

Instructions for Replacing Acrylic Lens



DO NOT TOUCH EDGE OF LENS

- Edges are cleaned and primed prior to shipping
- X Oils from skin will compromise seal
- ✓ Re-applying solvent / primer is recommended

*Consider: A&H Labor starts at
\$150.00 Per Hatch
Includes: - Chemicals
- Adhesives
- One Year Warranty*

Products Recommended (Atkins & Hoyle):

- Cast Acrylic Lens, Edges Rounded and Top Beveled
- GE Silicone "Acrylic Adhesive" with fine nozzle

Additional Recommendations (local hardware store):

- High Grade Solvent (ex. Toluene, Acetone)
- Silicone Primer (standard liquid)

Tools Required (not supplied):

- | | |
|--------------------------|---------------------------------|
| ◆ Utility Knife "X-Acto" | ◆ 80-grit paper / Angle Grinder |
| ◆ Putty Knife | ◆ Nitrile Gloves |
| ◆ Paper Towel | |

Instructions:

1. Remove the old lens by inserting a utility knife into the silicone seal.
 - a) Cut along the perimeter of the lens, ensuring the blade goes all the way through
 - b) Press the lens from the inside of the hatch, out. Careful not to bend the frame or it will need to be straightened.
2. Clean the contact surface of the aluminum frame by using sand paper or angle grinder / Dremmel. Clean until bare metal
 - a) Once old sealant is removed, use the solvent to clean oils from the frame, paper towel should come off clean when complete
3. Use paper towel to apply solvent then primer to both the lens AND the frame (contact surface). DO NOT TOUCH THE EDGE moving forwards
4. Identify the bottom of the lens, and remove the wax paper backing. Leave the paper on the upper (beveled) side of the hatch.
5. Center lens in aluminum frame, and caulk around lens until gap overflows with silicone.
6. Use putty knife to even silicone caulking (bead) with the aluminum frame.
7. Set hatch on level surface and allow up to five (5) full days for adhesive to cure.
8. Remove wax paper from topside of the lens. Enjoy a clear view!