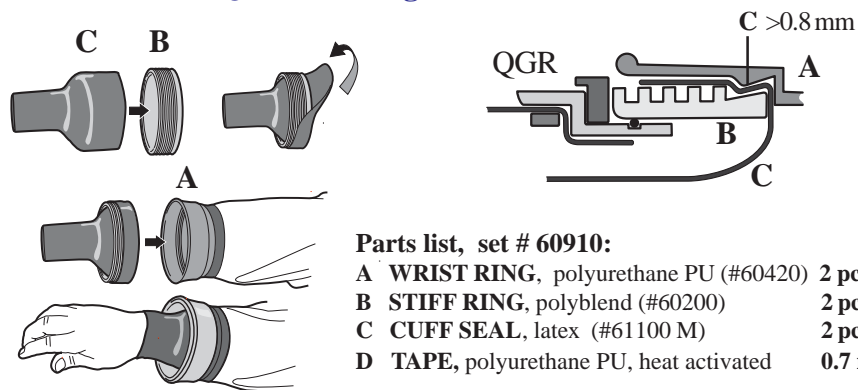


# QUICK CUFF set #60910

Quick exchange of latex cuff seals



### Parts list, set # 60910:

- A WRIST RING, polyurethane PU (#60420) 2 pcs
- B STIFF RING, polyblend (#60200) 2 pcs
- C CUFF SEAL, latex (#61100 M) 2 pcs
- D TAPE, polyurethane PU, heat activated 0.7 m

## QUICK CUFF

For field exchange of cuff seals in any dry suit!  
Can be installed by the suit manufacturer or later.  
Is one of three docking systems that is used for Quick Glove Rings (QGR) - the quickest donning and doffing of drygloves.

**NB! A latex seal (C) provides sealing between (A) and (B) and must be used at all times.** (Also when Quick Cuff is used in combination with Quick Glove Rings, but then you may trim the seal to a looser fit than if used without drygloves.) **Recommended minimum seal thickness: 0.8 mm** (0.03 inch), see drawing above. Using a thinner seal may cause leakage.



Tubes for pressure equalization between dryglove and suit are included in the QGR set.



QUICK DRY GLOVE SYSTEM  
MANUFACTURED BY

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### Assembly

A cuff seal **must** be used for sealing between the *Locking Groove* in the Stiff Ring (B) and the *Locking Edge* inside the PU Wrist Ring (A) to make the connection gas- and waterproof.

1. Place the latex cuff seal (C) inside the Stiff Ring (B) and fold it over the *Locking Groove* of the Stiff Ring. Let the latex cuff seal cover the Stiff Ring by approximately 1,5 cm.

The latex cuff can be secured with flexible tape before insertion into the wrist ring to prevent the seal from sliding. Make sure the seal **covers** the *Locking Groove*.

2. Insert the B+C assembly into the Wrist Ring (A). Force the Stiff Ring with both palms, pressing segment by segment until it finally "clicks" in place. No excessive latex should be visible outside the Stiff Ring. Several attempts may be needed to position the seal correctly.

### Disassembly

3. The *Locking Edge* inside the PU Wrist Ring (A) must be **dislocated** from the *Locking Groove* on the Stiff Ring (B). This is done by using both hands, **cupping** the Quick Cuff Assembly and using the  **fingertips** to push the inner (narrow) part of the Wrist Ring inwards/upwards (using it as a lever to push the Stiff Ring outwards) while pushing the outer edge of the Wrist Ring outwards with the  **thumbs**.

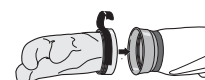
Or use a narrow screw driver to pry them apart. (3c)

### Maintenance and storage

**Remove the Stiff Ring regularly** to rinse the cuff seal and/or glove from salt or debris, and to relax the wrist ring from stress settings, **especially when storing for longer periods.**

**Avoid exposing the PU Wrist Ring to heat and sunlight.**

Heat and storage with inserted latex seal may cause the PU-material to expand, which may cause leakage. In the event this happens, heat the Wrist Ring internally with a hair dryer. Wrap a strong rubber band around to shrink the ring while cooling.



**Option:** a semi-permanent solution can be achieved by substituting the latex cuffs with latex gloves.

These are suggestions only. Whatever method chosen, convince yourself that the latex is properly treated. Make a leakage test before diving.

## Preparations before gluing

Measure and adjust the sleeve length wearing the suit and normal underwear garment. The installation may make the sleeve longer. When attached to the sleeve, the outer end of the Wrist Ring should not exceed the wrist when stretching the arms forward. As most sleeves are tapering, **ensure that the sleeve circumference is matching the wrist ring before length adjustment.** (If the sleeve becomes too short, use a neoprene extension.)

**Buff all non fabric surfaces that are supposed to be glued.** Make sure to have good ventilation when working with glue. Wash all surfaces that are to be glued (with Acetone or Toluene unless otherwise is stated by the glue manufacturer), prior to applying the first coat of glue. The PU material in Wrist Ring #60420 will be more receptive to the glue if swollen with solvent or preheated with a hot airgun (60-80°). Glue mixed with hardener has a limited pot life. Do not mix too much each time.

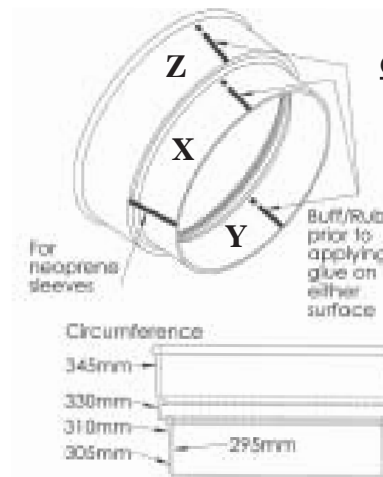
**A pre-glued PU tape (heat activated)** is supplied with the Quick Cuff set #60910. Apply glue on the suit and PU Wrist Ring #60420, but not on the tape. Let dry thoroughly. To activate Heat the tape and glue on sleeve and Wrist Ring, 5 cm at a time, with a hot air gun or hair dryer and stretch the tape gently when applying. Apply pressure to all glued surfaces and force remaining air in seams and air pockets towards the edges. Allow to cool under pressure or tension. Using a **heat activated PU glue** (for which the following instructions are intended) will allow you to eliminate mismatches as you can match the the two surfaces when dry.

An inside support that fills the sleeve end is a valuable help when fitting the glued surfaces. Use a hot air gun to melt the glue until good bonding is achieved. Heat one segment at a time in all four corners. Apply pressure and work on the remaining surfaces. Make sure that the glue is thoroughly hot and bonding well.

## Important issues about glue and gluing

**Polyurethane (PU) based glue is recommended** for the attachment of the PU wrist ring (#60420) to the suit. Neoprene glue is not recommended since it may permanently swollen the material. To achieve the best bonding and saturation of all materials, including natural rubber, the first (and possibly second) coat of PU glue must be thinned. PU glue can normally be thinned with Acetone or Toluene. (Follow the glue manufacturer recommends). Apply 2-3 **thin coats of glue** (mixed with hardener if recommended by glue manufacturer) on all surfaces making sure that all seams are well covered. The thinner the glue is, the better saturation of any suit material and fabric. Allow each coat to dry completely.

**These are recommendations only. Follow glue manufacturers instructions for proper bonding. Leakage test before use.**



## Gluing instructions for Wrist Ring art. # 60420

Depending on the sleeve circumference, the Wrist Ring can be cemented either on the inside or on the outside of the sleeve. If no surface matches your sleeve you may have to consider removing or inserting a **wedge** into the suit sleeve.

**X** On the inside of a medium circumference sleeve  
**Y** On the outside of a small circumference sleeve  
**Z** On a sleeve with large circumference

### Medium circumference sleeve:

On **neoprene suits**, cut the edge perpendicular and apply glue on exposed neoprene and the perpendicular surface of the Wrist Ring. Be extra careful to even out all sharp edges in joints and seams on the suit with sandpaper, not with glue.

**If using heat activated glue**, insert the wrist ring into the sleeve when the last layer of glue is dry. Place the glued surfaces together. Heat activate the glue, apply pressure and let dry. Reinforce the seams with tape to seal the edge. Apply pressure to all glued surfaces and allow to dry.

On **shell suits** the sleeve is attached on the narrow part of the Wrist Ring. Allow at least 5 mm for sealing tape to overlap the sleeve edge.

**Small circumference sleeve:** Follow the procedures above (medium circumference), **but** apply glue on the **inside** of the Wrist Ring (**Y**). Place the Wrist Ring on the outside of the sleeve. Tape the junction between the rear edge of the Wrist Ring and the sleeve. (If possible, turn the Wrist Ring inside out and seal with tape on the inside of the suit.)

On **neoprene suits**, chamfer the sleeve edge (45°), apply glue on the exposed neoprene and fold the chamfered edge to make the neoprene seals against the Wrist Ring.

**Large circumference sleeve:** Follow the procedures above (medium circumference), **but** apply glue on the **outside of the widest part of the Wrist Ring**. Cut away the narrow part of the Wrist Ring. (Leaving 5 mm will be helpful when detaching Stiff Ring #60200). Buff the outside thoroughly. Wash with solvent. Allow 5 mm for the tape to overlap.

