

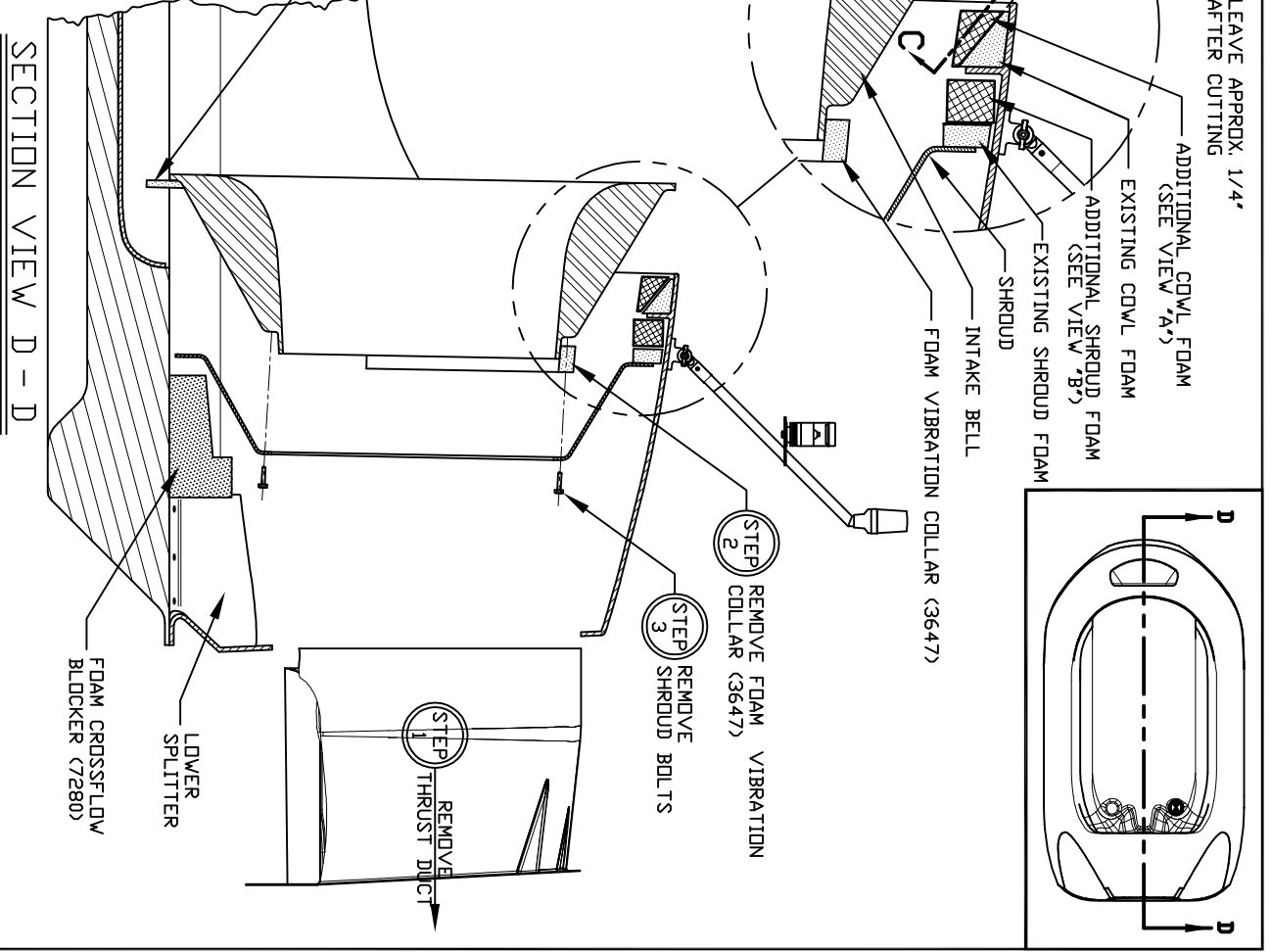
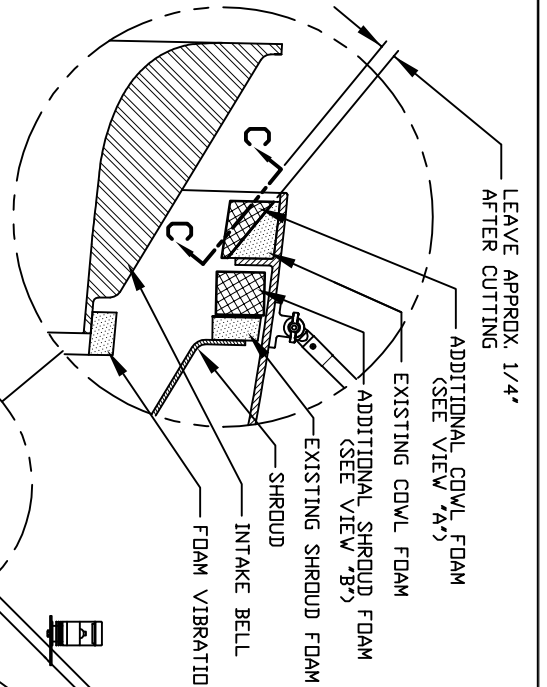
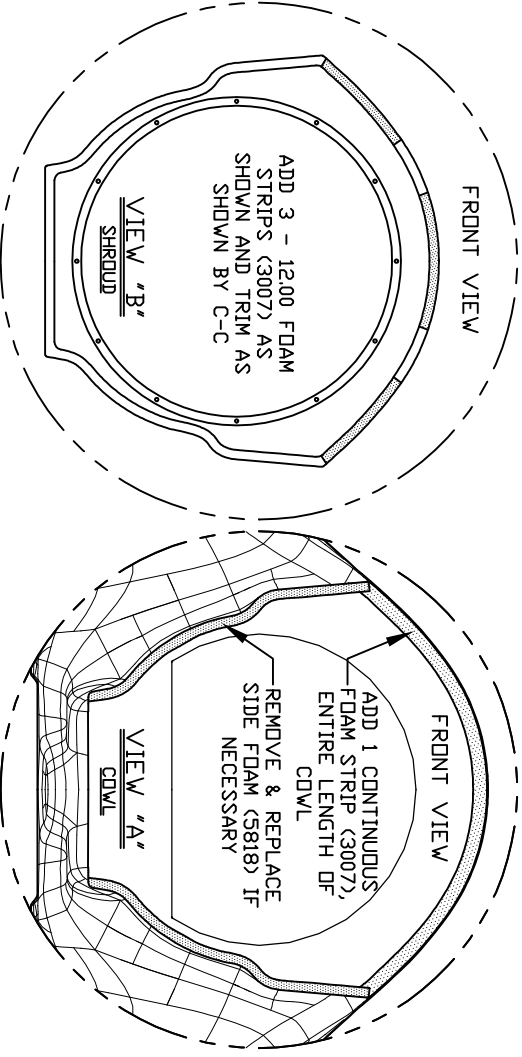
BILL OF MATERIAL

PART #	DESCRIPTION
3007	FOAM RUBBER
3647	FOAM VIBRATION COLLAR
7280	FOAM CROSSFLOW BLOCKER
5818	BELL TO BODY SEALING FOAM SIDES
5649	BELL TO BODY SEALING FOAM BOTTOM
3185	NEOPRENE ADHESIVE

ORDER OF OPERATIONS


- 1) REMOVE THRUST DUCT FROM REAR OF CRAFT.
- 2) REMOVE FOAM VIBRATION COLLAR (3647) USING A SHARP KNIFE.
- 3) LOOSEN/REMOVE SHROUD BOLTS FROM REAR.
- 4) ALLOW BELL TO FALL FORWARD, GIVING ACCESS TO COWL FOAM.
- 5) MEASURE AND CUT FOAM ADDITIONS TO LENGTH AND APPLY CONTACT ADHESIVE TO MATING SURFACES OF BOTH EXISTING FOAM AND FOAM ADDITIONS.
- 6) ALLOW ADHESIVE TO DRY FOR APPROX. 10 MINUTES UNTIL TACKY AND APPLY FOAM ADDITIONS AS SHOWN.
- 7) TRIM COWL FOAM AS SHOWN BY SECTION C-C
- 8) PUSH BELL BACK INTO POSITION, OIL SHROUD BOLTS AND REINSTALL, TORQUE FASTENERS TO SPECIFICATION LISTED BELOW.
* USE CARE TO NOT STRIP FASTENER THREADS.
- 9) FLIP FOAM VIBRATION COLLAR UPSIDE-DOWN & REINSTALL USING ADHESIVE OR REPLACE WITH NEW IF DAMAGED.
- 10) REINSTALL THRUST DUCT.

BELL/SHROUD FASTENER TYPE	TORQUE
HEX BOLTS & RIVET-NUTS	50 IN/LB
MACHINE SCREWS & WELLNUTS	10 IN/LB



ALL DIMENSIONS IN IN AND (mm)

# REQUIRED	CHECKED
SCALE	
FINISH	
WEIGHT	
USED ON ASSEMBLY	

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DRAWN BY: C. STEIMEL
NAME: THRUST BELL FOAM BUILD-UP KIT
DATE: 19 DEC, 2011
NUMBER: 17512

SIGN	REVISION	DATE