

HATCH MODIFICATION KIT

FITTING INSTRUCTIONS

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LiveWire
Connections

FITTING ADVICE AND WARNINGS

Radome hatch door (modification) kit to allow the installation of a pre-manufactured "access hatch" into the side wall of a VSAT or TVRO radome. This range of kits is suitable for SeaTel and Sailor radome up to 76" models

Comprising of:

- 1 x composite hatch door with catches - hatch door dimensions 454 x 454mm
- 1 x composite hatch door surround - overall dimensions 593 x 592mm
- 1 X cutting template
- 1 x full fitting instructions

Note: Kit requires recommended bonding adhesive (not supplied), see page five.

Notes:

i) Hatch to be located in RF sector blanking/blockage zone and is not intended to be installed in the prime Receive and Transmit sector.

ii) This modification will void Cobham's radome warranty, normal antenna and BDE warranty will apply to the rest of the antenna apart from actions arising from the installation of this hatch door kit.

iii) Please ensure that in fitting this Hatch Kit you comply with all appropriate Health and Safety regulations regarding the handling and use of composite materials and adhesives, use PPE protection and work in a well ventilated area.



1) To start the fitting procedure, firstly place the supplied paper template on the radome as shown



2) Using a 25mm hole saw, drill out the 4 corners of the hatch aperture



3) When all 4 holes have been drilled, proceed to cut the complete aperture with a shape suitable blade and by-hand if possible, avoid any vigorous cutting action



4) Picture showing the aperture cut out



5) Offer the hatch aperture into the cut-out to check for fit, you may find you will need to file the edges to create a good fit, ensure outer flange sits against the radome outer face.



6) Completed hatch cut-out aperture ready for the frame fitting.



7) Apply the adhesive all around the flange face as shown

Recommended adhesive:

Purok-QX60-35 Structural adhesive or similar adhesive



8) Hatch frame with all the adhesive applied ready for inserting into the radome



9) Place the hatch frame into the radome and clamp using a minimum of 4 clamps, quick release type clamps as shown are recommended for this procedure.



10) Picture showing detail of the clamping arrangement inside the radome



11) Remove the clamps after 3 hours of applying the adhesive



12) Apply a silicone bead on the side of the aperture hatch to seal the frame to the radome



13) Apply a bead of silicone around the hatch frame and radome to form smooth seal between surfaces



14) Correct orientation of the hatch into the frame



15) Insert the hatch into the frame and close the catches to ensure hatch is securely seated

Finished hatch modification

Note:

- Normal catch colour is White
- Note catch location will vary by model and size