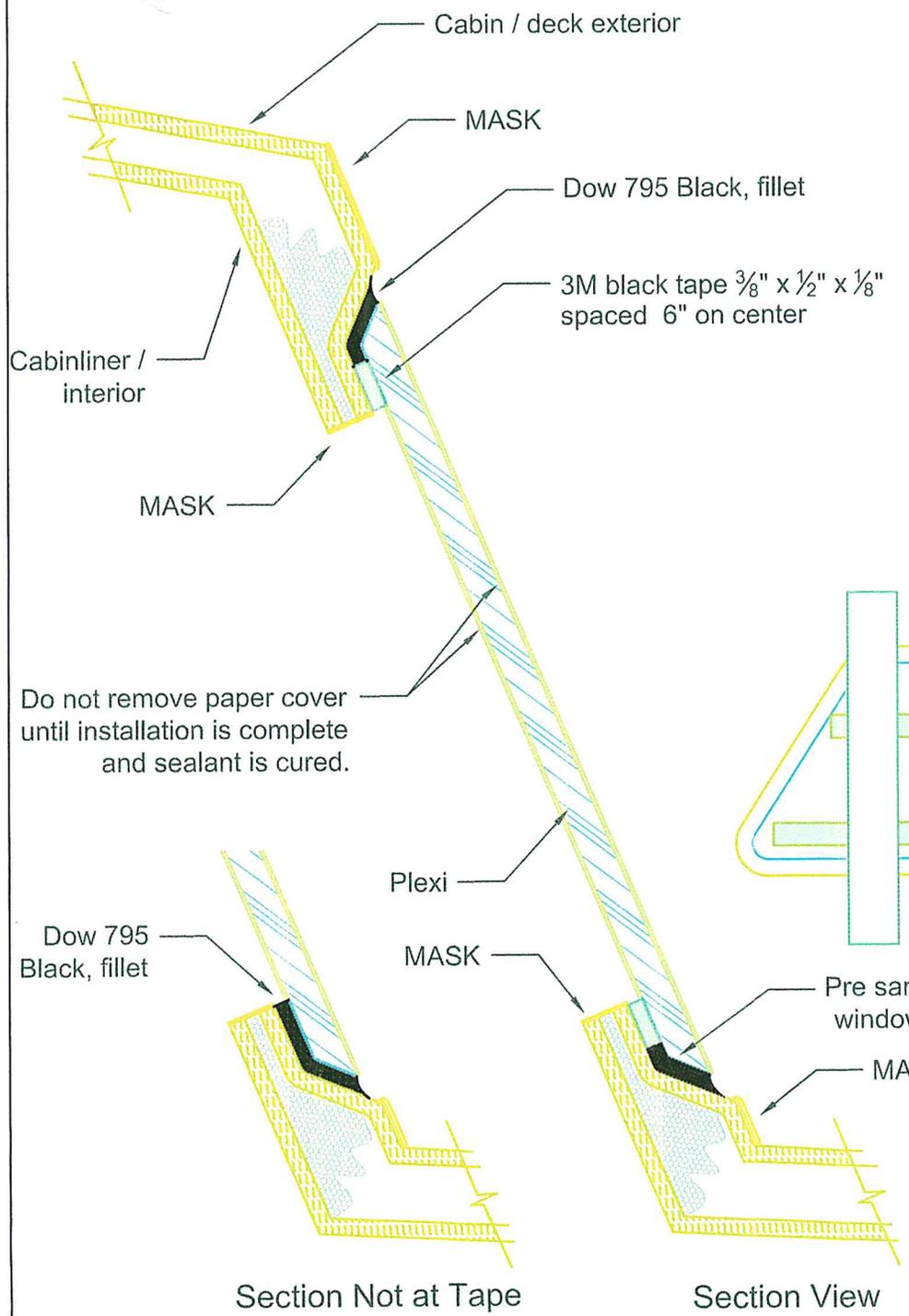
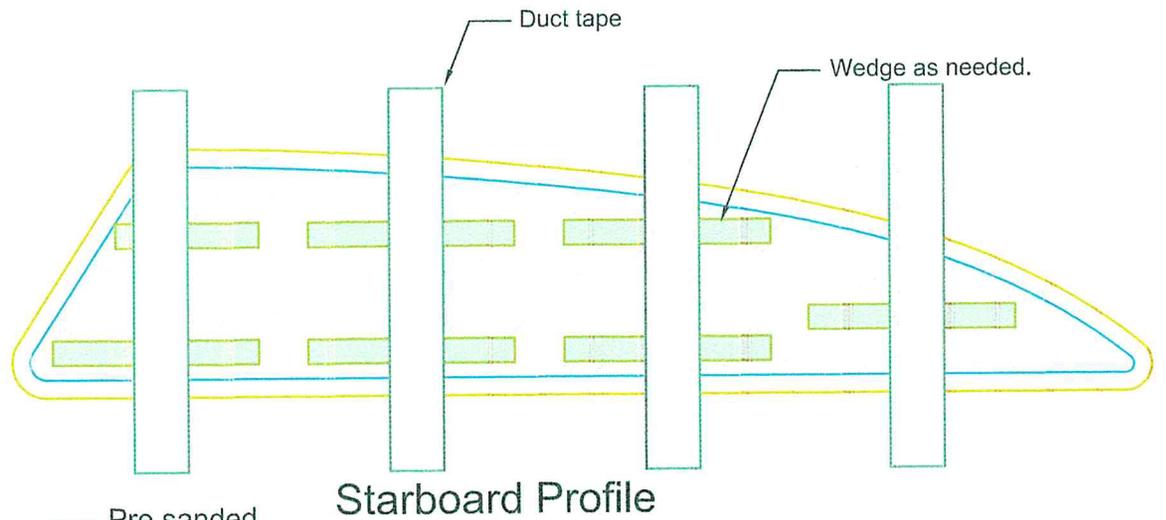


REMOVING AND REPLACING RECESSED ACRYLIC PORTLIGHTS / WINDOWS



1. Remove a portlight by inserting a flat blade tool, such as a putty knife, into the silicone joint on the outside. Start at the forward end of the portlight, the pointed end, and work the tool to break the seal and pry the acrylic loose. A small gauge wire can be worked under the forward end of the portlight and gently worked in a sawing motion to cut through the silicone bond.
2. After the acrylic is removed, scrape all the remaining silicone from the fiberglass, taking care not to damage any areas that will not be covered when the acrylic is reinstalled. **ALL THE SILICONE MUST BE REMOVED** from the fiberglass. Clean the surface with acetone to remove all silicone residue from the fiberglass. Wet sand the fiberglass with 180 grit paper and wipe it down with acetone to remove any residue and allow the fiberglass surface to dry thoroughly.
3. Cut black foam tape into  $\frac{1}{2}$ " x  $\frac{3}{8}$ " pieces and apply to the fiberglass surface on 6" centers along the edge of the window cutout.
4. Mask the interior edge, and exterior surfaces around the cutout to minimize cleanup.
5. Apply the DOW 795 Black Silicone sealant to the clean mounting surface on the cabin side, spreading it to a thickness of  $\frac{1}{4}$ " inch.
6. Press the pre sanded acrylic into place evenly. Use duct tape to hold the portlight in place. Use the wedges provided to create compression on the acrylic as necessary.
7. Remove excess silicone inside and out. Tool the outside silicone bead to create a clean edge. Clean up any areas necessary with mineral spirits.
8. Allow sealant to cure at least 48 hours. Remove duct tape, masking tape, and paper covering the acrylic. Clean as needed with mineral spirits.
9. Refer as needed to Product Information Sheet Dow Corning 795 Silicone Building Sealant.

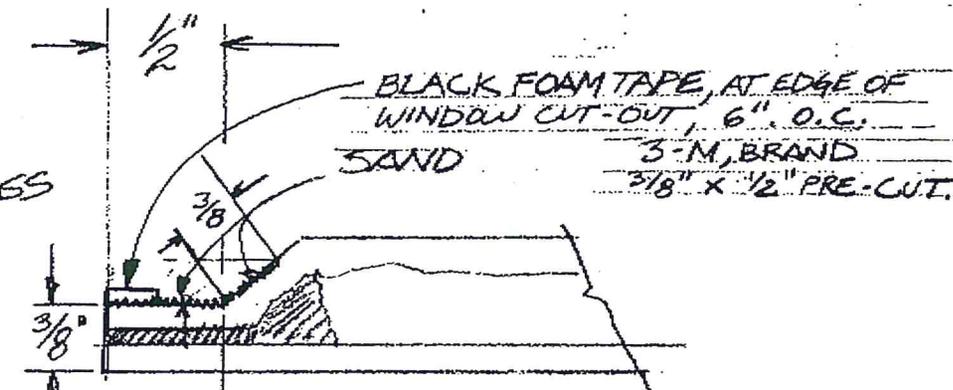
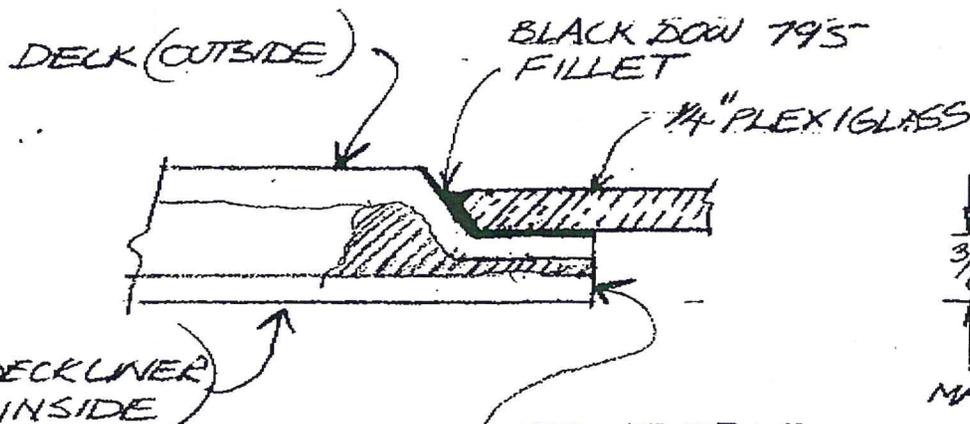
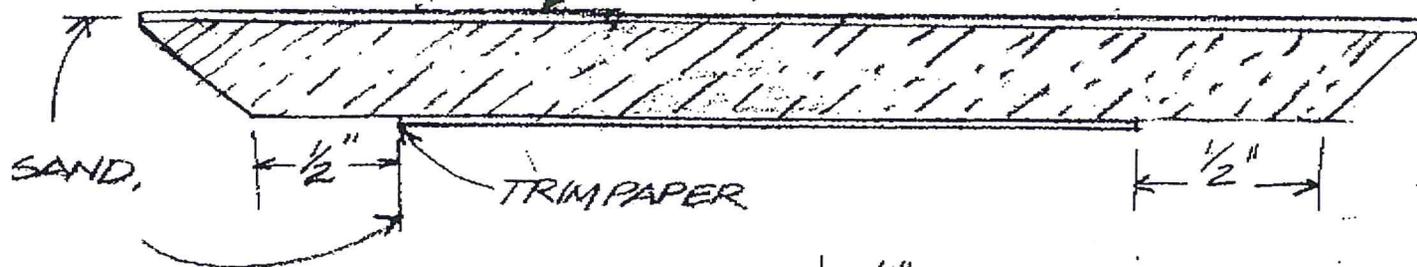


MATERIALS:

1. Acrylic portlight \_\_\_\_\_
2. Dow 795 Silicone Sealant \_\_\_\_\_
3. Black Foam Tape \_\_\_\_\_
4. Installation wedges \_\_\_\_\_

7   Release for CAD		B-25-14	
REV	DESCRIPTION	DATE	
<b>Catalina Yachts</b>		7800 BRYAN DIARY RD. LARGO, FL. 33777 (727) 544-6681	
SCALE: NA	APPROVED BY:	DRAWN BY JA	
DATE: 01/12/14		REVISED	
Portlight/Window Replacement			
BOAT:	TYPICAL		DRAWING NUMBER 22-26010

DO NOT REMOVE PAPER  
COVER UNTILL INSTALLATION  
IS COMPLETE



PAINT EDGE  
W/ ROLLER TO MATCH  
INTERIOR GEL COAT.

- 6) MASK INSIDE EDGE OF CUT OUT AND EDGE OF RECESS TO REDUCE CLEAN-UP REQUIRED
- 7) PLACE BLACK SPACERS AS SPECIFIED ABOVE ON EDGE OF CUT-OUT
- 8) COAT DECK OPENING EDGE W/ APPROX 1/8" SEALANT.
- 9) CLAMP OR TAPE PLEXI WINDOW IN PLACE UNTILL SEALANT IS CURED.

- 1) ROUTER CUT HOLE W/ JIG.
- 2) FILL VOIDS BETWEEN DECK AND DK. LNER, 3/8" THICK MAX MUST BE EVEN THICKNESS.
- 3) CLEAN AREA OF FIBERGLASS TO BE GLUED WITH SOLVENT.
- 4) WET SAND FIBERGLASS WITH 180 GRIT PAPER
- 5) WET SAND AREA OF PLEXIGLASS TO BE GLUED WITH 180 GRIT PAPER

CATALINA YACHTS INC.  
21260 VICTORY BLVD.  
WOODLAND HILLS, CA

SCALE: NONE

APPROVED BY:

DRAWN BY GD

DATE: 1-31-83

REVISED 5.7.96

WINDOW INSTALLATION, PLEXI

TYPICAL

DRAWING NUMBER

270-26005.6