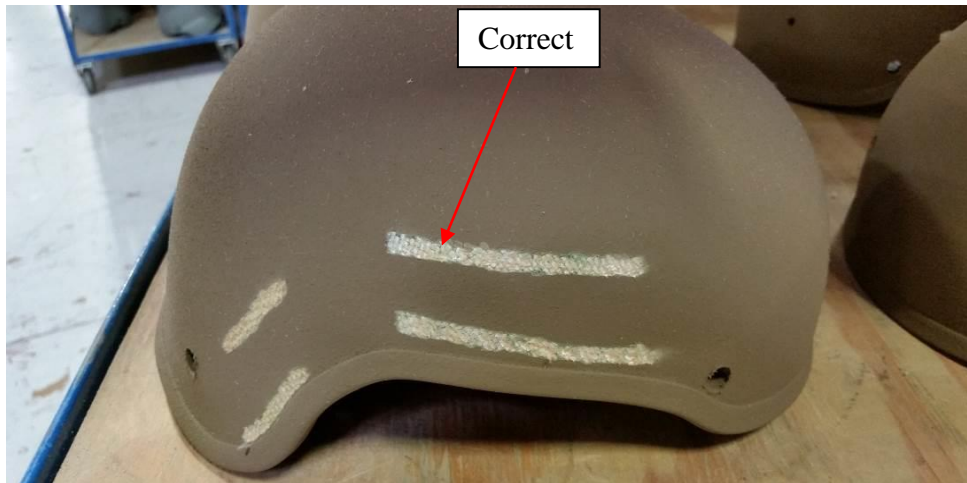


ArmorSource Rail Assembly Instruction

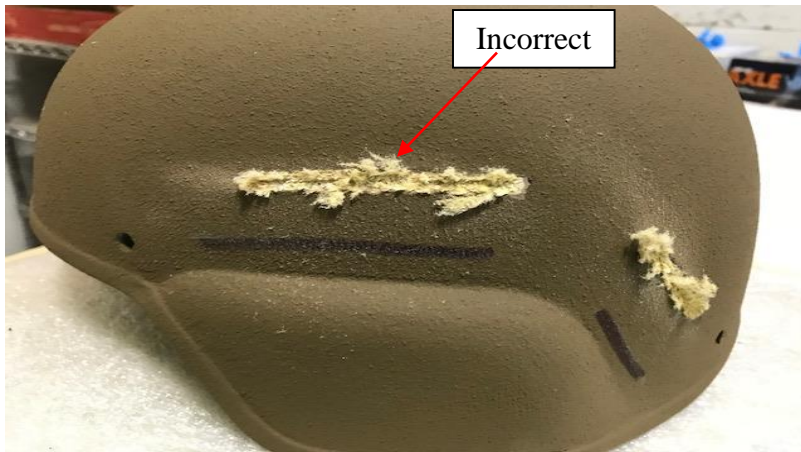
4.1 Instructions for ASR's applied using BetaSeal U-418



- 4.1.1 Using a barrel stone attachment or sanding drum in a Dremel tool (operating at 25,000 RPM), carefully grind away the paint and first layer of resin from the helmet exterior from marked line (as shown) raising the Kevlar fibers that are just below the paint. Do not dig below the outer layer - just raise the outer fibers for the epoxy to hold onto. Widen the ground line as shown below by making additional ground lines on both sides of the initially ground line so that the ground area between the dots to approximately $\frac{1}{4}$ " to $\frac{3}{8}$ " wide.



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- 4.1.2 Use a short blast of air to remove any residual dust created by grinding the paint from the helmet exterior. This will ensure the BetaSeal U-418 has a strong bond with the helmet.
- 4.1.3 Use the correct side ASR on the correct side of the helmet. Make sure ASR size matches the helmet size. See picture for Side and Size indicator.



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M – size Medium R – right side of helmet

- 4.1.4 Wear gloves. This adhesive is messy. Apply Betaseal U-418 Adhesive to the locations as shown. Do not over apply.



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Adhesive that oozes into deeper holes is permissible as long as it does not come through the hole and onto the exterior of the rail once applied to the helmet. Excess adhesive can be cleaned off easily after it cures completely.

- 4.1.5 Ensure that you are wearing clean gloves before application of rails. Stage the ASR in the position shown below to help minimize sliding of the ASR during final positioning.
- 4.1.6 Fully spread Betaseal U-418 to the ground/abraded area on helmet using a spatula to ensure seal of rail.



- 4.1.7 Move ASR into final resting position trying not to slide the ASR on the helmet. The rear of the ASR should be just touching the rubber edge and no more than a 1/16" above the rubber edge.

Rail cannot cover the retention bolt head. Clear access must be given in case hardware needs to be removed.

- 4.1.8 The front of the ASR on a regular cut and mid cut helmets is to rest on the ear extension of the helmet. For high cut helmets, the gap between the rubber edge and ASR shall be no greater than 1/16".

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The rail should rest on the edge of the ear cup as shown above.



Maximum gap between rubber edge and bottom of the rail = 1/16"

- 4.1.9 Clamp the front of the ASR with just enough pressure to keep rail in place. Proceed to clamp the rear of the ASR tightly. There is adequate clamping pressure when there is no gap between the ASR's front, back, and top edge and the helmet greater than 1/32". The gap between the lower edge of the ASR and helmet will be larger due to variations in rubber edge and helmet cut. Ensure the front of ASR did not shift. Re-position if needed and then fully tighten the front clamp. Some circumstances may require a third clamp applied to the center of the rail.

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Clamp position for regular cut helmet.



Clamp position for Mid Cut helmet.

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Clamp position for High Cut helmet.



Note: Medium High Cut helmets require 3 clamps to ensure rails adequately adhere to the helmet.

4.1.10 Allow the adhesive to dry overnight before removing the clamps from the helmet. Clean any residual Beta seal U-418 the next day.