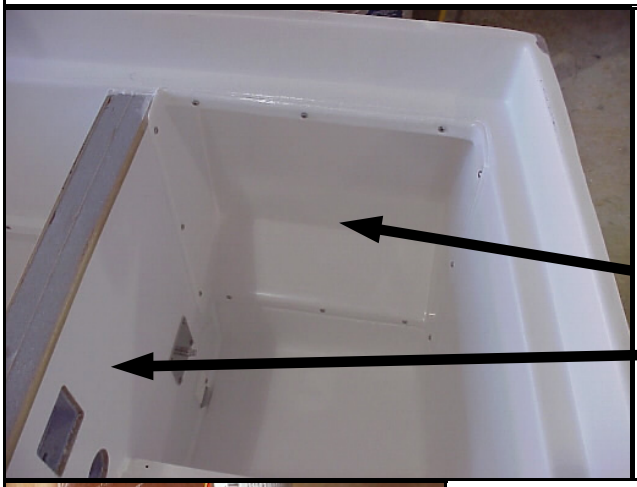
# 356 GALLEY ICEBOX
# SEALING & INSULATION 

The following instructions cover the sealing and insulation of the icebox when the galley is built. It is assumed that the cabinet maker has knowledge of how the galley is built. The icebox must be sealed and insulated properly to ensure condensation does not occur on the outside of the icebox and eventually rot the wood components of the galley.

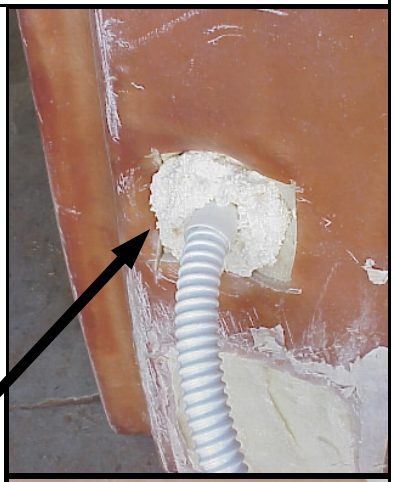


The entire perimeter of the divider will need to be caulked (733 white caulk) on both sides after it is secured in the icebox, also the perimeter of the flange of the insert will need to be caulked (733 white caulk) prior to installation in the fiberglass icebox.

INSERT

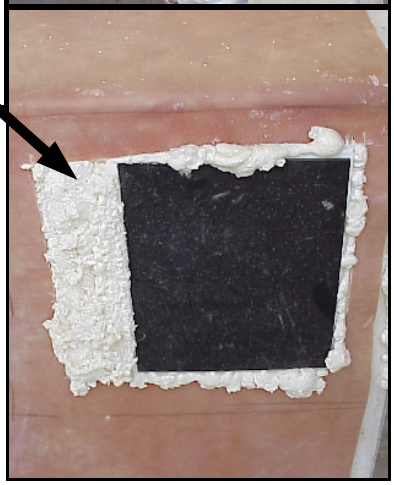
DIVIDER

After attaching the drain hose to the bottom of the icebox with the proper size hose clamp, fill the cavity with expanding foam.



Picture of voids after they have been filled

Also fill the voids between the insert and the icebox with expanding foam.



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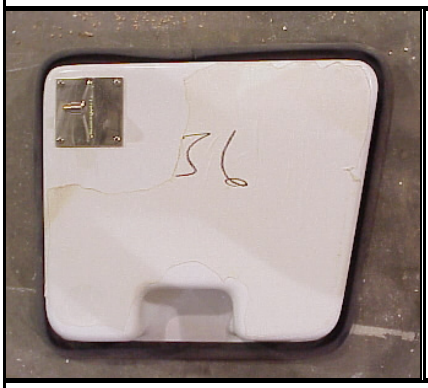
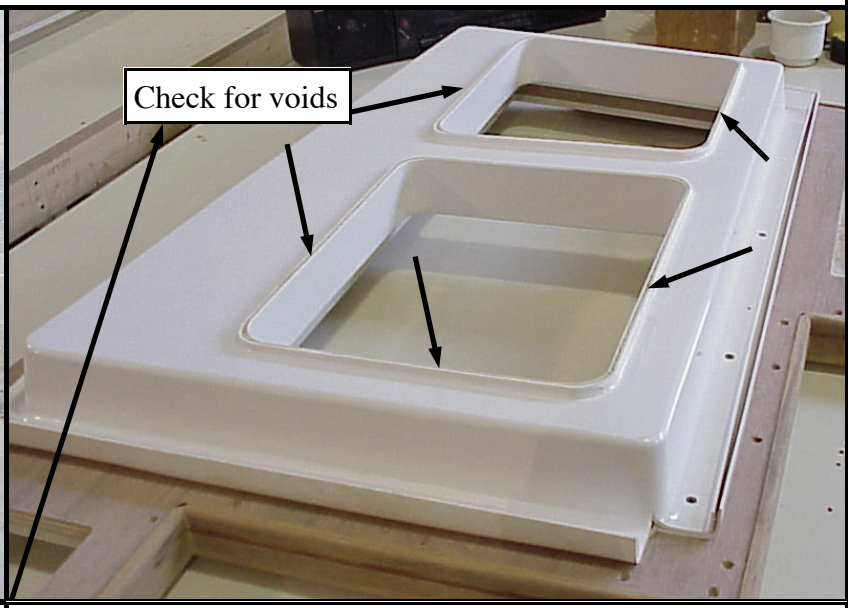


Glue the rubber gasket around the perimeter of the icebox lids with 401 loctite so the open side of the gasket faces in and the seam is on the hinge side of the lid.
Glue the seam together with 401 loctite.

NOTE: Prior to applying caulk all plastic surfaces must be roughed up using #40 grit sandpaper and cleaned with alcohol.




After the access holes of the icebox top insulator have been cut off check to make sure the part is completely filled with foam and there are no voids around the cut edge. If voids are found reject the part.

After checking for voids lay center the openings in the icebox top insulator with the holes in the galley top then mark the perimeter of the icebox top insulator onto the bottom of the galley with a pencil.

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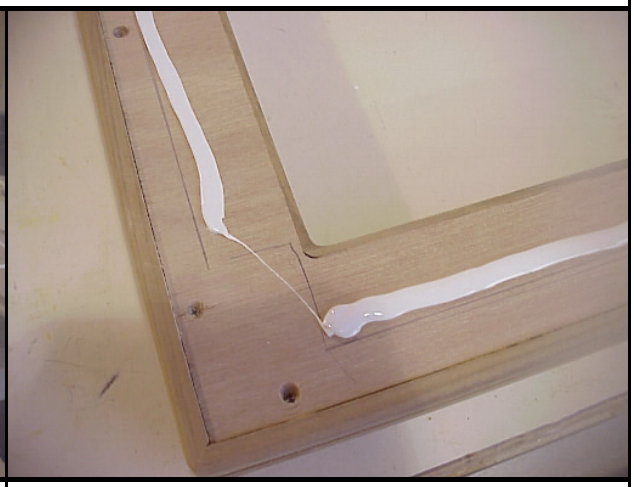
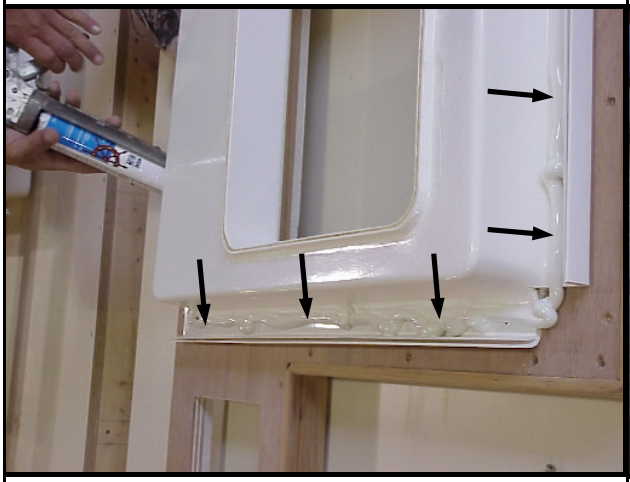
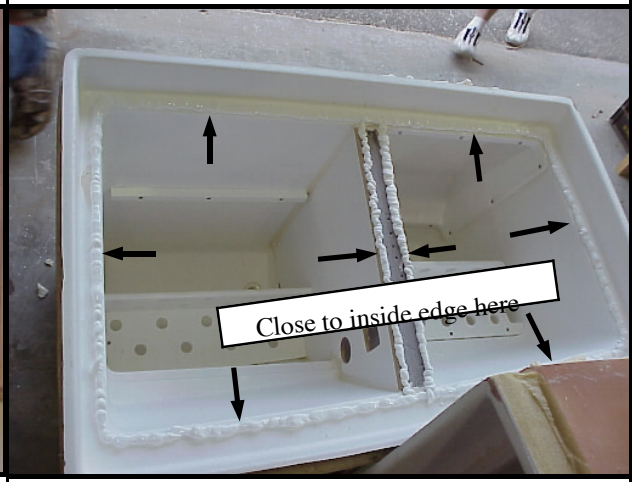
Caulk (using 5200) generously just inside the pencil line that was marked earlier on the bottom of the galley top.



Do not caulk the one notched corner. (Notice the pencil mark.)



Secure the icebox top insulator to the bottom of the galley top using #10 x 1" flathead screws every 6" to 8". Caulk (using 5200) generously just inside the outside perimeter on the bottom of the icebox top insulator.




Caulk (733 white caulk) generously along the inside edge of the second tier from the top and both edges on the top of the divider.

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Using two people, flip the icebox up and place it over the icebox top insulator. Press the icebox down well to ensure a good seal then secure using #10 X 1-1/4" panhead screws. Secure every 6" to 8" all the way around box. Access "half circles" have been provided where necessary.

Using a handsaw cut the excess foam around the back of the insert that expanded out from the early procedure.

On the side of the icebox that the insert is located foam the "half circles" cut into the fiberglass and the void between the icebox top insulator and the icebox. Before doing this step have the icebox face that goes on this side of the galley ready to install as it will need to be put in place and secured to the galley sub top before the foam has had time to expand. This will ensure that the foam will seal well. Also have the oven bulkhead that runs along the side of the icebox nearest the insert ready to temporarily place in position so the insert cover can be properly located.

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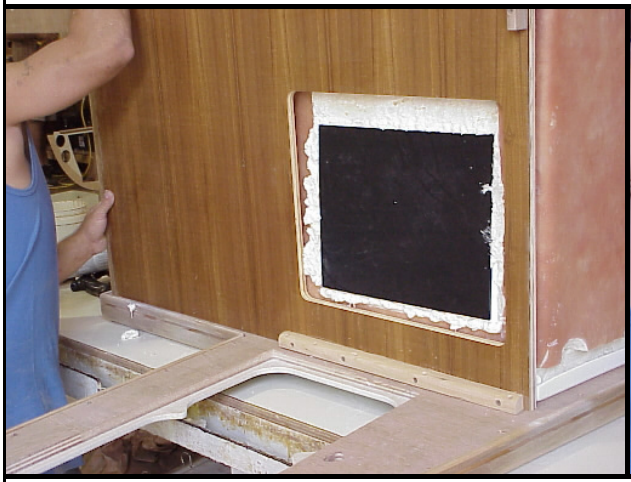

Before the foam that was placed between the icebox top and the icebox has had time to expand place the icebox face on the side of the icebox and secure it to the galley sub top.

After the icebox face and the forward galley bulkhead have been installed have the insert cover ready to install. Fill all voids around the insert flush to the wood face minimum to approximately 1/4" proud then apply a layer of foam on the back of the insert so it completely covers the back.

Place the insert cover over the insert and secure it to the wood face using #8 x 3/4 panhead screws every 4" to 6" around flange.

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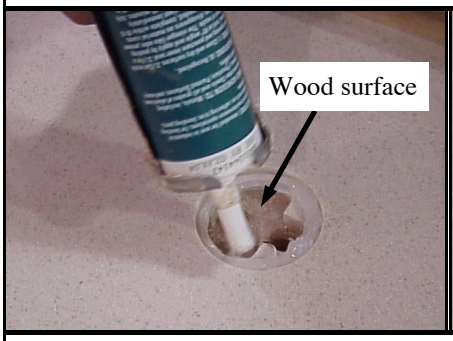



Before installing the handles on the icebox lids, fill cutout that will receive the handle with approximately 1/4" layer of 733 clear caulk. After the handles are installed clean up the excess caulk using alcohol. CAUTION: Avoid using acetone.

Caulk, using 733 white caulk, around the outside perimeter of the rubber gaskets where they meet the bottom of the icebox lid.

On the back side of the icebox place the foam gun nozzle all the way in the void between the top of the icebox and the side of the galley and inject foam while pulling the foam gun out, filling the void. Do this procedure on both sides. CAUTION: Do not over fill as foam will expand and distort the outer bulkheads.

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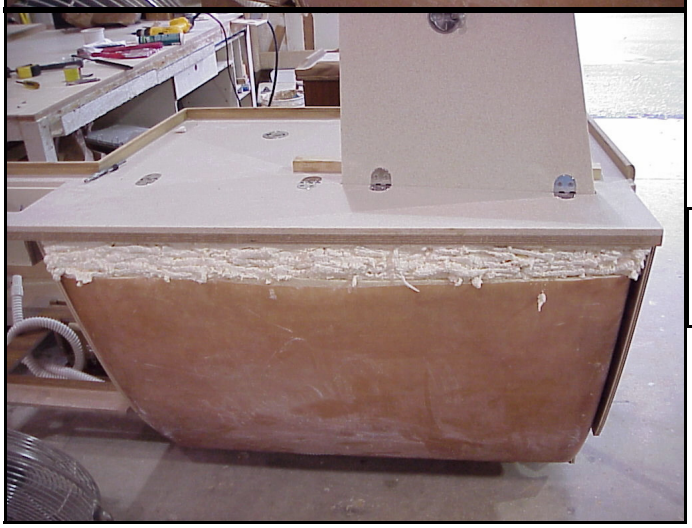
After filling the voids along the top on both sides apply expanding foam along the entire length of the cutout on the top back side



Back of icebox after it has been foamed