

## PROCEDURE 4.120

## INSTALLATION OF DOOR LATCH ASSEMBLY

In this procedure...

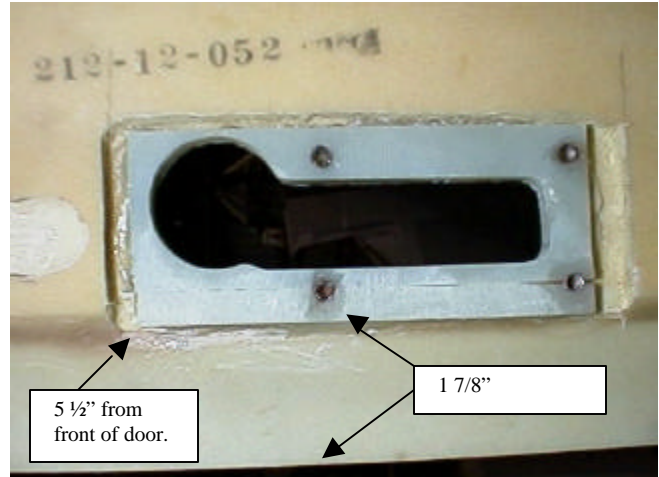
The G10 mounting block will be positioned and bonded into the door. The latch will be assembled and mounted. The pin receptacles will be positioned and bonded to the door and the pins and arms will be installed.

## SUPPLIED MATERIALS:

<u>Part No</u>	<u>Qty</u>	<u>Description</u>
212-12-058	1	Base Plate Right Door
212-12-059	2	Base Plate Left Door
212-12-060	2	Handle, Left
212-12-061	1	Handle, Right
212-12-062	2	Pivot, Left
212-12-062	1	Pivot, Right
212-12-064	2	Interior Door Handle, Left
212-12-065	1	Interior Door Handle, Right
212-12-066	3	Spring, Handle Hold-Down
212-12-067	3	Pin, Handle Pivot
212-12-069	3	Roll Pin 3/32" x 5/8"
212-12-070	3	Snap Ring
212-12-071	3	Spring, Overcenter
212-12-072	3	Retainer, Overcenter
212-12-073	3	Clevis Pin, Overcenter
212-12-074	2	Push-Pull Tube Cabin Door, Fwd
212-12-075	2	Push-Pull Tube Cabin Door, Aft
212-12-076	12	Clevis Pin, Push Pull Tube
212-12-077	6	Pin, Locking
212-12-079	3	Knob
212-12-080	1	Push-Pull Tube, Baggage Dr, Fwd
212-12-081	1	Push-Pull Tube, Baggage Dr, Aft
212-12-082	3	Mounting Block, G10
NAS77-7-010	3	Bushing
MS24693S71	12	Screw

**Step 1. Install G10 Mounting Block.**

To position the G10 mounting block, draw a parallel line parallel 1 7/8" up from the bottom of the door. Extend this line forward to the front edge of the door. Establish the location of the front bottom corner of the G10 mounting block by measuring aft along this line from the front edge of the door 5 1/2". Place the G10 block on the line with the front lower corner at this mark and draw around the perimeter of the G10 mounting block.



Remove the inner layer of fiberglass and the foam from this area. Use caution not to cut the outer layer of fiberglass. Sand this area so that the G10 block lays flat against the outer layer of fiberglass and parallel with the bottom edge of the door. (**Note: Make sure the bottom edge of the door has been it to the fuselage.**) Mill Fiber the G10 block in place. When cured cut out the inner area so that the base plate can be inserted into the G10 mounting block. The outer flange of the base plate should be flush with the outer door skin. If not sand the G10 block to achieve this fit. **When installing the G10 Block in the Baggage Door, center the block fore and aft.**

**Step 2. Install Helicole for mounting screws.**

Position the base plate in the G10 block. Use the holes in the base plate as guides and drill the four 3/16" holes in the block. Use caution not to drill all the way through. Follow the instructions provided by the Helicole Kit and drill, Tap and install the four 1032 helicoles.

**Step 3. Assemble the Latch mechanism.**

Press the NAS77-7-010 Flanged bushing into the base plate pivot hole.



**Step 4. Install the handle and pivot assembly in the base plate.**

Remove the door handle pivot pin and remove the handle from the pivot.

Place the hold down spring in the receptacle in the handle and reassemble the handle and the pivot. Insure that the handle moves freely in the pivot.



Insert the 3/16' " roll pin through the hole in the pivot shaft. Check and make sure that the pin is clocked correctly. See illustration at right. Left and Right Pivots have pins clocked differently.



Temporarily place the Inboard handle (**Single Pin Side Down**) on the pivot shaft. If the handle does not fit freely use a ream and clean out the pivot hole. Position the handle so that the pin fits in the machined groove the base plate. (Note: You may have to shorten the pin, or flatten one side of the pin so that it does not hit the side or the bottom of the groove when the handle is snug against the bushing flange.

Remove the handle and install the overcenter spring retainer onto the pin. Place the overcenter spring onto the retainer. Take the 1/4" clevis pin and drill out the cotter pin hole to 1/8". Place the clevis pin through the hole in the base plate in insert the overcenter spring retainer through the hole. Install the handle onto the pivot shaft. Place the snap ring on the pivot shaft to retain the handle. Make sure the snap ring is seated in the groove completely. (Note: On some early handles the pivot

bushing welded on the housing is too thick not allowing sufficient clearance to install the snap ring. If this is the case, remove sufficient material to allow the snap ring to fit into the groove on the pivot shaft. When removing this material make sure you keep the face of the bushing parallel with the handle.)

Correct operation of the latch should allow you to move the inside handle to its open and closed position without the outside handle moving. If this cannot be done you have the incorrect pivot installed. Disassemble the handle and replace the pivot with the correct one.

