

LEWMAR®

Flush Mitre Portlight Fitting Instructions

B40005 Issue 4

It is essential that the outer frame is placed squarely on the opening

When fitting a number of portlights it is advisable to prepare a template

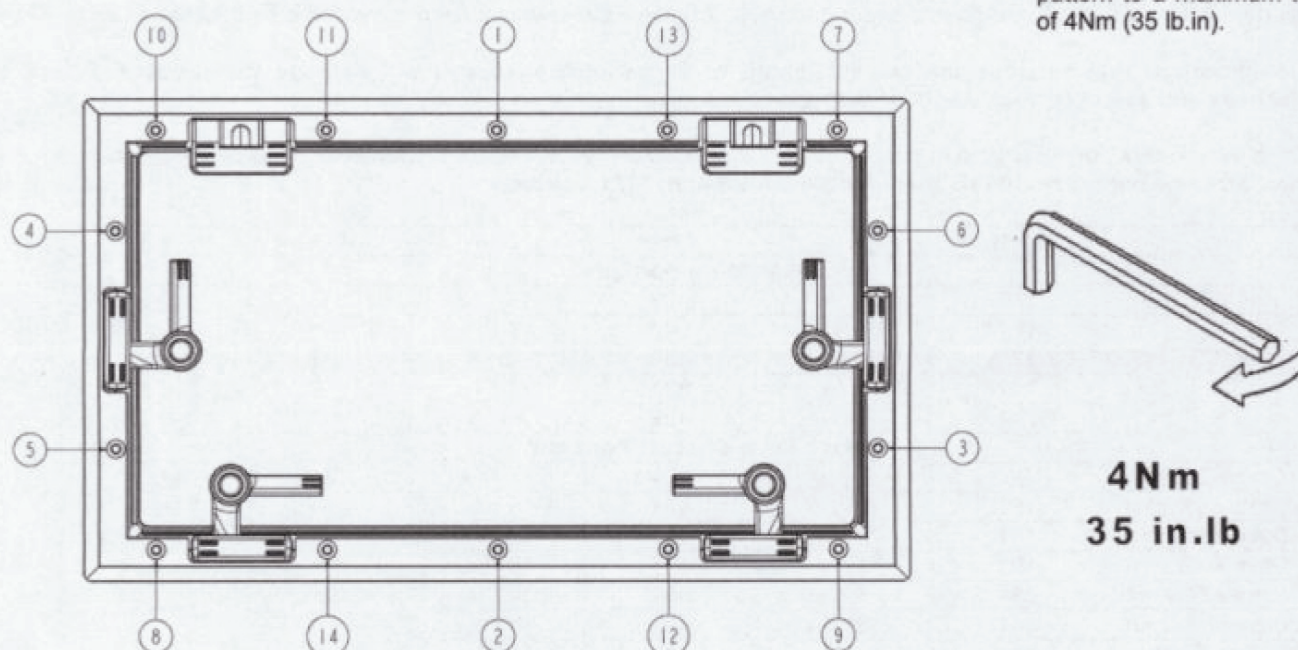
Cut out along pencil line using a suitable saw

It is recommended that openings have all burrs and sharp edges removed and exposed laminate be sealed with the appropriate material prior to fitting the product.

Portlights and Fixedlights should not be considered as stiffening members and it is recommended that the deck be adequately stiffened to prevent distortion during heavy weather.

Re-check the frame on aperture and then apply bedding compound to the channel in outer frame. Bedding compound must have good adhesive qualities (eg. silicone sealant), be a suitable grade for marine sealing applications, of 3mm minimum thickness and compressible to allow the outer frame to be pulled down in contact with the hull by the securing screws.

Position the outer unit and bolt firmly in place, lightly insert in all screws to ensure alignment then tighten following the below pattern to a maximum torque of 4Nm (35 lb.in).



Clean off surplus sealant. Always wash the Portlight or Fixedlight with soap, water and a soft cloth. Never use abrasive or solvent cleaners on the window, as this may at a later date damage the acrylic and print

Check for correct operation of the window, closing / locking operation, even pressure on the seal etc.

User Notes

Flyscreens, when fitted are located between the outer frame and seal, enabling the portlight to be closed with the flyscreen in place. See the separate sheet for detailed instructions.

Always wash the Portlight or Fixedlight with soap, water and a soft cloth.

Never use abrasive or solvent cleaners on the window, as this may at a later date damage the acrylic and print

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Lewmar Portlights & Fixedlights are for use on craft in accordance with the following standard
Modification of the product will invalidate compliance with this Directive

Size	ISO/DIS 12216:2002
601mm x 281mm -12mm	Design Cat A, Area 3
842mm x 214mm – 12mm	Design Cat A, Area 4
645mm x 190mm – 12mm	Design Cat A, Area 2B

The lower edge of product fitted in the hull AREA I should be a minimum of 600mm above the floatation plane in the crafts fully loaded ready-for-use condition, the boat being at rest in the upright condition.

Where craft are intended to be operated on 'OCEAN' or 'OFFSHORE' voyages (as defined by ISO/DIS 12216.2(E)), no part of the plate or its framing is to extend beyond the outer surface of the hull or of a built-in-fairing being an integral part of the hull.

Fitting Instructions

Lewmar Portlight and Fixedlights should be fitted to a flat surface with a maximum tolerance of +/-1mm

Hull Thicknesses	M5 x 12mm long	3.5 to 6.5mm
	M5 x 16mm long	7.0 to 9.0mm

Standard valance suit hull thickness 3.5 to 9.0mm hull thickness. Other valance types available for thicker hull up to 17.5mm

It is important that you use the correct length of screw otherwise you will damage the product. Check skin thickness and select correct length of screws.

With a pencil mark out the cut out to the recommended dimension shown below or see table in the Lewmar catalogue

Note: Sizes below are portlights manufactured from May 2021 onwards

Size	X mm	X in	Y mm	Y in	R mm	R in
Flush Mitre Portlight						
0	156	6 1/8	303	11 15/16	2.5	3/32
1	171	6 3/4	347	13 11/16		
3	171	6 3/4	429	16 7/8		
4	171	6 3/4	626	24 11/16		
5	244	9 5/8	429	16 7/8		
Flush Mitre Custom Portlight						
115mm x 322mm	96	3 25/32	303	11 15/16	5	3/16
180mm x 490mm	161	6 11/32	471	18 35/64		
150mm x 600mm	131	5 5/32	581	22 7/8		
200mm x 490mm	181	7 1/8	471	18 35/64		
270mm x 900mm	251	9 7/8	881	34 11/16		
360mm x 500mm	341	13 27/64	481	18 15/16		
300mm x 680mm	281	11 1/16	545	21 29/64		
360mm x 680mm	341	13 27/64	661	26		
338mm x 360mm	319	12 9/16	341	13 27/64		
440mm x 354mm	421	16 37/64	335	13 3/16		
Flush Mitre Fixedlight						
150mm x 600mm	131	5 5/32	581	22 7/8	5	3/16
174mm x 423mm	155	6 7/64	404	15 29/32		
193mm x 648mm	174	6 35/64	629	24 49/64		
240mm x 700mm	221	8 45/64	681	26 13/16		

