



# SERVICE INSTRUCTION **SI0008**

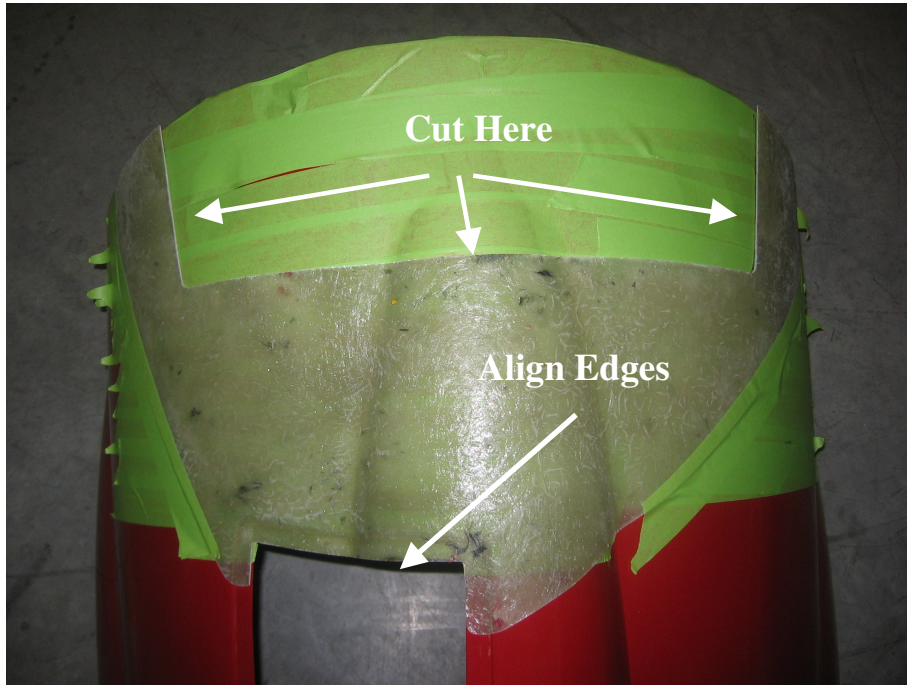
**EFFECTIVE DATE:** This Service Instruction is effective February 19, 2008.  
**SUBJECT:** Bottom Cowl Exit Lip.  
**MODELS AFFECTED:** CC11-100 S/N CC11-00001 through CC11-00047.  
**PURPOSE:** Bottom Cowl Exit Lip Installation Instructions

**PARTS LIST:**

PART NUMBER	DESCRIPTION	QTY
SC53007-001	BOTTOM COWL EXIT LIP	1
AN507C632R6	SCREW	17
AN363-632	NUT	17
AN960-6L	WASHER	17
HDW-A3236-012-935	DIMPLE WASHER	17
TEMPLATE	EXIT LIP TEMPLATE	1
TOUCH-UP-X	TOUCH-UP PAINT	1

**INSTRUCTIONS:**

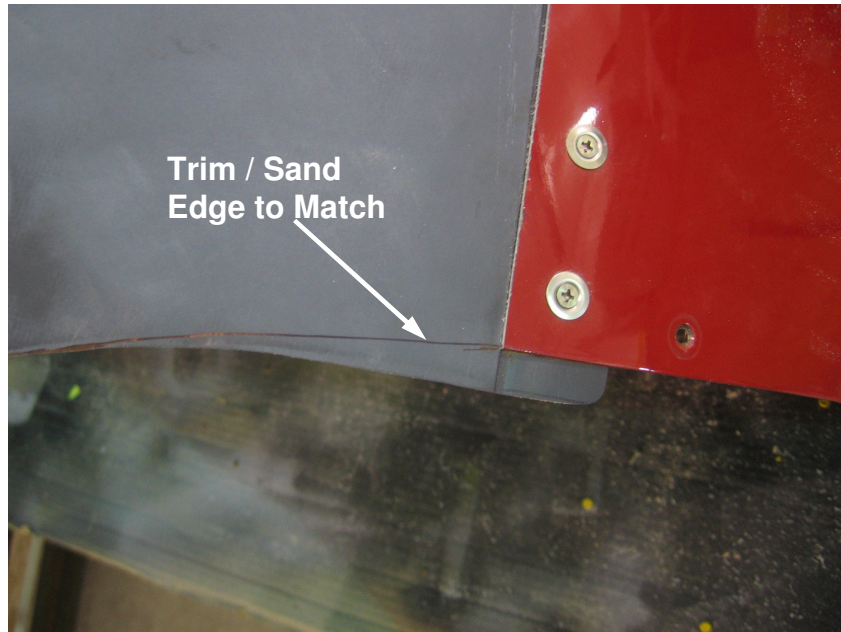
1. Remove cowling.
2. Set bottom cowl upside-down. Place template on cowl and match edge of access door with template edge. Cowl may be taped to prevent scratching. See Figure 1.
3. Mark and cut Bottom Cowl according to template. Sand edges and ensure Bottom Cowl Exit Lip (SC53007-001) fits. Apply touch-up paint to cut edge.
4. Tape or clamp Exit Lip in place. Mark and drill 17 holes with a #25 drill, centering holes in flange of lip. Countersink holes until dimpled washers sit flat. See Figure 2 for approximate screw layout.
5. Install AN507C632R6 screws, HDW-A3236-012-935 dimpled washers, AN960-6L washers, and AN363-632 nuts.
6. Trim or sand aft edges of lip to match edges of cowl. See Figure 3.
7. Apply touch-up paint where needed.
8. Reinstall cowl. Enlarge hole for gascolator, if needed.



**FIGURE 1 – TEMPLATE PLACEMENT**



**FIGURE 2 – APPROXIMATE HOLE/SCREW LOCATIONS**



**FIGURE 3 – AREA OF AFT EDGE OF LIP TO TRIM OR SAND**