

No: 000302

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By: FLC Date: 04-05-83 Page: 1 of 2

Send To: 904 FUSELAGE KIT

C ** AFFIX LABEL HERE **

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TSubject: REVISION OF FUSELAGE AND
CANOPY AFT HINGE MODIFI-
CATION PROCEDURE IN
PRODUCT LETTER 000295

When modifying the canopy aft hinge stud in accordance with the procedure in the subject product letter, several builders have found that the resulting drilled hole was not parallel to the axis of the hinge stud base. This resulted from not having the drill guide installed properly prior to drilling due to the presence of paint on the stud base. The instruction procedure did not account for the possible requirement to remove paint to ensure proper positioning of the drill guide. The procedure has been modified as follows and a copy of Revision C of Engineering Sketch X-90136 is attached.

For modification, refer to Engineering Sketch X-90136 and to Step D-2 of the 915 Canopy Kit product manual:

1. Jettison the canopy if it has been installed.
2. Remove the right seat back and armrest if it has been installed.
3. Remove the rear hinge assembly if it has been installed.
4. With a fine-blade hacksaw, carefully cut off the canopy hinge support stud at its shoulder without removing any material from the shoulder. File away any remaining stud portion smooth and flush with the shoulder, removing a minimum of material from the shoulder.
5. Scrape all paint off all surfaces of the stud base.
6. Slide the 30455-001 drill guide over the stud base toward the rear of the fuselage UNTIL THE INTERNAL SHOULDER OF THE GUIDE IS AGAINST THE FRONT FACE OF THE STUD BASE. Clamp the guide in position with a small C-clamp.
7. Using the drill guide, carefully drill through the center of the stud base with the 50227-058 (3/16" dia) drill. To ensure a straight and parallel hole, hold the drill without lateral or twisting forces on the sides of the drill guide. Apply and release drilling force alternately to clear drill cuttings. Use a lubricating or cutting oil on the drill while drilling.
8. Clean, prime, and repaint the stud base, as appropriate.
9. If the canopy was installed previously, reinstall it using the 50068-022 bolt, 50070-019 washer, and 50287-001 castle nut for the rear hinge

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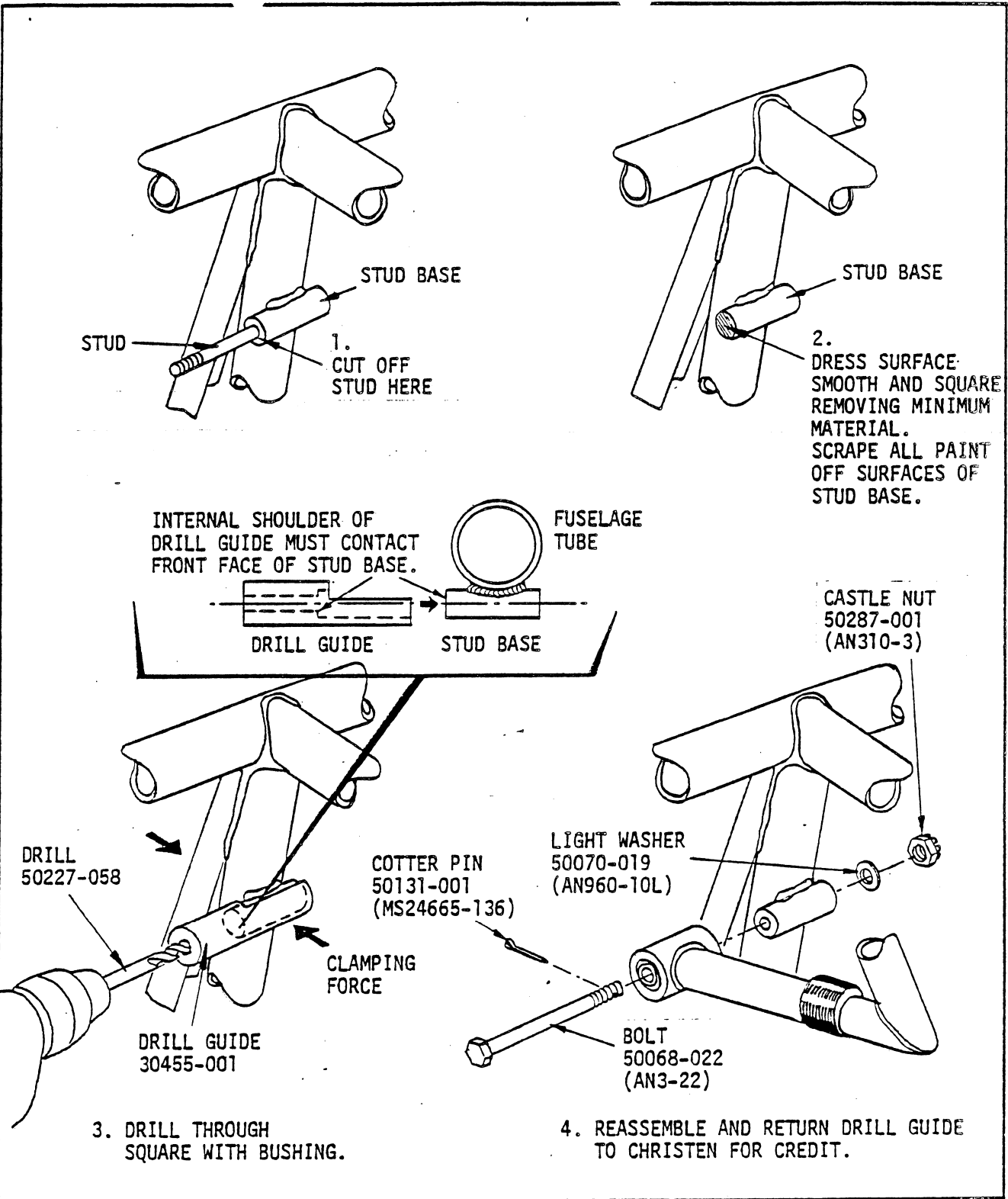
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attachment. Tighten the nut securely to seat all bearing parts, then loosen the nut slightly to allow free rotary bearing movement with moderate drag but with no axial play.

10. Secure the castle nut in its adjusted position with the 50131-001 cotter pin. Clinch the prongs of the cotter pin if the aircraft has been completed (through 923 Kit), or spread the prongs only slightly to keep the pin in position, but to allow removal later during remaining construction.
11. Reinstall all rear seat and canopy components as appropriate.

Enclosure:

Engineering Sketch X-90136, Rev. C



UNLESS OTHERWISE SPECIFIED: TOLERANCES: FRAC. \pm 1/64 DEC. XXX \pm .005 ANGLES \pm 0° 30' DIMENSIONS IN INCHES DO NOT SCALE DRAWING	MATERIAL AND CONDITION		 CHRISTEN INDUSTRIES HOLLISTER, CALIFORNIA		
	NOTED				
	FINISH		ENGINEERING SKETCH TITLE AFT CANOPY PIVOT REPAIR		
	NONE				
DRAWN BY	DATE	PROJECT	CODE	NO.	ISSUE
I. CLEDE	8-21-81	EAGLE II AIRCRAFT	PA	X-90136	C
APPROVED BY	DATE				
<i>[Signature]</i>	8-22-82				