

GENERAL NOTES
(UNLESS OTHER WISE 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 PR1431C 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 110-337 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.

This drawing has been prepared for a specific alteration to a specific aircraft or component based on information supplied to Aviation Engineering Consultants of USA, LLC (AECUSA-LLC) by the person responsible for arranging the alteration or his agent. The use of the data on any other aircraft or component may lead to an unsafe alteration and therefore the data is not to be used for any other purpose than for which it was originally supplied without the written approval of AECUSA-LLC.

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10-32UNC-2A

110-337

NAS1097AD4

-03

MS21062-3

-02

-01

Angle

Screw

Antenna

Rivet

Doubler Assy

Nutplate

Doubler

Installation

0.050 2024-T3, AMS-QQ-A-250/5

0.040 2024-T3, AMS-QQ-A-250/5

.75x.75x10

0.040 x 5 x 4

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ZONE

REV

DESCRIPTION

DATE

APPROVED

-

Initial Release

2011-0X

J.BROWN

NAS 523 FASTENER CODE

BASIC CODE

DASH NO. FOR DIA.
N = MFD HEAD NEAR SIDE
F = MFD HEAD FAR SIDE

D = DIMPLE
FIGURE = NO. OF SHEETS
TO BE DIMPLED
C = COUNTERSUNK

DASH NO. FOR LENGTH
W = SPOTWELD OPTIONAL

BASIC CODES

BB = MS20426AD

BJ = MS20470AD

YA = HL18PB70

LZ = NAS1097AD

=Existing - not used

=Existing - NAS1097AD

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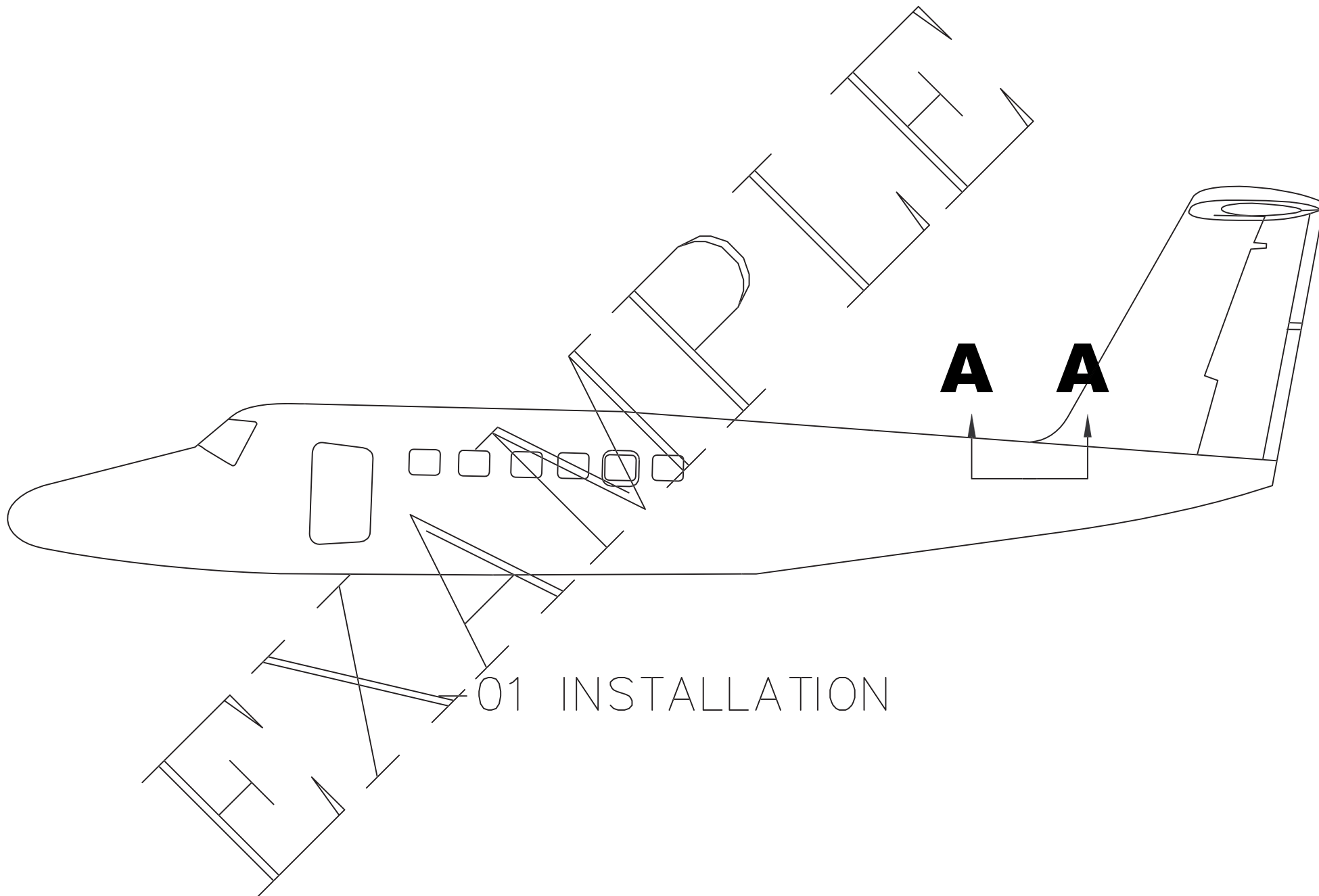
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MS21062-3

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DIMENSIONS ARE IN INCHES
TOLERANCES:
.X= ± 1 , .XX= ± 0.3
.XXX= ± 0.15
ANGLES $\pm 0^{\circ}-30^{\circ}$

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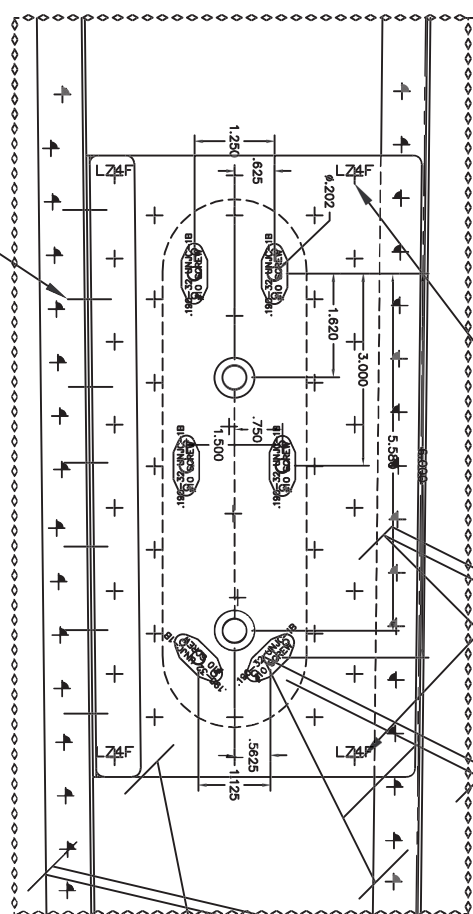
TITLE 110-337 ELT ANTENNA INST IN A C550 - XX

DWG. NO.00-1500-03-17-XXX

Rev. - SHEET 2



BJ4N
Typ This
Flange

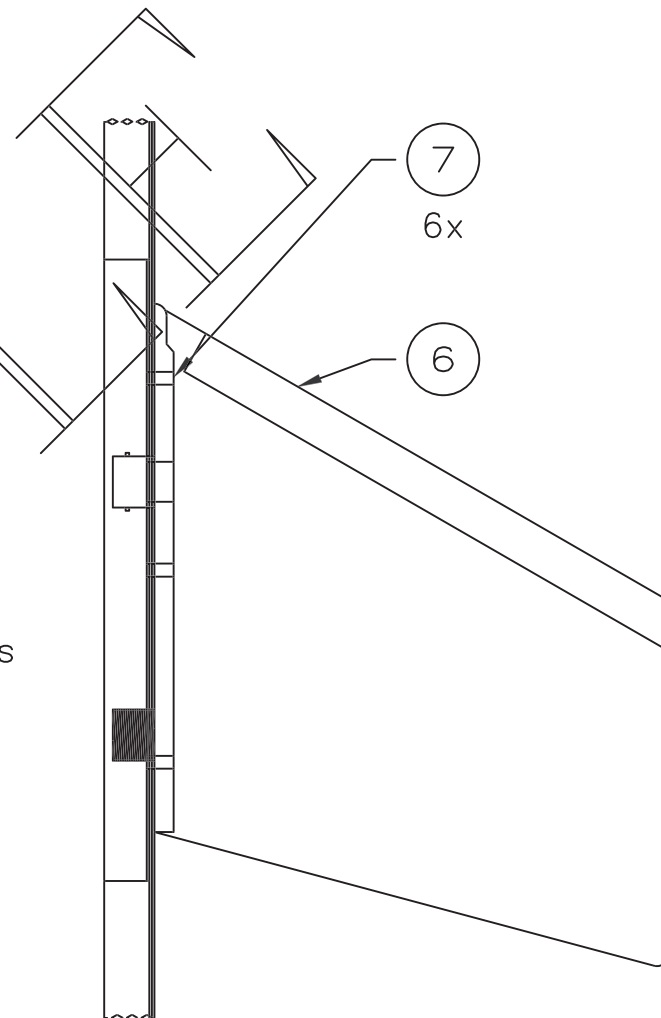
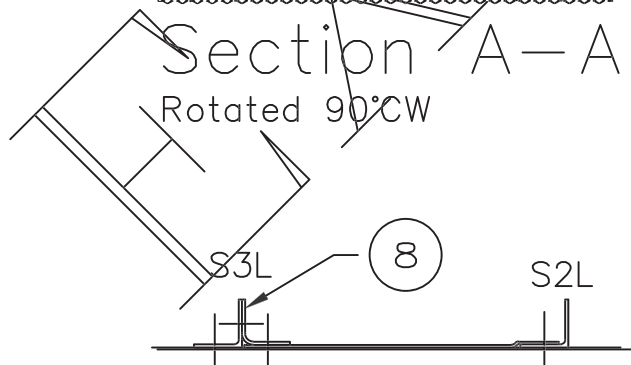


FS 428.5

3 Rivets in
the end rows

FS 442.5

Section A-A
Rotated 90°CW



DIMENSIONS ARE IN INCHES
TOLERANCES:
.X= $\pm .1$, .XX= $\pm .03$
.XXX= $\pm .015$
ANGLES $\pm 0^\circ - 30'$

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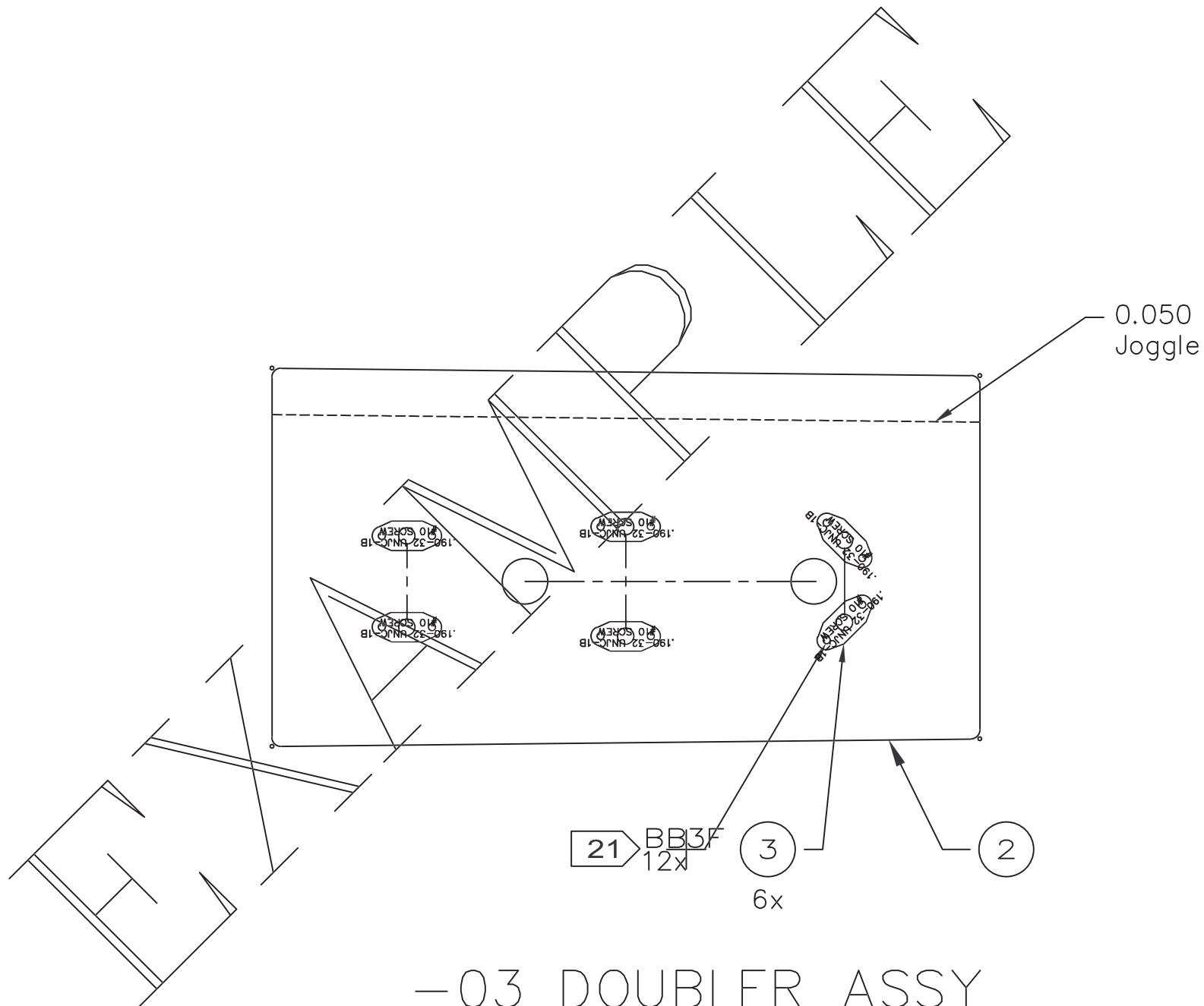


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TITLE 110-337 ELT ANTENNA INST IN A C550 - XX

DWG. NO.00-1500-03-17-XXX

Rev. - SHEET 3



—03 DOUBLER ASSY

DIMENSIONS ARE IN INCHES
TOLERANCES:
.X= ± 0.1 , .XX= ± 0.3
.XXX= ± 0.15
ANGLES $\pm 0^{\circ}-30^{\circ}$

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Rev. - SHEET 4