356 SOP QUAD COVER AND EMERGENCY TILLER INSPECTION PORT INSTALLATION

FORWARD MOUNTING HOLES ARE 1/2" IN FROM EDGE & 1/2" AFT OF NOTCHES
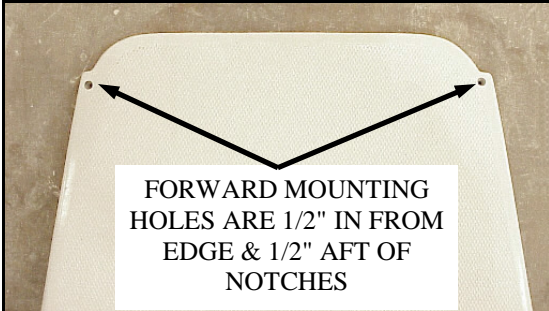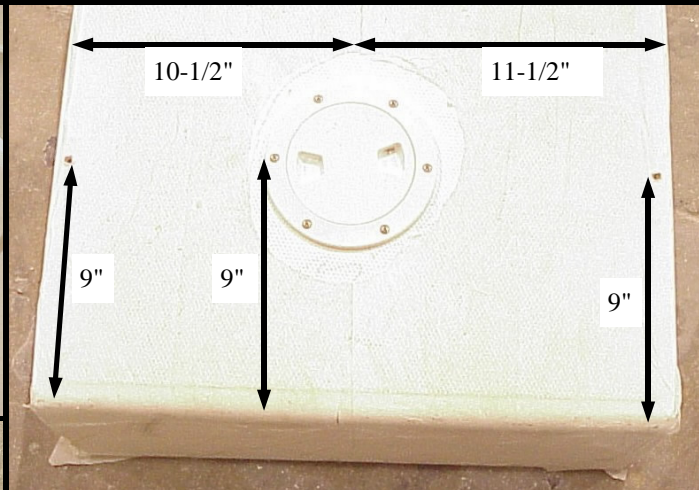
#	#Ea.	Description	Size	Part Number
1	1	Quad Cover	356	
2	4	Quad Cover Fasteners	#10 x 1 1/2" O/H	
3	1	Inspection Port	DP40-W	300520
4	6	Inspection Port Fasteners	#8 x 3/4" P/H	466950

1. The quad cover may or may not come with the inspection port installed and the mounting holes already drilled, this SOP is going to assume they did not come that way.
2. Measure 9" forward from the aft end of the quad cover and 11-1/2" inboard from the starboard side of the quad cover (or 10-1/2" inboard from the port side). This will be the center of inspection port, mark this location.
3. Drill the marked location using 4 3/4" hole saw.
4. Place the inspection port in this hole, line up two of the holes directly port to starboard, then mark the mounting hole locations.
5. Remove the inspection port then drill the marked locations using a 1/8" drill bit.
6. Dremel the edges of the holes to expose raw edge of glass (only edge of hole).
7. Clean the surface and hardware with alcohol.
8. Caulk the perimeter of the inspection port and mounting holes with white 739 caulk.
9. Secure the inspection port to the quad cover using the designated fasteners.
10. Clean up all excess caulk with alcohol.
11. Place the quad cover in position at the cockpit walk thru. Make sure quad cover is flush with deck and slid all the way forward.
12. The two forward mounting hole locations will be located 1/2" in from the edge and 1/2" aft of the notch. The two aft mounting hole locations will be located 1/2" in from the edge and 9" forward from the aft end of the cover (the same distance as the inspection port) (see pictures for clarification).
13. Drill thru the quad cover and into the deck using a C-7 drill assembly.
14. Dremel the edges of the holes in the deck to expose the raw edge of glass (only edge of hole).
15. Do not attach the quad cover to the deck several components will have to be installed under the quad cover up the line.

Revision Dates:

Expected Time: 10 min.