



SERVICE INSTRUCTION **SI0004**

EFFECTIVE DATE: This SERVICE INSTRUCTION is effective December 6, 2007
SUBJECT: Front Seat Reinforcement Installation
MODELS AFFECTED: CC11-100 S/N CC11-00020 through CC11-00047
PURPOSE: TO PREVENT FRONT SEAT FROM CRACKING

PARTS LIST:

PART	DESCRIPTION	QTY
SC22110-001	FRONT SEAT REINFORCEMENT	2
AN526C1032R12	SCREW 10-32 X 3/4	24
AN365-1032A	NYLON LOCK NUT	24
AN960-10	FLAT WASHER	24

TOOLS REQUIRED:

3/8" DRILL

#11 DRILL BIT

12" LONG #30 OR SMALLER DRILL BIT

PHILLIPS SCREW DRIVER

3/8" END WRENCH OR SOCKET

6 – VISE CLAMPS OR "C" CLAMPS

SEE FIGURE 1 FOR VIEW OF TOOLS

INSTRUCTIONS:

WARNING: SEAT SHOWN FOR REFERENCE ONLY DO NOT INSTALL ON CRACKED OR DAMAGED SEAT

1. Remove seat from aircraft. Belly pan will need to be removed to access seat bolts.
2. Remove seat cover.
3. Turn seat upside down on a workbench for best access.
4. Starting at the radius of the seat, place and form reinforcement (SC22110-001) along seat with the longer end of the reinforcement positioned along the back of the seat. Clamp reinforcement to the seat. **(Refer to Figure 2).**

NOTE: Be sure clamps are not placed over any holes on the reinforcement.
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5. Continue clamping reinforcement in place by working from the center out to the edge. **(Refer to FIGURES 2 through 6)**



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6. After reinforcement is clamped completely in place, check the distance to the outer edge to ensure you have a MINIMUM OF 0.40" to 0.50" clearance between the reinforcement and the edge of the seat. If needed, check measurement with the edging removed. **(Refer to FIGURE 7)**
7. If clearance is not achieved, unclamp all clamps and start over at Step 4.
8. After edge clearance is confirmed, match drill through holes of reinforcement into the seat side using a #11 drill bit. **(Refer to FIGURE 8)**

NOTE:

Be sure to pull back foam as to not wrap it up in the drill bit.

9. In the area of the seat brackets, switch to a 12" - #30 drill bit. Drill through the holes in the seat bracket. **(Refer to FIGURE 9)**
10. Switch back to the #11 drill bit and back drill the last three (3) holes in the seat.
11. Insert a screw (AN526C1032R12) through each hole from the outside of the seat.
12. Place a washer (AN960-10) and a nut (AN365-1032A) on each screw.
13. Tighten all nuts on to screws along reinforcement. Remove each clamp when the nut and screw on each side of the clamp have been tightened into place.
14. Repeat the same process on the opposite side of the seat.
15. Reinstall seat cover and trim.
16. Reinstall seat into aircraft.

NOTE:

DO NOT FORGET TO REINSTALL THE BELLY PAN.



FIGURE 1 – TOOLS NEEDED FOR INSTALLATION

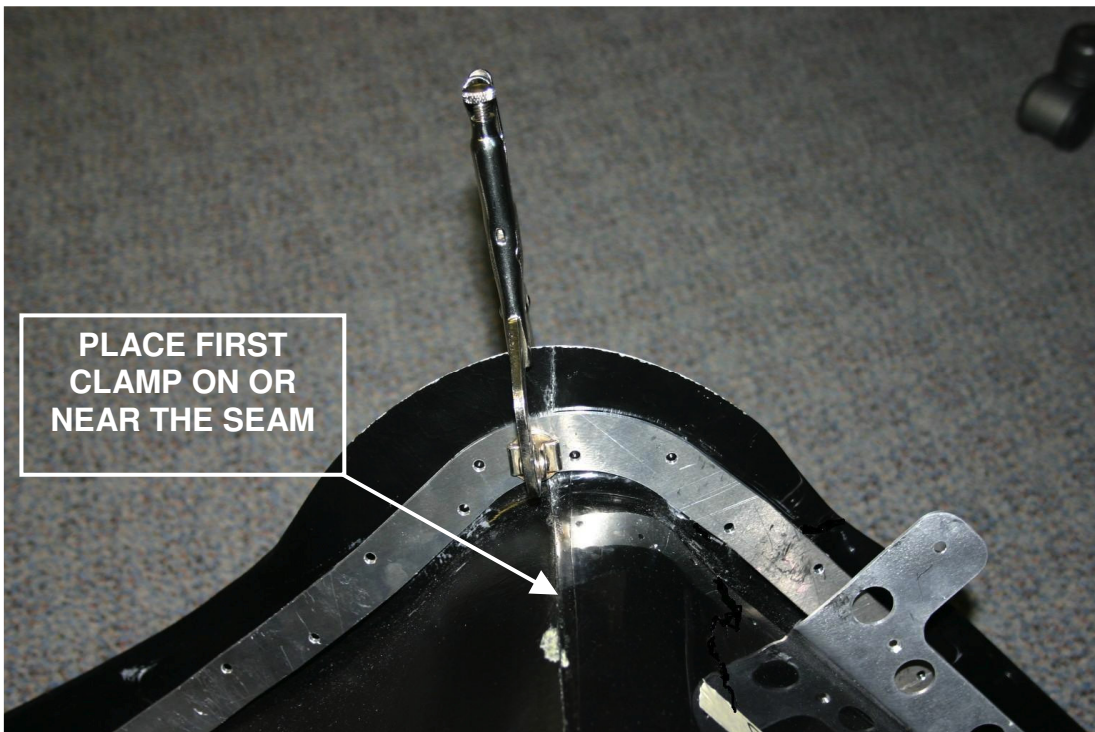


FIGURE 2 – REINFORCEMENT POSITIONING ON SEAT

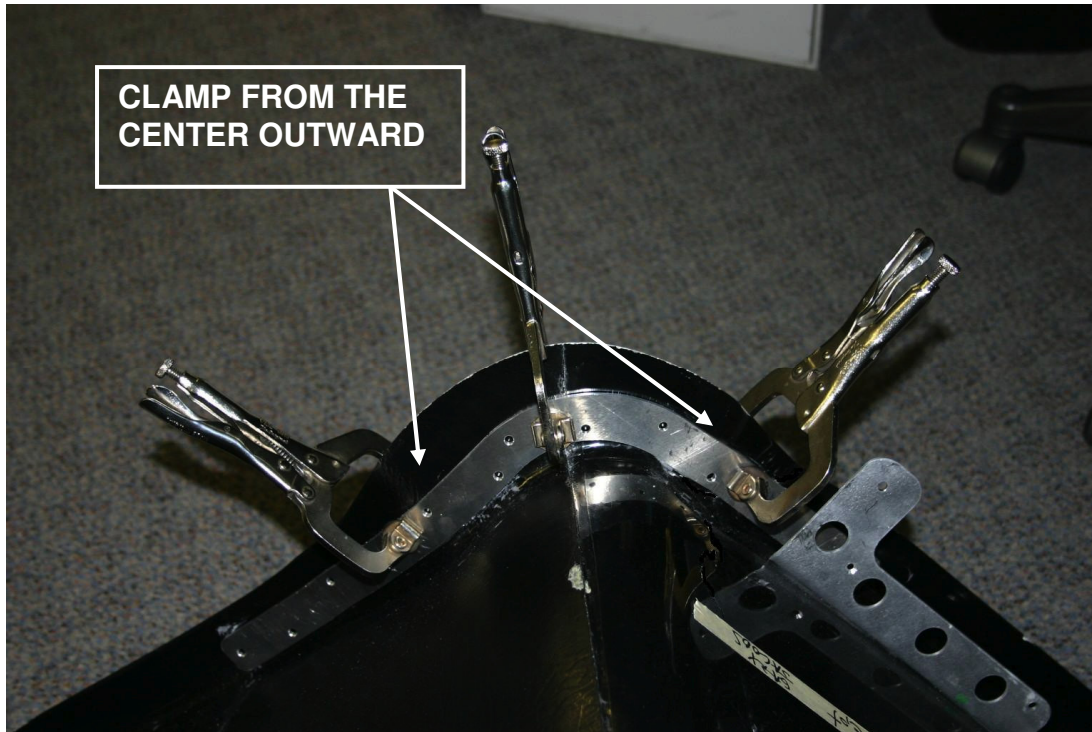


FIGURE 3 – ADDITIONAL CLAMP POSITIONS

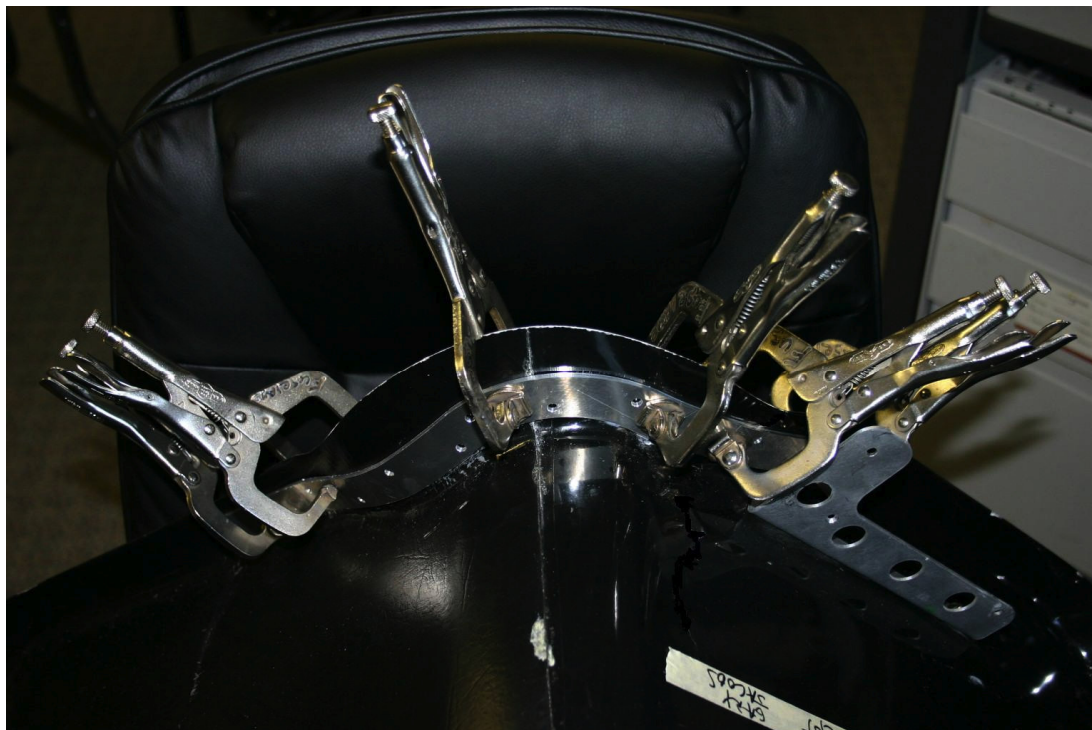


FIGURE 4 – CLAMP POSITIONS MOVING OUTWARD

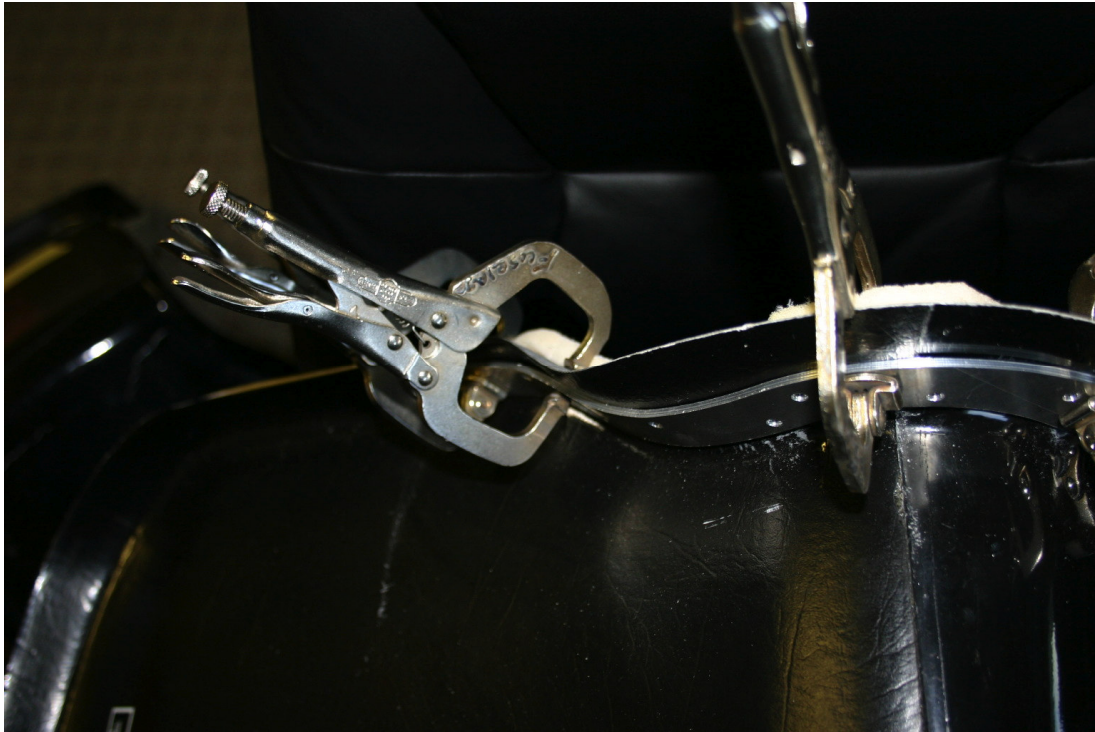


FIGURE 5 – FORMING AND CLAMPING OF REINFORCEMENT

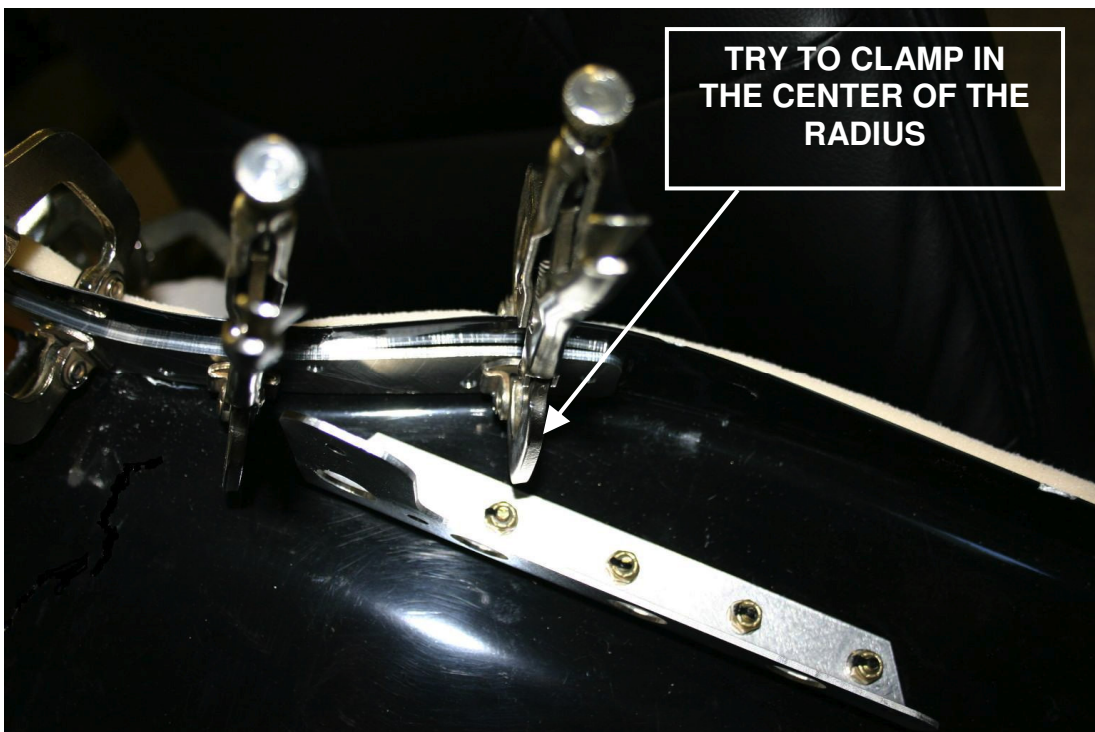


FIGURE 6 – CLAMP POSITION NEAR SEAT BRACKET

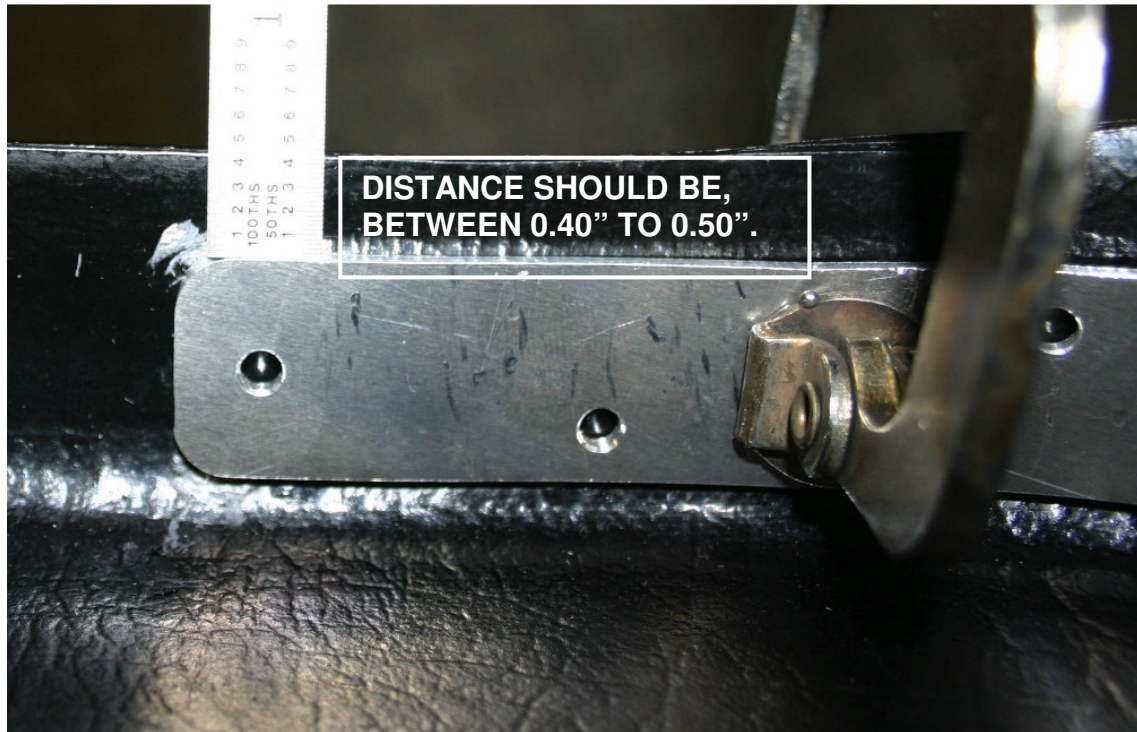


FIGURE 7 – REINFORCEMENT CLEARANCE FROM SEAT EDGE

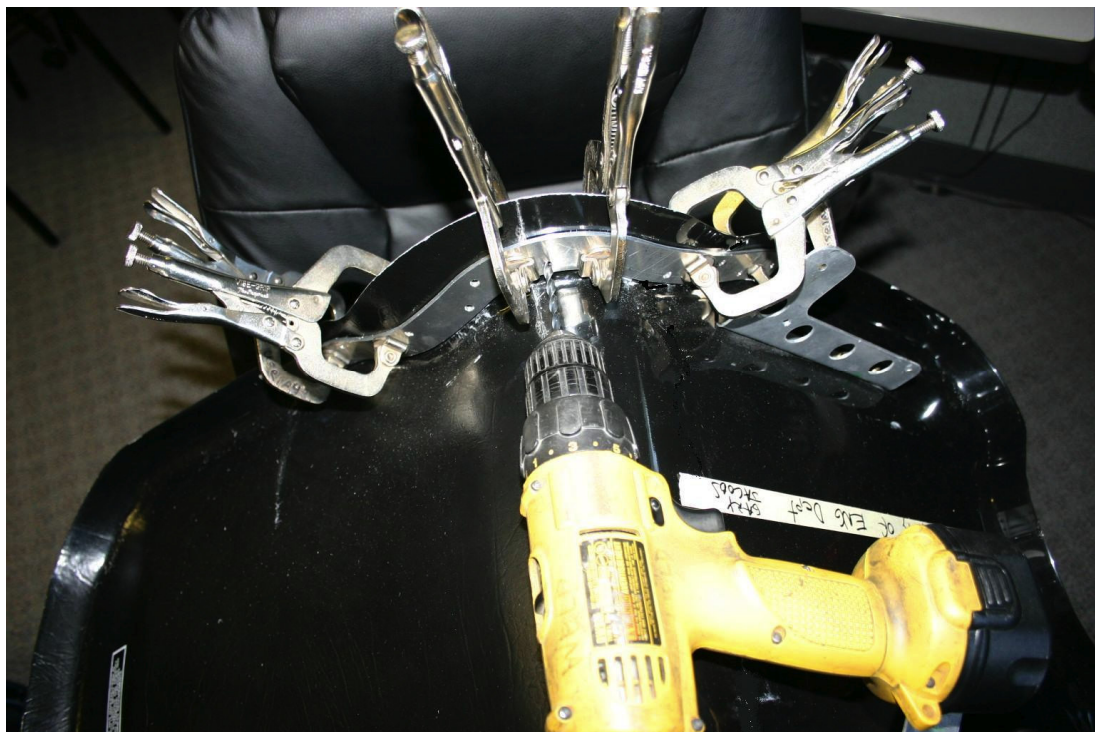


FIGURE 8 – MATCH DRILLING HOLES INTO SEAT



FIGURE 9 – MATCH DRILL HOLES WITH #30 BIT THROUGH SEAT BRACKET



FIGURE 10 –COMPLETED INSTALLATION ON SEAT BACK

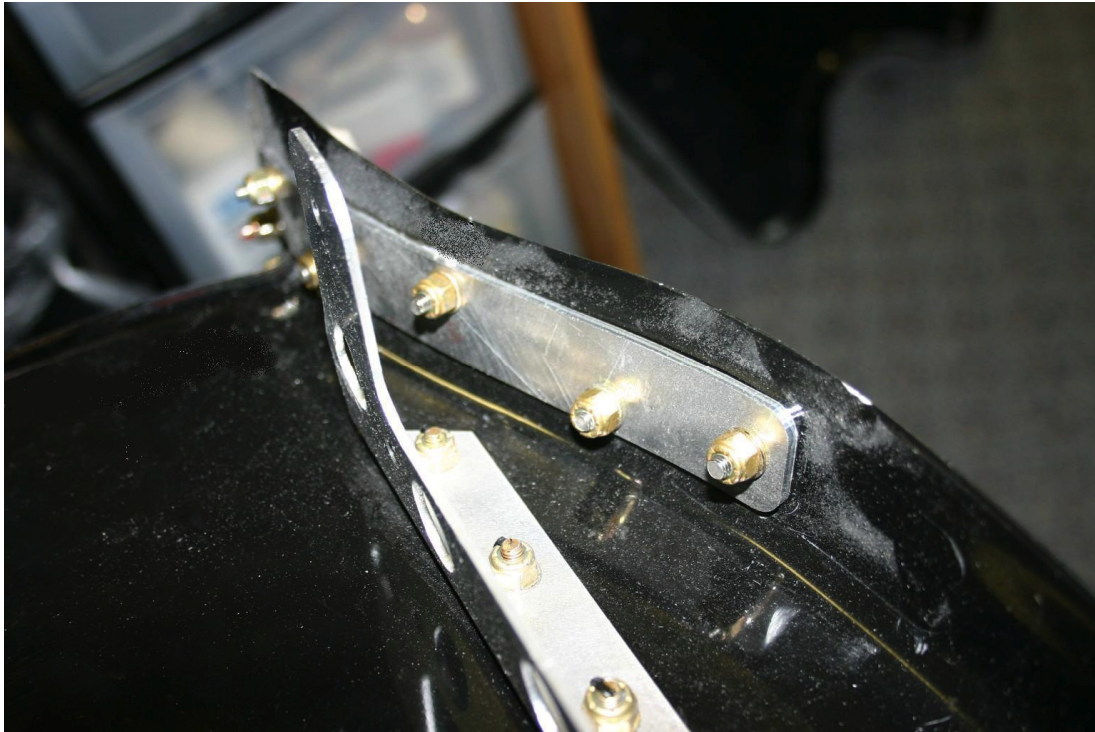


FIGURE 11 –COMPLETED INSTALLATION ON SEAT BOTTOM NEAR BRACKET