

INSTALLATION INSTRUCTIONS

TRANSTRIKE + ULTRAGUARD LIGHTNING DIVERTER STRIPS



Excellence in Aerospace since 1943

Transtrike Diverter Strips may be used to provide lightning protection of radomes, canopies, tip tanks, and any other plastic or fiberglass surfaces.

MATERIALS REQUIRED

1. Select Transtrike Diverter Strips to be installed
2. Select Termination.
3. Flexible Non-Conductive Epoxy Kit. DG PN 15348 (one kit for each 30 feet of diverter Strip to be installed).
4. Cheesecloth
5. 100 grit aluminum oxide sandpaper
6. Isopropyl alcohol or M.E.K.
7. Masking tape
8. Multimeter
9. Brush (1/2")
10. Megohmmeter (500V)
11. Rubber Roller DG PN 16470 (Adhesive Backing Method only; see below)

REQUIRED FACILITIES

The installation should be performed inside. Any moisture on the surfaces will severely hamper the adhesive bonding process.

SURFACE PREPARATION

Prepare the surface area of the desired mounting location. Clean area with cheesecloth dampened with M.E.K. or isopropyl alcohol. DO NOT flood surfaces, as this may damage the finish.

PREPARATION

Position strip on mounting surface to determine length. Cut to correct length.

APPLICATION

Epoxy Method

Mix flexible epoxy kit (PN 15348) and brush onto backside of the Strip.

CAUTION: ONCE EPOXY KIT IS MIXED, WORKING TIME IS APPROXIMATELY 45 MINUTES.

Position strip and apply sufficient pressure on strip to obtain a continuous extrusion of adhesive at edges. Excessive extruded adhesive should be removed leaving a faired fillet on edges. This can be accomplished by wiping the edge of the strip with dry cheesecloth. No voids are allowed under the strip. Masking tape is recommended for holding the diverter strips in position while the adhesive cures. Adhesive should cure a minimum of 24 hours at 70°F - 80°F. Remove masking tape after adhesive has cured. Check again for voids along strip edges. Apply additional adhesive as necessary.

Adhesive Backing Method

Transtrike is also available with a pressure-sensitive adhesive backing already installed on the Strip. To install this version of Transtrike, begin by peeling off the paper backing from one end and firmly press the Transtrike onto the mating surface, applying firm, uniform pressure across the diverter strip, and avoiding wrinkles or air entrapment. Use roller (PN 16470) to apply pressure over the entire bonded area. Allow the self-adhesive Transtrike to cure at

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60°F - 90°F for 24 hours minimum. Accelerated cure can be accomplished by using a heat gun or heat lamp at 150°F maximum for one (1) hour. Curing at room temperature (72°F) for 72 hours is acceptable. If the Transtrike is terminated short of the radome nose, the forward end of the Transtrike must be cured at 150°F for one (1) hour.

GROUNDING

Termination Kit (PN 18003) is recommended for insuring a good termination capable of handling typical lightning strike current. Check resistance between termination and airframe with low voltage multimeter. Resistance should be 0.1 ohms or less. See Figure #1 for grounding instructions.

INSPECTION

After installation, check strip resistance with 500V Megger (0.25 - 10.0 megohms per foot). Installed in the recommended way, the Transtrike diverter strip is capable of handling multiple lightning strikes. Strips and terminations should be checked periodically and replaced or repaired as necessary.

MULTIPLE INSTALLATIONS

For protecting large areas, use spacing of 12 - 24 inches between strips, depending on the dielectric strength of bonding surface and the shape and closeness of the mounting surface to enclosed metal objects.

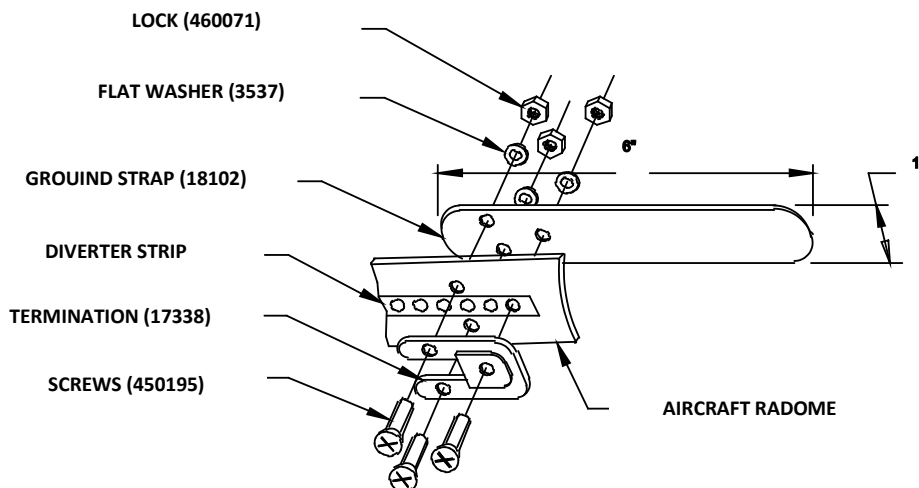


FIGURE 1- TRANSTRIKE DIVERTER TERMINATION KIT (PN 18003)*

1. Transtrike Diverter Termination Kit includes all necessary hardware to insure a good ground, capable of handling typical lightning strike currents.
2. Using Termination (PN 17338) as a drilling template, align with center hole over hole in end of strip. If diverter strip has no mounting tab, then drill center hole for termination through last segment dot on strip. Drill three (3) holes with #26 drill.

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3. Temporarily mount termination using supplied hardware. Determine where ground strap is to be mounted. Ground strap should be maintained in as straight a position as possible. Cut to desired length and drill required mounting holes. Remove sharp edges from newly cut ground strap.
4. Permanently mount termination by first applying epoxy (*) (PN 15348) to back of termination. Mount and tighten down. Remove excess epoxy with dry cheesecloth leaving a fillet around the edge to keep moisture out. Wipe epoxy off exposed segments of strip.

(*) Epoxy Kit PN 15348 is not included in Termination Kit. If required, it must be ordered separately.