

## PROCEDURE 4.110

## INSTALLATION OF BAGGAGE DOOR

**In this procedure ...**

The baggage door will be trimmed to fit the baggage door inset and the hinges will be installed.

<u>SUPPLIED MATERIAL</u>	<u>QTY</u>	<u>DESCRIPTION</u>
212-12-053	1	Baggage Door
212-12-056	1	Baggage Door Hinge Assembly
AN526C-1032R8	6	Screws
AN3-15	2	Bolts
AN310-3	2	Nuts
MS24665-132	2	Screws
212-12-083	1	Gas Strut
212-12-084	1	Gas Strut Mount Door
212-12-085	1	Gas Strut Mount Fuselage
AN3-5	2	Bolts

**Step 1. Trim Door Seal Flange and Trim Door to Fit Joggle.**

Remove the inner portion of the baggage doorframe and trim the door seal flange to 1 inch from the door joggle.

Trim the door to fit into the preformed joggle. Tape door into position.



**Step 2. Install Hinge Assembly in Fuselage.**

Position the Hinge Assembly parallel with the top to the door cutout. Rotate the hinge arms to the up position and move the support until you have 1/8" clearance between the hinge arm and the edge of the door joggle. Mark the position of the hinge bracket on the fuselage. On older model aircraft the outer skin and foam core will have to be removed from an area 2" outboard from the hinge bracket.



Bevel the foam at 45° and laminate 3 plies 7781 over the cutout area. Reposition the hinge and drill the four mounting screw holes. Countersink the the holes on the fuselage skin and attach the hinge bracket. you want to cover the screw heads laminate ply of 7781 BID over the screw heads and bodywork the area.



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**3. Locate and Bond Hinge Attach Points Door.**

Swing hinge arms onto the door and mark location. Remove the baggage door from the aircraft. Remove the foam in the marked area and reinstall the door in the joggle and place tap around the edges to hold in place.



Place the G10 hardpoints into the cutout areas. Swing the hinge arm so that it contacts the G10 Block. Make sure the block is positioned so that the face of the arm lies flat on the G10 blocks. Bond the G10 blocks in position. Laminate 2 tapes over the blocks.

Reinstall the door if removed to accomplish the previous Step.

**Step 4. Attach Hinge Arms to Door.**

Position the Hinge Arms against the G10 hardpoints and mark the screw locations. Remove the door and install 1032 helicoils. Reinstall the door and attach the hinge arms with screws. If the top of the door hits the fuselage before the hinges bottom out, remove material from the top of the door and back fill the joggle area.



