

GENERAL NOTES

(UNLESS OTHERWISE SPECIFIED)

1. Fabricate per AC 43.13.
2. Assembly shop practice per AC 43.13.
3. Flange corner radii are to be R .25.
4. Alodine all aluminum parts per Mil-C-5541.
5. Epoxy prime per Mil-P-23377.
6. Remove all burrs and sharp edges.
7. Torque per AC 43.13-1A or MIL-N-25027.
8. Surface finish of parts to be 125 microinches
9. Install safety wire per AC 43.13-1A or MS33540.
10. All dimensions are prior to finish applications.
11. Equally spaced attachment tolerance to be +/- 0.100".
12. Minimum attachment spacing to be 4D+.060" center to center.
13. Attachments located from part edge 2D+.060" for details, 2D minimum on assembly, 2D from joggles and adjacent structure.
14. Identify per MIL-STD-130 using rubber stamp or and written with indelible ink. Small assemblies may be tagged.
15. Symbols + between end fastener symbols indicate identical fasteners equally spaced.
16. Install solid rivets per AC 43.13-1A. Install all other fasteners per manufacturer's instructions.
17. Faying surface seal all external skin mating joints and install fasteners wet using PR1431G or P/S 870C sealant.
18. Fillet or brush coat edges of mating parts using PR1422-B2, CS3204 class B, or P/S 890 class B sealant.
19. Mix all sealants and adhesives per the Mfg's instructions.
20. Antenna must be bonded to airframe for P-static and lightning protection. Reference AC 43.13-1B Chapter 12 Section 2 Paragraph 12-9 (b) for inspection antenna guideline & Chapter 11 Section 15 Paragraph 11-193 for lightning protection. Also reference a/c manufacturer's maintenance manual for recommended antenna bonding practices.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED
	-	Initial Release	2011-0X	J.BROWN

INSTALLATION NOTES

- A. Install the GA 56 Flange Mount Antenna at FS xxx BL 0.0 per the manufacturer's instructions.
- B. Doubler may be larger, and fastener spacing greater than shown. Flanges may be added. Nutplate is attached to the doubler only.

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4		10-32UNC-2A	Screw			7	
1		GA 56 - Flange Mount	Antenna			6	
AR		NAS1097AD4	Rivet			5	
8		MS20486AD3	Rivet			4	
4		MS21059-3	Nutplate			3	
1	5	-02	Doubler	0.040 2024-T3, AMS-QQ-A-250/5	0.040 x 5 x 4	2	
		-01	Installation			1	
	-01	NOTE	PART NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL/SPECIFICATION	STOCK SIZE	ITEM NO.

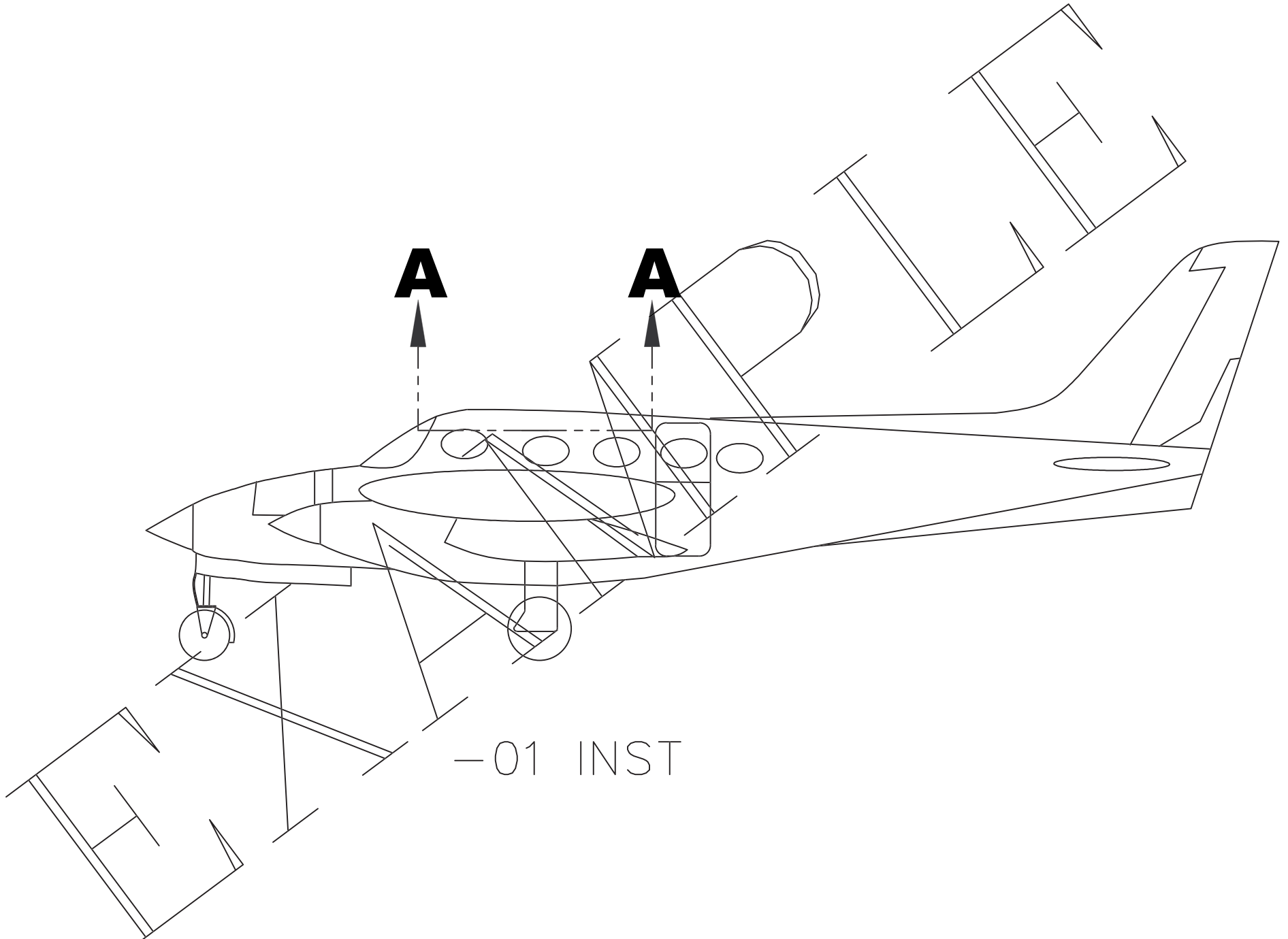
PARTS LIST

DIMENSIONS ARE IN INCHES
 TOLERANCES:
 .X= ±.1, .XX= ±.03
 .XXX= ±.015
 ANGLES ±0°-30'

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TITLE: G	56 GPS FLANGE MOUNT ANTENNA INST - XX		
APPRVD	2011-0X	DWG. NO. 00-1500-03-05-xxx	SHEET 1 OF 3



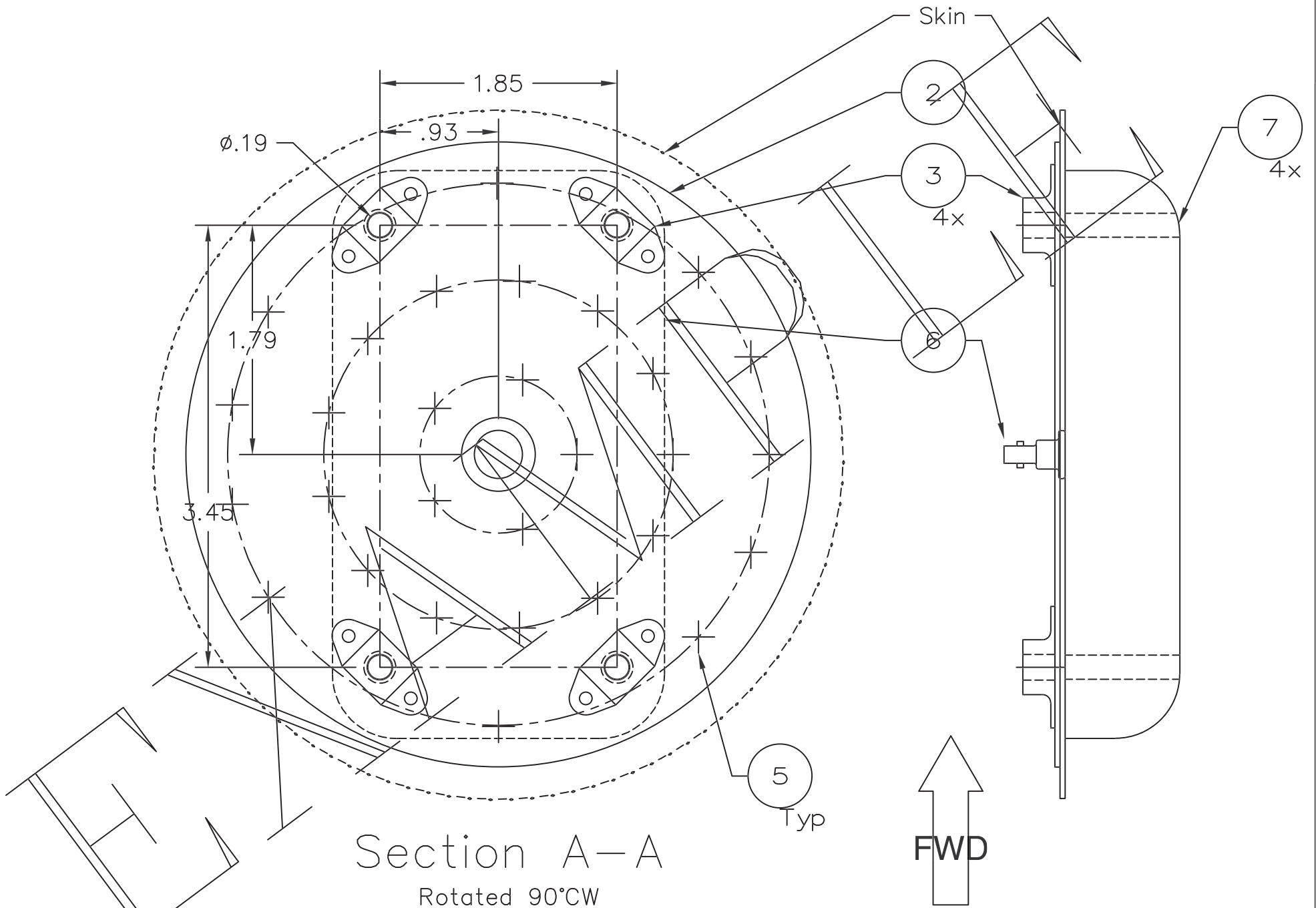
-01 INST

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TITLE GA 56 GPS FLANGE MOUNT ANTENNA INST - XX	
DWG. No. 00-1500-03-05-XXX	Rev. - SHEET 2



Section A-A
Rotated 90°CW

DIMENSIONS ARE IN INCHES
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.X = ±.1, .XX = ±.03
.XXX = ±.015
ANGLES ±0°-30'

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Rev. - SHEET 3