

Initial Install PIREP for STC #SA02486SE*

(*Full STC'd instructions are included with the kit)

1. I recommend jacking the aircraft and leveling I/A/W Beechcraft Maintenance Manual. If jacking the aircraft isn't available try to at least level the plane about its longitudinal axis. This will play a part as you are fitting the panel for final fitment and making sure the panel is level.
2. Disconnect battery power from aircraft.
3. Remove single or double yoke arm (this will make it so much easier)
4. If your aircraft has a plastic beauty panel to cover the structural panel remove that to gain access to the structural panel.
5. Remove the firewall access panel on the left side to gain access to the original Beechcraft floating panel.
6. Remove the attaching hardware that holds the floating panel in place, which will allow you to remove the instruments from the floating panel.
7. Support the instruments or remove them as you complete the following steps. Be sure to cap or plug any open lines so that debris or foreign objects do not contaminate lines. Mark wires that you disconnect for disassembly.
8. I recommend measuring the distance between your floor and the lower side of the panel/center control column (next to trim wheel) and place a support board. This can be a 1"x 2" or a 2" x 2". When you drill out the rivets holding the panel this will want to sag if not supported.
9. You will want to undo the windlass on the right side, it does cover your rivets holding the panel.
10. With a spring-loaded center punch, locate the rivets holding the structural panel to the airframe. In the center of the rivet head you will find a small dimple. Place the

pointed end of the center punch into the recessed dimple and actuate the punch a couple of times to help the drill bit find its location.

11. With a drill (I use a Dotco 1/4 pneumatic drill for precision) insert a #40 drill bit and start to drill the rivets. Be sure to keep the drill at a 90 degree angle to the panel. Try not to put too much pressure as you are drilling, the #40 drill bit is very small and can bend or break easily. I had 26 rivets (7 on left, 13 around control column and 6 on right side). With all of those rivets out of the way, if you still have an original panel you will need to drill out the rivets across the top of the panel.

12. On the forward side of the panel at the bottom are a few rivets holding the base of the panel to the top side of the piano keys. These rivets are toward the outboard edges. Use a small dremel tool to shave off the head of the rivet. Once the heads have been ground use plastic tool to wedge between aluminum key and panel. After the baseline is out be sure to file or grind tails of rivets off flush with piano keys.

13. Grab your new panel and head towards the plane. The easiest way to start fitting is to slide left side under window rail and place notch on right side near the right hand door post (A pillar), lift panel up and fit around center console. Each plane has little differences so filing might be necessary. Be sure to leave a little gap all the way around the edges so the panel and airframe are not rubbing each other.

14. Once the panel is fitted in take a level and make sure it's level across the top (left to right). Once satisfied, drill from forward side through engine compartment side and back drill a couple of holes with a #40 drill, inserting clecos as you go.

Questions?

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