Working instruction No. 2 for TN348/20

Canopies - installation of gas-strut mechanism

Execute all work according to drawing 5R142

1. Remove the microphone from the pylon between the canopies. Fix part 5R141/1 with a screw M4 approx. 10 mm long through the front lower hole to the front microphone mounting thread.
2. Drill through the other 3 holes in part 5R141/1 with a dia. 5mm drill max. 15 mm deep.
3. Remove part 5R141/1
4. Enlarge the 3 dia. 5 mm holes to dia. 7mm 15mm deep, insert and rivet the 3 rivet nuts.
5. Mark the rear microphone mounting thread to part 5R141/1 and drill a 5 mm hole.
6. Mount the lower support 5R141/1 together with the microphone according to drawing 5R142, apply resin thickened with cottonflocks between support and canopy pylon.
7. Mark the gluing surfaces for the upper supports 5R140/4, /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 5R140/4 to the rear canopy frame and 5R140/5 to the front canopy frame with resin thickened with cottonflocks, screw a screw M5x10 DIN7984 with washer 5,3 DIN125 through part 5R140/5 into the existing M5 thread. Let the resin cure at room temperature for a minimum of 20 hours.
8. Screw the ball fitting of the connector WX22 from the front into lower support 5R141/1, use Loctite 243 to secure the connection.
9. Push part 5R141/1 from the rear into the lower support 5R141/1 and secure with a circlip.
10. Connect the gas-struts, don't install their locking devices!
11. The restraining cable for the front canopy may be removed, the restraining cable for the rear canopy is still necessary.
12. Check if the canopy hinges touch the cut outs in the fuselage with canopies fully opened. File off from fuselage if necessary. There should be a 1 mm clearance.
13. Check for correct functioning according to AFM section 7.14.

Material list

Drawings 5R142 and 5V98

retrofit kit part. no. 41060005 consisting of:
1 lower support 5R141/1
1 5R141/2
1 of each upper supports 5R140/4 and /5
1 circlip 10x1 DIN471
1 gas-strut G0615012000305WX22PF2200080N
1 gas-strut G0615012000305KP03PF2200080N
3 rivet nuts RIVTI M5 338262
4 bolts M5x10 DIN7984-8.8 zn
4 washers 5,3 DIN125 St zn
1 bolt M4x25 DIN912-8.8 BIC

Resin/hardener MGS L285/H286 thickened with cottonflocks

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