

Accessory Kit No. AK-113B

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DATE: December 17, 1974

TITLE: Cockpit Vent Accessory Kit

MODELS AFFECTED: AAL-0015 thru AAL-0459

WEIGHT AND BALANCE CHANGE:

Weight Increase: .38 lb.

Arm: 79.00 in.

Parts List

<u>Quantity</u>	<u>Part Number</u>	<u>Description</u>
2	804036-1	Scoop
2	901049-1	Fresh Air Valve
2	804036-2	Seal
1	102371-1	Canopy Stop
1	102371-2	Canopy Stop
4	1601-0410	Rivet (Avex)
6	AES1021Z6-8C	Screw
6	A1181-6Z-1	Nut
2	803007-34	Placard

Description of Installation

1. Installation of fresh air scoop, air valve and related attaching hardware.
2. Installation of extensions on canopy aft stops.
3. Estimated time to accomplish this installation is two (2) man hours.

Installation Instructions (Refer to figure 1)

Installation of canopy stop extensions as follows:

1. No upholstery panels need to be removed for installation of new stops.
2. Extended stops to be installed on inside of original stops with extended portion of stop facing forward and bead of extended stop facing inward.
(Note: These stops are not needed on AAL-0190 thru AAL-0459.)
3. Line up extended stop over original stop and mark hole centers by using holes in extended stop as guide.
4. Drill .136/.139 dia. holes (2) in each original stop. Drilling should be done from inside of aircraft. Care should be taken not to hit canopy glass with drill bit as hole is drilled.
5. Using "pop" rivet tool (United Shoe Machinery, Part No. PRG410 or equivalent), install extended stops as shown in figure 1 using (2) 1601-0410 rivets per stop.

NOTE: Revision "B" adds AAL-0459 as ending serial.

Installation of Fresh Air System as follows:

1. Place masking tape over inside and outside of lower front corners of canopy.
2. Locate holes as shown in figure 2. (Mounting holes can be located using valve for template after 2" hole is made.)
3. Carefully drill holes. (2" hole saw with slow turning 1/2" drill may be used for large hole.)
CAUTION: Excess pressure can cause cracking of canopy.
4. Remove masking tape from inside and outside and deburr holes very carefully.
5. Locate 804036-1 scoop, 804036-2 seal and 901049-1 valve with scoop facing forward, valve facing aft and (3) holes in above items lined up per figure 1. (Note: Scoop to be installed outside of aircraft and valve inside of aircraft.)
6. Install AES1021Z6-8C screws from valve side and A1181-6Z-1 nuts on scoop side.
7. Tighten screws just enough to draw nuts flat against scoop flange.
CAUTION: Overtightening of screws can cause cracking of canopy and valve.
8. Clean exterior surfaces of scoops with iso-propyl alcohol and install 803007-34 placards.
9. This completes installation.

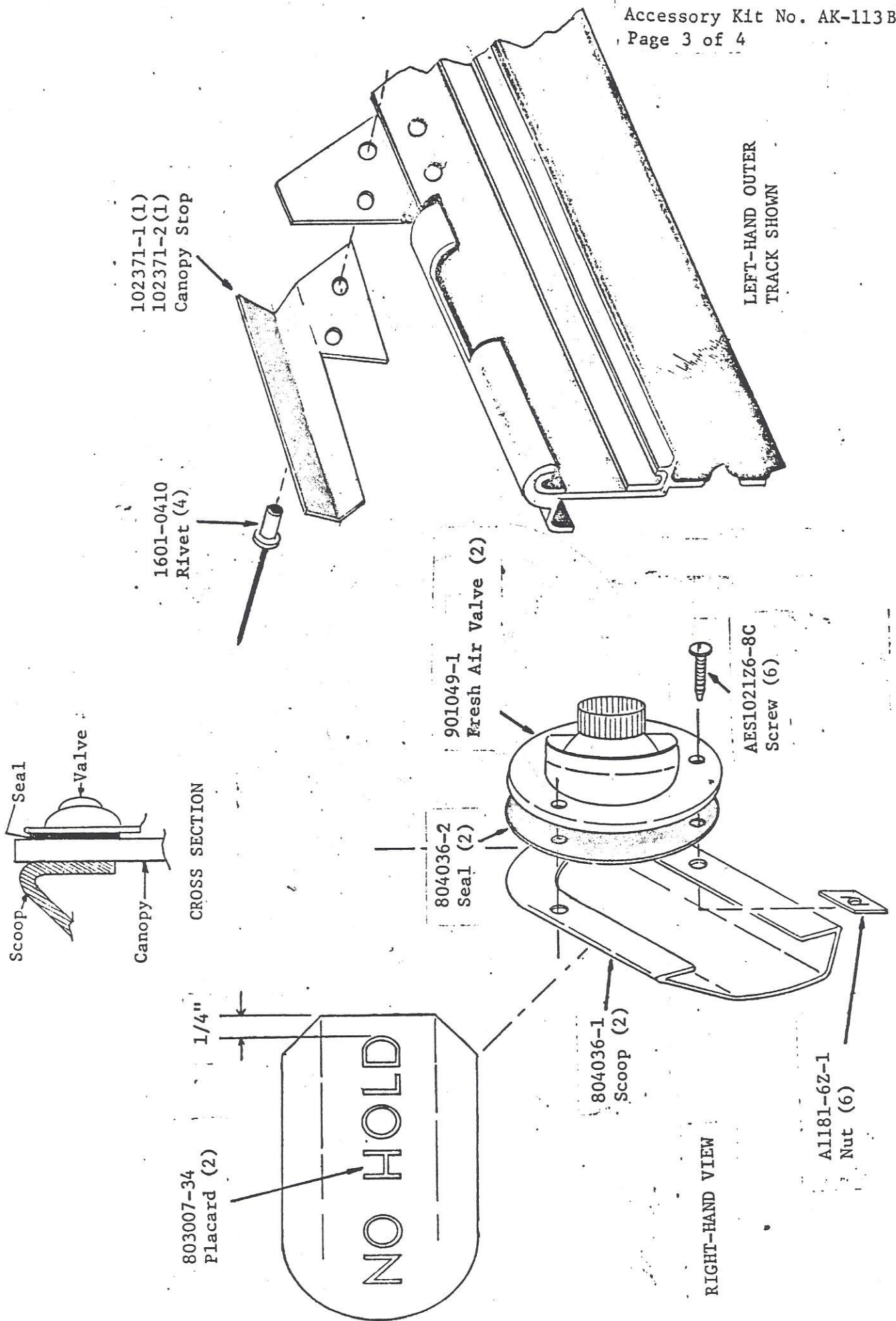


FIGURE 1

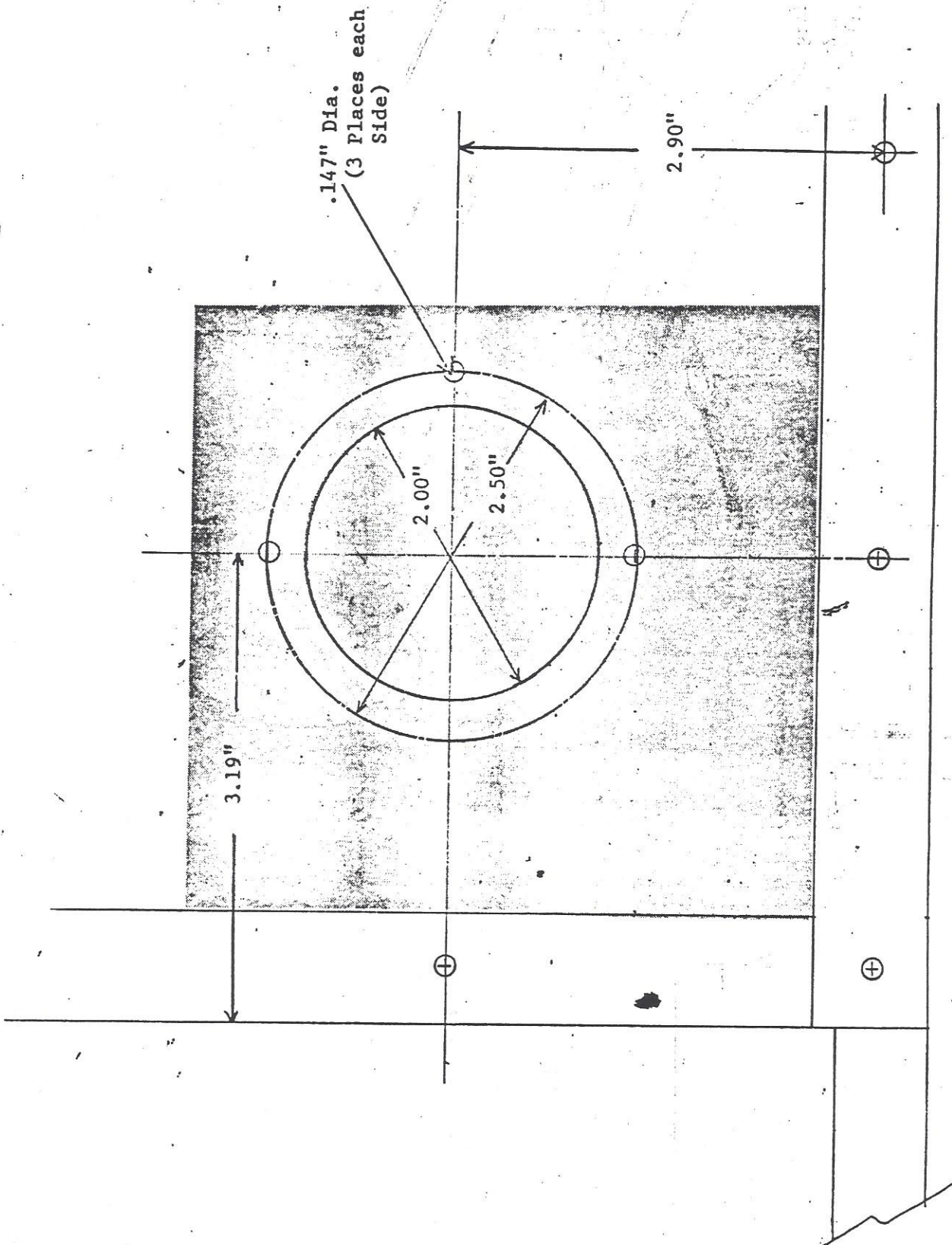


FIGURE 2