

PM-284L & PM-284R

Special Instructions For Masking Gulfstream 100/Astra 1125/Astra SPX Landing Light Lenses

Please read this entirely before attempting to apply a Lens Protective Mask.

Materials Required;

1. Lens Mask(s)
2. Spray Bottle
3. Wetting Solution, consisting of
 - * 4 oz. Isopropyl Alcohol, 70% by volume (common "rubbing" alcohol)
 - ***CAUTION: Do Not** use aircraft deicing alcohol! It will adversely effect the adhesive.
 - ^ 12 oz. Distilled Water
 - ^**NOTE:** Use Distilled Water only. Contaminates may cause rust stains or other problems later.
 - + 21 drops Clear or White Dishwashing Liquid, regular strength, or 7 drops concentrated.
We have provided a dropper cap which will fit most US Brands of Dishwashing
 - +**NOTE:** We recommend Ivory Dishwashing Liquid because it has no coloring agents, which may discolor the mask.

Liquid

4. Plastic Squeegee
5. Razor Blade Knife (New Blade Only)
- ~6. Paper Towels (High Quality, Oil Free, Single Ply Only)
~**NOTE:** Multiple Ply Paper Towels have adhesive which may turn into a release agent when alcohol is applied. Use only high quality plain white or natural color paper towels. Some paper towels have oil in them. Test and choose your paper towels carefully.
7. For Installation Over a New or Freshly Polished Lens — Sandpaper (600-1500 Grit)
8. Protective Gloves (Hospital-type latex or nitrile)
- °9. Non-silicone based automotive type paste wax
 - °**CAUTION:** Most waxes have at least a small amount of silicone to improve the shine. These are OK. Silicone based wax, RTV and other silicone agents, however, can spread and act as a release agent for paint as well as for adhesive.

CAUTION: Do not apply masks in direct sunlight or high ambient temperature. Blistering, rapid premature drying of the wetting solution and other application problems may arise.

CAUTION: Polyurethane must be firmly attached to a solid substrate. If it spans a crack or covers a hole where it is not glued down, the material will vibrate during flight, work harden and become brittle. This can cause some of the material to crack or peel away. To avoid this problem and also address the need for the lens to be removable, you may elect to trim along the edges of the lens. You may want to remove the masking under the heads of the mounting screws to ensure the screw heads do not protrude above the surface of the lens.

NOTE: The lens mask should be applied at temperatures above 50 degrees Fahrenheit, in a timely manner, without interruption, to avoid application problems.

Preparation

1. For a New or Freshly Polished Lens — Lightly scuff the lens surface using sandpaper so that mechanical adhesion can occur.
2. For a Hazed Lens — If possible, have lens refurbished prior to applying mask.

Installation

A. References

Phase Inspection Program Figure 1 (Sheet 2 of 3) location Y-129

Illustrated Parts Catalog:

57-40-00 Figure 7, Page 3, item 280 & 280A, Cover, Transparent L & R

PN:25W117116-001

PN:25W117116-002

Accompanying Illustration

B. Procedure

1. Place two marks on the leading edge adjacent to the light lens at approximately the center of the leading edge using tape or other non-permanent means. These marks will be used to help align the mask.
 2. Remove the mask from the support form but **Do Not** remove the release liner covering the adhesive.
 3. Position the mask on the lens in the proper orientation.
 4. Mark the ends of the mask with a non-permanent mark or tape to align with the marks on the leading edge made in the previous step.
 5. Remove the mask from the lens.
 6. Thoroughly clean the lens using wetting solution. Wipe dry with paper towels.
- CAUTION:** Removing the lens mask liner must be done by peeling away only a small amount of the Release liner each time and spraying the adhesive of the lens mask with the wetting solution. Repeat until entire lens mask is separated, then spray entire lens mask again with wetting solution. Failure to peel the lens mask in small steps may cause the mask to stick to itself and ruin the mask.
7. Separate the lens mask from the release liner in several small steps.
 8. Spray the lens with wetting solution.
 9. Place the wetted lens mask on the lens, ensuring that the mask is oriented correctly. Align the index marks on each end of the mask to the leading edge radius marks previously made.
 10. Smooth mask along surface of lens using hands. Start at the center of the leading edge and rub along the leading edge, inboard and outboard, to tack down the mask leading edge.
 11. Smooth out the mask by squeegeeing from the center of the leading edge radius, using small strokes of the squeegee.
- NOTE:** Use only light to moderate pressure on the squeegee.
12. Dry outside surface with a paper towel.
 13. Inspect for moisture underneath the mask. If any is found, wet again and squeegee it out.
 14. Allow lens to air dry a minimum of one hour, then apply a coat of non-silicone based wax per manufacturer's instructions prior to flight.

Maintenance

1. **Clean and wax periodically as required.** We recommend that you use full strength Nights Spray Nine® or full strength Mr. Clean® to clean the mask. Apply a coat of non-silicone based wax after each cleaning.
2. The user should determine an appropriate schedule to check for damage (i.e., cuts, blisters perforations, edge lifting, hazing, discoloration, separation, etc.).

Mask Removal

THE LENS MASK SHOULD BE REPLACED AT THE FIRST SIGN OF DAMAGE.

1. Peel the lens mask by lifting an edge on one end and carefully pulling off at an angle of 180°.
2. If adhesive residual remains on the lens after the mask has been removed, clean lens using a rag saturated in denatured alcohol. Softened residue may be removed faster with a plastic squeegee.