

PANEL GUARD INSTALLATION INSTRUCTIONS

MODELS: BELL 407

Read all of the installation instructions thoroughly
prior to the installation of this product



Weight & Balance

<u>Part Number</u>	<u>Description</u>	<u>Weight</u>	<u>Long. Arm</u>	<u>Lat. Arm</u>
AAL-312-012-001	Panel Guard, Detail	0.68* 0.31 (Kg)	148.16 3.76 (m)	27.08 RBL 0.69 (m) RBL


* Total increase in weight to aircraft.

General Notes

1. All Installation Instructions must be completed in accordance with standard aircraft practices. Refer to the current revision of the FAA manual AC 43.13, Aircraft Inspection, Repair & Alterations, for instructions.
2. All Dimensions are in imperial measures (inches/pounds).
3. Refer to the Panel Guard Illustrated Parts Breakdown for the part numbers of the items contained within this document.
4. Refer to the Panel Guard Maintenance Manual Supplement for the inspection and maintenance of the items contained within this document.

Installation Notes

1. An application of paint after installation is acceptable, but **not** mandatory.
 - Abrade the exterior surface of the Panel Guard, Detail as required and wipe the entire area clean with MEK (Methyl Ethyl Ketone).
 - Coat with primer per MIL-PRF-23377, TYPE 1, CLASS C.
 - Coat with paint per MIL-PRF-85285, TYPE 1.

 Apply sealant to faying surfaces, 100% coverage, Max .030 total thickness.

 Apply bead (fillet) of sealant around entire perimeter.



Installation Instructions

1. Temporarily install the Panel Guard, Detail, Item 1, as shown and mark its perimeter on the Side Body Fairing. Reference Figure 1.
2. Remove the Panel Guard, Detail and prepare the faying surface of the Side Body Fairing by removing any obstructions, residual fuel, dirt, etc.
3. Abrade the faying surface of the Side Body Fairing with aluminum oxide abrasive paper, 240 grit or finer, and wipe the entire area clean with MEK (Methyl Ethyl Ketone).

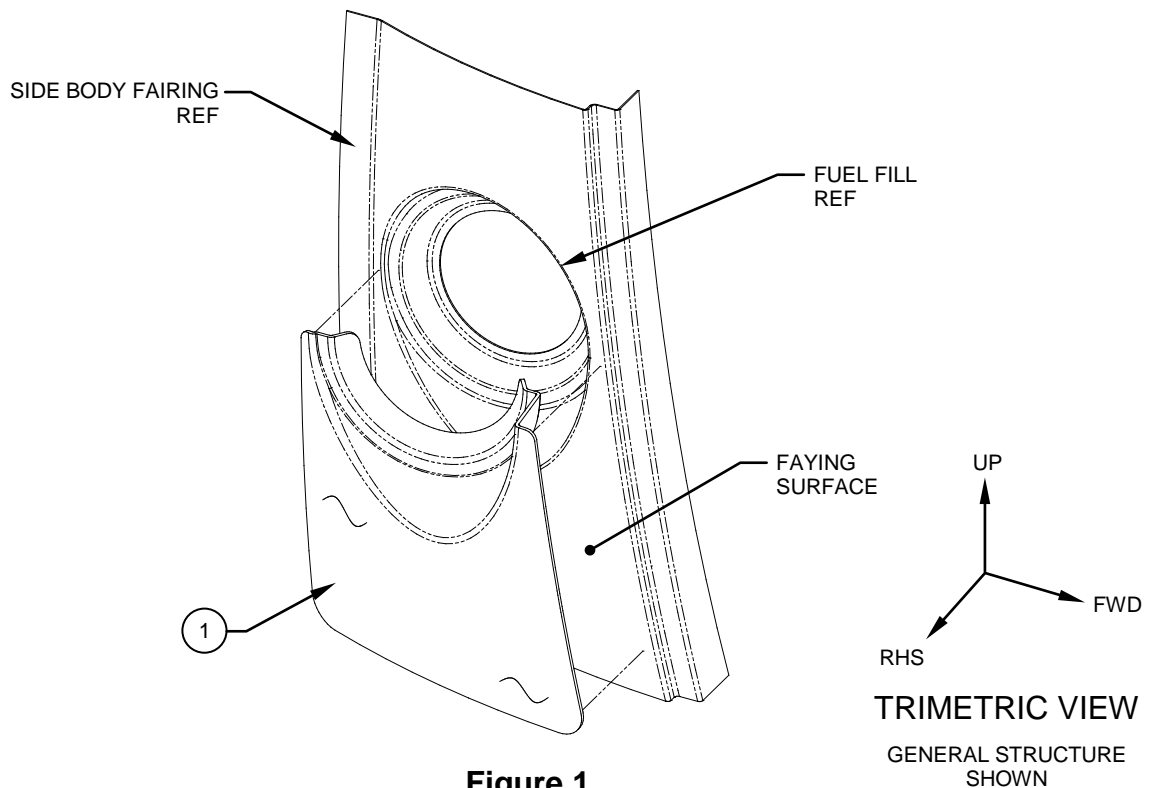


Figure 1

4. Prepare the faying surface of the Panel Guard, Detail by wiping the entire area clean with MEK (Methyl Ethyl Ketone).
5. Apply the Sealant, Item 2, to the faying surfaces of the Panel Guard, Detail/Side Body Fairing and install as shown. Reference Figure 2.

NOTE: Apply pressure as required to ensure proper adhesion.



Installation Instructions

6. Remove any sealant squeezeout and maintain pressure on the Panel Guard, Detail as required until the Sealant has set-up.
7. Once the Sealant has set-up, apply a bead (fillet) of Sealant around the entire perimeter of the Panel Guard, Detail. Reference Figure 2.

NOTE: Maintain pressure on the Panel Guard, Detail as required until the Sealant has cured.

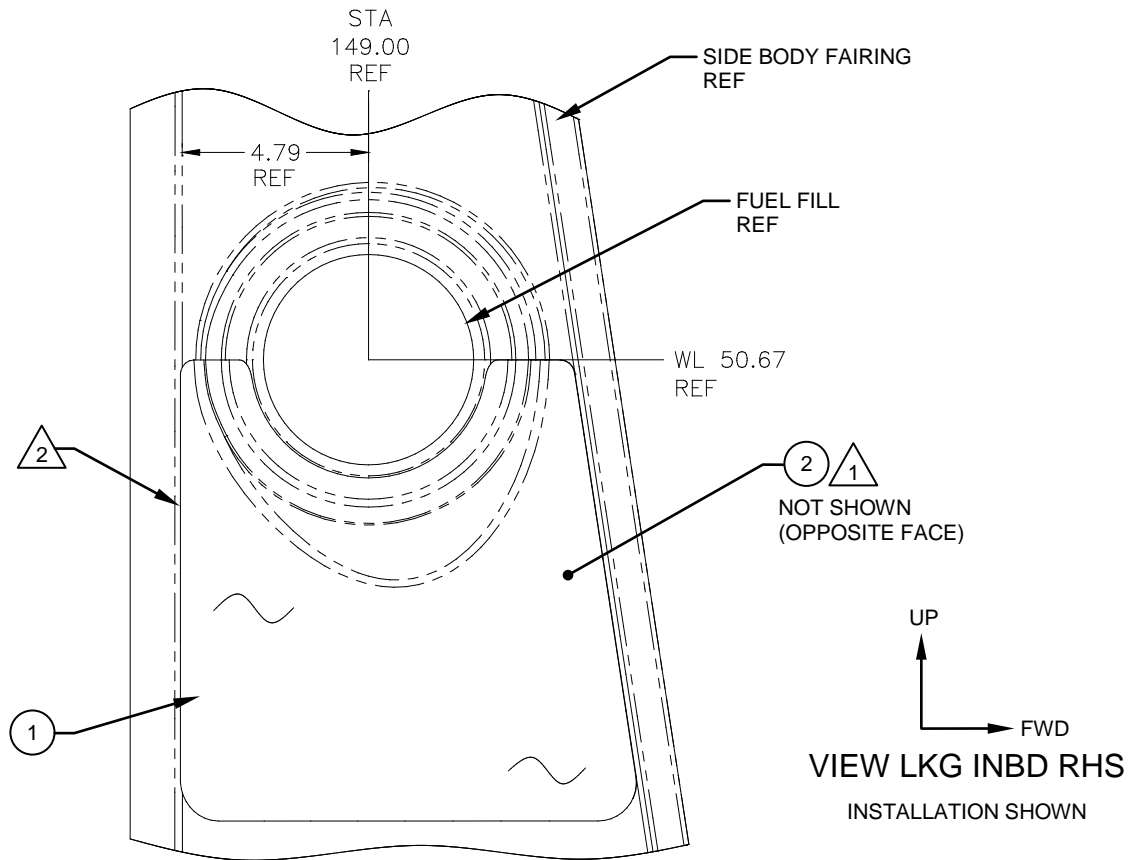


Figure 2

8. Installation complete.
9. Perform a general inspection of all items to ensure proper installation.
10. Update the aircraft log book for the installation of the Panel Guard, Detail.