

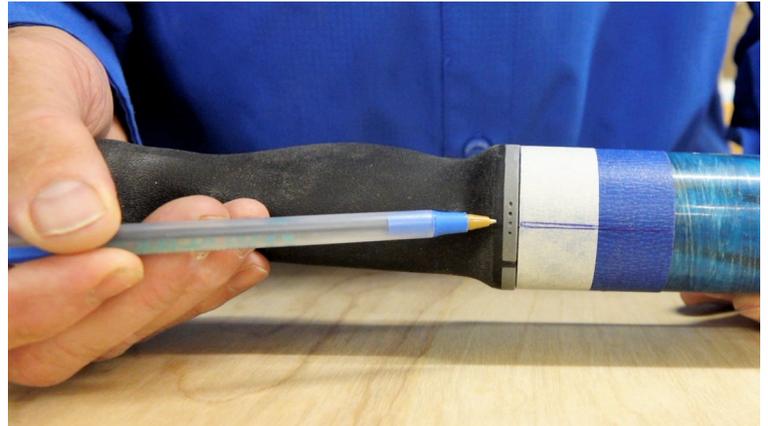
PRO-LOKS OARS

Gilman Grips are compatible with Pro-Loks oars. Pro-Loks handles are made as an integral part of the oar shaft, and will need to be sawn off to install your Gilman Grips oar handles. Here's the step-by-step process for installing your Gilman Grips:

1) Mark where you want to cut the handle with masking tape on the oar shaft. This will be where the oar shaft is the largest diameter at the transition of the handle. Use a fine carbide tipped saw blade or a fine metal cutting blade in a chop saw to cut off the factory grip. This method will not shorten the finished length of your oars, because your Gilman Grips will be inserted into the oar shaft, replacing the factory handle. With the factory handle sawn off you can move on to step #2.

2) Indexing your Gilman Grips. The correct indexing/clocking is critical, and these directions must be followed precisely.

- A. Wrap a piece of 2" wide masking tape all the way around the oar shaft on the end where the grip will go. You will be drawing two lines on the tape at the center of the oar shaft on the top of the oar in step B. The top of the oar will be directly in line with the 3/4" button hole at the blade end of the oar. You will use these two lines to index your Gilman Grips to the top of the oar blade.
- B. Next, you need to find the center of the oar shaft. Place the oar on a flat surface long enough to support the full length of the oar. A flat floor, counter or table should work fine. Shim up each side of the blade end of the oar (with something the same height like two books or two same-sized blocks) until the blade sits flat. Next, elevate the grip end of the oar shaft with blocking or a book. Find a flat object that is 1" thick. On the button side of the oar shaft (the button is down by the blade), place your 1" thick object against the oar shaft at the grip end of the shaft and let it rest on top of the blocking you are using to prop up the grip end. Using your 1" object as a guide, trace a line on the tape with a ballpoint pen where the top of your 1" object hits the oar shaft. Rotate the oar 180 degrees, place your 1" object against the oar shaft where you drew your first line, and trace another line using your 1" guide. Now you will have two lines on the same side of the oar very close together. Your oar's **center line** is centered between these two lines. **IMPORTANT:** If there is any movement in the oar blade at the button, it is important to take the movement out by twisting the oar shaft in a clockwise direction on one side and a counterclockwise direction on the opposite side before you make your mark.
- C. Indexing your Gilman Grips. You will find four small round indexing marks on the collar of your Gilman Grips. The collar is the part of the grip that will butt up to the end of the oar shaft. The collar will be Gray on the Black grips or Lime Green on the Purple grips. When you install your Gilman Grips in step 3, you will find the second indexing mark from the top of the grip, and line this indexing mark up with your **center line** and the top of your oar blade. The top of your Gilman Grips will have a Black or Purple line perpendicular to the collar 1/2" above the second indexing mark.



3) Installing your Gilman Grips. You will need to adjust the cylinder diameter to create a snug fit into the oar shaft.

- A. After indexing your Gilman Grips (see indexing instructions), test the fit of the Gilman Grips in the oar shaft. We recommend using a file or sandpaper to slightly bevel the inside edge of the oar shaft to slip over the black TPE waterproof gasket on your Gilman Grips. The fit should be snug but the grip should slide all the way in until the collar of the Gilman Grips touches the oar shaft. The fit will not be as snug initially when the glue is applied, because it will lubricate the surfaces.
- B. Oar shafts have slight differences in the inside diameter (I.D.) size. You will need to adjust the diameter of the Gilman Grips cylinder for the proper fit. Sand down the diameter of your Gilman Grips cylinder to create the desired fit using 80-100 grit sandpaper. Have someone hold the grip so the cylinder overhangs the edge of a bench. Don't put the Gilman Grip in a vice, which may damage it. Next, place a $\frac{1}{2}$ sheet of sandpaper over the top of the cylinder. With one hand on each end of the sandpaper, slide the sandpaper back and forth, so you are sanding the top half of the cylinder. Repeat this process by rotating the grip 3 times using one-third of a rotation each time. Be sure to sand the cylinder evenly including the black TPE gasket at the collar each time. Repeat until you have the correct fit. Be sure the Gilman Grips will slip all the way into the oar shaft before applying the adhesive.
- C. Once you have the correct fit, use 3M High-Strength Spray Adhesive ("Spray 90") to coat approximately 4" inside the oar shaft. Then, starting about $\frac{3}{4}$ " away from the collar of the Gilman Grips, coat the Gilman Grips cylinder (the part that will slip into the oar shaft) with Spray 90, trying not to spray all the way to the collar. Let the application dry for about 2 minutes. Dry time is directly related to the air temperature and the time will need to be reduced in temperatures over 70 degrees.
- D. Slip the Gilman Grips into the oar shaft, rotating and twisting the Gilman Grips back and forth as you slip it into the oar shaft. Once the Gilman Grips is inserted all the way to the TPE gasket, pull the Gilman Grips all the way out with a twisting motion. Let the parts dry for about 10 minutes.
- E. Now apply a second coat of Spray 90 on each part exactly as you did previously. Let dry for approximately 2 minutes. The time will be shorter in hot temperatures and longer in cold temperatures.
- F. Insert the Gilman Grips into the oar shaft again with a twisting motion, then pull back apart and let dry for about 30 seconds.
- G. Use a paper towel to wipe off any excess glue at the end of the oar shaft.
- H. Now ***in one motion*** insert the Gilman Grips all the way into the oar shaft and align the second indexing mark with your center line (see indexing instructions). It's best to slip the grip all the way in then rotate the Gilman Grips to the correct indexing mark. The Gilman Grips must be fully inserted and indexed before the adhesive becomes tacky. Do not bang the grip on the floor or use a hammer to bang the grip in. If the glue sets up before you get the Grip all the way in or indexed you can use a hot air gun to warm up and re-activate the adhesive. Do not overheat the

- oar shaft or apply heat to the TPE on the Grip. The glue should re-activate at about 300 degrees.
- I. Repeat this process on the other oar. Re-check the alignment in about 20 minutes. Let the oars sit in a 70 degree or warmer room for a minimum of 48 hours undisturbed, to allow for the glue to cure before use. Do not let them sit in a cold room, because the glue will not cure properly. Use lacquer thinner to clean any excess glue off the oar.

Spray 90 can be purchased at most home improvement centers or good hardware stores for between \$11 to \$15. We recommend using only 3M Spray 90 because it is designed to be used with polypropylene and has a 600 pound psi shear strength. In addition, this adhesive can be reactivated with heat to make adjustments to the indexing or to remove the Gilman Grips.

See our website's Help Center section for How-To videos. Please note, we recommend using spray 90 adhesive for installations on Pro-Lok oars. This will make it easy to remove the Gilman Grips if you break an oar shaft.

My cell number is 406-763-6464. Please give me a call if I can help. If you happen to be in Whitefish, MT, I would be happy to install your Gilman Grips for you.

Please feel free to talk to Dan Little at Pro-Loks about cutting off your factory handle.
509-369-3775
info@pro-loks.com