



# 1 Mount AXON Light Assembly on HPI and Eurobase

## Service Bulletin

AGL Installation Guidelines, Rev. 1, 2025/07/22



# Fixing Hardware

## Before You Start

Gather all necessary tools and equipment for installation, as detailed in the product manual.  
Ensure the shallow base is installed in accordance with the manufacturer's recommendations.

## Using the Right Fixing Hardware

---



### WARNING

Only use fixing hardware from the same type as the one originally supplied with the base or adapter ring!

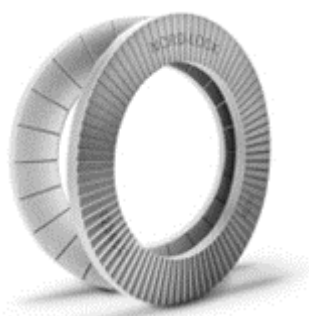
---

Since mid-2006, the shallow bases supplied by ADB Safegate include an indication of the type of thread on the bottom or flange of the base.



To determine the correct type of fixing hardware, note the following:

- M10 bolts require the use of a 17mm socket, supplied by ADB Safegate.
- Nordlock anti vibrant washers are composed of two washers facing each other. If they are separate, make sure to place them in the correct orientation.



- HPI and Eurobase bases require the use of Loctite 2701 or 638.
- Reliance bases are equipped with Helicoil screwlocks that have a polygonal spire in the middle to prevent the Bolt from unscrewing.



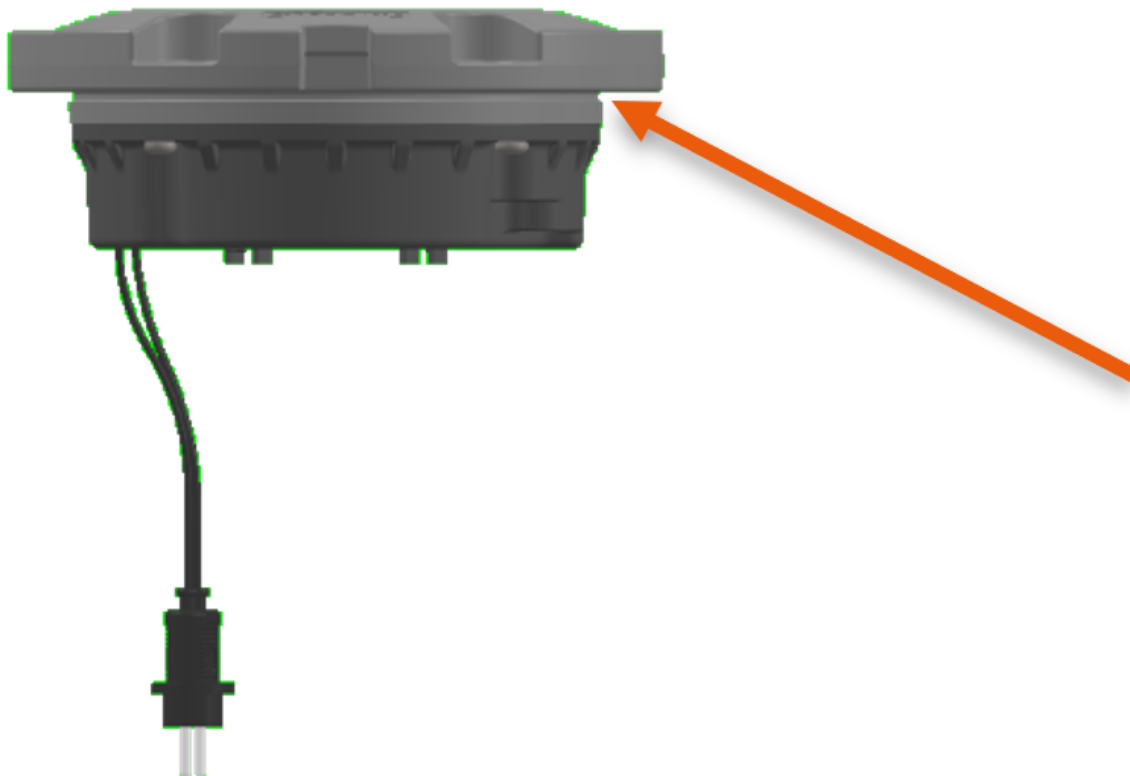
## Mount AXON Light Assembly on HPI and Eurobase

Mount and Connect the Light Assembly

| Step | Action                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |
|------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1    | Carefully clean and de-grease the contact surfaces of the light fixture and base or adapter ring, ensuring surfaces are clean and smooth.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |
| 2    | <p>In case a light has already been mounted on the base previously, ensure that the thread is clear from any debris.</p> <p>Remove old Loctite residues using a manual thread-cleaning device, size M10.</p> <p>Clean (for example with pressurized air) to make sure the threaded hole is dry and free of dirt.</p> <p>Ensure that the thread-cleaning device is correctly aligned with the thread hole. Clean the thread-cleaning device after use.</p> <p>Check the thread inside the threaded hole for damage, by using a go/no-go M10 thread gauge.</p> <div><div>GO                  NO GO</div></div> <div><div><b>CAUTION</b><p>If a solvent or oil based product has been used to clean the thread, make sure the product has been completely cleaned out. Those products could damage the o-ring.</p></div></div> |

## Step Action

- 3 If the O-ring is not installed, use a new, clean one, positioned in the dedicated groove of the light fixture.



- For AXON light with HPI base use the grey O-ring provided by ADB Safegate
- For AXON light with Eurobase use the blue O-ring provided by ADB Safegate

Never re-use an O-ring.

- 4 Do not lubricate the O-ring.



### CAUTION

"Never lubricate the gasket with silicone or any other kind of grease. Avoid the use of soap containing silicone or glycerine. "

Make sure the surface that will be in contact with the O-ring is free of any solvent or oil.

- 5 Connect the light by inserting its plug into the receptacle of either the shallow base or the secondary cable of the transformer. If applicable, connect the earth bonding to the light fixture grounding screw or lug, and torque to 2.5 Nm.

## Step Action

- 6 Gently install the light fixture; press it firmly into the adapter ring or base and ensure it is correctly seated.  
Make sure not to drop the light fixture or to pinch the secondary or ground wires between the base and light fixture.



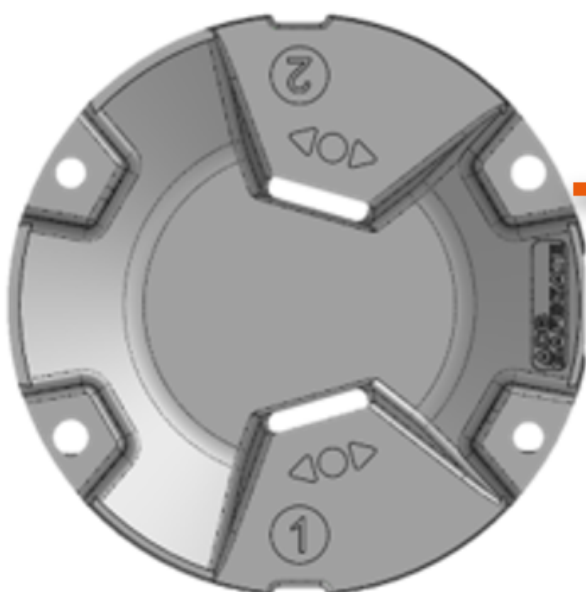
### CAUTION

Verify the contact surfaces are clean and free from debris and the light fixture is seated correctly onto the base or adapter ring.



### CAUTION

For curved lights, make sure that the logo on the top of the light is pointed towards the centre of curvature of the taxiway.



Center of  
curvature

- 7 Place Loctite 2701 or 638 on the first three threads of the bolt.  
Align the correct ADB Safegate approved bolt with the anti-vibrant washer by hand.  
Take into consideration the specific recommendations regarding safe handling and storage of Loctite 2701 or 638.  
See the Loctite 2701 and Loctite 638 Data Sheet available on the internet [www.loctite.com](http://www.loctite.com).

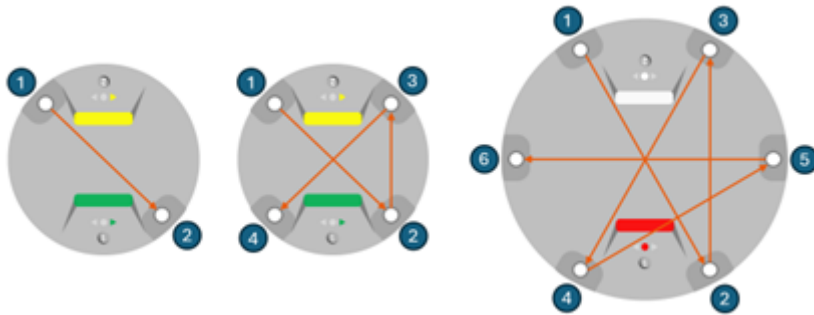


### CAUTION

Never use a high speed tool or shock wrench for tightening or untightening.

**Step Action**

- 8 Torque down the bolt using a calibrated torque wrench.  
When reaching 5 Nm switch to the next bolt following a star sequence as shown below.  
When all bolts are torqued to 5Nm continue the star sequence adding 60° of turn to each bolt until you reach the final torque of 21 Nm.  
Take additional care not to exceed 35rpm when tightening the bolt to avoid galling between the bolt and the thread.



**CAUTION**

Do not use high speed or impact tools for tightening and untightening.

- 9 Perform an additional torque check on each bolt to ensure the required torque is achieved. This also helps to seat the fitting within the base.
- 10 Ensure that the bolt and washer are flush to the light once the required torque has been achieved.

| Step | Action |
|------|--------|
|------|--------|

- |    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |
|----|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 11 | Visually inspect the installation to ensure the fixture is evenly seated in the base. Ensure all items including tools are accounted for.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |
| 12 | <p>Refer to the light fixture recommended maintenance program for optimal service life. The recommendation is based on movement area categorisation and annual air traffic movements.</p> <p>We further recommend a re-torque* of lights &amp; visual inspection 1 week after installation to check for any installation anomalies and bedding in. If inspection is successful, we recommend moving to the instruction manual recommendation. If anomalies are noted, continue with a 1 week inspection regime and investigate potential cause.</p> <p>This is a recommendation only and should be risk assessed locally and adapted according to local data driven analysis.</p> <p>We further recommend the use of a CMMS, such as ADB Safegate CORTEX Service, to electronically schedule and track maintenance and provide audit traceability and data analysis of maintenance &amp; inspection tasks in accordance with ICAO and FAA standards.</p> |



**Note**

Break loose torque may drop below the recommended torque within the 1 week. This is typically due to slight settlement following installation.



# Empowering the Airside **Evolution**

SMARTER. BETTER. **NOW.**

