Working instruction No. 2 for TN348/20

Canopies - installation of gas-strut mechanism

Execute all work according to drawing 10R142

1. Produce a drilling pattern according to drawing 10V98.
2. Remove the loudspeaker housing from the pylon between the canopies.
3. Drill 4 dia. 7mm 15mm deep holes into the pylon between the canopies using the drilling pattern 10V98. Insert and rivet the 4 rivet nuts.
4. Mount the lower support 10R141/1 to the rivet nuts, apply resin thickened with cottonflocks between support and canopy pylon. Refit the loudspeaker housing.
5. Mark the gluing surfaces for the upper supports 10R140/4, /5 at the canopy frames. Use the existing thread in the front canopy frame to position the marks. Roughen the gluing surfaces, all paint must be removed
   Glue 10R140/4 to the rear canopy frame and 10R140/5 to the front canopy frame with resin thickened with cottonflocks, screw a screw M5x10 DIN7984 with washer 5,3 DIN125 through part 10R140/5 into the existing M5 thread. Let the resin cure at room temperature for a minimum of 20 hours.
6. Screw the ball fitting of the connector WX22 from the front into lower support 10R141/1, use Loctite 273 to secure the connection.
7. Push part 10R141/1 from the rear into the lower support 10R141/1 and secure with a circlip.
8. Connect the gas-struts, don't install their locking devices!
9. The restraining cable for the front canopy may be removed, the restraining cable for the rear canopy is still necessary.
10. Check for correct functioning according to AFM section 7.14.

Material list

Drawings 10R142 and 10V98

retrofit kit part. no. 41060005 consisting of:
1 lower support 10R141/1
1 10R141/2
1 of each upper supports 10R140/4 and /5
1 circlip 10x1 DIN471
1 gas-strut G0615012000305WX22PF2200080N
1 gas-strut G0615012000305KP03PF2200080N
4 rivet nuts RIVTI M5 338262
5 screws M5x10 DIN7984-8.8 zn
5 washers 5,3 DIN125 St zn

Resin/hardener MGS L285/H286 thickened with cottonflocks

Issued: 26.05.2008
Author: Dipl. Ing. Wilhelm Dirks