



Pre-Paint>Fuselage>Underbody penetrations

Issue Revision Table

Issue	Date:	Change(s):	Issued by:
1			
2			
3	5/07/2021	Adopt "Section Only" Manual System, Add Issue Revision Table and model applicability. Change position of XPNDR penetration to 2500mm (was 415mm)	AS

Model Applicability

Aircraft Model	J-160	J-170	J-230	J-430
Document Applicability			Yes	

Objectives of this task:

To turn the fuselage upside down, make all the required penetrations and fit the fairings.

Materials required:

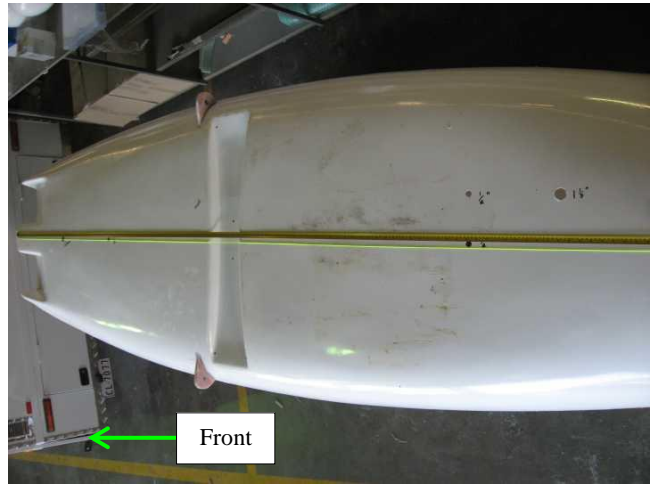
Epoxy resin and flock

Pre-Paint>Fuselage>Underbody penetrations>Procedure

Roll the fuselage over carefully onto a padded surface– some old bedding material is ideal – so that it is upside down and place a saw stool under the empennage so that the fuselage is roughly level.

Measure the centre of the fuselage at the base of the firewall and mark that point, and then mark the centreline with a builders chalk line: line up from the firewall centre and in line with the existing ½” hole in the rear of the undercarriage well and flick the chalk line to mark the centreline. The next page has details of all the measurements. Print it and take it with you.

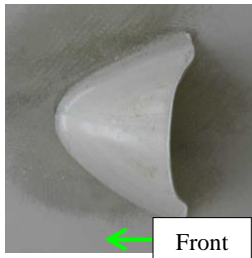
Place a tape measure on the firewall datum (hold it in place with masking tape) and run it out to 2600mm and tape it in place and then carefully mark the position of each hole with a marker pen. Recheck each mark and then drill each hole.



Note that the 22mm transponder hole is optional depending on whether or not you are fitting a transponder. If you plan to fit a transponder at a later date then drill it now and plug it until required.

Clean each hole carefully, removing any burrs and rough edges.

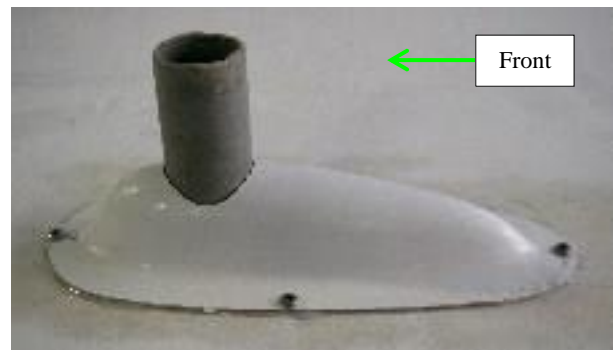
Sand the base of each fairing and the area that it will be bonded to.



Mix a small batch of resin and coat the base of each fairing and the area that it will be bonded to.

Place the small fairings over the three fuel drain holes and flock into place with the open side facing the rear of the aircraft.

Locate the quick drain fairing by placing a short length of 1 1/8” tube into the fuselage hole and then slip the fairing over the tube with the long side to the rear of the aircraft.



Angle the tube until it is at right angles to the floor section and flock the fairing into place.

Secure with 2 self-tapping screws until the flock is cured and remove the length of aligning tube.

