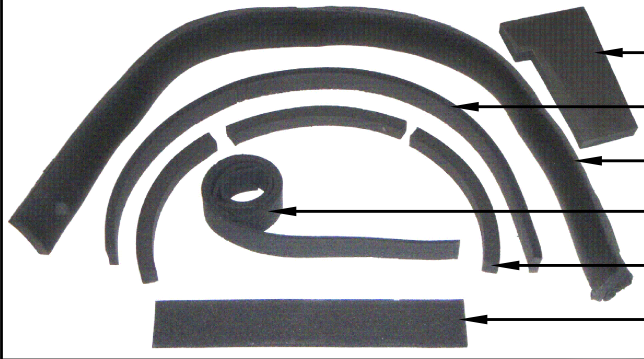
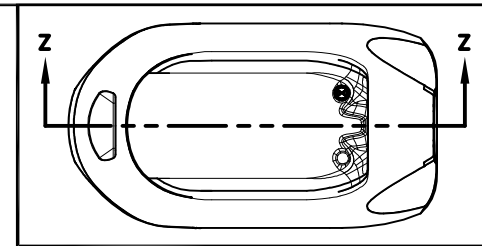


BUILD-UP KIT 6455 CONTENTS



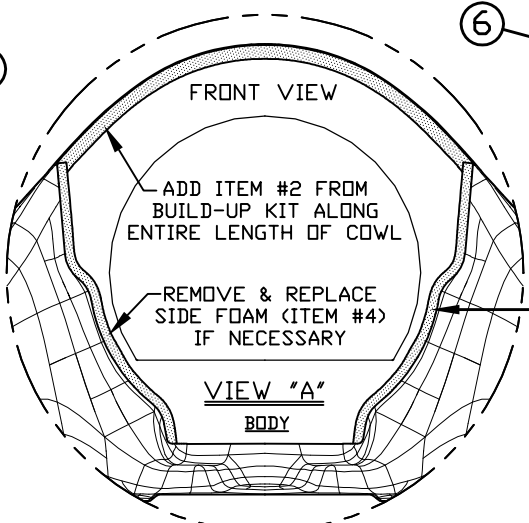
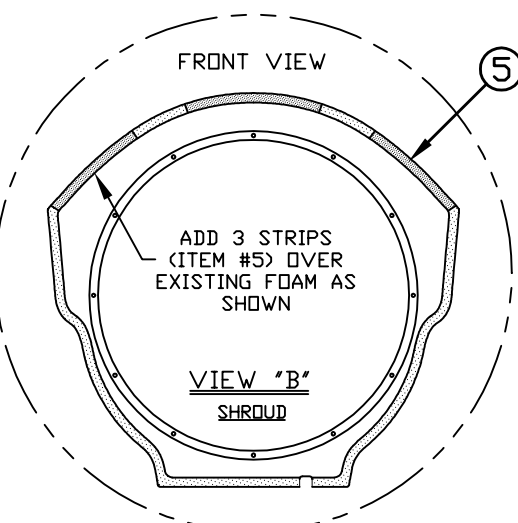
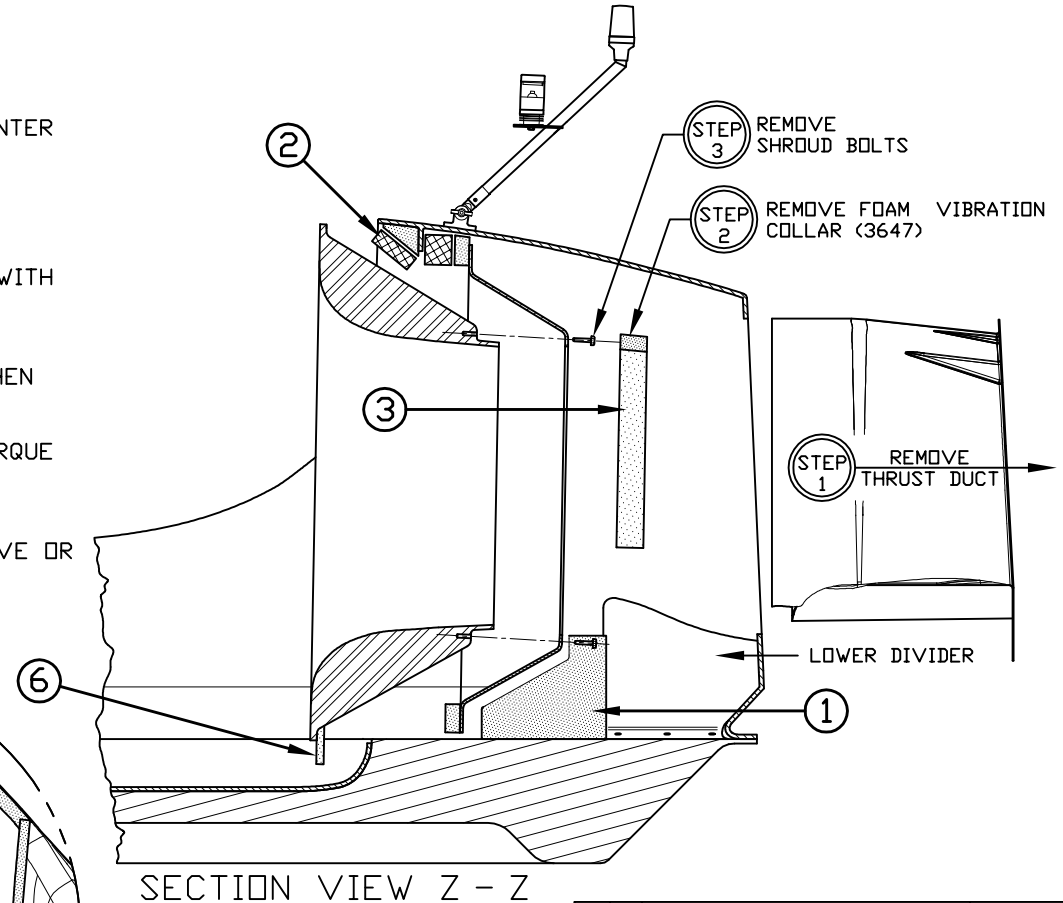
- ① REPLACEMENT CROSS-FLOW BLOCKER
- ② BODY LIP BUILD-UP FOAM
- ③ REPLACEMENT FOAM VIBRATION COLLAR
- ④ REPLACEMENT BELL TO BODY SEALING FOAM, SIDES*
- ⑤ SHROUD BUILD-UP FOAM
- ⑥ REPLACEMENT BELL TO BODY SEALING FOAM, BOTTOM



BELL/SHROUD FASTENER TYPE	TORQUE	
HEX BOLTS & RIVET-NUTS (NEWER CRAFT)	50 IN/LB	5.6 Nm
MACHINE SCREWS & WELLNUTS (OLDER CRAFT)	10 IN/LB	1.1 Nm

ORDER OF OPERATIONS

- 1) REMOVE THRUST DUCT FROM REAR OF CRAFT.
- 2) PEEL FOAM VIBRATION COLLAR (3647) OFF SHROUD STARTING IN THE CENTER AND WORKING OUT TO THE SIDES.
- 3) LOOSEN/REMOVE SHROUD BOLTS FROM REAR AND ALLOW BELL TO FALL FORWARD, GIVING ACCESS TO COWL FOAM SHOWN BELOW IN FIGURE "A".
- 4) APPLY CONTACT ADHESIVE TO FOAM ADDITIONS SUPPLIED IN KIT ALONG WITH MATING SURFACES OF EXISTING FOAM/FIBERGLASS.
*CUT ITEM #4 FROM KIT IN HALF BEFORE APPLYING ADHESIVE
- 5) ALLOW ADHESIVE TO DRY FOR APPROX. 10 MINUTES UNTIL TACK-FREE, THEN APPLY FOAM ADDITIONS AS SHOWN.
- 6) PUSH BELL BACK INTO POSITION, OIL SHROUD BOLTS AND REINSTALL; TORQUE FASTENERS TO SPECIFICATION LISTED ABOVE.
* USE CARE TO NOT STRIP ALUMINUM RIVET-NUTS IN BELL
- 7) FLIP FOAM VIBRATION COLLAR UPSIDE-DOWN & REINSTALL USING ADHESIVE OR REPLACE WITH NEW IF DAMAGED.
- 8) REINSTALL THRUST DUCT.



④ *CUT IN HALF

CS 3	REVISE FOR KIT, EDIT NOTES & DRAWING	31 JAN, 2014
CS 2	CORRECTED VIB. COLLAR POSITION & PART NAMES	28 JAN, 2012
SIG. NO.	REVISION	DATE

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DRAWN: C.STEIMEL
NAME: THRUST BELL FOAM BUILD-UP KIT INSTRUCTIONS

FINISH: WEIGHT: (KIT 6455) 14.0 oz [395g]
DATE: 19 DEC, 2011
NUMBER: 17512
REV. 3

# REQUIRED:	CHECKED:
SCALE:	CJ173 12-FEB-2014
FINISH:	EW1 04-MAR-2014