade tip when the blades are in the closed position.
- Start at one end of blade. Peel off 1-2 feet of release paper at a time and place seal firmly onto blade surface. Do NOT touch the adhesive. Use finger or roller to press seal to blade. Do NOT stretch seal as it will pop off in time.

Blade & Frame Material	Blade Seal Material	Blade Seal Part Number	Blade Attachment	Adhesive	Temperature °F (°C)	
					Minimum	Maximum
Mill finish	EPDM	480393	Adhesive	3M #9469	-20 (-29)	250 (121)
	Silicone	464605	Adhesive	3M #9469	-60 (-51)	400 (204)
Painted	EPDM	480394	Adhesive	3M #4257	-20 (-29)	250 (121)
	Silicone	480395	Adhesive	3M #4257	-60 (-51)	400 (204)

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