

PROCEDURE 4.090

INSTALLATION OF CABIN AND BAGGAGE DOOR PIN RECEPTICLES

In this procedure...

The door pin receptacles will be positioned and bonded into the main cabin doors jams and the baggage door jams.

FOR THIS PROCEDURE THE FOLLOWING PARTS WILL BE REQUIRED:

<u>PART NUMBER</u>	<u>QTY</u>	<u>DESCRIPTION</u>
212-12-078	6	Receptacle, Door Pin

Step 1. Determine the receptacle location.

Using a straight edge make a mark on the fore and aft door joggle 3" up from the bottom door joggle. Mark the door flange 1.5" above and below this location. Remove the 3" of flange between these two points. On the inside of the fuselage cut the inner skin and remove the foam so that the receptacle can be positioned horizontally on the 3" centerline and vertically centered on the flange. Locate the receptacle on both the fore and aft side of the door.



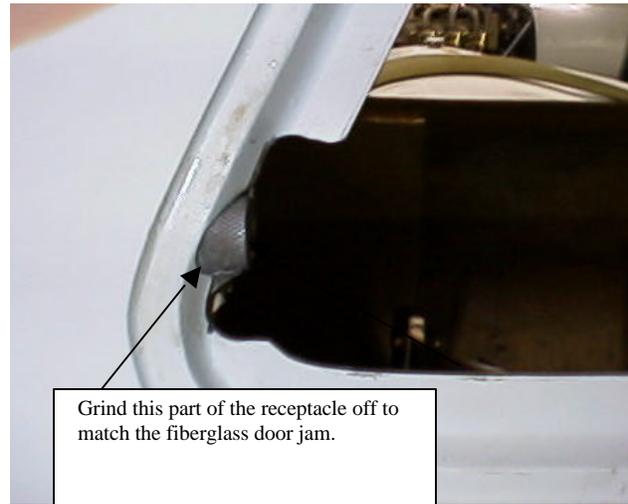
Center of receptacle is 3" up from this point.

Step 2. Laminate Receptacle in Position

Cut a straight piece of steel or aluminum tubing, (That fits the inside diameter of the receptacle) 4" longer than the width of the door. Slip the receptacles on the tubing and place them in the cutout. Hold in place with clamps.



The tube will keep the receptacles parallel to the bottom of the door flange. Check to make sure you have maintained the 3" height above the bottom door joggle. Once you are sure of proper alignment use a milled fiber mix to secure in position. Position the receptacle so that the end can be ground off flush with the door jam.



Step 4. Bodywork and put final laminates over receptacle.

Use a piece of thin aluminum to serve as a backing plate to laminate the flange area removed in Step 1. Shape the aluminum so that you have a $\frac{3}{4}$ " standoff from the center of the receptacle. Laminate 5 plies over the aluminum to reconstruct the new flange. Once the laminate is cured remove the aluminum strip. Use milled fiber to fill any voids around the receptacle on the inside of the fuselage and place 3 laminates over the receptacle lapping onto the fuselage skin by a minimum of 6" in each side of the receptacle.

When complete remove the tube by cutting out the center section and slipping out of the receptacle.

