LED PAPI Heated Lens Assembly - Replacement Kit Installation Guide
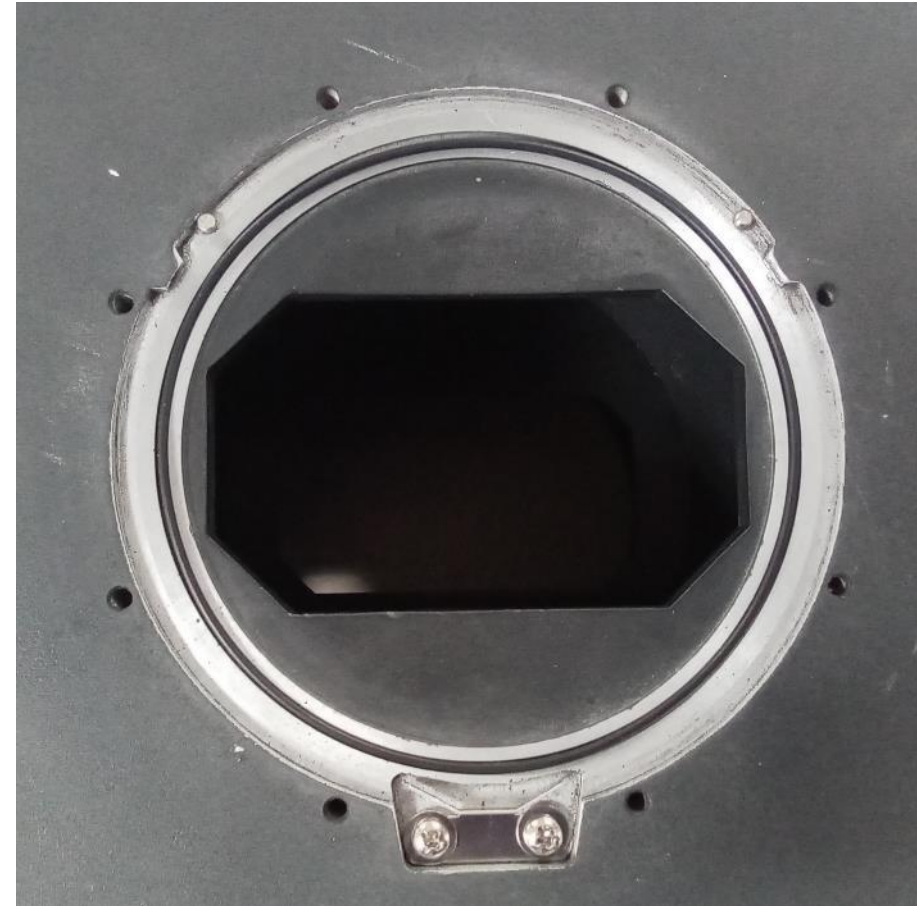# P/N: 88-00205

Included:
- 2x Nitrile Gloves – Note: Gloves must always be worn when handling the lens!
- 1x Suction Cup for Lens Positioning
- 1x 3oz. Tube of Black Permatex Silicone
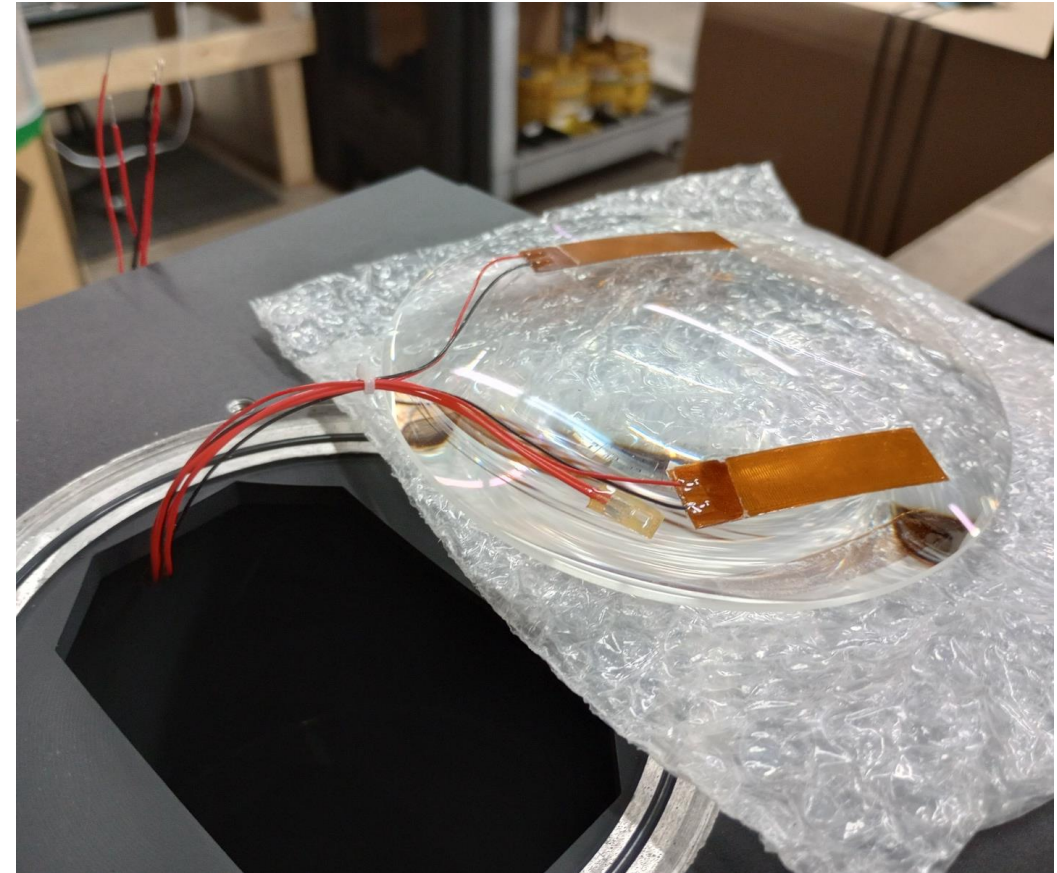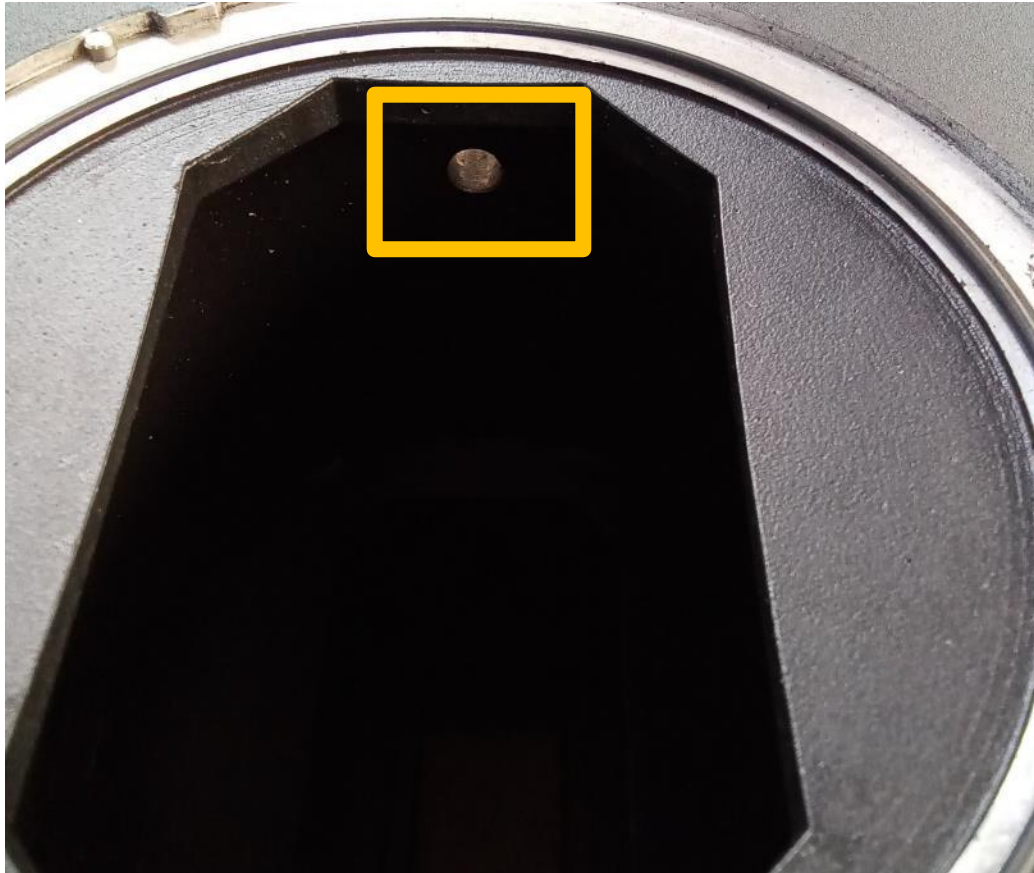
Required / Not Included:
- Torque Wrench with 9/64" Allen Bit – Set to 5 in-lbs. Torque
- Loctite 248

➢ Remove the existing lens, O-Ring, and any debris from the wiring thru-hole found behind the Right Cover / Display assembly.

➢ Keep the 88-00031 Lens Heater harness connected to the 88-00100 control board! Disconnect the old lens from the harness.

➢ Place the new 88-00004 lens O-Ring into the channel.

- Rest the lens on its bubble wrap and feed the 88-00005 lens heater wiring through the indicated hole after debris is cleared.
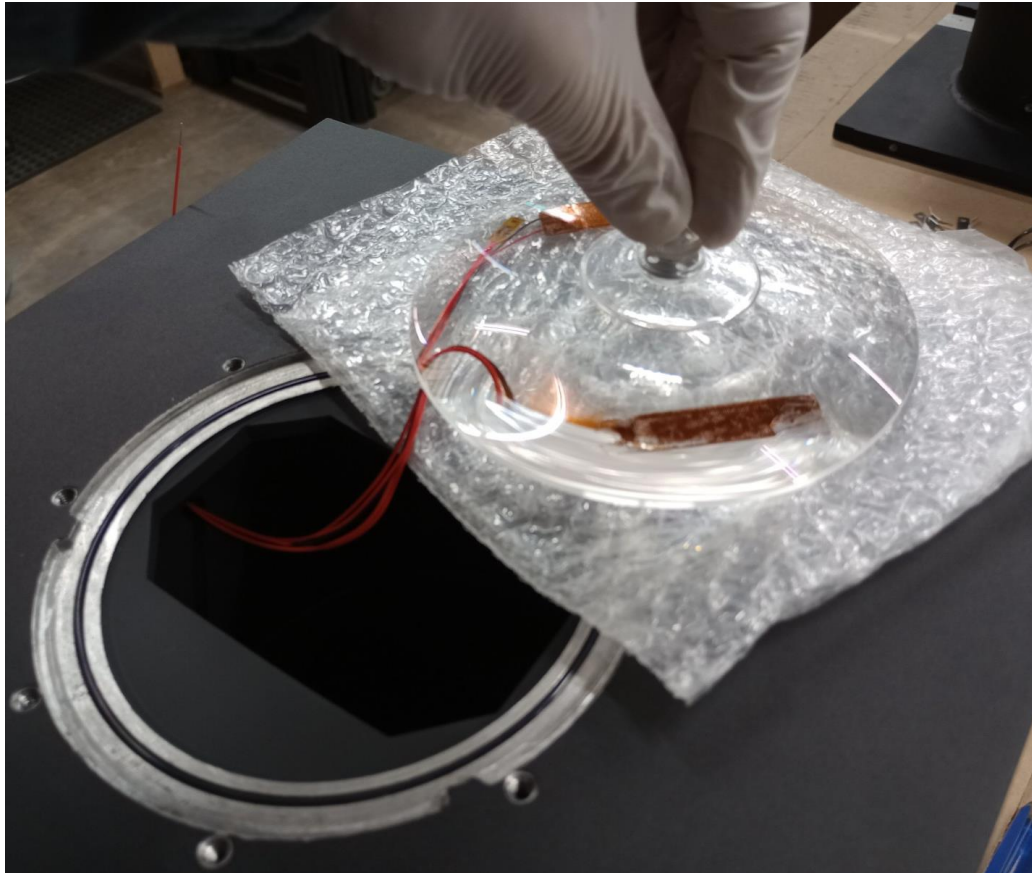
- Gloves must always be worn when handling the new lens.

➢ Direct the lens heater wiring out the side of the chassis.

➢ Ensure that the twisted pairs of heater wires stay together! There should be a pair of two black wires & a pair of two red wires.
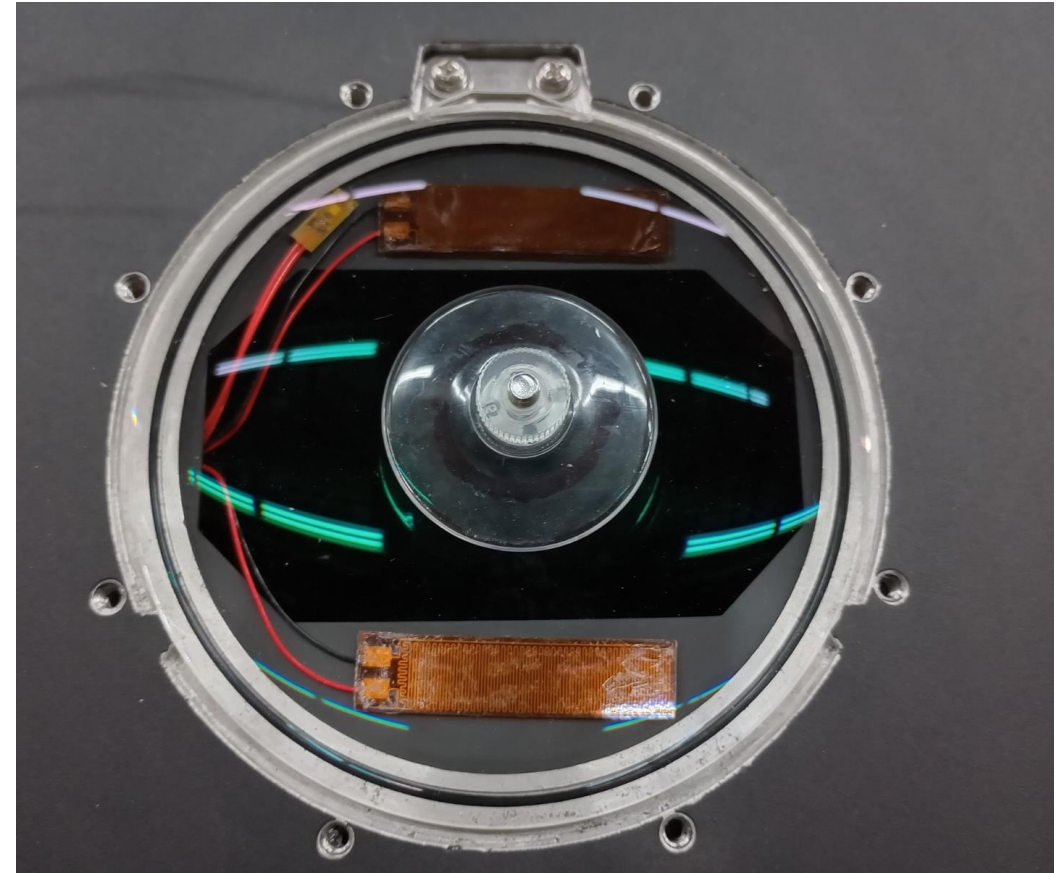

Retain twisted pairings!

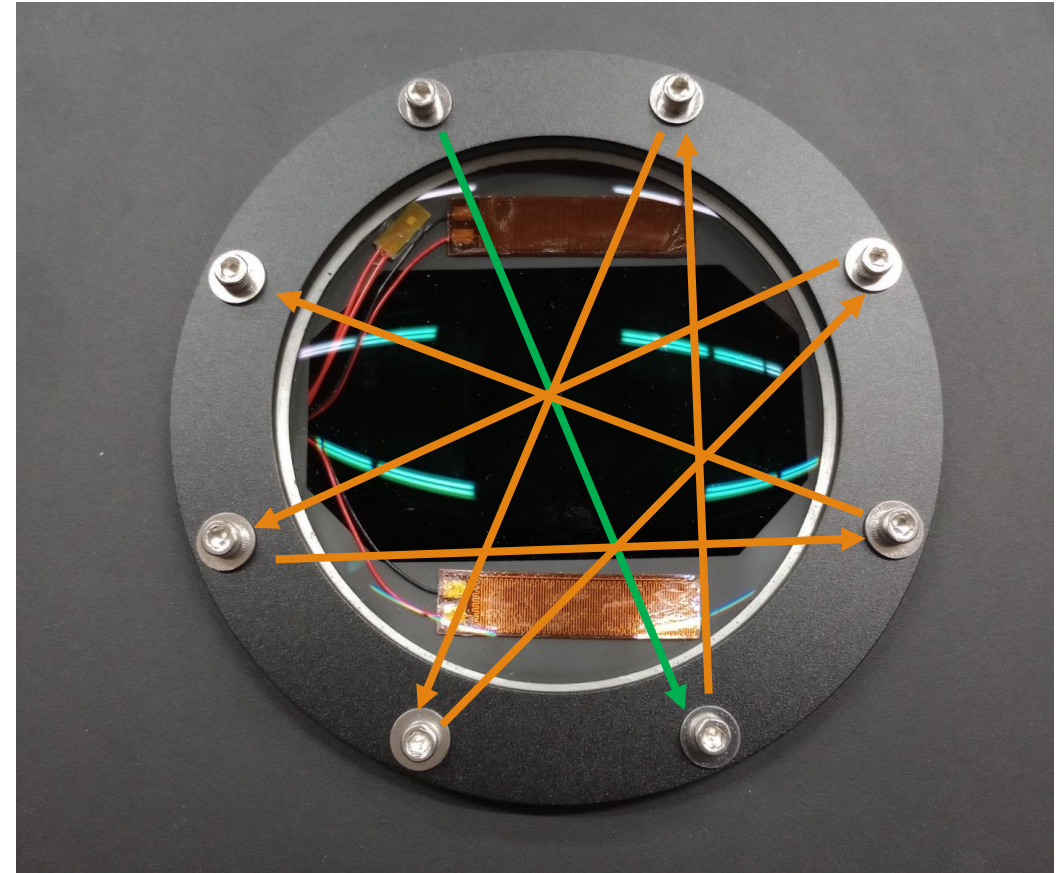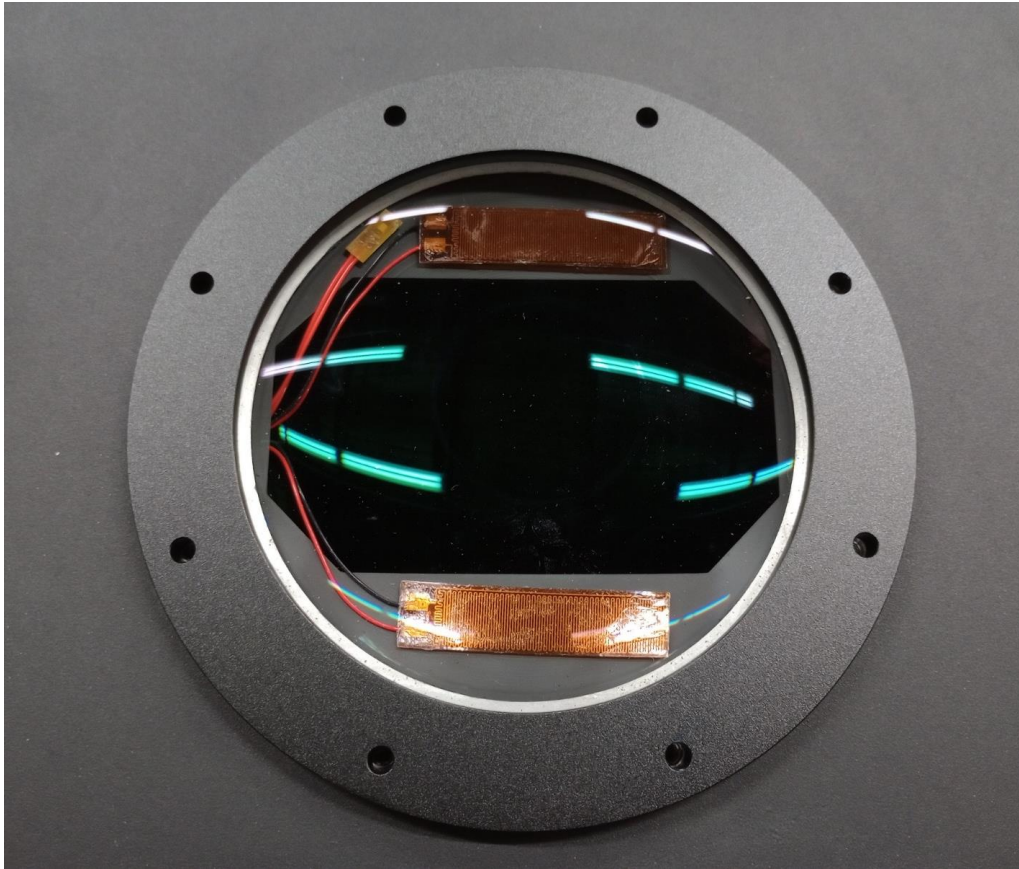➤ Place the suction cup in the center of the lens to assist with placement.

➤ Place the 88-00005 lens over the O-Ring on the chassis. ==Ensure that no wires are overlapping between the lens and the chassis!==
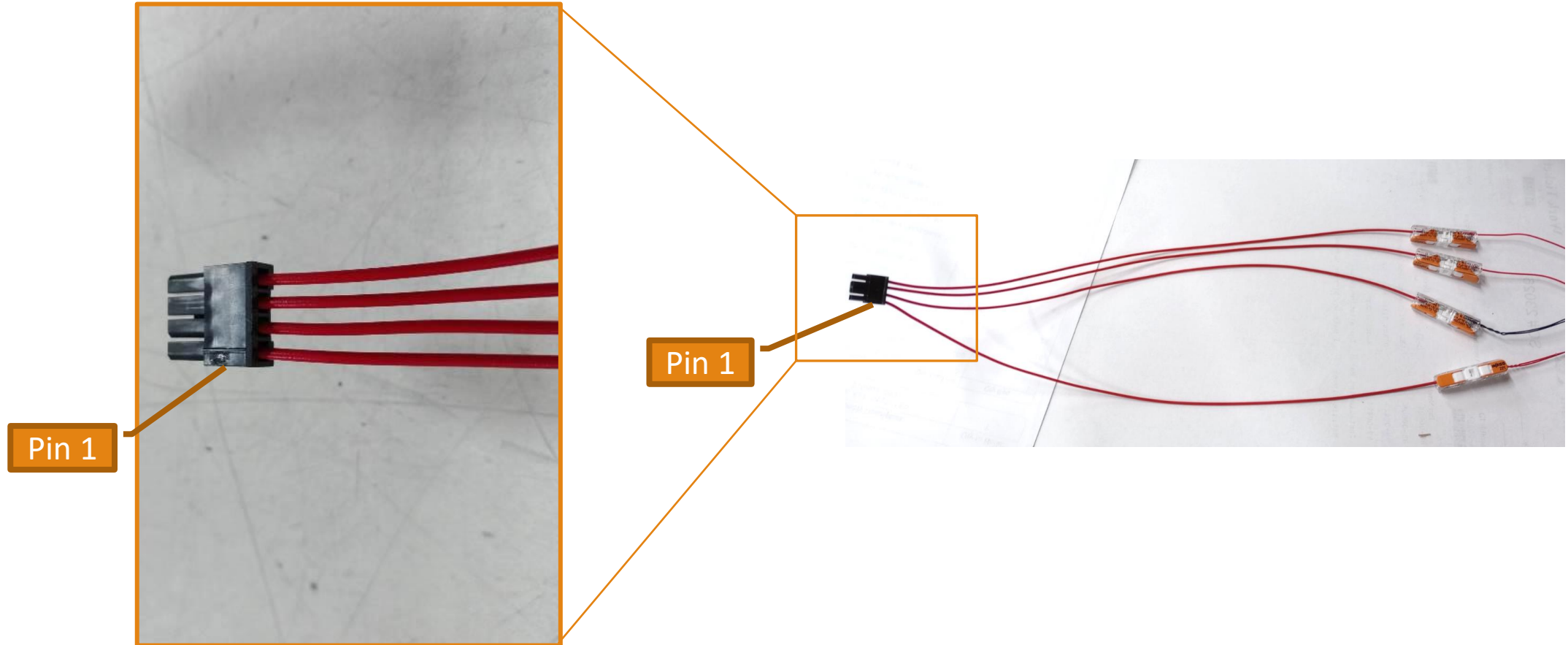
➤ Carefully remove the suction cup and wipe any smudges off with a soft microfiber or cotton cloth.

➤ Place the 88-00006 lens retaining ring back into position.

➤ Using blue Loctite 248, carefully fasten (8) #8-32 x ½" bolts (ALC p/n 99-00258) with (8) #8 washers (ALC p/n 99-00105) in a star pattern using a Torque Wrench with 9/64" Allen Bit set to 5 in-lbs.

➤ Locate the 88-00031 Lens Heater harness and identify Pin 1 by finding the ribbed position indicated:

➤ **Attach the harness as listed:**

➤ Pins 1 & 2: Twisted pair of Red, or Twisted pair of Black, Heater wires

➤ Pins 3 & 4: (RTD) Individual Red Thermistor wires

Pin 1

Pin 1

➢ Seal the hole in the chassis using the black Permatex Silicone.