

**** ON A/C ALL**

57-37-12 PB 801 CONF 00 - GLAZING - WING TIP NAVIGATION LIGHT - REPAIRS

TASK 57-37-12-300-001-A

Wing-Tip Glazing Assembly Lens - Polishing Procedure

WARNING: PUT THE SAFETY DEVICES AND THE WARNING NOTICES IN POSITION BEFORE YOU START A TASK ON OR NEAR:

- THE FLIGHT CONTROLS
- THE FLIGHT CONTROL SURFACES
- THE LANDING GEAR AND THE RELATED DOORS
- COMPONENTS THAT MOVE.

MOVEMENT OF COMPONENTS CAN KILL OR CAUSE INJURY TO PERSONS AND/OR CAN CAUSE DAMAGE TO THE EQUIPMENT.

WARNING: MAKE SURE THAT THE FLIGHT CONTROL SAFETY-LOCKS AND THE WARNING NOTICES ARE IN POSITION.

WARNING: BE CAREFUL WHEN YOU USE CONSUMABLE MATERIALS. OBEY THE MATERIAL MANUFACTURER'S INSTRUCTIONS AND YOUR LOCAL REGULATIONS.

1. Reason for the Job

To polish and remove small surface scratches or erosion damage on the Wing-tip Navigation Light Glazing Assembly Lens.

NOTE: This procedure is for Nordam Acrylic Lenses only (Post Modification 28219, 30791, 30889).

2. Job Set-up Information

A. Fixtures, Tools, Test and Support Equipment

REFERENCE	QTY	DESIGNATION
No specific	1	ACCESS PLATFORM 4M (13 FT)-ADJUSTABLE
No specific	AR	PAPER - ABRASIVE (GRADE 320)
No specific	AR	PAPER - ABRASIVE (GRADE 400)
No specific	AR	POLISHING KIT - MICRO-MESH
No specific	AR	SAFETY BARRIER(S)
No specific	AR	WARNING NOTICE(S)
(98D27803500001)	1	LOCKING TOOL ZERO POS

B. Consumable Materials

REFERENCE	DESIGNATION
(Material No. 08ABC1)	Aqueous Cleaner-Aircraft Exterior Pressure Spraying -
(Material No. 14SBA1)	Textile-Lint free Cotton -

C. Referenced Information

Customer : CTV	Manual : AMM
Type : A318/A319/A320/A321	Selected applicability : ALL
Rev. Date : May 01, 2018	
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REFERENCE	DESIGNATION
** ON A/C 001-160, 163-165, 201-350	
(Ref. 57-37-12-000-802-A).	Removal of the Navigation-Light Glazing Panel
(Ref. 57-37-12-400-802-A).	Installation of the Navigation-Light Glazing Panel
** ON A/C ALL	
Ref. NTM 572908	

3. Job Set-up

Subtask 57-37-12-941-052-A

A. Safety Precautions

- (1) As necessary, use the applicable SAFETY BARRIERS, specified by the operator's instructions and your local regulations.
- (2) Install the LOCKING TOOL ZERO POS (98D27803500001) on the flap/slat control lever.
- (3) Put the WARNING NOTICE(S) in the cockpit to tell persons not to operate the flaps or slats.

Subtask 57-37-12-010-050-A

B. Get Access

- (1) Put the ACCESS PLATFORM 4M (13 FT)-ADJUSTABLE below the applicable wing-tip, zone 534(634).
- (2) If necessary, remove the applicable Navigation Light Glazing Panel (Ref. AMM TASK 57-37-12-000-802).

4. Procedure

Subtask 57-37-12-350-050-A

A. To Repair the Navigation Light Lens



NOTE: A POLISHING KIT - MICRO-MESH is necessary for this repair procedure.

NOTE: Always wind the abrasive papers around the foam block and work in a straight-line movement and at alternate right angles. Each subsequent application of abrasive paper must overlap the area that was worked before. Make sure that the damage has been removed before you continue with the subsequent grade of abrasive paper. Protect all areas of the lens that do not require repair.

- (1) During this procedure, keep the surface of the acrylic lens wet with water to keep it cool and prevent heat distortion.
 - As necessary, add a small quantity of Aqueous Cleaner-Aircraft Exterior Pressure Spraying - (Material No. 08ABC1) to the water for lubrication.
- (2) Measure and record the maximum depth of the damage to be repaired Ref. NTM 572908.

NOTE: The maximum depth of damage that can be repaired is 0.889 mm (0.0350 in.).

- (3) Use PAPER - ABRASIVE (GRADE 320) over the defective area and remove all signs of damage. Flush the surface with water to remove all debris and dry with a clean lint-free cloth.
- (4) Use PAPER - ABRASIVE (GRADE 400) over an area that overlaps the previous area and remove the 320 grade pattern. Flush the surface with water to remove all debris and dry with a clean Textile-Lint free Cotton - (Material No. 14SBA1).

- (5) Use 1500 Micro-mesh grade wet or dry abrasive paper over an area that overlaps the previous area and remove the 400 grade pattern. Flush the surface with water to remove all debris and dry with a lint-free cloth.
- (6) Use 1800 Micro-mesh cloth over an area that overlaps the previous area and remove the 1500 grade pattern. Flush the surface with clean water to remove all debris and dry with a lint-free cloth.
- (7) Use 2400 Micro-mesh cloth over an area that overlaps the previous area and remove the 1800 grade pattern. Flush the surface with water to remove all debris and dry with a lint-free cloth.
- (8) Use 3200 Micro-mesh cloth over an area that overlaps the previous area and remove the 2400 grade pattern. Flush the surface with water to remove all debris and dry with a lint-free cloth.
- (9) Use 3600 Micro-mesh cloth over an area that overlaps the previous area and remove the 3200 grade pattern. Flush the surface with water to remove all debris and dry with a lint-free cloth.
- (10) Use 4000 Micro-mesh cloth over an area that overlaps the previous area and remove the 3600 grade pattern. Flush the surface with water to remove all debris and dry with a lint-free cloth.
- (11) Use 6000 Micro-mesh cloth over an area that overlaps the previous area and remove the 4000 grade pattern. Flush the surface with water to remove all debris and dry with a lint-free cloth.
- (12) Measure and record the minimum thickness of the lens Ref. NTM 572908.

NOTE: The minimum thickness permitted is 3.33 mm (0.1311 in.).

- (13) The reworked area will have a hazed finish. Remove the haze as follows:
 - (a) Use the Micro-mesh cotton flannel wipe to apply a sufficient amount of Micro-Gloss and polish until the Micro-Gloss has almost gone.

NOTE: Water can be added to extend the working life of the Micro-Gloss. In warm weather it is recommended to polish the lens in small areas.

- (b) Continue to polish with the Micro-Gloss until you get a bright and transparent finish.
- (14) Flush the lens surface with water and dry with a lint-free cloth.
- (15) If you cannot get a satisfactory optical quality by polishing, the glazing panel must be replaced.

5. Close-up

Subtask 57-37-12-410-050-A

A. Close Access

- (1) Make sure that the work area is clean and clear of tools and other items.
- (2) If applicable, install the wing-tip glazing assembly (Ref. AMM TASK 57-37-12-400-802).

Subtask 57-37-12-942-051-A

B. Removal of Equipment

- (1) Remove the LOCKING TOOL ZERO POS (98D27803500001) from the flap/slat control lever.
- (2) Remove the access platform(s).
- (3) Remove the warning notice(s).
- (4) Remove the safety barriers.

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