

**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.
21. Install thru doubler only.

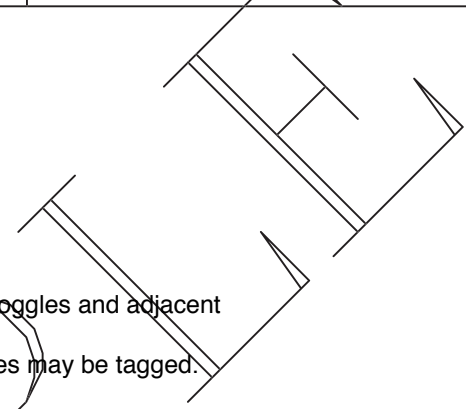
**INSTALLATION NOTES**

- A. Install the CI 420-1 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. Nuts and washers may be used in place of nutplates.

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**REVISIONS**

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



**NAS 523 FASTENER CODE**

<b>BASIC CODE</b>	<b>DASH NO. FOR DIA.</b> N = MFD HEAD NEAR SIDE F = MFD HEAD FAR SIDE
D = DIMPLE FIGURE = NO. OF SHEETS TO BE DIMPLED C = COUNTERSUNK	<b>DASH NO. FOR LENGTH</b> W = SPOTWELD OPTIONAL

**BASIC CODES**

BB = MS20426AD	LZ = NAS1097AD
BJ = MS20470AD	
YA = HL18PB70	

QTY	NOTE	PART NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL/SPECIFICATION	STOCK SIZE	ITEM NO.
4		8-32UNC-2A	Screw			7
1		CI 420-1	Antenna	COMANT		6
AR		NAS1097AD4	Rivet			5
8	21	MS20426AD3	Rivet			4
4	B	MS21062-3	Nutplate			3
1	4, 5	-02	Doubler	0.040 2024-T3, AMS-QQ-A-250/5	0.040 x 5 x 4	2
	1	-01	Installation			1

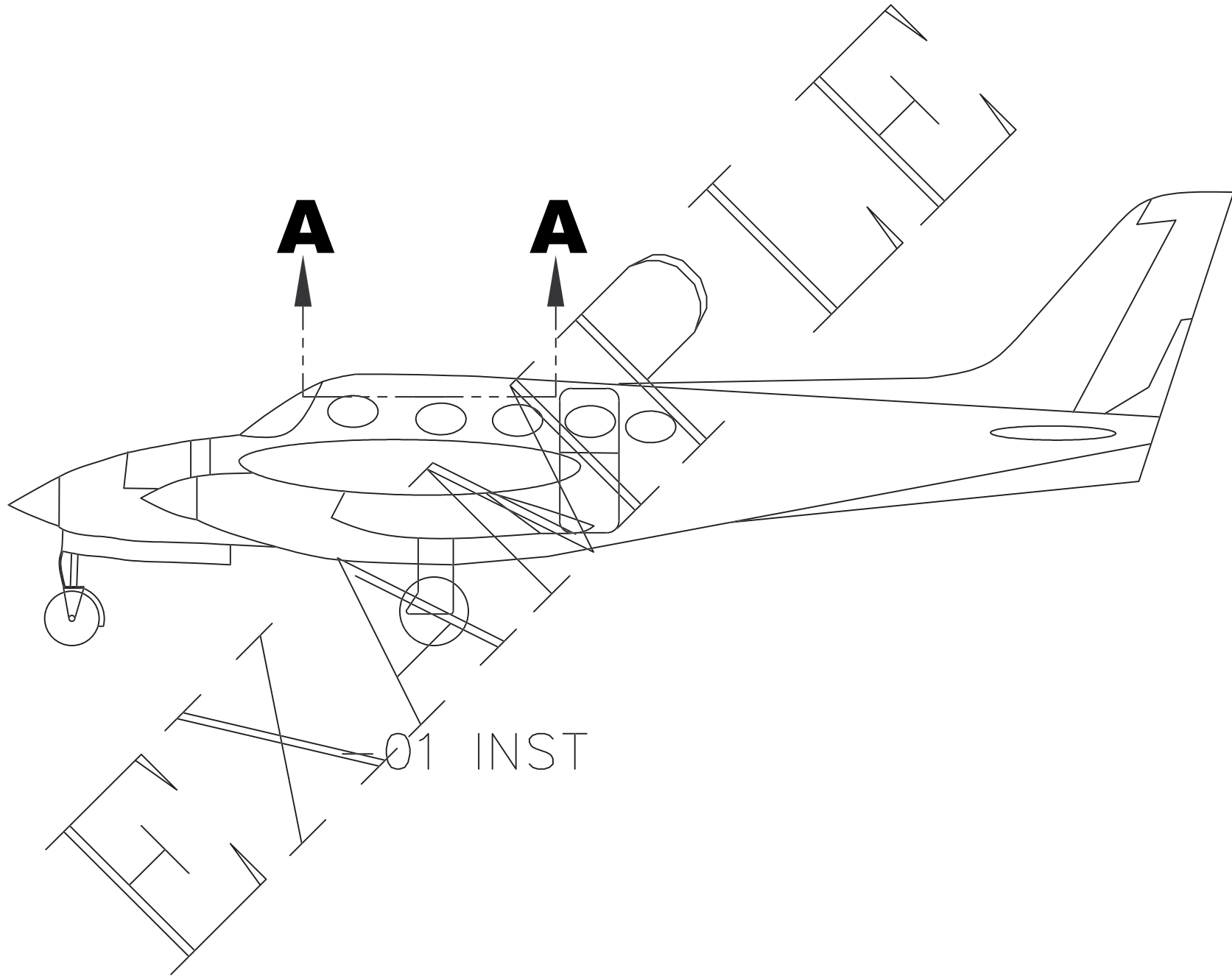
**PARTS LIST**

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

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TITLE: CI 420-1 XM ANTENNA INST - XX



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

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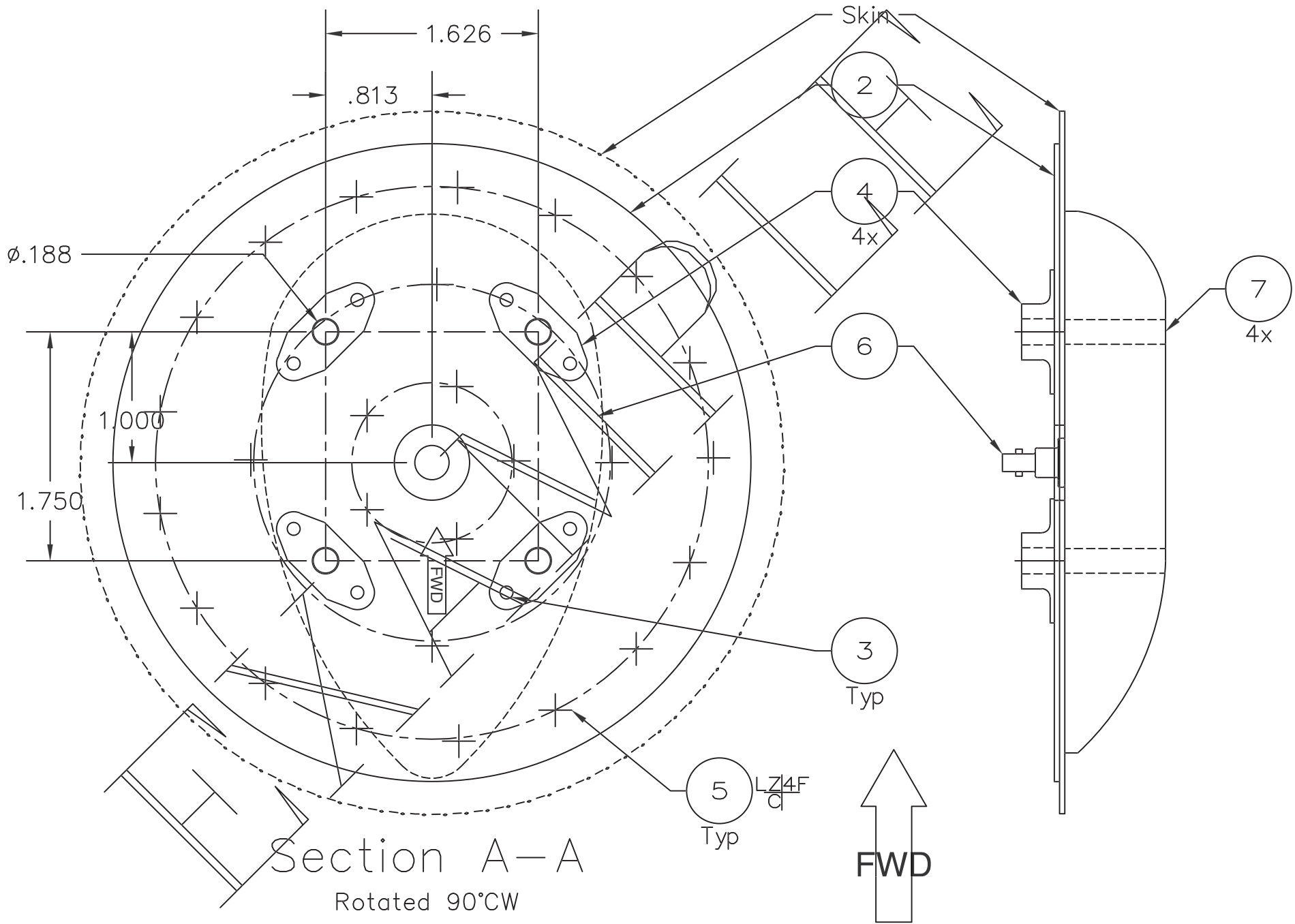


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DWG. NO. 00-1500-03-11-XXX

Rev. - SHEET 2



Section A-A  
Rotated 90°CW

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

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Rev. - SHEET 3