



SERVICE INSTRUCTION **SI0005**

EFFECTIVE DATE: This Service Instruction is effective December 5, 2007.

SUBJECT: Exhaust Clamp Assembly Installation for S2 Exhaust Systems

MODELS AFFECTED: CC11-100 S/N CC11-00033, CC11-00048 through CC11-00055, CC11-00057.

COMPLIANCE TIME: Prior to next flight.

PURPOSE: To replace existing exhaust hanger and clamp assembly with the newly designed system.

PARTS LIST:

PART NUMBER	DESCRIPTION	QTY
SC57261-001	S2 EXHAUST CLAMP	4
SC57262-001	S2 EXHAUST CLAMP BUSHING	2
SC57262-003	S2 EXHAUST CLAMP BUSHING	2
SC57263-001	S2 EXHAUST HANGER	1
SC57263-003	S2 EXHAUST HANGER	1
SC57264-001	S2 EXHAUST HANGER RUBBER ISOLATOR	1
AN3-14A	BOLT	2
AN3-35A	BOLT	2
AN3-7A	BOLT	2
AN363-1032	NUT, HI-TEMP LOCK	6
AN960-10	FLAT WASHER	10
AN970-3	FLAT WASHER, LARGE AREA	2
HDW-D-1202	CENTURY DIE SPRING	2
HDW-D-1404	CENTURY DIE SPRING	2

INSTRUCTIONS:

1. REMOVE ENGINE COWLING.
2. REMOVE OLD EXHAUST CLAMP.
3. GRIND OFF ANY MOUNTING TABS WELDED ONTO THE EXHAUST PIPES.

NOTE:
PAY CLOSE ATTENTION TO AVOID GRINDING INTO THE PIPE.

4. LOOSELY ASSEMBLE FOUR (4) SC57261-001 WITH FASTENERS, SC57262-001, SC57262-003, SC57263-001, SC57263-003, AND SC57264-00, AS SHOWN IN PHOTO 1 AND ATTACHED DRAWING SC57260.
5. OMIT (2) HDW-D-1202 SPRINGS, (2) AN363-1032, AND (2) AN960-10 AS SHOWN IN FIGURE 1.

6. SLIDE CLAMP SUB-ASSEMBLY ONTO S2 EXHAUST SYSTEM TO APPROXIMATELY ¼" FROM EXHAUST BENDS AS SHOWN IN PHOTO 2.
7. COMPRESS CLAMPS USING CHANNEL LOCKS OR VICE GRIPS AND INSTALL HDW-D-1202 SPRINGS (2), AN363-1032 (2), AND AN960-10 (2).
8. TIGHTEN FASTENERS (AN3-14A) IN CENTER OF CLAMPS UNTIL THERE IS APPROXIMATELY .25" BETWEEN INSIDE OF CLAMPS AS SHOWN IN FIGURE 2.
9. FASTEN SC57263-003 TO ENGINE USING CENTER OIL TANK MOUNTING STUD SHOWN IN PHOTO 3.
10. TIGHTEN CLAMP ASSEMBLY TO EXHAUST PIPES UNTIL 3-5 THREADS ARE SHOWN BEYOND NUTS (AN363-1032).
11. WHEN HANGER ASSEMBLY IS APPLYING VERY LITTLE TENSION ON THE EXHAUST SYSTEM, TIGHTEN NUTS AND BOLTS INSTALLED THROUGH SC57263-003, SC57264-001, AND SLOT OF SC57263-001 UNTIL 5 TO 7 THREADS ARE SHOWN BEYOND NUTS (AN363-1032).
12. REINSTALL ENGINE COWLING.



PHOTO 1 – S2 EXHAUST CLAMP ASSEMBLY

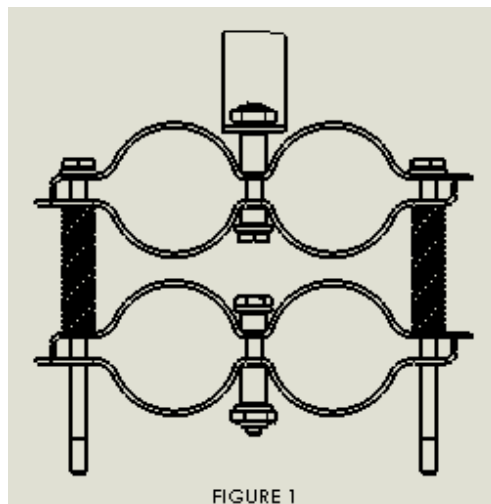


FIGURE 1

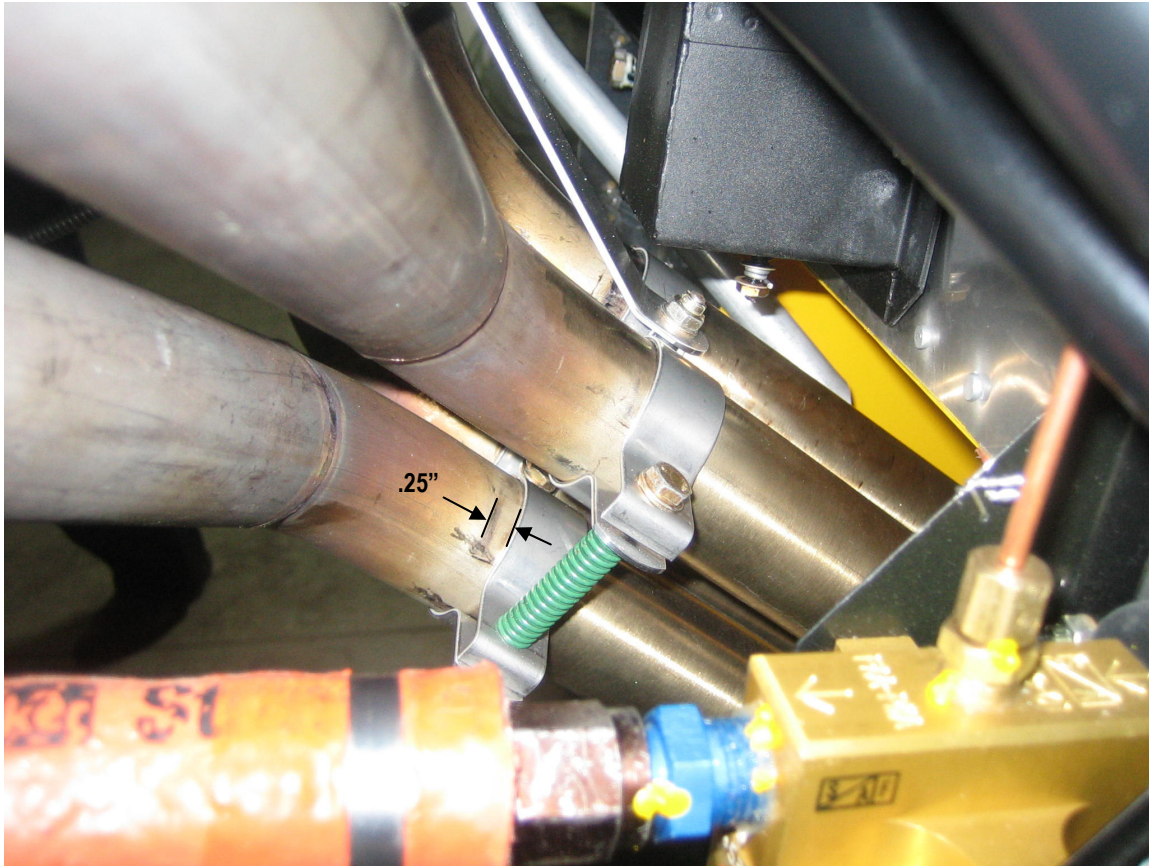


PHOTO 2 – EXHAUST CLAMP POSITION ON EXHAUST TUBES

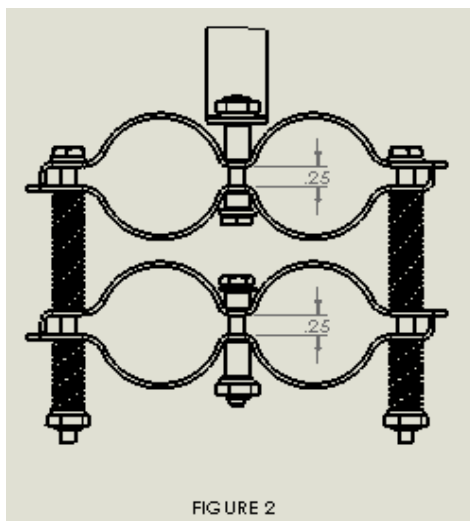
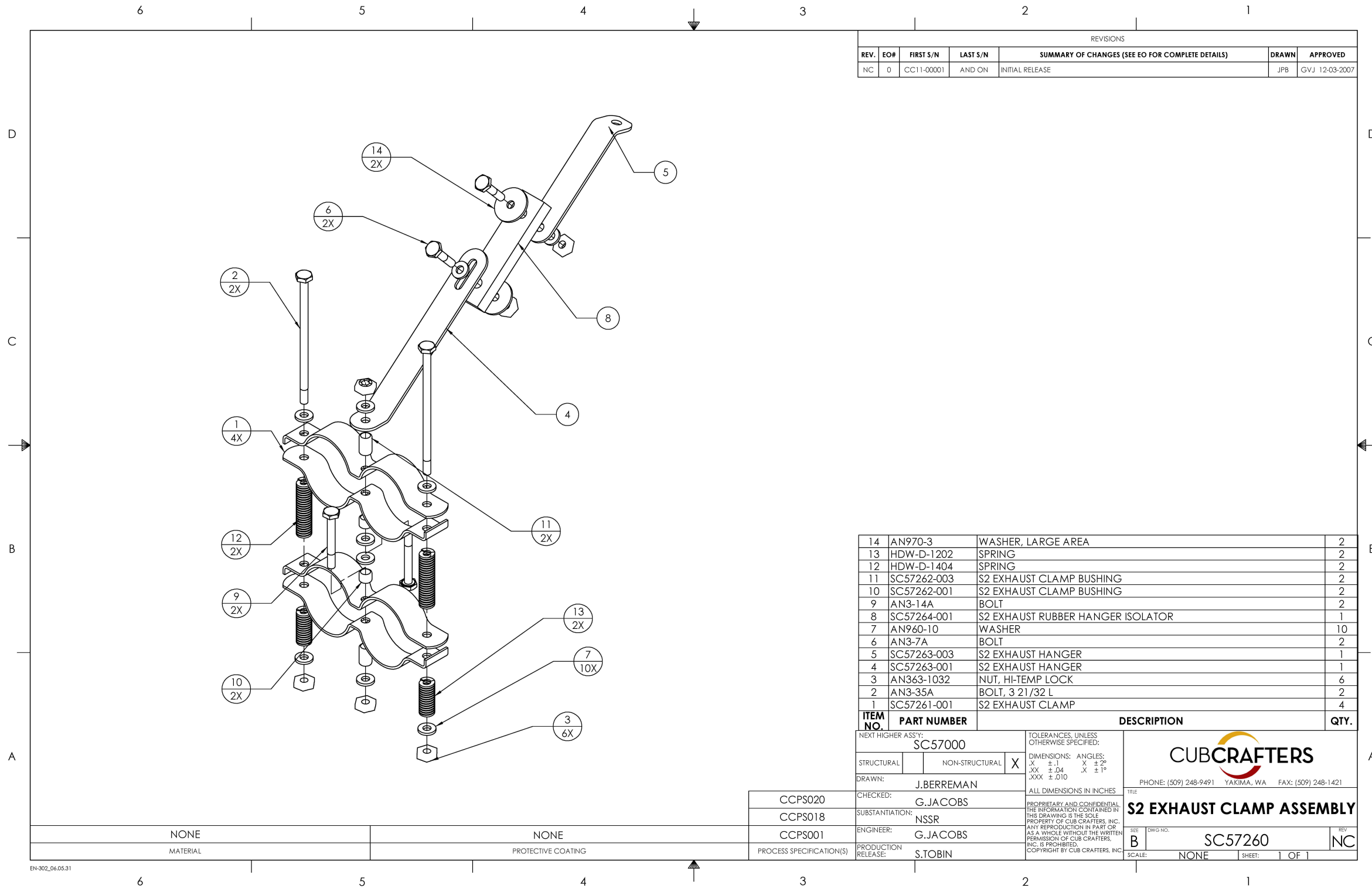


FIGURE 2



REVISIONS						
REV.	EO#	FIRST S/N	LAST S/N	SUMMARY OF CHANGES (SEE EO FOR COMPLETE DETAILS)	DRAWN	APPROVED
NC	0	CC11-00001	AND ON	INITIAL RELEASE	JPB	GVJ 12-03-2007

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
14	AN970-3	WASHER, LARGE AREA	2
13	HDW-D-1202	SPRING	2
12	HDW-D-1404	SPRING	2
11	SC57262-003	S2 EXHAUST CLAMP BUSHING	2
10	SC57262-001	S2 EXHAUST CLAMP BUSHING	2
9	AN3-14A	BOLT	2
8	SC57264-001	S2 EXHAUST RUBBER HANGER ISOLATOR	1
7	AN960-10	WASHER	10
6	AN3-7A	BOLT	2
5	SC57263-003	S2 EXHAUST HANGER	1
4	SC57263-001	S2 EXHAUST HANGER	1
3	AN363-1032	NUT, HI-TEMP LOCK	6
2	AN3-35A	BOLT, 3 21/32 L	2
1	SC57261-001	S2 EXHAUST CLAMP	4

NEXT HIGHER ASSY: SC57000		TOLERANCES, UNLESS OTHERWISE SPECIFIED:	
STRUCTURAL	NON-STRUCTURAL	X	DIMENSIONS: ANGLES:
DRAWN: J.BERREMAN		.X ±.1 X ±2°	
CHECKED: G.JACOBS		.XX ±.04 X ±1°	
SUBSTANTIATION: NSSR		.XXX ±.010	
ENGINEER: G.JACOBS		ALL DIMENSIONS IN INCHES	
PRODUCTION RELEASE: S.TOBIN			
CCPS020 CCPS018 CCPS001		PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF CUB CRAFTERS, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF CUB CRAFTERS, INC. IS PROHIBITED.	
MATERIAL: NONE		TITLE: S2 EXHAUST CLAMP ASSEMBLY DWG NO: SC57260 SCALE: NONE SHEET: 1 OF 1	
PROTECTIVE COATING: NONE		SEE: B REV: NC	

DRAWING SC57260

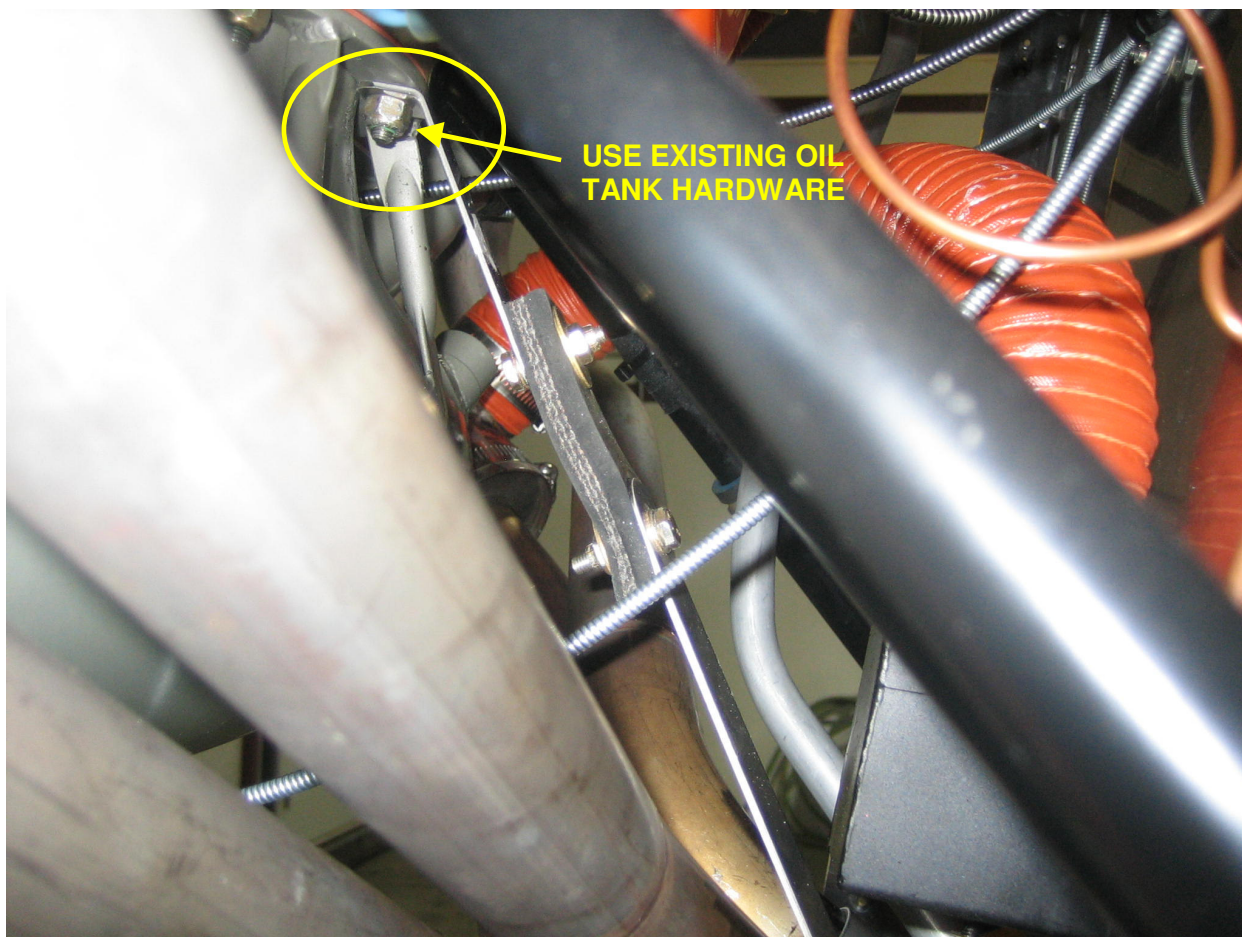


PHOTO 3 – EXHAUST HANGER ATTACHMENT TO ENGINE