



November 5, 2020

[ACLER Instructions](#)

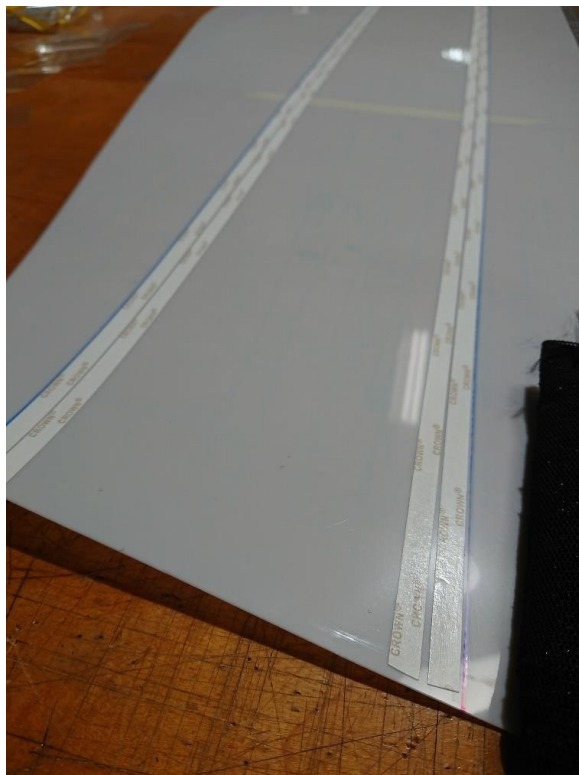
Please read through these entire instructions before beginning and be sure you understand them.

Roll one of the Mylar inserts out on a clean surface. Use sandbags or some other kind of weights to hold it down. You will be applying the ACLER panels to the back side of the Mylar inserts. Consequently, once the ACLER panels are applied, you will have a left insert and a right insert. (The Mylar inserts will be labeled 'LEFT' and 'RIGHT'.) Note for later reference that in the first two photos shown, the leading edge of the Mylar insert (the edge of the Mylar insert that will lie along the bottom of the glider's leading-edge tube once installed) is positioned towards the bottom of the photo. (For additional identification, the slits cut in the Mylar insert are cut into this edge of the insert.)



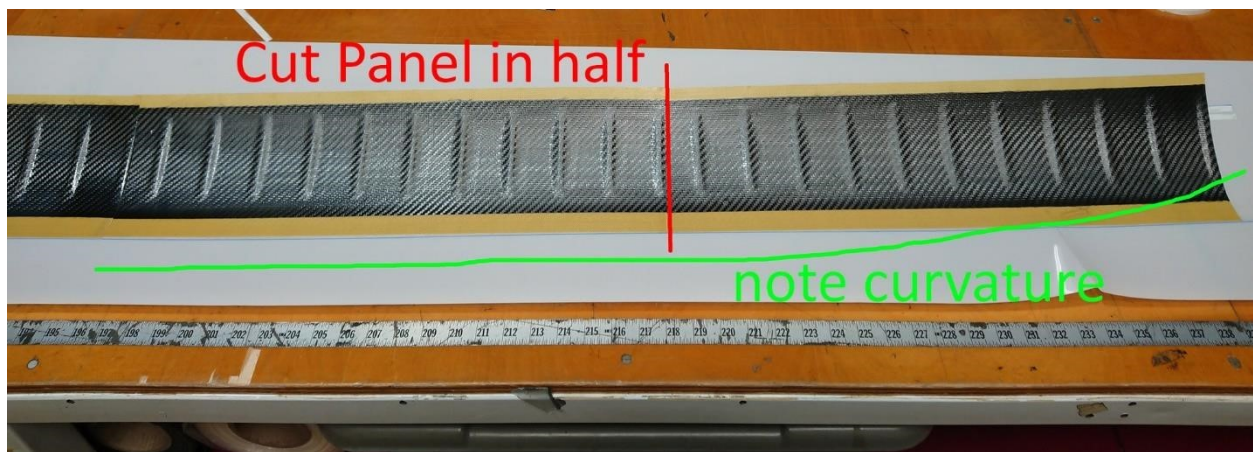
ACLER Instructions

Apply 2 rows of seam-stick along the inside of each of the marked lines – two rows inside the line nearer the leading edge and 2 rows inside the line nearer the trailing edge.



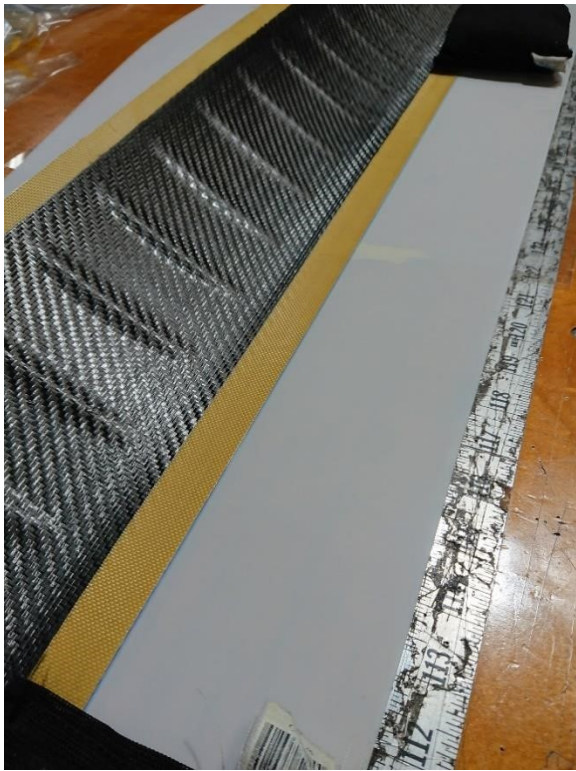
ACLER Instructions

Lay out 3 ACLER panels with the natural curve of the panel facing convex up (edges higher than the center). Cut the most outboard panel in half. This is to account for the glider's leading-edge curvature. Apply one strip of seam stick chordwise to the upward facing side of the inboard edge of each ACLER panel (as shown) where the panel will overlap the adjacent panel (or half panel).



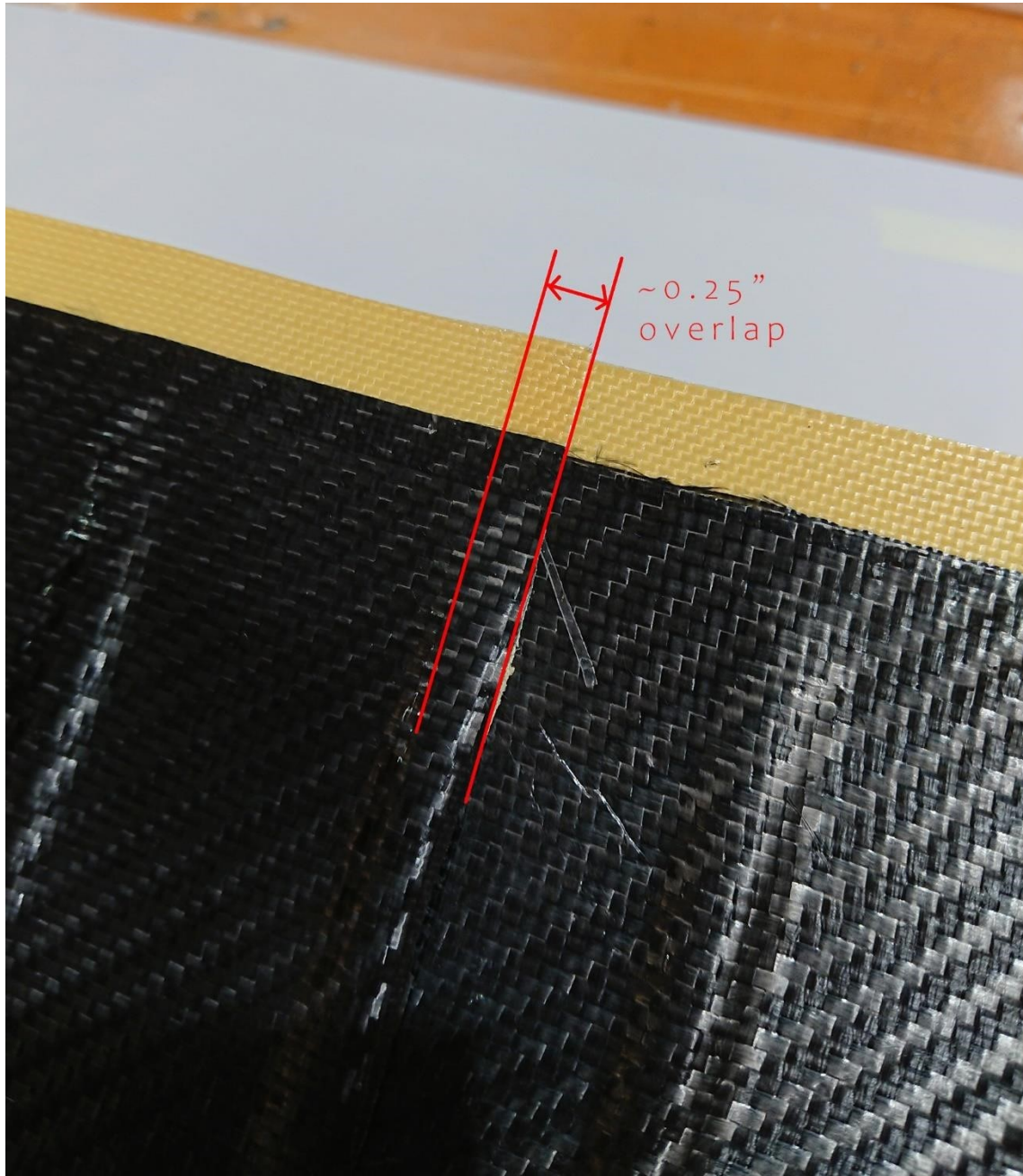
ACLER Instructions

Remove the backing paper from the two strips of seam stick closer to the leading edge. Carefully align and stick down the ACLER panels to these two rows of seamstick, such that each panel overlaps the previous by about 0.25", the width of the chordwise seam stick you have applied in the previous step.



ACLER Instructions

Remove the backing paper from the chordwise strips of seamstick you applied earlier and press the adjacent ACLER panels together along the areas of overlap.



The last panel has been cut in half to account for the curvature in the leading edge. The marked line on the leading-edge curves as you move outboard toward the tip. Attach the outboard panel halves in a way that best fits the curvature.

Remove the backing paper from the two trailing edge strips of seam stick. Carefully attach the trailing edge of the panels as follows: While holding the leading edge of the Mylar, hold tension on the trailing edge and pull up, in sort of a wraparound motion to stick the trailing edge down. Work on one panel at a time. The thing to avoid is bubbles or slack in the Mylar between the strips of adhesive. That will create a soft, squishy bubble in the finished leading edge. We want a nice firm leading edge.

ACLER Instructions

After attaching, flip it over and inspect for bubbles. Some small loose areas are to be expected, but there shouldn't be any large, soft areas where the Mylar depressed more than, say, 0.25" or so. If there are large bubble like that, pull the trailing edge of the ACLER panel up and reapply. When you are satisfied that there are no major bubbles, press the seam stick down firmly. From the front side, you can see the adhesive through the Mylar where it is pressed down and where it isn't.

