

No: 000164

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Send To: 915 CANOPY KIT

B-0021
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T

Subject: PARTIAL ASSEMBLY OF 915
CANOPY KIT IN PREPARATION
FOR FIELD INSTALLATION OF
KIT BY CHRISTEN PERSONNEL

As you may have been advised in a previous product letter, we intend to make field installations of the first 10 or 15 915 Canopy Kits to check the accuracy and completeness of the product manual procedures. Your kit may be included in this field installation group.

To speed the field installation procedure, we are sending to you several parts for immediate installation on your aircraft. Please refer to Engineering Sketches 90119 and 90120 and perform the parts installation as follows:

1. Mark and cut out the notches on the right side cockpit coaming as shown in Engineering Sketch X-90119.
2. Install the 30909-001 panel and 30910-001 panel by inserting the top edge of the panel between the fuselage longeron and the cockpit coaming and by aligning the bolt hole near the bottom of the panel with the bushing welded to the adjacent fuselage member.
3. Mark and cutout a 3/8 inch deep notch in the 30910-001 panel to match the cut-out in the cockpit coaming.
4. Trim both ends of the 31197-001 front seat cover for a snug fit between the cockpit coamings.
5. Mark and drill a clearance hole near each end of the top surface of the front seat cover in alignment with the bushings in the fuselage cross member.
6. Drill and dimple 6 screw holes in the front surface of the seat cover to match the existing attachment holes along the top of the front seat.
7. Adhere the placards to the panels and seat cover by peeling back the protective paper from the rear surface of the placard a little at a time while pressing firmly to eliminate bubbles. Do not disturb the paint mask coating on the front surface of the placards.
8. Prime and paint parts with the placards in place. When the paint is dry, remove the mask coating using a sharp pointed tool or tweezer to catch the edge of the mask coating. Peel back the mask coating slowly, and if any air bubbles appear on the placard surface, puncture the bubble with a sharp needle and allow air to escape.

To prepare for the field installation by Christen personnel, have the follow-

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ing items available:

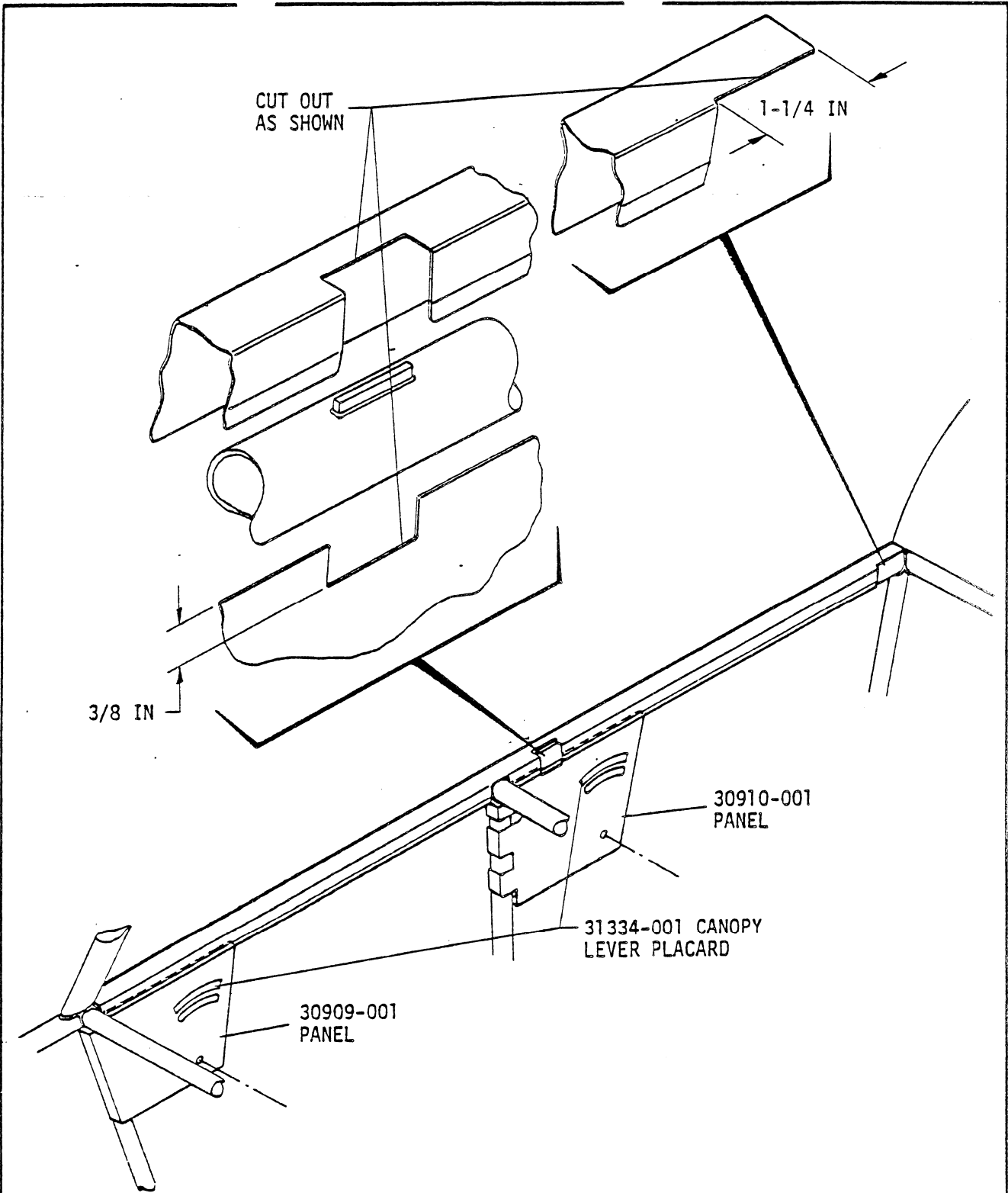
1. Workbench with vise
2. 110 VAC electrical outlet
3. Air supply, 80 psi minimum
4. If possible, 8 heat lamps with electrical connections and a means of mounting. These will be used to speed curing of adhesives used in the installation.


Prepare your aircraft for the canopy installation by removing all of the side panels adjacent to the front and rear cockpit areas, except the left rear panel which should be left in place with only a few screws. Also remove the spacer band which runs along the top of the instrument panel between the panel and the cabane area cowling panel. Keep the spacer readily available.

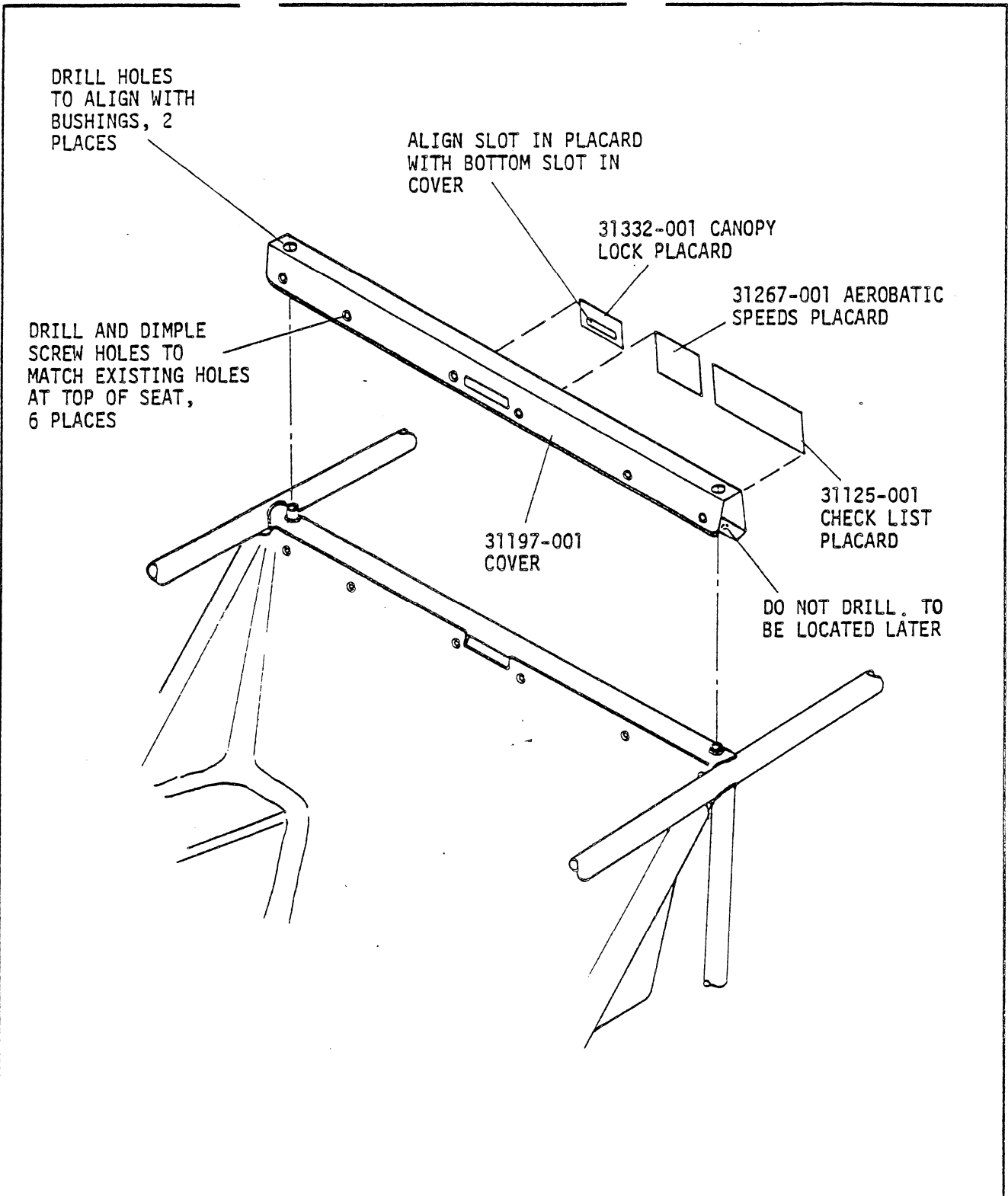
We will telephone you as soon as possible to arrange a mutually convenient time for the field installation of your canopy kit.



Enclosures:

- 1 ea X-90119 Engineering Sketch
- 1 ea X-90120 Engineering Sketch
- 1 ea 30909-001 Panel
- 1 ea 30910-001 Panel
- 1 ea 31197-001 Cover



UNLESS OTHERWISE SPECIFIED: TOLERANCES: FRAC. $\pm 1/64$ DEC. XXX $\pm .005$ ANGLES $\pm 0^{\circ} 30'$ DIMENSIONS IN INCHES DO NOT SCALE DRAWING	MATERIAL AND CONDITION NOTED			CHRISTEN  CHRISTEN INDUSTRIES HOLLISTER, CALIFORNIA		
	FINISH NONE					ENGINEERING SKETCH
	DRAWN BY I. CLEDE	DATE 5-12-80	PROJECT EAGLE II AIRCRAFT	TITLE CANOPY PANELS INSTALLATION		
	APPROVED BY <i>[Signature]</i>	DATE 5-13-80		CODE X-90119	NO. X-90119	ISSUE



UNLESS OTHERWISE SPECIFIED: TOLERANCES: FRAC. ± 1/64 DEC. XXX ± .005 ANGLES ± 0° 30' DIMENSIONS IN INCHES DO NOT SCALE DRAWING	MATERIAL AND CONDITION NOTED			CHRISTEN  CHRISTEN INDUSTRIES HOLLISTER, CALIFORNIA		
	FINISH NONE					
	DRAWN BY I. CLEDE	DATE 5-12-80	PROJECT EAGLE II AIRCRAFT		TITLE SEAT COVER INSTALLATION	
	APPROVED BY 	DATE 5-13-80			CODE NO. X- 90120	ISSUE