

**SPECIAL INSTRUCTIONS FOR MASK APPLICATION
OF THE PM-110**

PM-110 for Learjet models 23, 24, 25, 31, 35, & 36 with deice hole in radome.

Remove deice system plastic plug before installing mask (boot). Before you put the mask on the radome, ream the deice hole. This will eliminate any buildup of paint or anything else in the hole, and also will give you a nice sharp edge where the plug goes in. Then install the mask and let it set for 24 hours before cutting the hole in the mask. If you miss this waiting step, the mask shrinks away from the hole and you get a gap around the plug which allows the alcohol to get under the mask.

Very carefully cut the mask flush with the hole so that you get a nice clean cut without jagged edges. When this is done, apply by dabbing or brushing a penetrating adhesive made by Loctite called Superbond #420. It has a green label. Be careful not to slop any of this adhesive on the mask; but if you do, use Loctite cleaning agent X-NMS item #76820 to clean the adhesive off.

Caution! When replacing a deice system plastic plug, be careful not to let the plug rotate. Hold pressure on the outside of the plug to accomplish this.

When performing a radome deice system test inspection, make sure all of the residual alcohol is removed from the mask area including the hole area around the deice system plastic plug.

Go back and check one hour later for any alcohol present and soak up or wipe up again. Repeat as needed to ensure that no alcohol lays in contact with the mask for any length of time.

Beware of using silicone waxes, RTV, or other silicone agents anywhere on the aircraft or in close proximity of the aircraft.

These agents become airborne and spread over long distances. Residue from silicones just keep coming back to the surface and are a release agent for most adhesives and paints.

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INSTRUCTIONS
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