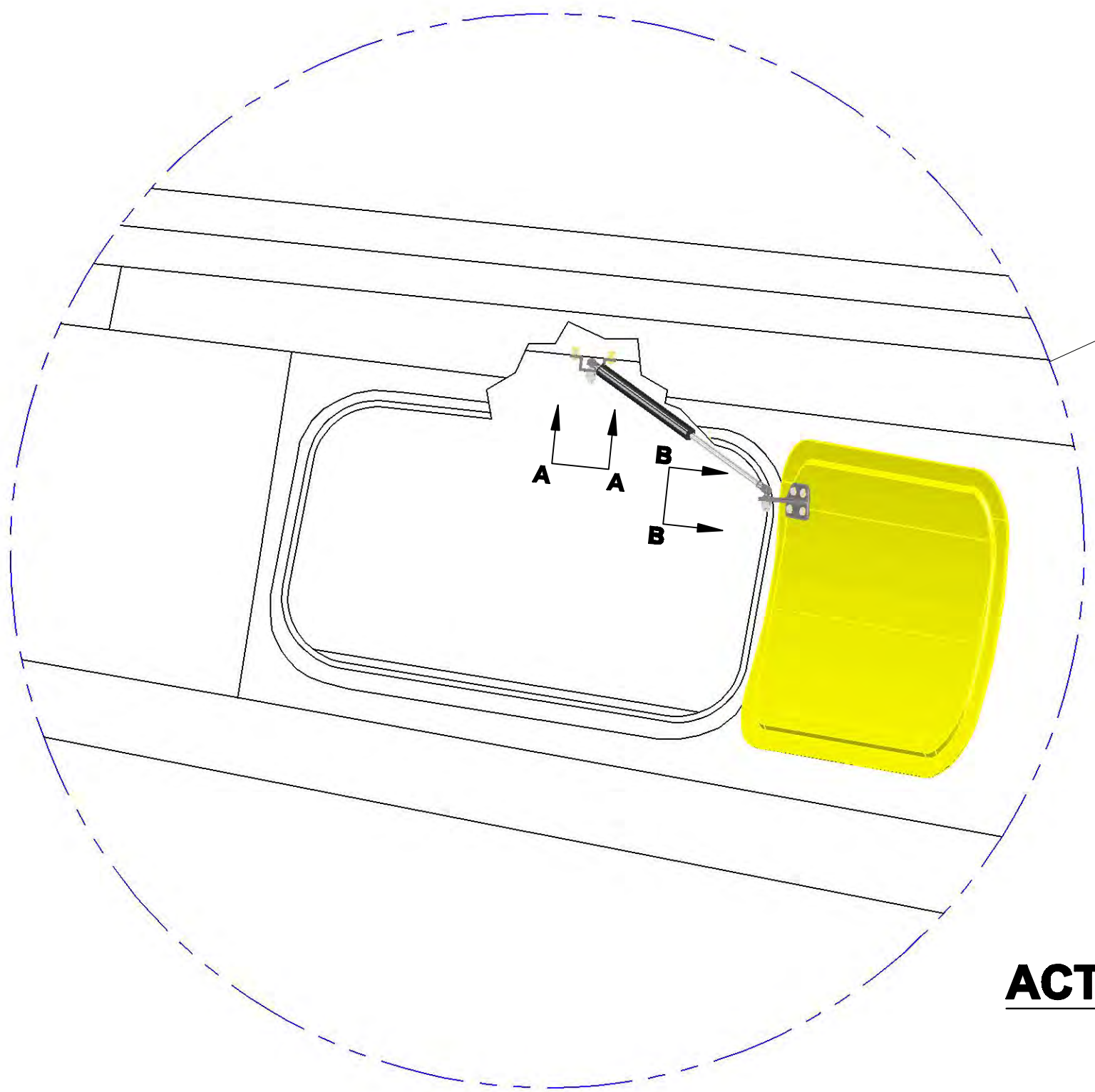
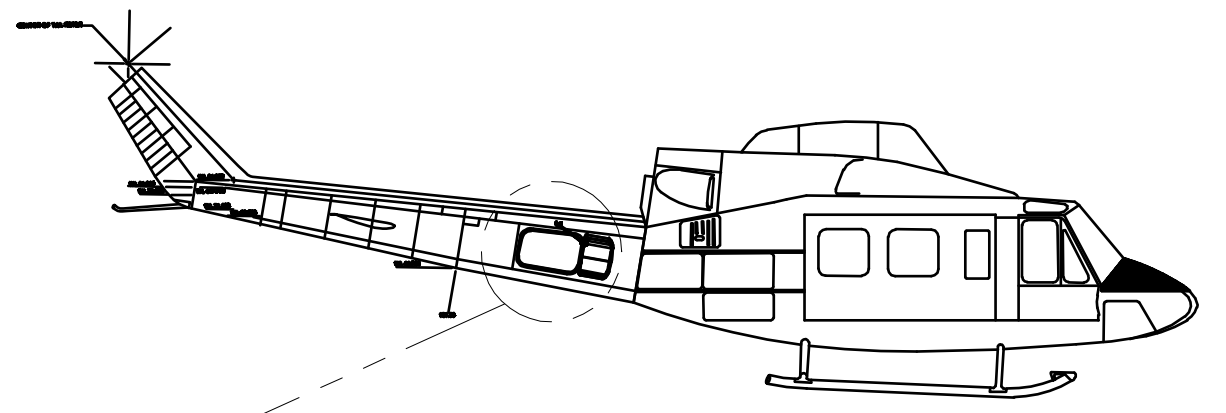


REV	ZONE	DESCRIPTION	DATE	DRAWN	APP



ACTUATOR KIT INSTALLATION AREA

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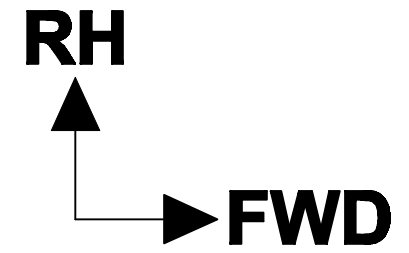
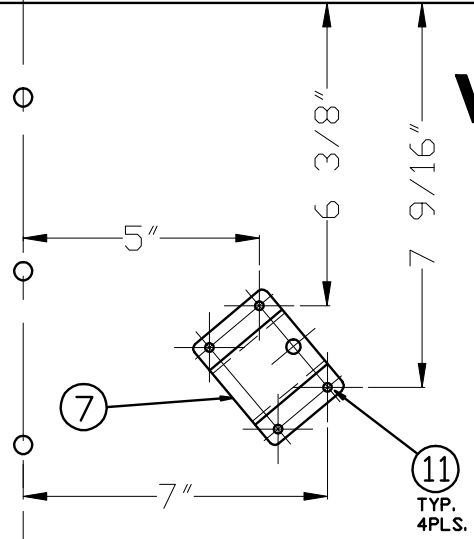
DWG SIZE B	FILE NO.	DWG NO. HF-412-I-5230-01
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REV	ZONE	DESCRIPTION	DATE	DRAWN	APP

DOOR OPENING

VIEW LOOKING UP

LOCATE & ORIENTATE BRACKET AS SHOWN. MATCH DRILL TO LOCATE HOLES FOR INSERTS. INSTALL INSERTS (SEE INSERT INSTALLATION PROCEDURES PG.6)



BOOM
STA. 59.50

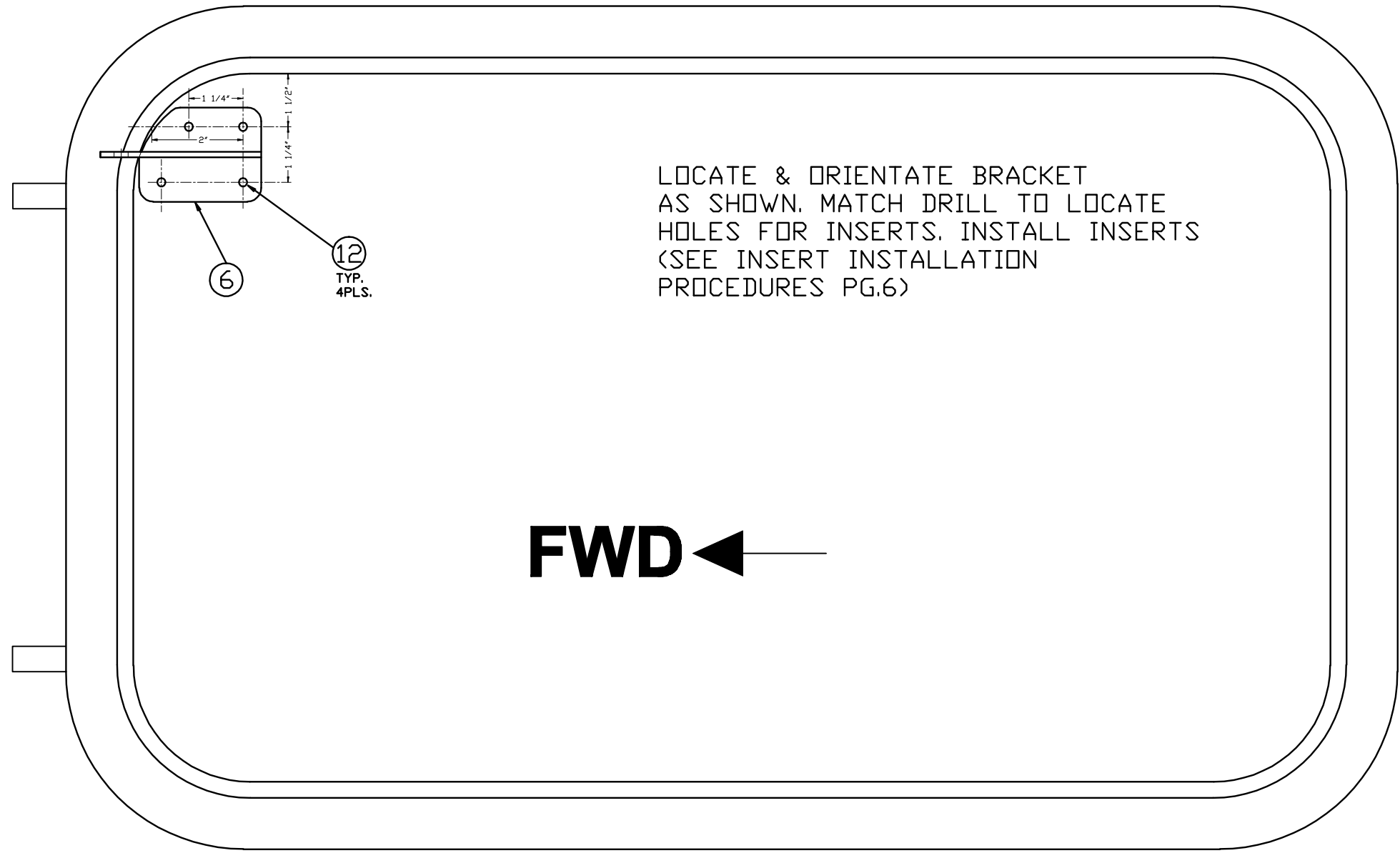
VIEW AA - CEILING BRACKET INSERT LOCATION

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LOCATE & ORIENTATE BRACKET AS SHOWN. MATCH DRILL TO LOCATE HOLES FOR INSERTS. INSTALL INSERTS (SEE INSERT INSTALLATION PROCEDURES PG.6)

FWD ←

**VIEW BB - DOOR BRACKET INSERT
INSTALLATION LOCATION**

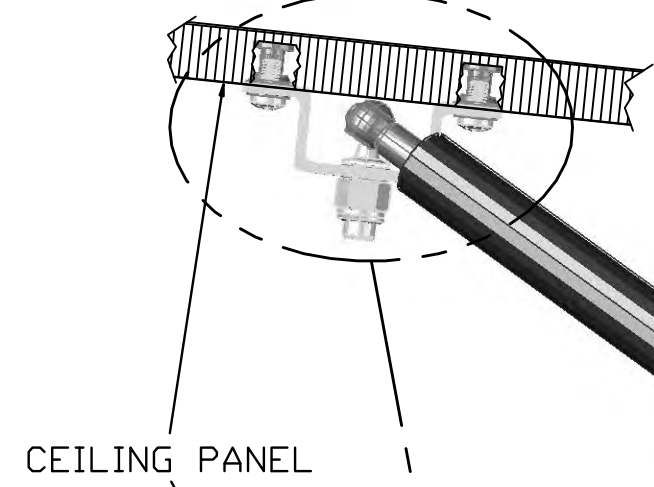
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HELIFAB

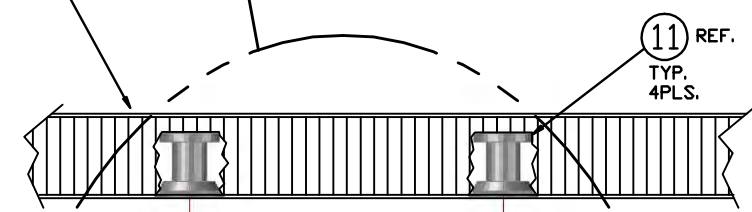
DWG SIZE B	FILE NO.	DWG NO. HF-412-I-5230-01
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REV	ZONE	DESCRIPTION	DATE	DRAWN	APP

ASSEMBLED DOOR ACTUATOR

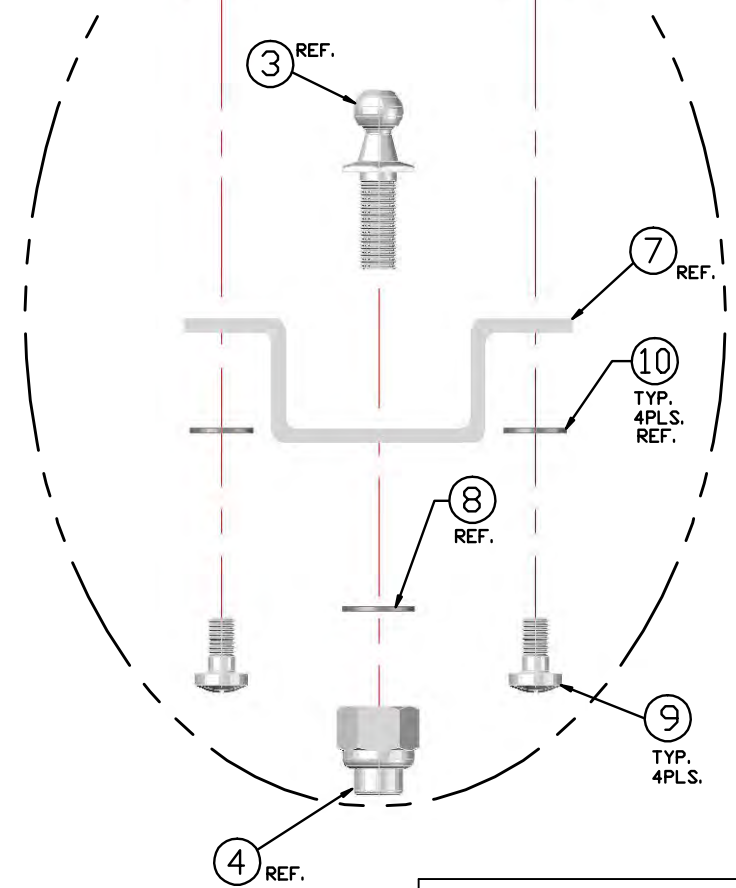


CEILING PANEL



11 REF.
TYP.
4PLS.

3 REF.



7 REF.

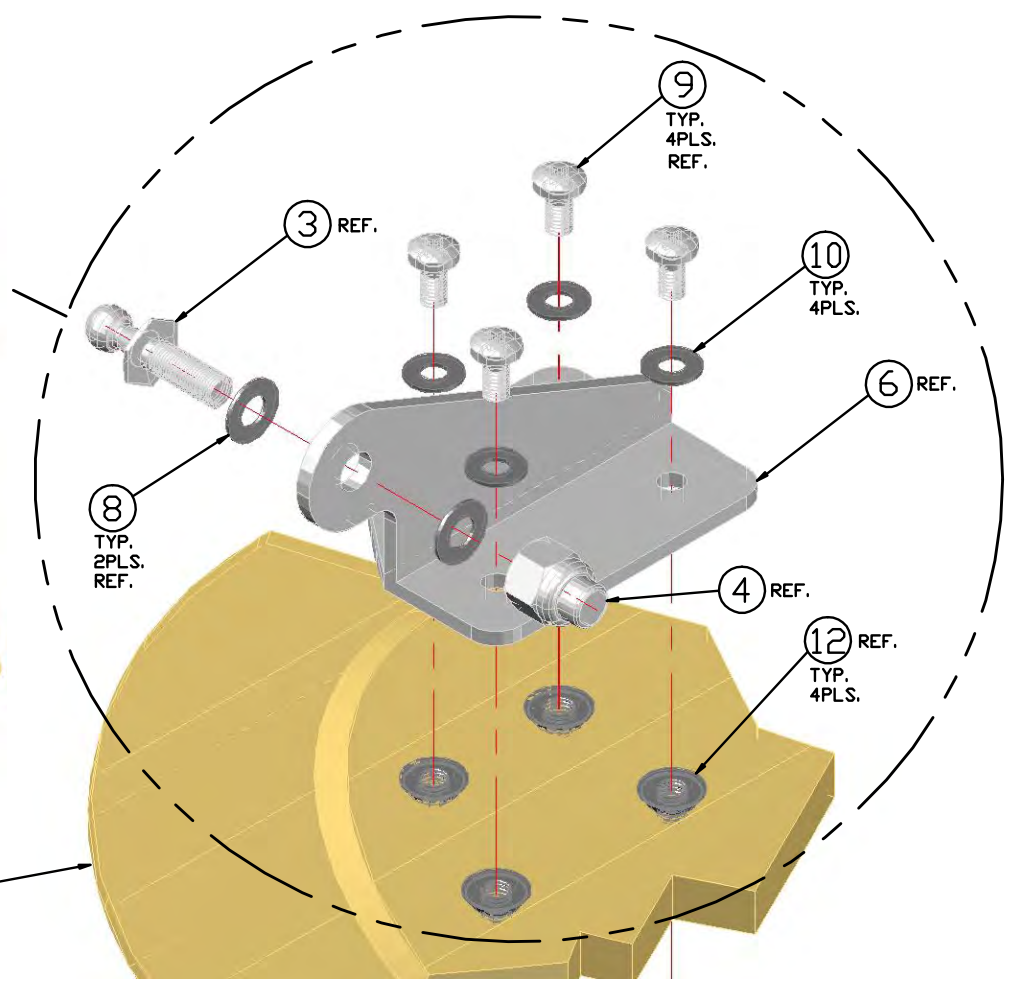
10 TYP.
4PLS.
REF.

8 REF.

9 TYP.
4PLS.

4 REF.

BAGGAGE DOOR



9 TYP.
4PLS.
REF.

3 REF.

10 TYP.
4PLS.
REF.

6 REF.

8 TYP.
2PLS.
REF.

4 REF.

12 REF.
TYP.
4PLS.

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INSERT INSTALLATION PROCEDURES

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CAUTION: Before using solvents, extinguish all flames and pilot lights. Keep product and its vapors away from heat, sparks and flame. During application and until vapors are gone, avoid using spark producing electrical equipment such as switches, appliances etc. AVOID prolonged breathing of vapors and repeated contact with skin.

CAUTION: Avoid overheating the skins during the drilling operation. Overheating may cause bond separation between the skin and core.

CAUTION: Care must be taken not to damage or drill through the back face of the panel.

INSERT PREPARATION

Prior to bonding, inserts shall be prepared as follows:

- Solvent clean inserts by soaking in Methyl-Ethyl-Ketone or RHO SOLV756.
- Air dry for a minimum of 15 minutes.
- Wear gloves when handling clean dry inserts.

INSTALLATION OF INSERTS

Inserts shall be installed in the following manner:

Identify insert locations and drill hole to a diameter of 0.469/0.474, ensuring that drilling is through panel face and core only. Undercut honeycomb core .10" to .25" (measuring from the edge of the hole) using caution not to damage interior surfaces of the panel skins. The tools used to prepare the holes shall be clean to avoid contaminating the area of insert installation. Debris from the drill and cutting operation shall be removed prior to installing the insert.

CAUTION: Removal of excess core may cause air entrapment (bubbles) when the adhesive is injected.

Deburr hole in face sheet. and dimple (metal face sheet) or countersink (composite face sheet)

Apply adhesive (Table 1) to the flange of the insert. Install insert while the liquid adhesive is within its pot life time. Care shall be used to insure proper alignment and to avoid trapped air or incomplete fill within the potted area.

Inject potting adhesive into only one of the drilled injection holes until a steady flow of adhesive is flowing from the other hole.

NOTE: Air pressure shall not exceed 40 psi when injecting adhesive.

Remove excess adhesive.

REMOVAL OF EXCESSIVE ADHESIVE AND SEALING

The excessive adhesive squeeze-out extruding from the potted areas shall be removed before curing. This excess and any adhesive that may have collected on the surface outside the bond region shall be cleaned off using cheesecloth moistened with MEK. All pinholes/unfilled areas shall be sealed to preclude fluid entry into the core or panel interior.

CURING SCHEDULE

Temperature Cycle and Time Range. Temperature cycles and times are specified in Table 1. When heat is required for curing the adhesive, timing shall start after the bondline reaches curing temperature. Heat for curing may be attained from any properly regulated source i.e., heat lamp, infrared source, etc.

VISUAL INSPECTION OF INSERTS

Potted inserts shall be visually inspected for pinholes and unfilled areas around the perimeter of the insert head and/or injection holes. All visible inholes/unfilled areas shall be filled with an adhesive to assure that the panel is sealed against moisture/fluids.

TABLE 1. ADHESIVE DATA

			STANDARD CURE CYCLE		ALTERNATE CURE CYCLE	
ADHESIVE NAME/#	MIXING RATIO RESIN/CATALIST BYWEIGHT	POT LIFE	TIME (MINUTES)	TEMP. (°F)	TIME MINUTES	TEMP. (°F)
EA 934 NA	100 PARTS A TO 33 PARTS B	30-40 MINUTES	7 DAYS	70-90	60-70	170-190
MANOBOND 6398	100 PARTS A TO 27 PARTS B	40 MINUTES	7 DAYS	70-90	60-70	170-190

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REV	ZONE	DESCRIPTION	DATE	DRAWN	APP

GENERAL NOTES:

1. FASTENER INSTALLATION SHALL BE IN ACCORDANCE WITH FAA ADVISORY CIRCULAR NO. AC 43.13-1B.
2. ALODINE PROCESS - APPLY CHEMICAL FILM TREATMENT AS PER MIL-C-5541.
3. FINISH - APPLY PRIMERS AND PAINT FINISH PRODUCT ACCORDING TO MANUFACTURER'S INSTRUCTIONS. PRIMER AS PER MIL-P-23377.
4. ALL RIVETS EQUALLY SPACED BETWEEN END RIVET UNLESS OTHERWISE SHOWN, QUANTITY AS SHOWN OR NOTED. EDGE DISTANCE 0.38" TYPICAL.
5. EDGE DISTANCE:
 - UNIVERSAL HEAD - 2 TIMES SHANK DIAMETER
 - COUNTERSUNK HEAD - 2 1/2 TIMES SHANK DIAMETER
 - UNLESS OTHERWISE SHOWN
6. UNLESS OTHERWISE SPECIFIED BREAK ALL SHARP EDGES 0.015 X 45° OR .015R
7. TOLERANCES:
 - (DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED)
 - TOLERANCES ON DECIMALS XXX + 0.010 XX + 0.03 X + 0.1 ANGLES + 2
 - ALL FRACTIONS + 1/16"
8. RIVET, SCREW, AND BOLT QUANTITY MAY BE INCREASED TO PICKUP EXISTING SHIP RIVET LOCATIONS.
9. HOLE SIZES AS FOLLOWS:
 - MS20427M4-* RIVET - DRILL .128 DIA. - LENGTH TO SUIT APPLICATION.
 - MS20426AD4-* - DRILL .128 DIA. - LENGTH TO SUIT APPLICATION.
10. RIVET SPACING 0.9" TO 1.3" UNLESS OTHERWISE SPECIFIED.
11. CAUTION: APPLICATION OF EXCESSIVE PRESSURE WHEN DRILLING AND RIVETING MAY DEFORM SKIN RESULTING IN UNACCEPTABLE SKIN WAVINESS.
12. ALL BEND RADII SHALL BE IN ACCORDANCE WITH AC 43-13-1B TABLE 4-6 UNLESS OTHERWISE SPECIFIED.
13. INSERT INSTALLATION SHALL BE ACCORDANCE WITH AA-PS-0001.
14. EDGE FILL EXPOSED EDGES OF PANELS WITH FILLER ATR-1000. UNDER CUT CORE APPROXIMATELY 0.5"
15. HARD POINT PANELS BY DRILLING REQUIRED HOLE THROUGH PANEL. UNDERCUT CORE APPROXIMATELY 0.5" AND FILL VOID WITH 6398 ADHESIVE. REDRILL TO REQUIRED HOLE SIZE IF REQUIRED.
16. ALL WELDS PER MIL-STD-2219.
17. INSTALL USING MIL-S-8802 TY II CL B-2 PROSEAL.

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