

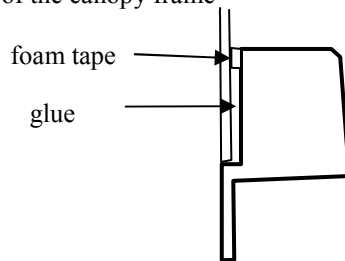
Subject : Gluing Plexiglas canopies

Effectivity : All gliders and motorgliders

Accomplishment : for repairs

Reason : 'Foss Than' glue which is mentioned in most repair manuals for gluing Plexiglas canopies is no longer available.  
Acrifix 90 which is mentioned in some repair manuals is still available, but we don't recommend its use.  
As a replacement, Teroson Macroplast should be used.

Instructions : 1. The Plexiglas must not be sanded for gluing. The canopy frame must be sanded. Cut canopy to exact shape.  
2. Attach a foam tape WM-moll 1710 grey 9mm wide, 2mm thick to the upper edge of the canopy frame



3. Mix glue Teroson Macroplast UK 8303B60  
resin UK 8303B60  
hardener UK5400  
mixing ratio of resin-hardener is 6:1 by weight  
After mixing the components add a little Aerosil to make the glue viscous.
4. Apply the glue to the canopy frame up to the foam tape.
5. Install the canopy and press down using tape and wooden blocks.

Material : All Materials are available from DG-Fluzeugbau.

Remarks : All instructions may be executed by the owner. They have to be inspected and entered in the aircraft logs by a licensed inspector with the next annual inspection.

Bruchsal, date:  
October 1. 2003

Author:  
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This service info has been approved by EASA date 23. April 2008 with technical note DG-G-04.  
Approval No. EASA.A.C.09568.