

GENERAL NOTES:

- PERFORM ALL WORK IN ACCORDANCE WITH STANDARD PRACTICES OF EUROCOPTER AS350 SRM & AC43.13-1B/2B.
 - AIRCRAFT METAL WORK * AC43.13-1B, CH 4 & 6
 - AIRCRAFT HARDWARE * AC43.13-1B, CH 7
 - STRUCTURAL DATA * AC43.13-2B, CH 1
 - ANTENNA INSTL. * AC43.13-2B, CH 3
- DEBUR, BRUSH ALODINE (AS PER MIL-C-5541), AND EPOXY PRIME (AS PER MIL-P-23377) ALL MODIFIED OR NEWLY FABRICATED BARE METAL PARTS.
- EQUIVALENT FASTENERS MAY BE USED IN LIEU OF THOSE SPECIFIED. FASTENER LENGTH TO BE DETERMINED ON INSTALL.
- NO LESS THAN A MINIMUM:
 - 2D FASTENER EDGE DISTANCE
 - 4D FASTENER CENTER TO CENTER DISTANCE
 - 3T BEND RADIUS
- PAINT EXPOSED SURFACE IAW MIL-C-22750 (OR EQUIVALENT) TO MATCH EXISTING COLOUR OF ACFT. DO NOT PAINT ANTENNA.
- THE DATA CONTAINED HEREIN CONSIDERS STRUCTURAL DETAILS ONLY. REFER TO APPLICABLE WIRING DIAGRAMS FOR DETAILS REGARDING WIRING, EQUIPMENT, AND SYSTEMS OPERATIONS.

7 UP TO SIX ANTENNAS MAY BE INSTALLED AT ONCE. POSITION THE ANTENNAS UPON INSTALLATION. THE LOCATION OF THE ANTENNAS CAN BE INTERCHANGED. ENSURE THAT EACH ANTENNA IS 6 INCHES AWAY FROM AN EXISTING STRUCTURE (IE. LIGHTS, LANDING GEAR, JACKING MOUNTS AND OTHER ANTENNAS). MEASURE DISTANCE BETWEEN ANTENNA AND ADJACENT ITEM FROM ANTENNA'S CONNECTOR.

8 UP TO FOUR ANTENNAS MAY BE INSTALLED AT ONCE. POSITION THE ANTENNAS UPON INSTALLATION. THE LOCATION OF THE ANTENNAS CAN BE INTERCHANGED. ENSURE THAT EACH ANTENNA IS 6 INCHES AWAY FROM AN EXISTING STRUCTURE (IE. LIGHTS, LANDING GEAR, JACKING MOUNTS AND OTHER ANTENNAS). MEASURE DISTANCE BETWEEN ANTENNA AND ADJACENT ITEM FROM ANTENNA'S CONNECTOR.

9 UP TO FIVE ANTENNAS MAY BE INSTALLED AT ONCE. POSITION THE ANTENNAS UPON INSTALLATION. THE LOCATION OF THE ANTENNAS CAN BE INTERCHANGED. ENSURE THAT EACH ANTENNA IS 6 INCHES AWAY FROM AN EXISTING STRUCTURE (IE. LIGHTS, LANDING GEAR, JACKING MOUNTS AND OTHER ANTENNAS). MEASURE DISTANCE BETWEEN ANTENNA AND ADJACENT ITEM FROM ANTENNA'S CONNECTOR.

10 INSTALL ITEMS 301 & 302 (OR 303 OR 304 OR 324) IN CENTER PEDESTAL, ONTO DZUS RAILS. USE PROVIDED PROVISIONS. LOCATE UPON INSTALLATION.

11 ITEM 305 IS OPTIONAL. MAY BE INSTALLED ON SECONDARY STRUCTURE WITHIN THE ROTORCRAFTS CABIN OR FLIGHT DECK IN ACCORDANCE WITH MANUFACTURERS INSTRUCTIONS AND AC43.13 1B/2B STANDARD PRACTICES, USING STANDARD AIRCRAFT HARDWARE,

12 DRILL HOLES THROUGH SKIN OF FUSELAGE TO MATCH ANTENNA'S FOOTPRINT. MATCH FASTENER AND CONNECTOR HOLE SIZES AS SHOWN ON INSTALL

13 DEBURR HOLE AND REMOVE DEBRIS AND LOOSE MATERIAL FROM CAVITY AND SURFACE OF COMPOSITE PANEL. FILL UNDERCUT WITH EPOCAST 87269-A/B (OR EQUIVALENT) TO MATCH THE HOLE EDGE IN FACINGS, SAND SMOOTH AND FLUSH WHEN CURED.

14 ENSURE PROPER ELECTRICAL BONDING BETWEEN THE DOUBLER AND AIRCRAFT IN ACCORDANCE WITH ANTENNA MANUFACTURER INSTRUCTIONS. GROUND USING ELECTRICAL STRAPS AS REQUIRED PER AC43.13 CHAPTER 11 SECTION 15.

15 SIZE AND TRIM DOUBLERS AS REQUIRED UPON INSTALLATION.

16 ITEM 312 CAN ONLY BE INSTALLED IF THE ROTORCRAFT IS IN A HIGH-SKID LANDING GEAR CONFIGURATION.

ITEMS 312 IS COMPRISED OF THE FOLLOWING COMPONENTS:

- P/N 302-002-001 TUNER BOX (1.63 LBS)
- P/N 302-002-002 COAXIAL CABLE (9 INCHES) (0.13 LBS)
- P/N 302-002-003 45° BASE MOUNT WITH KIT (0.31 LBS)
- P/N 302-002-004 WHIP ANTENNA ROD (0.13 LBS)
- P/N 302-002-005 INSTALLATION KIT, CONN. WITH PIN (0.30 LBS)

TUNER BOX IS TO BE INSTALLED ON THE INTERIOR BOTTOM SHELL ASSEMBLY USING STANDARD AN/MS #10 HARDWARE IN ACCORDANCE WITH THE PRACTICES OF AS350 MAINTENANCE MANUAL AND/OR AC43.13-1B/2B.

17. IDENTIFY PARTS WITH MIN 0.12 HIGH CHARACTERS USING PERMANENT INK. IDENTIFICATION TO INCLUDE PART NUMBER AND REVISION STATUS.

18 UP TO TWO ANTENNAS MAY BE INSTALLED AT ONCE. POSITION THE ANTENNAS UPON INSTALLATION. THE LOCATION OF THE ANTENNAS CAN BE INTERCHANGED. ENSURE THAT EACH ANTENNA IS 6 INCHES AWAY FROM AN EXISTING STRUCTURE (IE. LIGHTS, LANDING GEAR, JACKING MOUNTS AND OTHER ANTENNAS). MEASURE DISTANCE BETWEEN ANTENNA AND ADJACENT ITEM FROM ANTENNA'S CONNECTOR.

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RECORD OF REVISIONS				
REV	DATE: (DD/MM/YY)	DESCRIPTION OF CHANGES	DWN	APPD
A	05/03/13	INITIAL ISSUE	CMA	JW
B	09/10/13	REVISED TO INCLUDE ITEM 317 AND NOTE 17.	CES	JW
C	02/04/14	ITEM 318 TO 323 ADDED, DISTINGUISHED BETWEEN -001, -003, -005 INSTALLS. REORGANIZED LOM & FLAG NOTES.	JA	TM
D	04/06/14	-007 INSTALL, FLAG NOTE 18 & ITEM 324 ADDED.	JA	TM



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AS 350 D AS 350 BA AS 350 B3 AS 350 B2 AS 350B, AS 350B1 USED ON APPLICATION		UNLESS OTHERWISE SPECIFIED, ALL LINEAR DIMENSIONS ARE IN INCHES. TOLERANCES: LINEAR: X.X ±0.1 X.XX ±0.03 X.XXX ±0.010 ANGULAR: X.X ±0°30' MACHINED SURFACES: 125 ✓		TDFM 9000 ANTENNA INSTALLATION - AS350 SIZE B DWG NUMBER: 5004272 SCALE: NTS NCA: L6518 SHEET 1 OF 19

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QUANTITY/DASH NO														LIST OF MATERIAL						
														NUMBER	DESCRIPTION	MATERIAL	SPEC	SIZE	ITEM	
														-121	INTERNAL DOUBLER, AT-1108	AL ALY 2024-T3	QQ-A-250/5	0.050" THK	121	
	1													-119	INTERNAL DOUBLER, AT-256	AL ALY 2024-T3	QQ-A-250/5	0.050" THK	119	
		1												-117	INTERNAL DOUBLER, S65-1227	AL ALY 2024-T3	QQ-A-250/5	0.050" THK	117	
			1											-115	INTERNAL DOUBLER, S65-8282	AL ALY 2024-T3	QQ-A-250/5	0.050" THK	115	
				1										-113	INTERNAL DOUBLER, AV-925	AL ALY 2024-T3	QQ-A-250/5	0.050" THK	113	
					1									-111	INTERNAL DOUBLER, 21-50-45	AL ALY 2024-T3	QQ-A-250/5	0.050" THK	111	
						1								-109	INTERNAL DOUBLER, CL-295	AL ALY 2024-T3	QQ-A-250/5	0.050" THK	109	
							1							-107	INT/EXT DOUBLER, CL-306	AL ALY 2024-T3	QQ-A-250/5	0.050" THK	107	
								1						-105	INTERNAL DOUBLER, CL-285	AL ALY 2024-T3	QQ-A-250/5	0.050" THK	105	
									1					-103	INTERNAL DOUBLER, CL-275	AL ALY 2024-T3	QQ-A-250/5	0.050" THK	103	
										1				-101	INTERNAL DOUBLER, CL-292	AL ALY 2024-T3	QQ-A-250/5	0.050" THK	101	
											A/R	A/R	A/R	A/R	-071	AT-1108 INSTALL				71
											A/R	A/R	A/R	A/R	-069	AT-256 INSTALL				69
											A/R	A/R	A/R	A/R	-067	S65-1227 INSTALL				67
											A/R	A/R	A/R	A/R	-065	S65-8282 INSTALL				65
											A/R	A/R	A/R	A/R	-063	AV-925 INSTALL				63
											A/R	A/R	A/R	A/R	-061	21-50-45 INSTALL				61
											A/R	A/R	A/R	A/R	-059	CL-295 INSTALL				59
											A/R	A/R	A/R	A/R	-057	CL-306 INSTALL				57
											A/R	A/R	A/R	A/R	-055	CL-285 INSTALL				55
											A/R	A/R	A/R	A/R	-053	CL-275 INSTALL				53
											A/R	A/R	A/R	A/R	-051	CL-292 INSTALL				51
															-007	TDFM 9100 INSTALLATION	9100 CONFIGURATION	NOTE 18		7
															-005	TDFM 9300 INSTALLATION	9300 CONFIGURATION	NOTE 9		5
															-003	TDFM 9200 INSTALLATION	9200 CONFIGURATION	NOTE 8		3
															-001	TDFM 9000 INSTALLATION	9000 CONFIGURATION	NOTE 7		1

ODD DASH NUMBER IS SHOWN. THE NEXT HIGHER CONSECUTIVE EVEN DASH NUMBER IS OPPOSITE.



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AVIATION ENGINEERING LIMITED TEL (905) 405-1371 FAX (905) 405-1373

TDFM 9000 ANTENNA
INSTALLATION - AS350
SIZE: B DWG NUMBER: 5004272 REV: D
SCALE: NTS NCAGE: L6518 SHEET 2 OF 19

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QUANTITY/DASH NO														LIST OF MATERIAL						
-071	-069	-067	-065	-063	-061	-059	-057	-055	-053	-051	-007	-005	-003	-001	NUMBER	DESCRIPTION	MATERIAL	SPEC	SIZE	ITEM
				6											P101F25-()	INSERT, NON-FLUSH PLUG		ALCOA FASTENING	#1/4	214
				6											S101D25-()	INSERT, FLUSH SLEEVE		ALCOA FASTENING	#1/4	213
6	8	4	6		6	6				4	3				P101F18-()	INSERT, NON-FLUSH PLUG		ALCOA FASTENING	#10	212
6	8	4	6		6	6				4	3				S101D18-()	INSERT, FLUSH SLEEVE		ALCOA FASTENING	#10	211
							4	6							P101F15-()	INSERT, NON-FLUSH PLUG		ALCOA FASTENING	#8	210
							4	6							S101D15-()	INSERT, FLUSH SLEEVE		ALCOA FASTENING	#8	209
				6											MS21059L4	NUTPLATE, SELF-LOCK 2LUG, FLOAT			#1/4-28	208
6	8	4	6		6	6				4	3				MS21059L3	NUTPLATE, SELF-LOCK 2LUG, FLOAT			#10-32	207
							4	6							MS21059L08	NUTPLATE, SELF-LOCK 2LUG, FLOAT			#8-32	206
		4				6									MS24694-()	SCREW, MACHINE FLAT CSK, STRCT			#10-32	205
				6											MS27039-()	SCREW, MACHINE PAN HEAD, STRCT			#1/4-28	204
6	8		6		6					4	3				MS27039-()	SCREW, MACHINE PAN HEAD, STRCT			#10-32	203
							4	6							MS27039-()	SCREW, MACHINE PAN HEAD, STRCT			#8-32	202
12	16	8	12	12	12	12	8	12	8	6					MS20426AD3-()	RIVET, SOLID CSK HEAD	AL ALY		ø3/32	201

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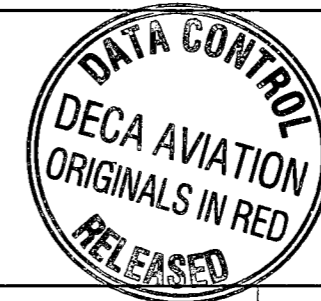
TDFM 9000 ANTENNA
 INSTALLATION - AS350

SIZE B	DWG NUMBER: 5004272	REV D
SCALE: NTS	NCAGE: L6518	SHEET 3 OF 19

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QUANTITY/DASH NO	NUMBER	DESCRIPTION	MATERIAL	SPEC	SIZE	ITEM		
	1	121270-D-91-()	FM TRANCEIVER - TDFM-9100	TECHNISONIC INDUSTRIES	7.0 LBS	324		
1		SC-D-459388	AT-1108/ARC ANTENNA	RAMI ANTENNA	3.5 LBS	323		
1		65256BI	AT-256A/ARC ANTENNA	M5815/01-1	2.0 LBS	322		
1		S65-1227-2	UHF ANTENNA	SENSOR SYSTEMS INC.	1.4 LBS	321		
1		S65-1227	UHF ANTENNA	SENSOR SYSTEMS INC.	1.3 LBS	320		
1		S65-8282-51	VHF/UHF ANTENNA	SENSOR SYSTEMS INC.	2.5 LBS	319		
1		S65-8282-50	VHF/UHF ANTENNA	SENSOR SYSTEMS INC.	2.5 LBS	318		
1		S65-8282-34	VHF/UHF ANTENNA	SENSOR SYSTEMS INC.	2.5 LBS	317		
1		AV-925	VHF/UHF/700/800 ANTENNA	RAMI ANTENNA	1.8 LBS	316		
1		21-50-45	MULTIBAND FM COMM ANTENNA	COOPER ANTENNAS	2.5 LBS	315		
1		CL-295-250	DUAL BAND/DUAL PORT ANTENNA	COMANT INDUSTRIES	2.0 LBS	314		
1		CL-295-200	DUAL BAND/DUAL PORT ANTENNA	COMANT INDUSTRIES	2.0 LBS	313		
1		302-0002-000	ANTENNA, FLX-3050B	FOXTRONIC INC.	2.5 LBS	312		
1		CL-306	800 ANTENNA, 806 TO 870 MHZ	COMANT INDUSTRIES	0.15 LBS	311		
1		CL-285	RADIOPHONE ANTENNA	COMANT INDUSTRIES	0.75 LBS	310		
1		CL-275	RADIOPHONE ANTENNA	COMANT INDUSTRIES	0.5 LBS	309		
1		CL-292-4	FM EXTENDED BAND ANTENNA	COMANT INDUSTRIES	0.5 LBS	308		
1		CL-292-3	FM EXTENDED BAND ANTENNA	COMANT INDUSTRIES	0.5 LBS	307		
1		CL-292-1	VHF COMMUNICATION ANTENNA	COMANT INDUSTRIES	0.5 LBS	306		
(1)	(1)	(1)	RC-9000	TRANSCEIVER REMOTE CONTROL	NOTE 11	TECHNISONIC INDUSTRIES	1.0 LBS	305
1		101263-D-93-()	FM TRANCEIVER - TDFM-9300	TECHNISONIC INDUSTRIES	7.0 LBS	304		
1		101263-D-92-()	FM TRANCEIVER - TDFM-9200	TECHNISONIC INDUSTRIES	7.0 LBS	303		
1		101263-D-90-()	FM TRANCEIVER - TDFM-9000	TECHNISONIC INDUSTRIES	7.0 LBS	302		
1	1	1	1	SRA-6000	SWITCH RECEIVER ATTENUATOR	TECHNISONIC INDUSTRIES		301

ODD DASH NUMBER IS SHOWN. THE NEXT HIGHER CONSECUTIVE EVEN DASH NUMBER IS OPPOSITE.

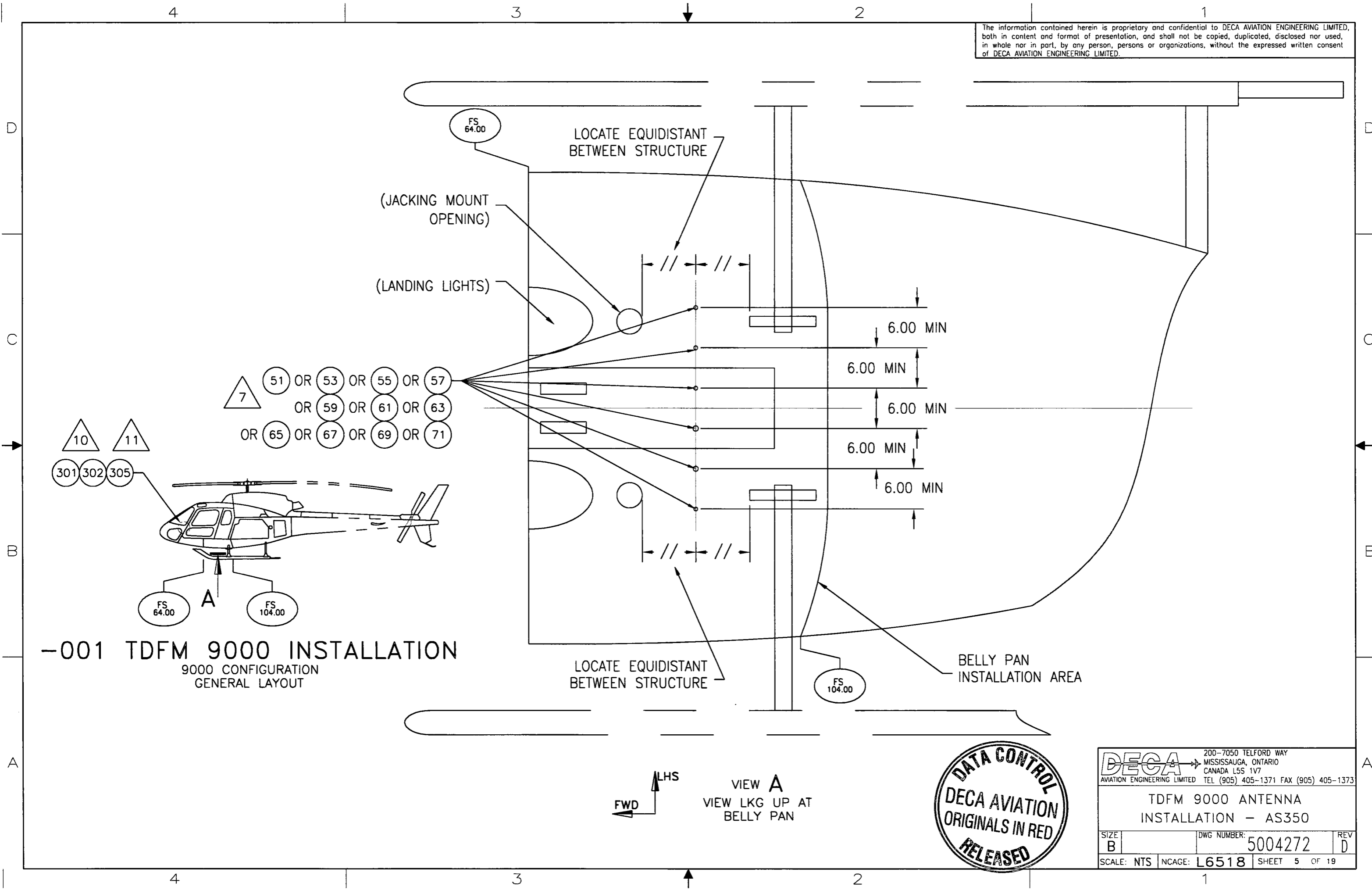


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TDFM 9000 ANTENNA
 INSTALLATION - AS350

SIZE B DWG NUMBER: 5004272 REV D
 SCALE: NTS NCAGE: L6518 SHEET 4 OF 19

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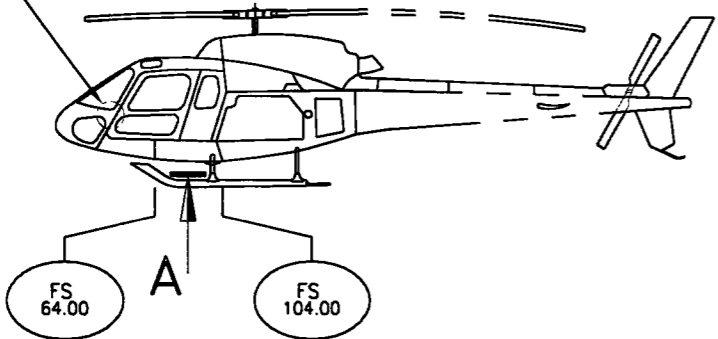


-001 TDFM 9000 INSTALLATION
 9000 CONFIGURATION
 GENERAL LAYOUT

- △ 7
- 51 OR 53 OR 55 OR 57
- OR 59 OR 61 OR 63
- OR 65 OR 67 OR 69 OR 71

- △ 10
- △ 11

- 301
- 302
- 305



LOCATE EQUIDISTANT BETWEEN STRUCTURE

(JACKING MOUNT OPENING)

(LANDING LIGHTS)

6.00 MIN

6.00 MIN

6.00 MIN

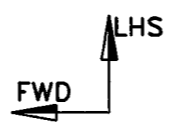
6.00 MIN

6.00 MIN

LOCATE EQUIDISTANT BETWEEN STRUCTURE

BELLY PAN INSTALLATION AREA

FS 104.00

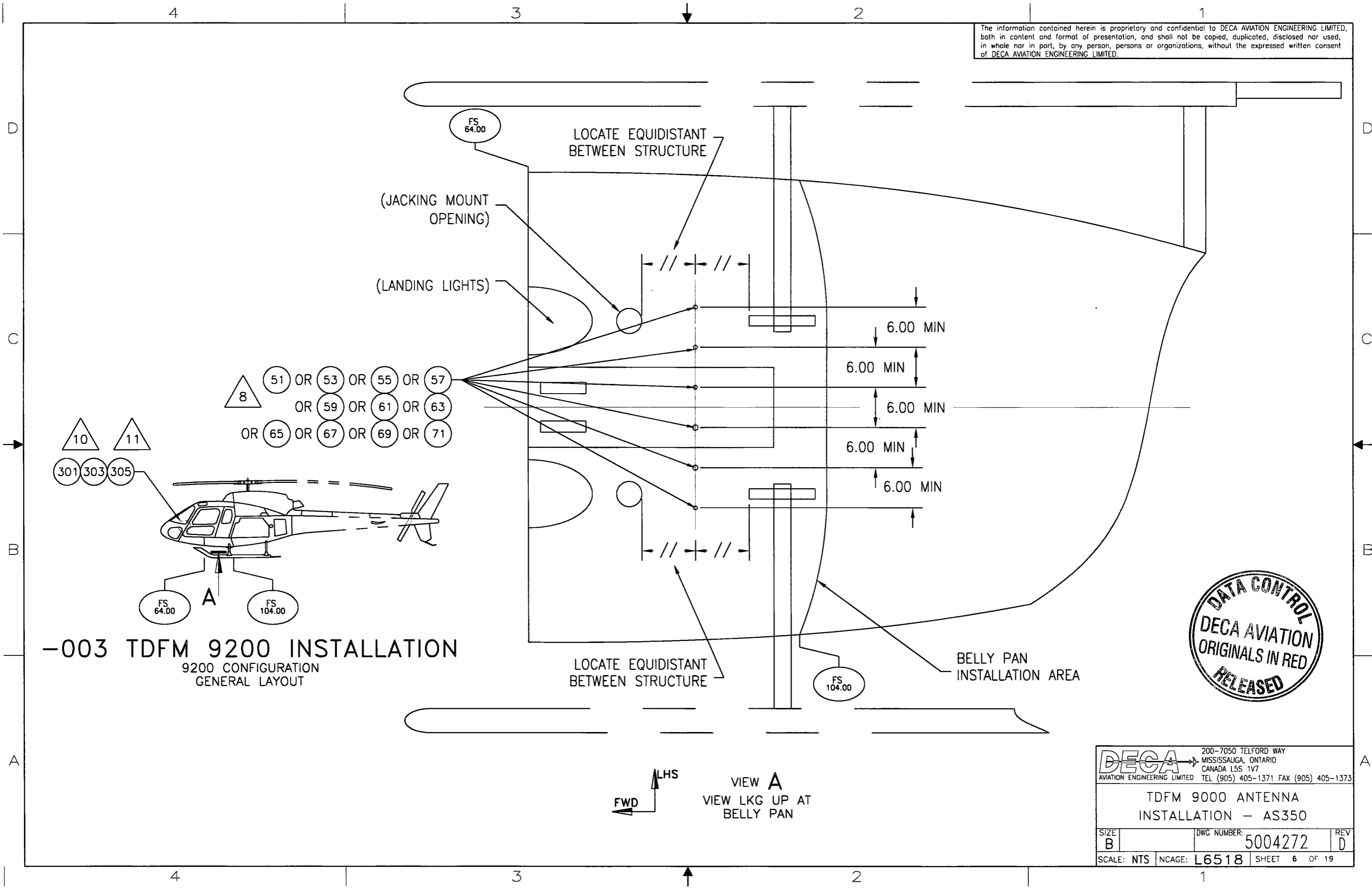


VIEW A
 VIEW LKG UP AT
 BELLY PAN



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TDFM 9000 ANTENNA INSTALLATION - AS350			
SIZE B	DWG NUMBER: 5004272	REV D	
SCALE: NTS	NCAGE: L6518	SHEET 5 OF 19	

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-003 TDFM 9200 INSTALLATION
 9200 CONFIGURATION
 GENERAL LAYOUT

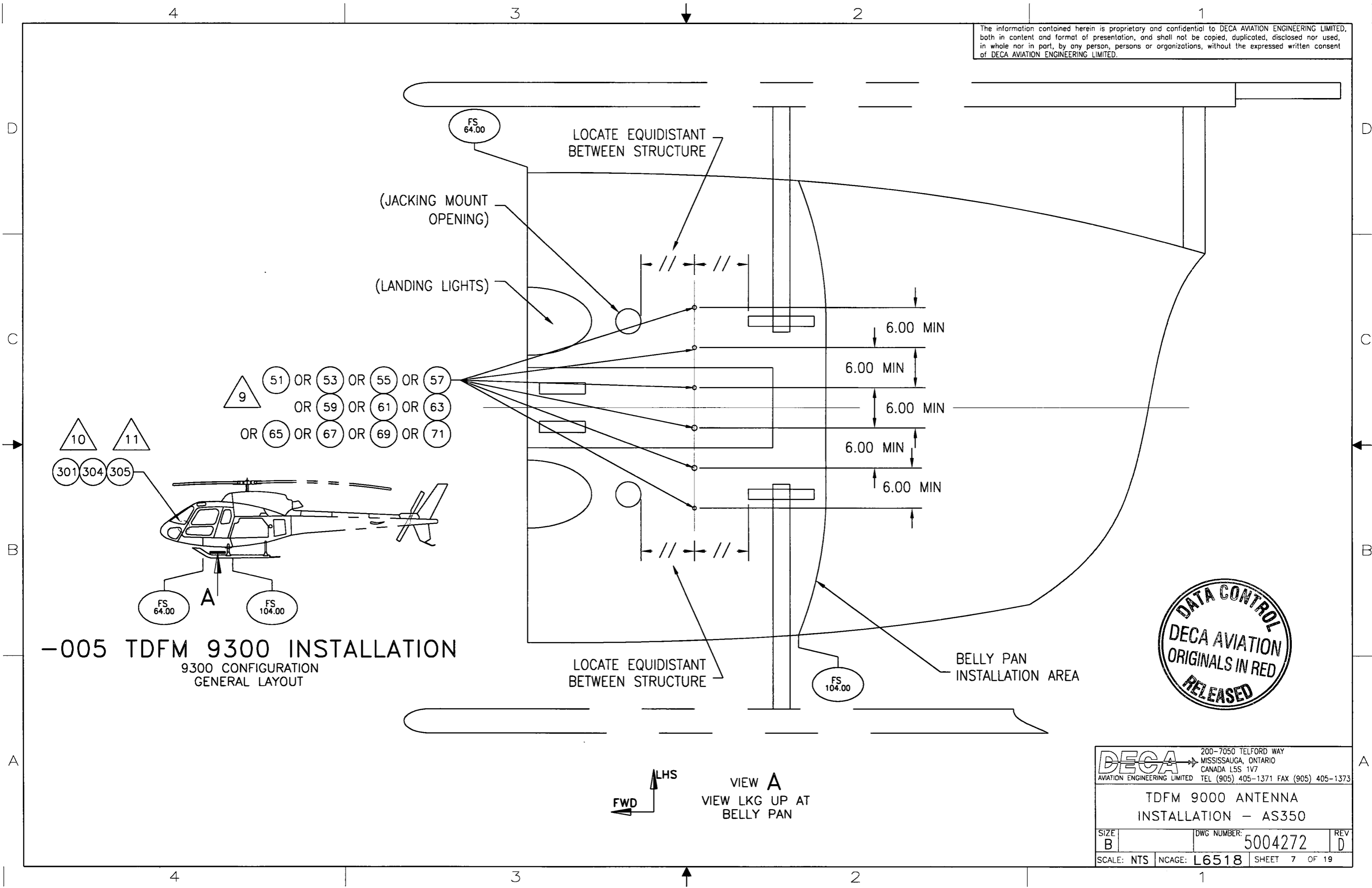


FWD ↑
 LHS ↑
VIEW A
 VIEW LKG UP AT
 BELLY PAN

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 MISSISSAUGA, ONTARIO
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TDFM 9000 ANTENNA INSTALLATION - AS350		
SIZE B	DWG NUMBER: 5004272	REV D
SCALE: NTS	NCAGE: L6518	SHEET 6 OF 19

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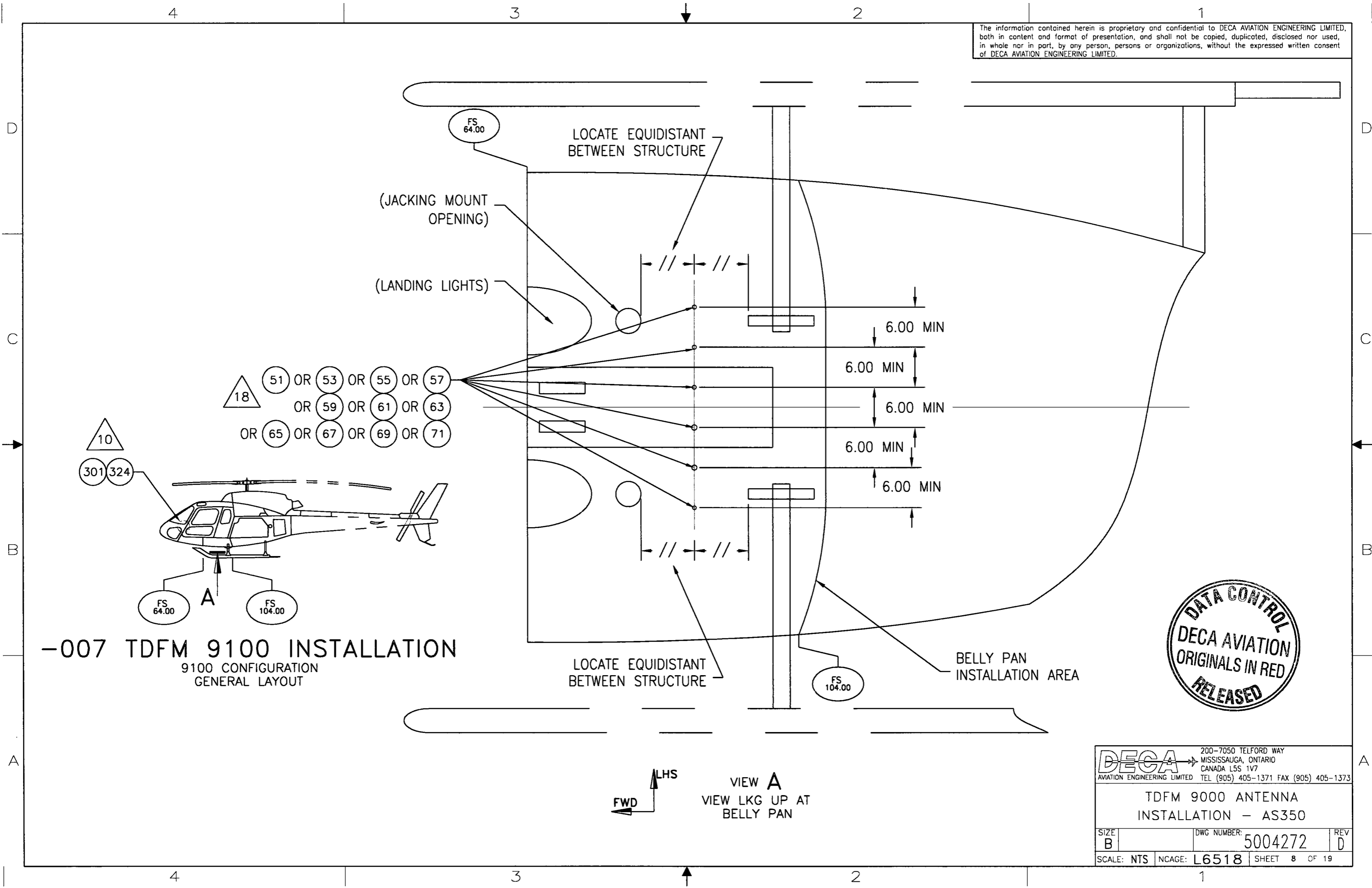
-005 TDFM 9300 INSTALLATION
9300 CONFIGURATION
GENERAL LAYOUT



FWD ↑
LHS ↑
VIEW A
VIEW LKG UP AT
BELLY PAN

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SIZE B	DWG NUMBER: 5004272	REV D	
SCALE: NTS	NCAGE: L6518	SHEET 7 OF 19	

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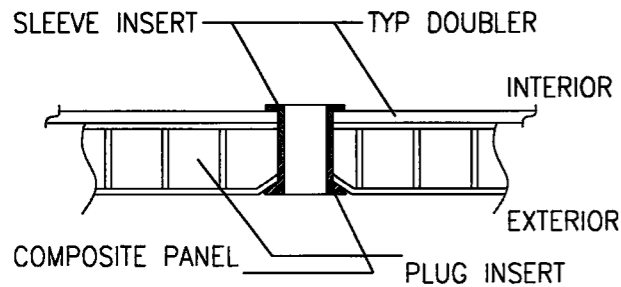
-007 TDFM 9100 INSTALLATION
 9100 CONFIGURATION
 GENERAL LAYOUT



FWD ↑
 LHS ↑
VIEW A
 VIEW LKG UP AT
 BELLY PAN

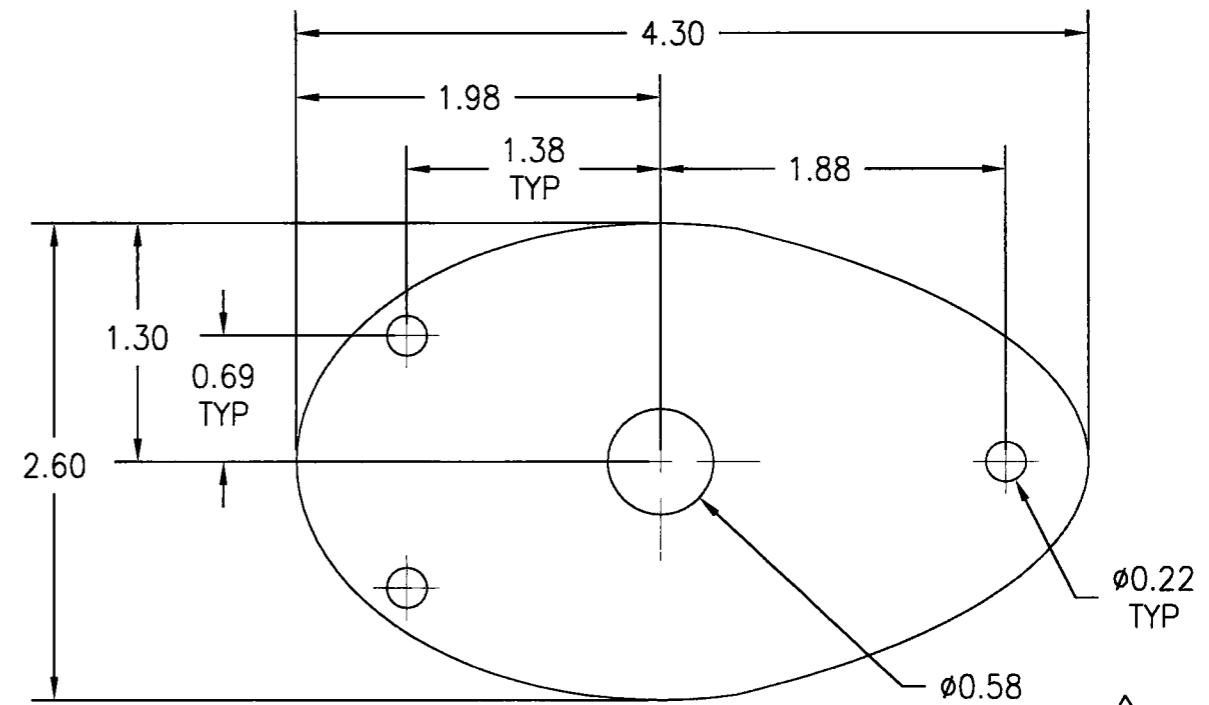
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TDFM 9000 ANTENNA INSTALLATION - AS350			
SIZE B	DWG NUMBER: 5004272	REV D	
SCALE: NTS	NCAGE: L6518	SHEET 8 OF 19	

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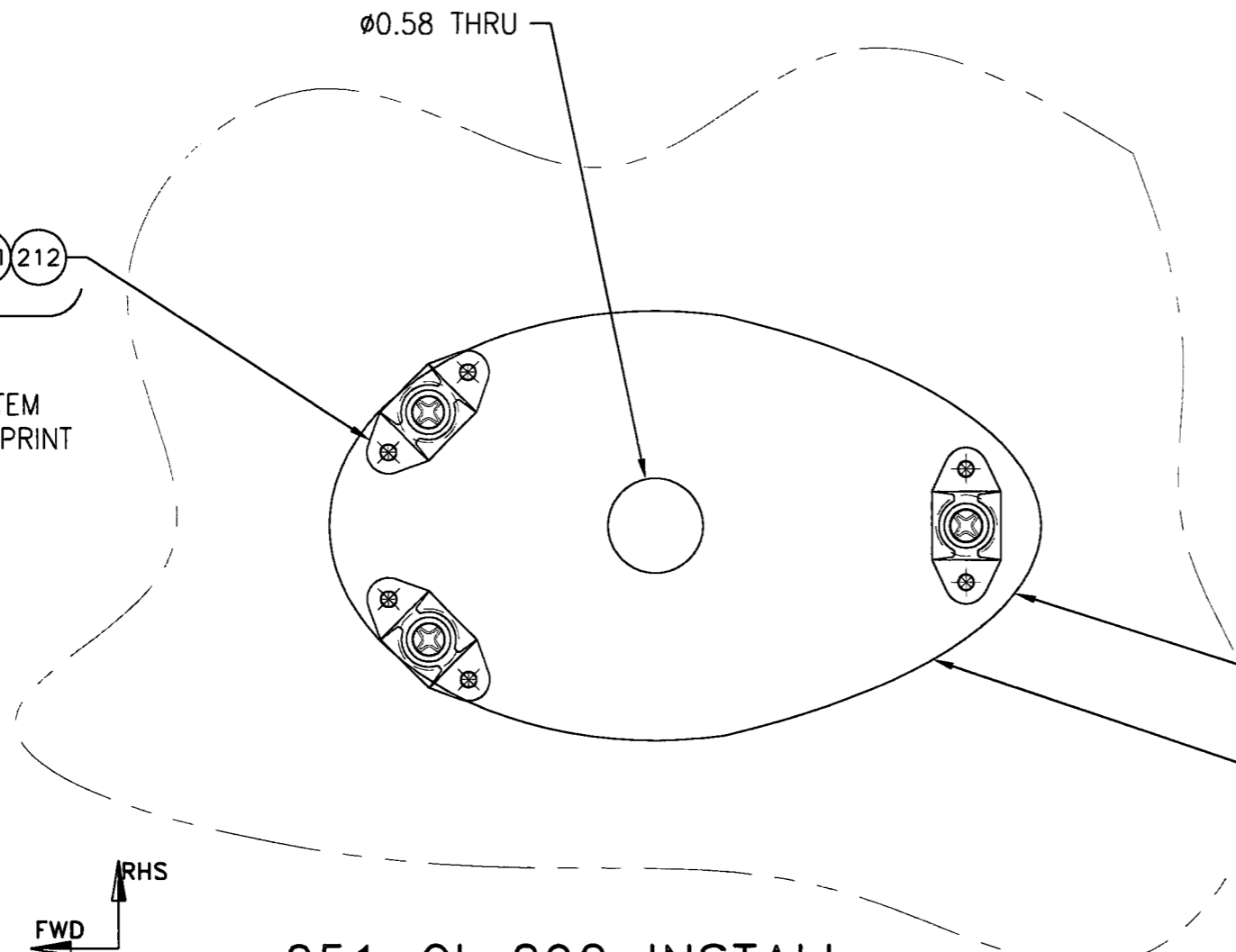
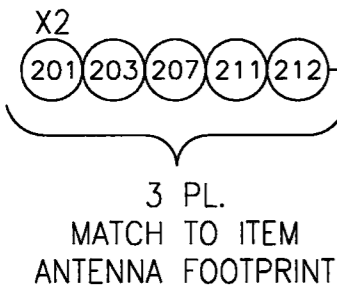


NOTE: $\triangle 12$ $\triangle 13$
 DRILL $\phi 0.309$ HOLE FOR ITEM 211/212 INSERT ON COMPOSITE PANEL. APPLY PRESSURE TO OPPOSING SIDES OF INSERT USING A HAND ARBOR PRESS. PRESSURE NOT TO EXCEED 1800 LBS. SKIN WILL DIMPLE AUTOMATICALLY.

TYPICAL INSERT CROSS SECTION

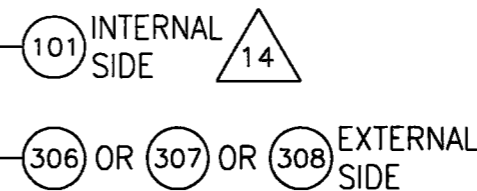


-101 INTERNAL DOUBLER, CI-292



-051 CI-292 INSTALL

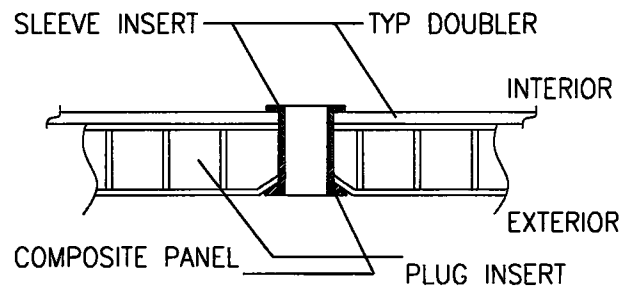
INTERNAL VIEW
LKG AT DOUBLER



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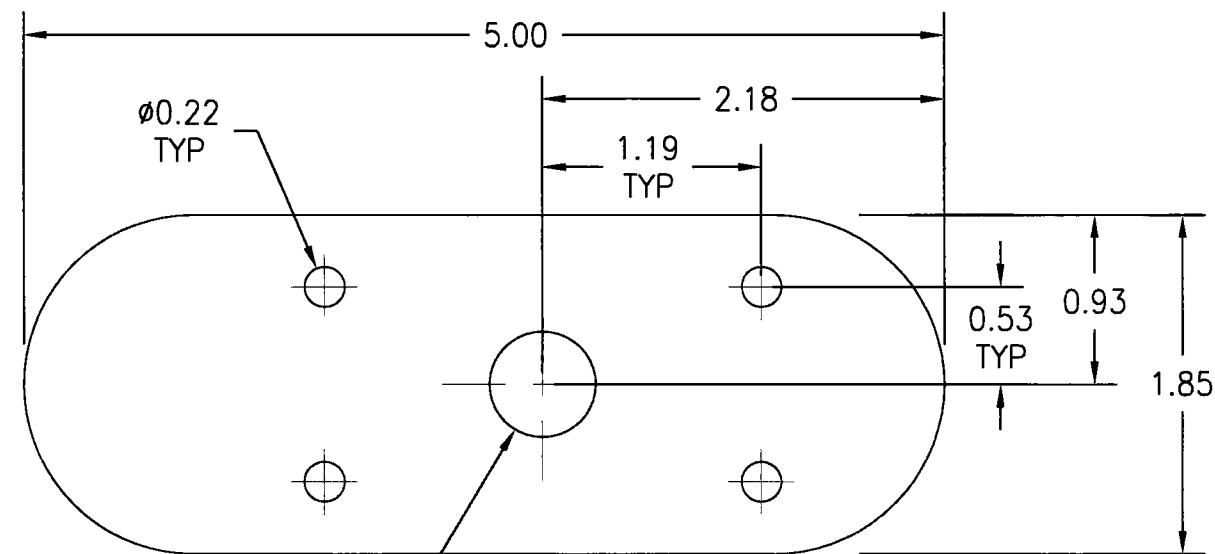
TDFM 9000 ANTENNA INSTALLATION - AS350		
SIZE B	DWG NUMBER: 5004272	REV D
SCALE: NTS	NCAGE: L6518	SHEET 9 OF 19

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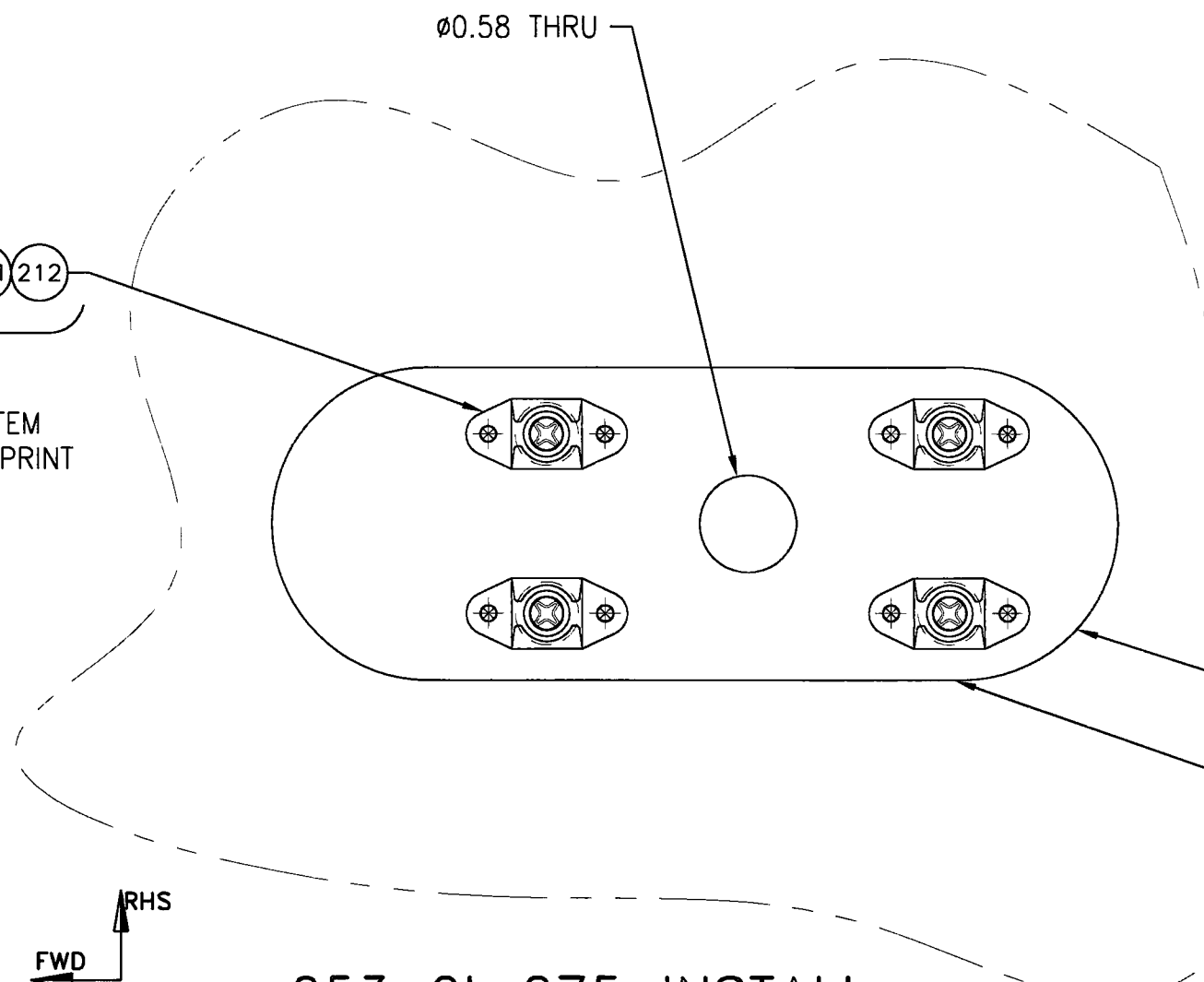
NOTE: $\triangle 12$ $\triangle 13$
 DRILL $\phi 0.309$ HOLE FOR ITEM 211/212 INSERT ON COMPOSITE PANEL. APPLY PRESSURE TO OPPOSING SIDES OF INSERT USING A HAND ARBOR PRESS. PRESSURE NOT TO EXCEED 1800 LBS. SKIN WILL DIMPLE AUTOMATICALLY.

TYPICAL INSERT CROSS SECTION



-103 INTERNAL DOUBLER, CI-275 $\triangle 15$

X2
 201 203 207 211 212
 4 PL.
 MATCH TO ITEM
 ANTENNA FOOTPRINT



-053 CI-275 INSTALL

INTERNAL VIEW
 LKG AT DOUBLER

$\triangle 14$
 103 INTERNAL SIDE
 309 EXTERNAL SIDE

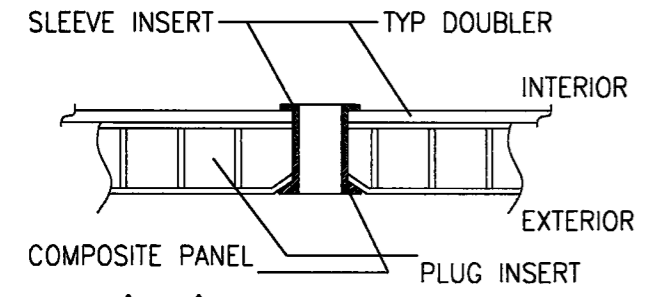


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 INSTALLATION - AS350

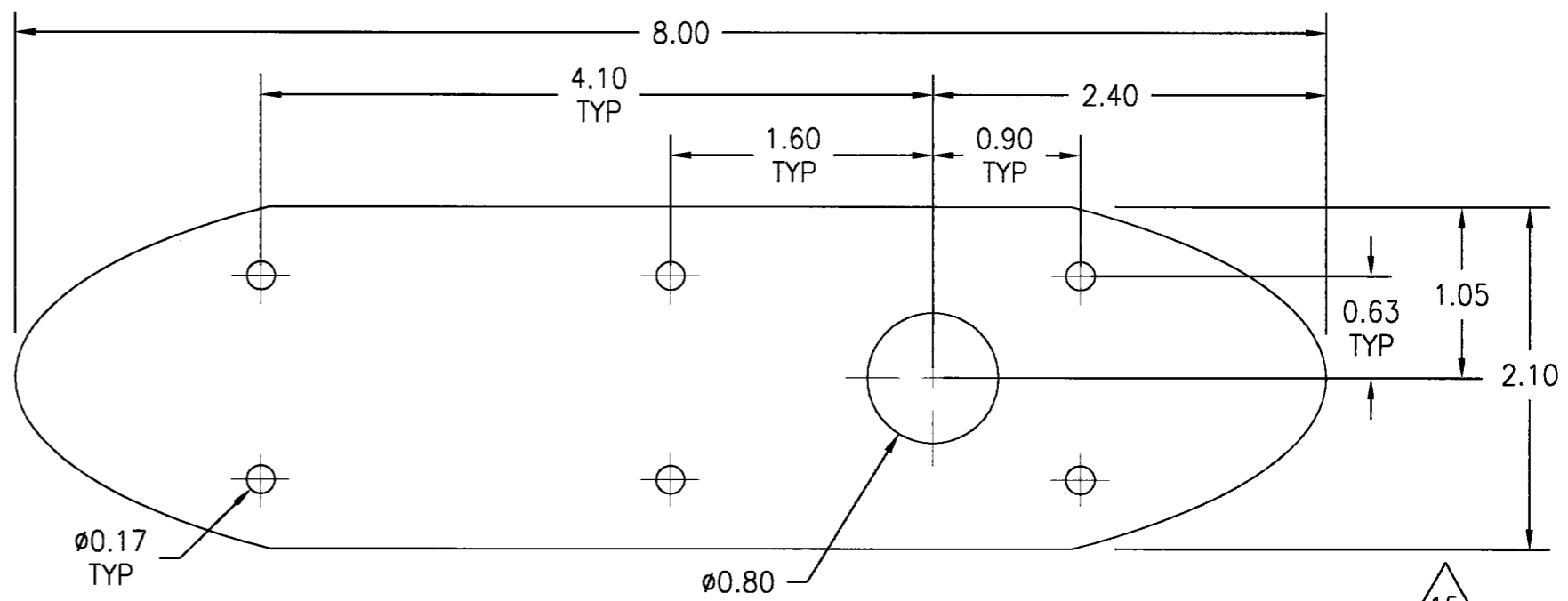
SIZE B	DWG NUMBER: 5004272	REV D
SCALE: NTS	NCAGE: L6518	SHEET 10 OF 19

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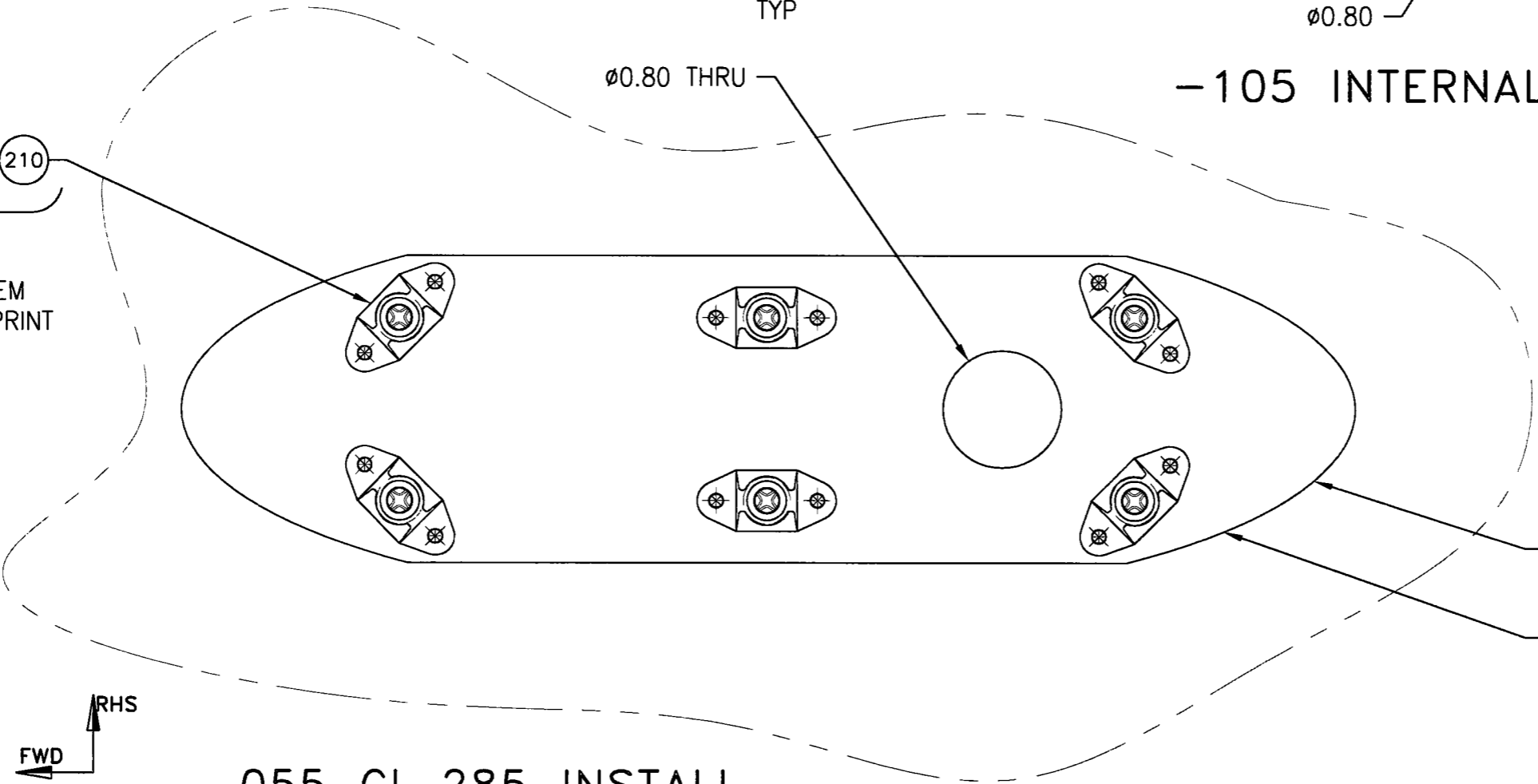
NOTE: $\triangle 12$ $\triangle 13$
 DRILL $\phi 0.278$ HOLE FOR ITEM 209/210 INSERT ON COMPOSITE PANEL. APPLY PRESSURE TO OPPOSING SIDES OF INSERT USING A HAND ARBOR PRESS. PRESSURE NOT TO EXCEED 1800 LBS. SKIN WILL DIMPLE AUTOMATICALLY.

TYPICAL INSERT CROSS SECTION



-105 INTERNAL DOUBLER, CI-285 $\triangle 15$

X2
 (201) (202) (206) (209) (210)
 6 PL.
 MATCH TO ITEM
 ANTENNA FOOTPRINT



-055 CI-285 INSTALL

INTERNAL VIEW
 LKG AT DOUBLER

(105) INTERNAL SIDE $\triangle 14$
 (310) EXTERNAL SIDE

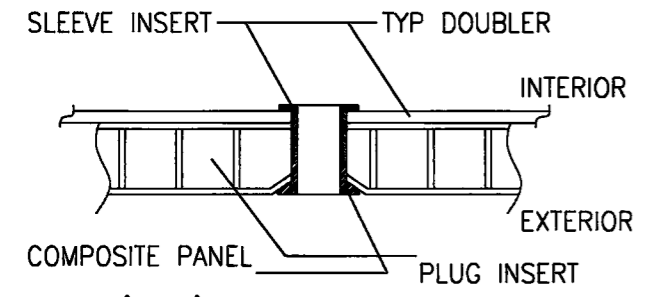


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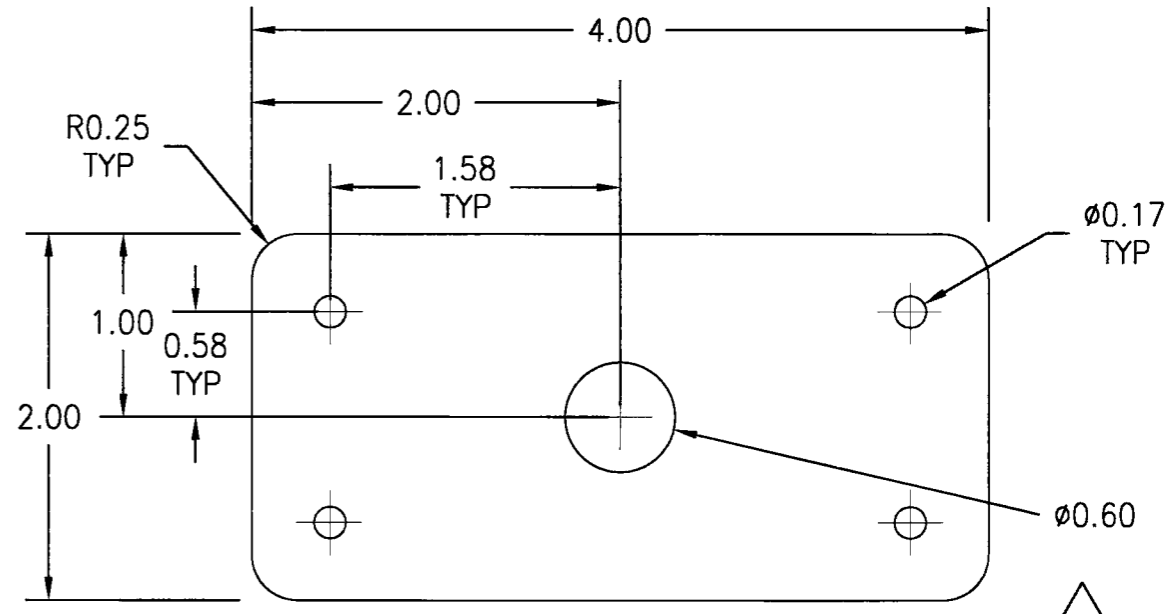
SIZE B	DWG NUMBER: 5004272	REV D
SCALE: NTS	NCAGE: L6518	SHEET 11 OF 19

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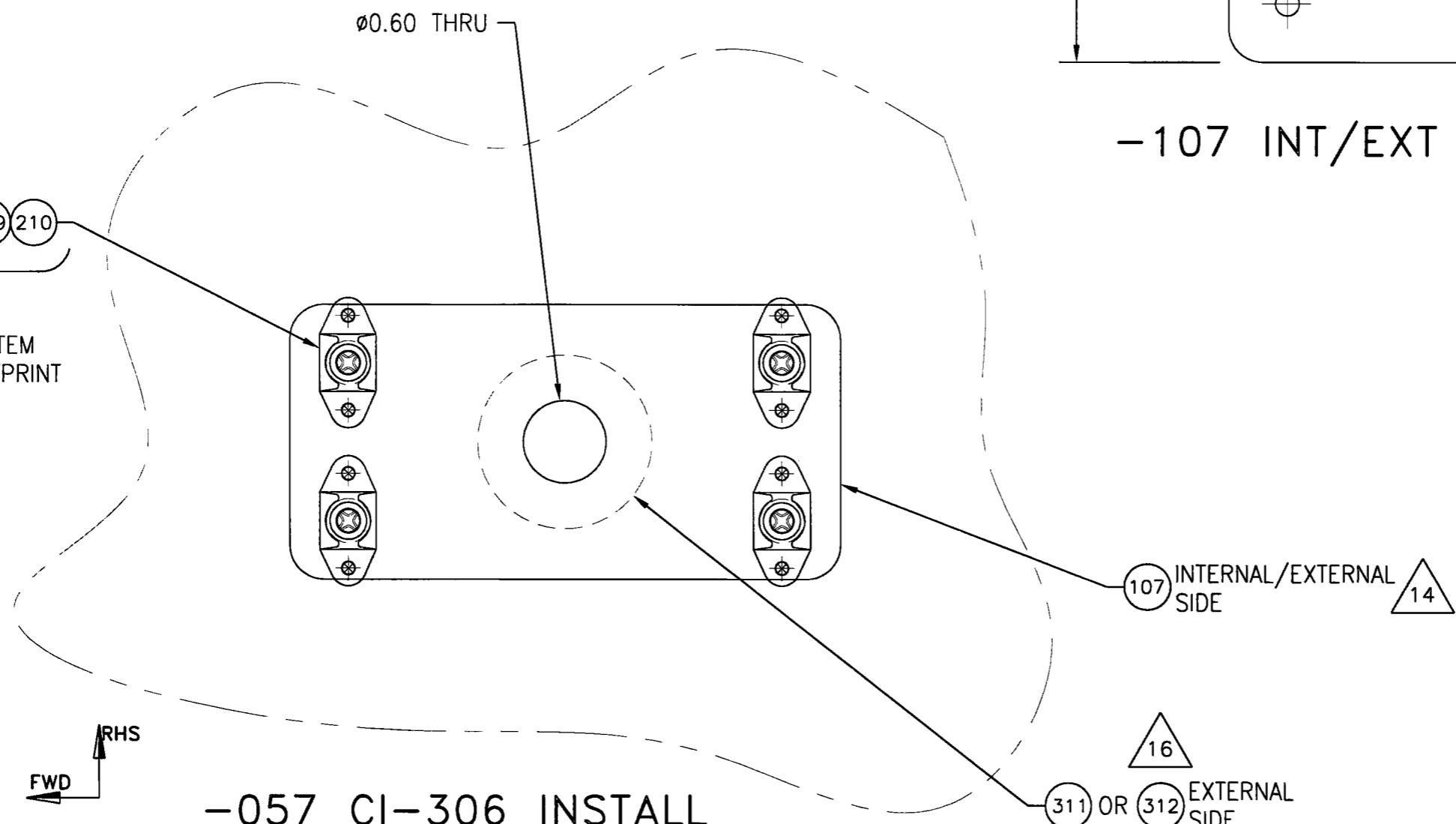
NOTE: $\triangle 12$ $\triangle 13$
DRILL $\phi 0.278$ HOLE FOR ITEM 209/210 INSERT ON COMPOSITE PANEL. APPLY PRESSURE TO OPPOSING SIDES OF INSERT USING A HAND ARBOR PRESS. PRESSURE NOT TO EXCEED 1800 LBS. SKIN WILL DIMPLE AUTOMATICALLY.

TYPICAL INSERT CROSS SECTION



-107 INT/EXT DOUBLER, CL-306

X2
201 202 206 209 210
4 PL.
MATCH TO ITEM
ANTENNA FOOTPRINT



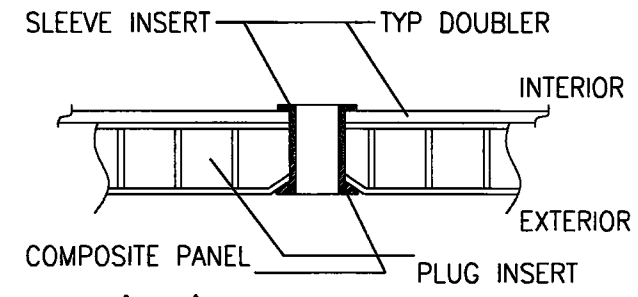
-057 CI-306 INSTALL

INTERNAL VIEW
LKG AT DOUBLER

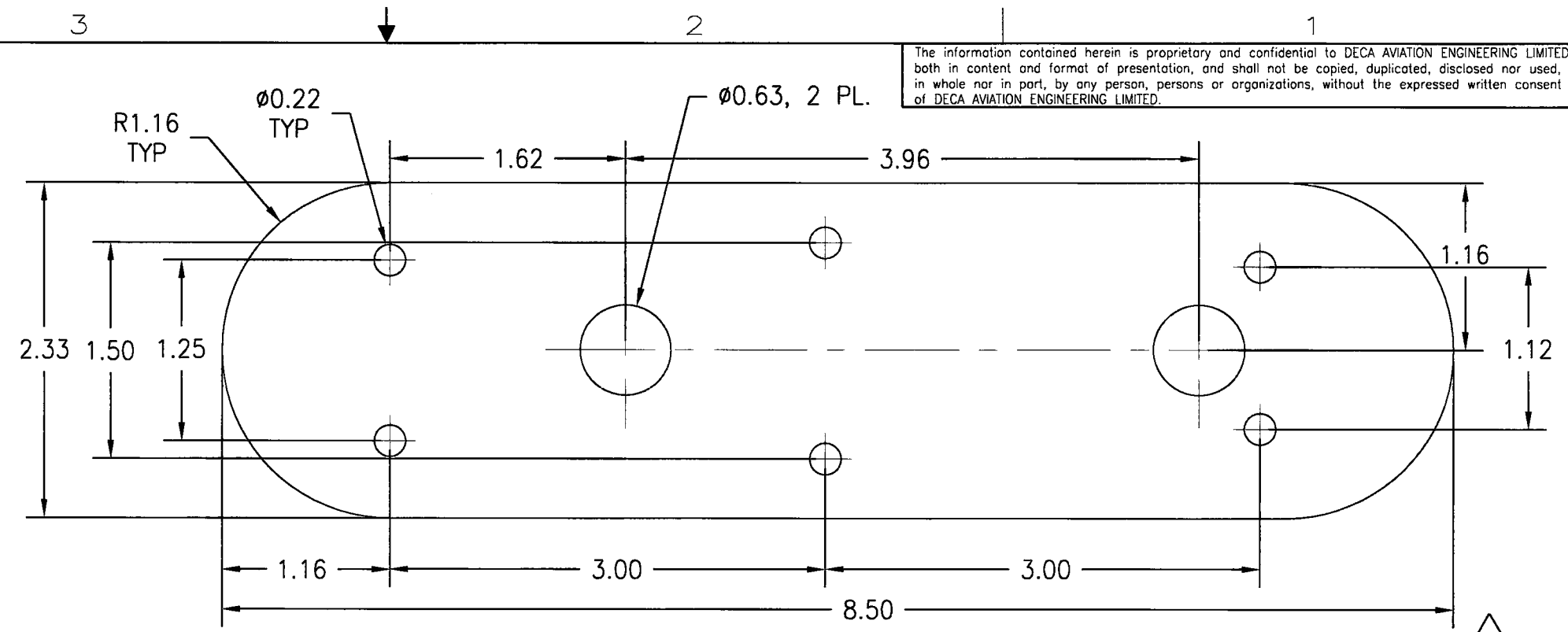


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TDFM 9000 ANTENNA INSTALLATION - AS350			
SIZE B	DWG NUMBER: 5004272	REV D	
SCALE: NTS	NCAGE: L6518	SHEET 12 OF 19	

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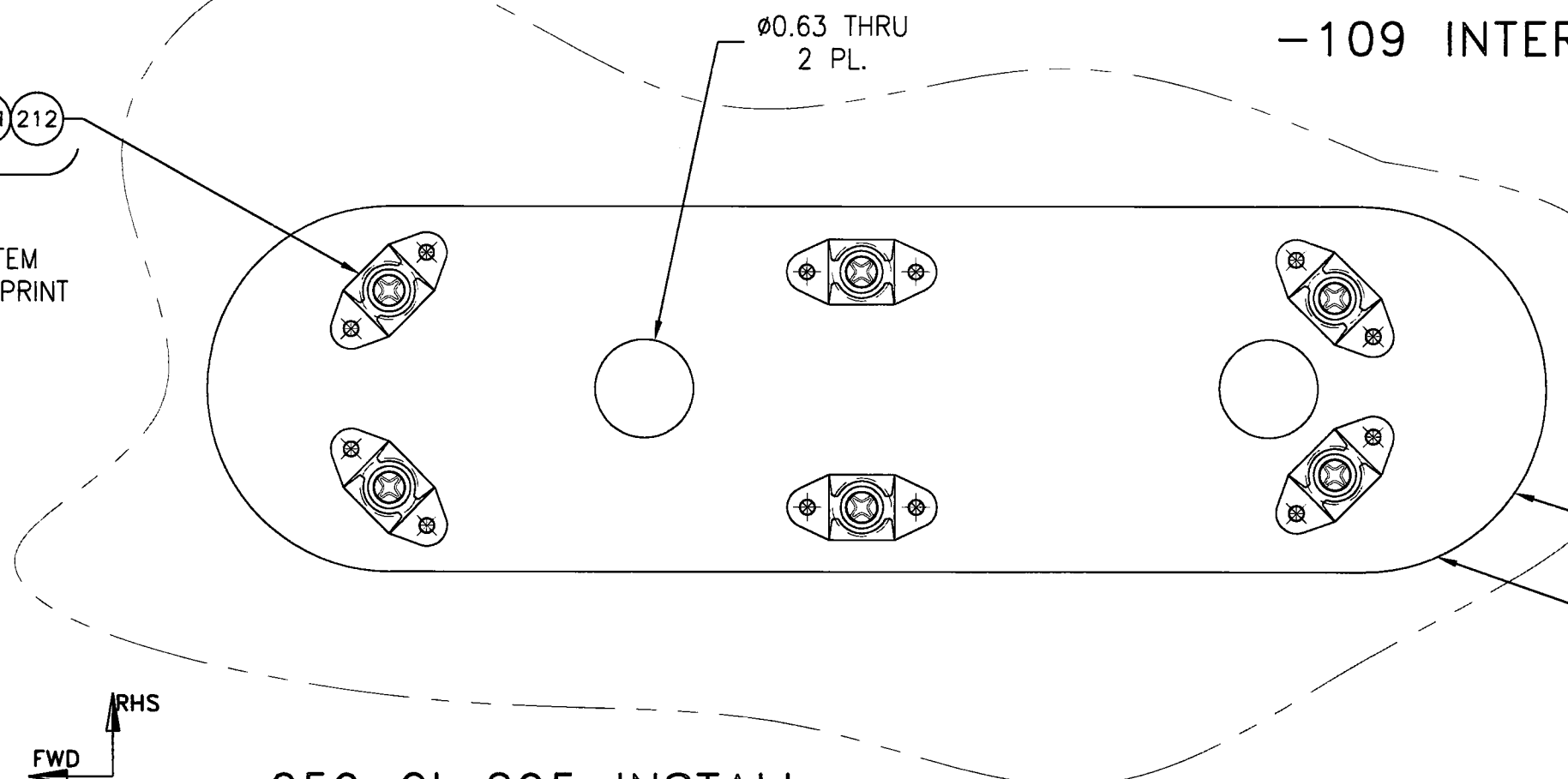


NOTE: $\triangle 12$ $\triangle 13$
 DRILL $\phi 0.309$ HOLE FOR ITEM 211/212 INSERT ON COMPOSITE PANEL. APPLY PRESSURE TO OPPOSING SIDES OF INSERT USING A HAND ARBOR PRESS. PRESSURE NOT TO EXCEED 1800 LBS. SKIN WILL DIMPLE AUTOMATICALLY.
 TYPICAL INSERT CROSS SECTION



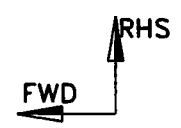
-109 INTERNAL DOUBLER, CI-295

X2
 201 205 207 211 212
 6 PL.
 MATCH TO ITEM
 ANTENNA FOOTPRINT



-059 CI-295 INSTALL

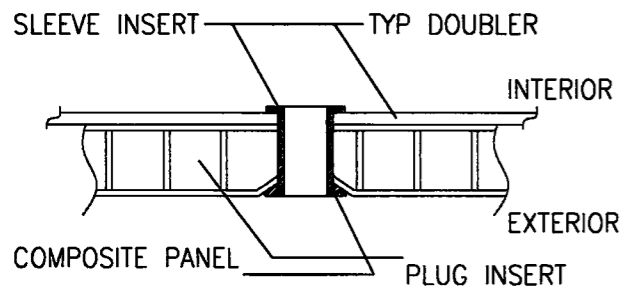
INTERNAL VIEW
 LKG AT DOUBLER



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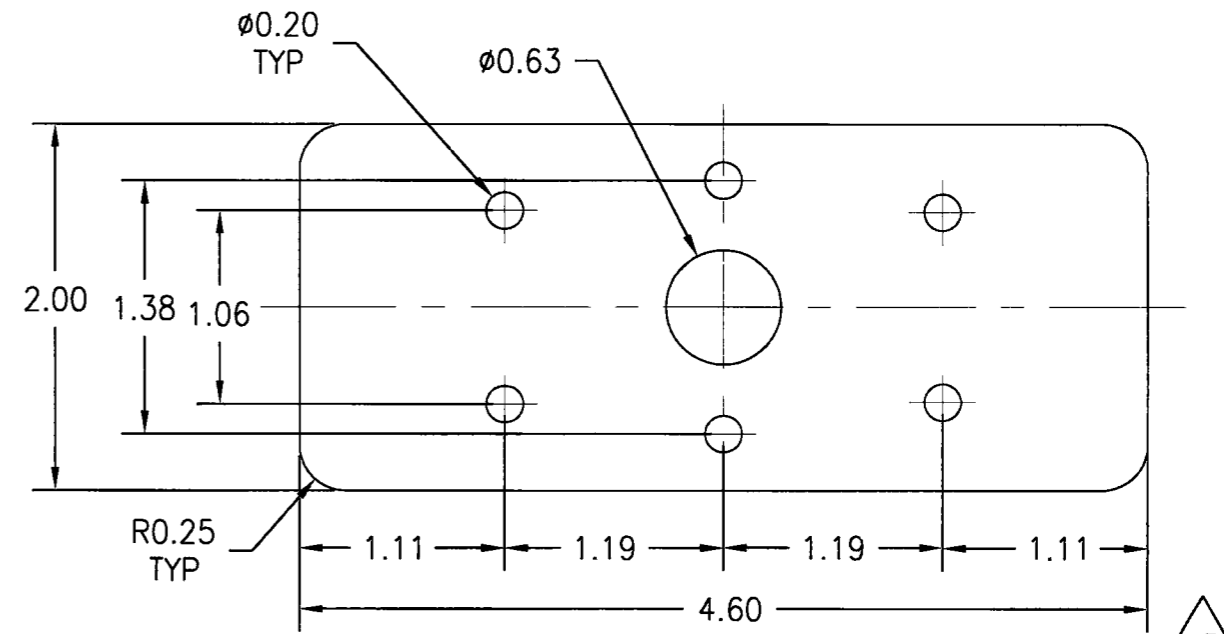
TDFM 9000 ANTENNA INSTALLATION - AS350		
SIZE B	DWG NUMBER: 5004272	REV D
SCALE: NTS	NCAGE: L6518	SHEET 13 OF 19

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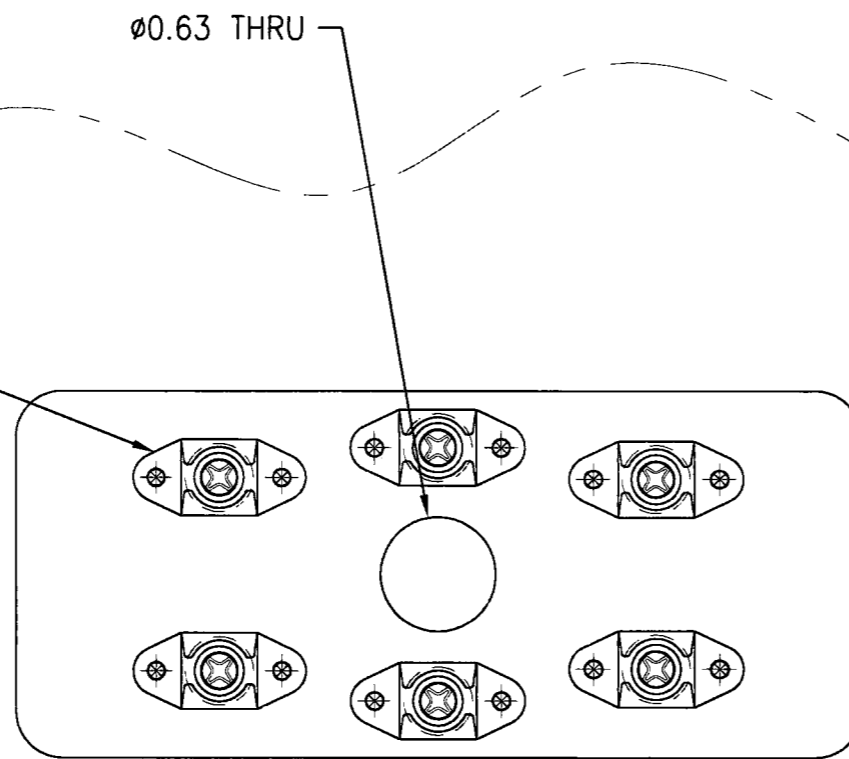
NOTE: $\triangle 12$ $\triangle 13$
 DRILL $\phi 0.309$ HOLE FOR ITEM 211/212 INSERT ON COMPOSITE PANEL. APPLY PRESSURE TO OPPOSING SIDES OF INSERT USING A HAND ARBOR PRESS. PRESSURE NOT TO EXCEED 1800 LBS. SKIN WILL DIMPLE AUTOMATICALLY.

TYPICAL INSERT CROSS SECTION



-111 INTERNAL DOUBLER, 21-50-45 $\triangle 15$

X2
 201 203 207 211 212
 6 PL.
 MATCH TO ITEM
 ANTENNA FOOTPRINT



$\triangle 111$ INTERNAL SIDE $\triangle 14$
 $\triangle 315$ EXTERNAL SIDE



RHS
 FWD

-061 21-50-45 INSTALL

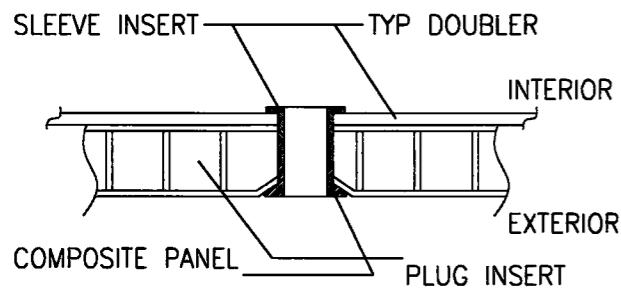
INTERNAL VIEW
 LKG AT DOUBLER

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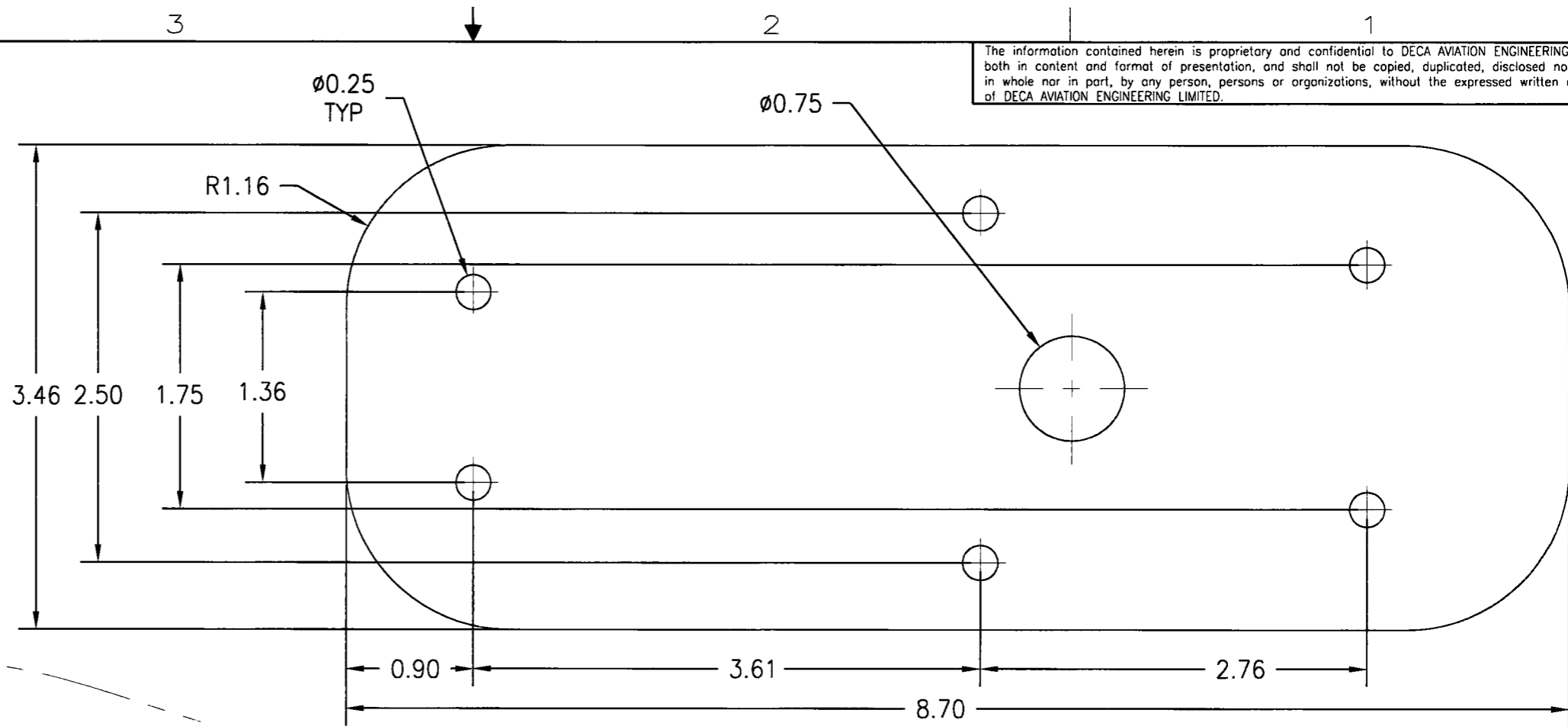
SIZE B	DWG NUMBER: 5004272	REV D
SCALE: NTS	NCAGE: L6518	SHEET 14 OF 19

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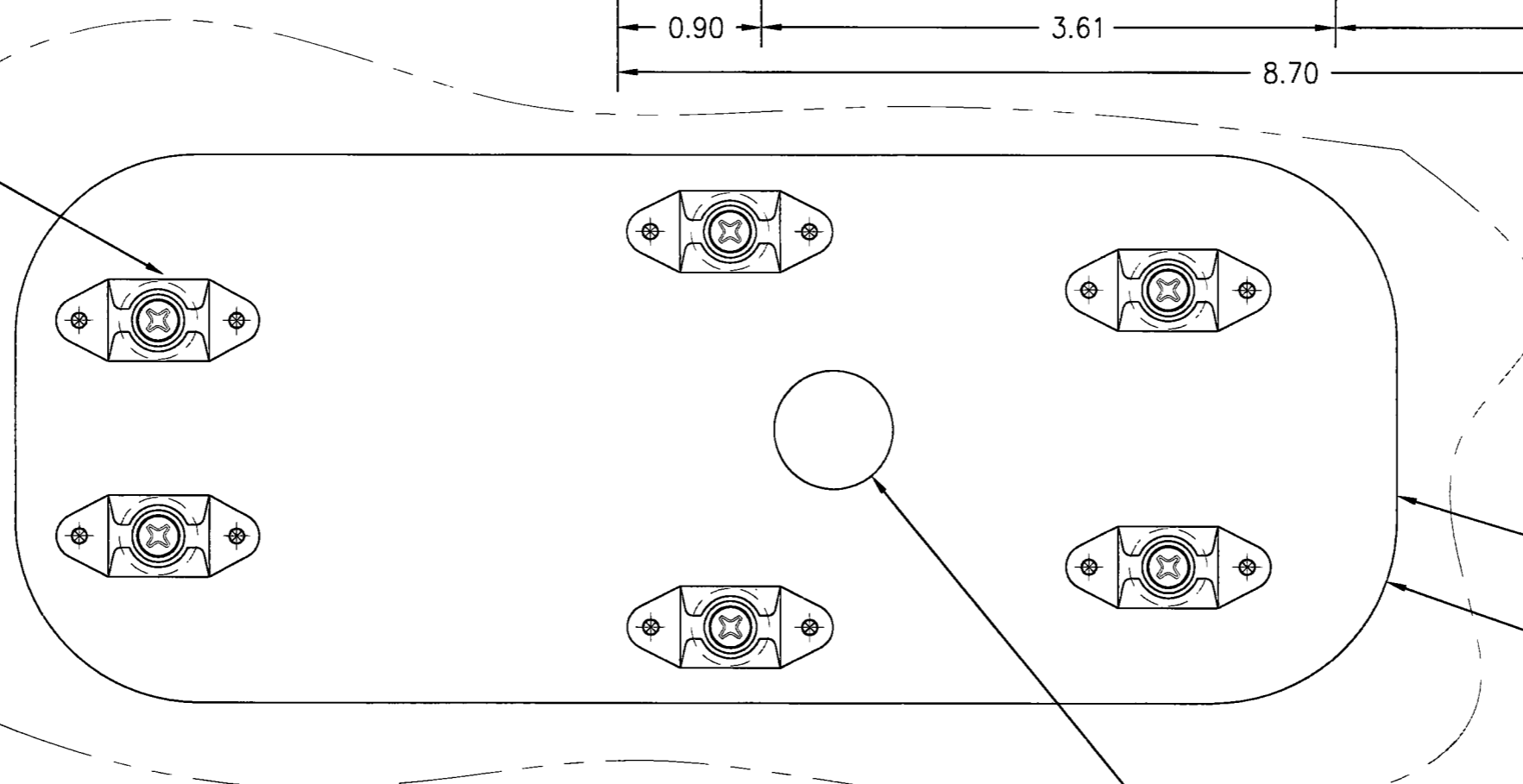


NOTE: $\triangle 12$ $\triangle 13$
 DRILL $\phi 0.372$ HOLE FOR ITEM 213/214 INSERT ON COMPOSITE PANEL. APPLY PRESSURE TO OPPOSING SIDES OF INSERT USING A HAND ARBOR PRESS. PRESSURE NOT TO EXCEED 1800 LBS. SKIN WILL DIMPLE AUTOMATICALLY.

TYPICAL INSERT CROSS SECTION



X2
 201 204 208 213 214
 6 PL.
 MATCH TO ITEM
 ANTENNA FOOTPRINT



$\triangle 15$ - 113 INTERNAL DOUBLER, AV-925



113 INTERNAL SIDE $\triangle 14$
 316 EXTERNAL SIDE

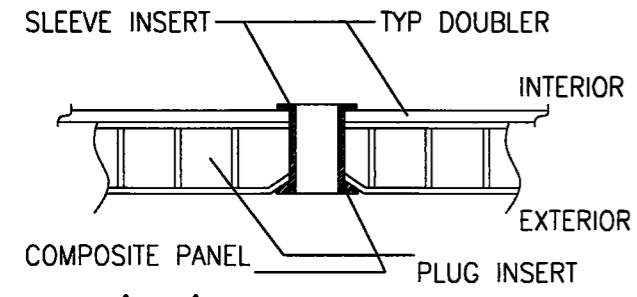
-063 AV-925 INSTALL

INTERNAL VIEW
 LKG AT DOUBLER

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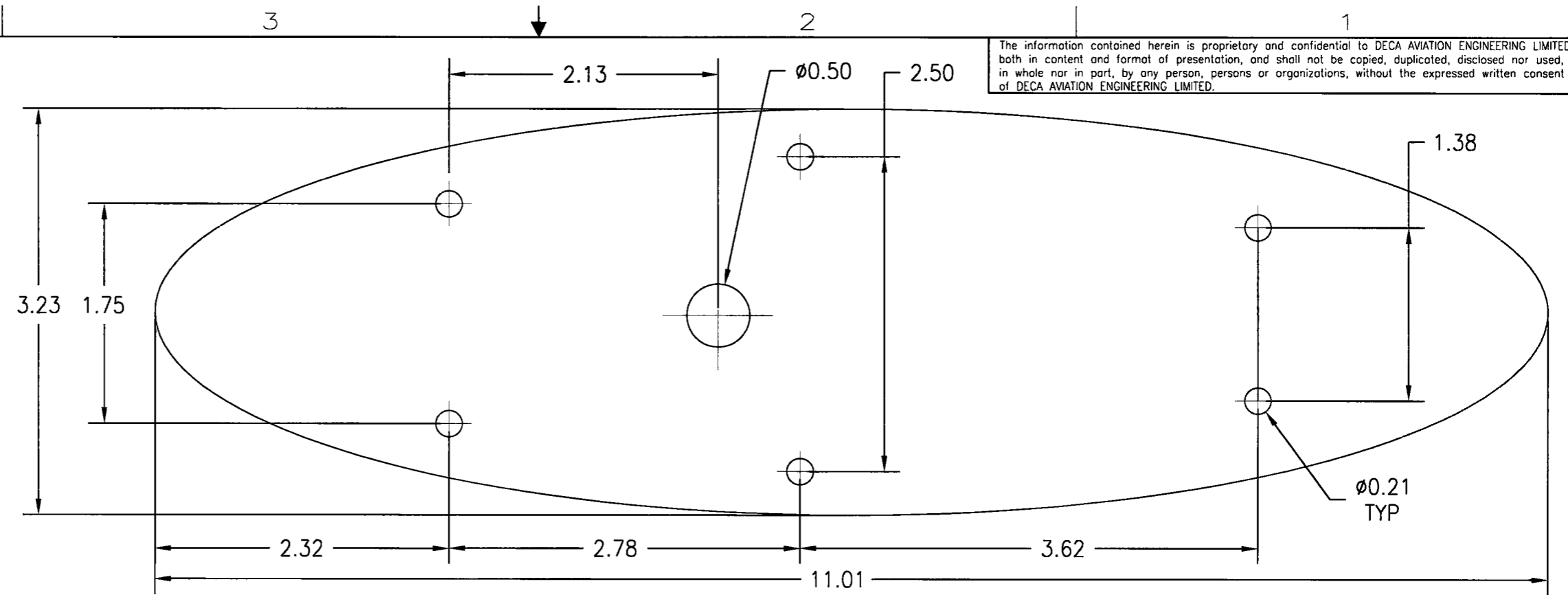
TDFM 9000 ANTENNA INSTALLATION - AS350		
SIZE B	DWG NUMBER: 5004272	REV D
SCALE: NTS	NCAGE: L6518	SHEET 15 OF 19

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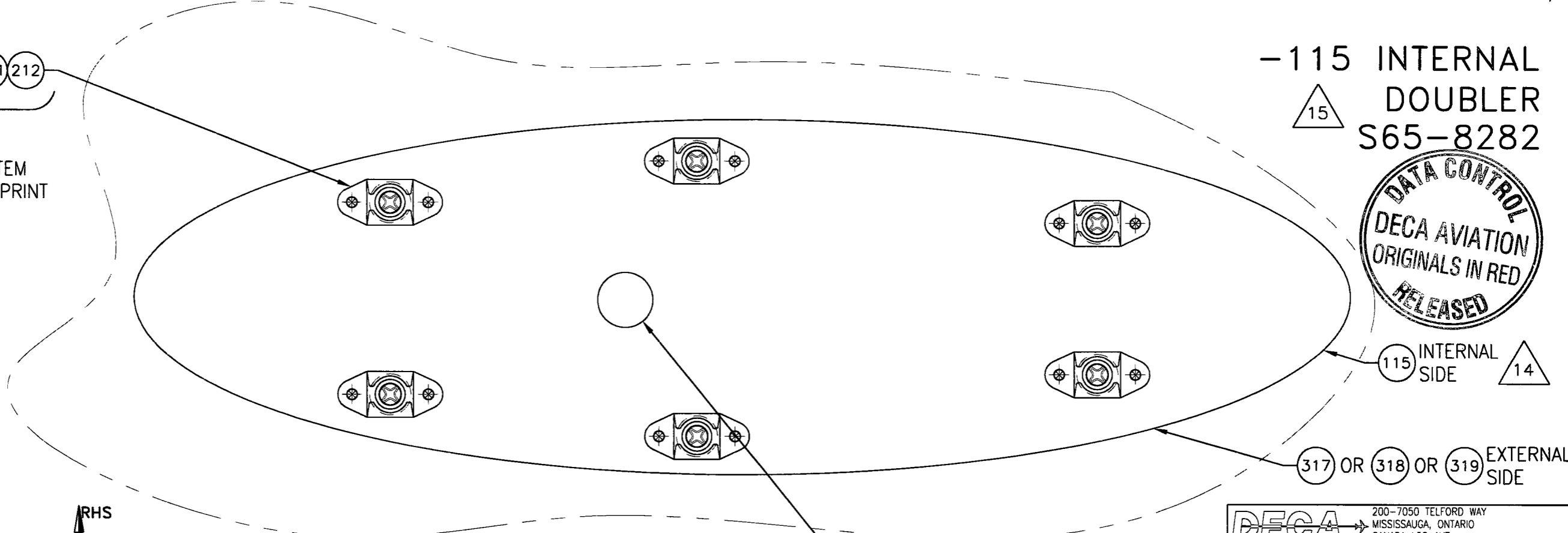


NOTE: $\triangle 12$ $\triangle 13$
DRILL $\phi 0.309$ HOLE FOR ITEM 211/212 INSERT ON COMPOSITE PANEL. APPLY PRESSURE TO OPPOSING SIDES OF INSERT USING A HAND ARBOR PRESS. PRESSURE NOT TO EXCEED 1800 LBS. SKIN WILL DIMPLE AUTOMATICALLY.

TYPICAL INSERT CROSS SECTION



X2
201 203 207 211 212
6 PL.
MATCH TO ITEM
ANTENNA FOOTPRINT



RHS
FWD

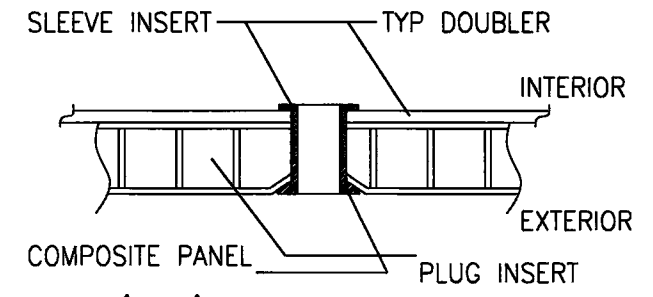
-065 S65-8282 INSTALL

INTERNAL VIEW
LKG AT DOUBLER

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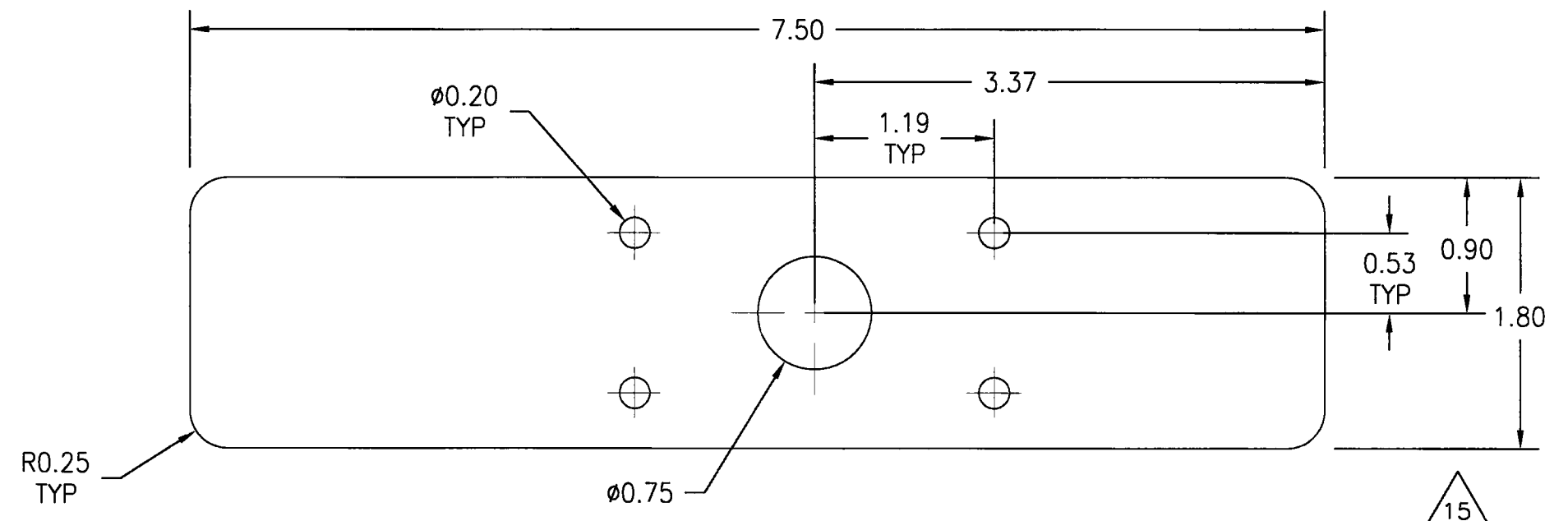
TDFM 9000 ANTENNA INSTALLATION - AS350		
SIZE B	DWG NUMBER: 5004272	REV D
SCALE: NTS	NCAGE: L6518	SHEET 16 OF 19

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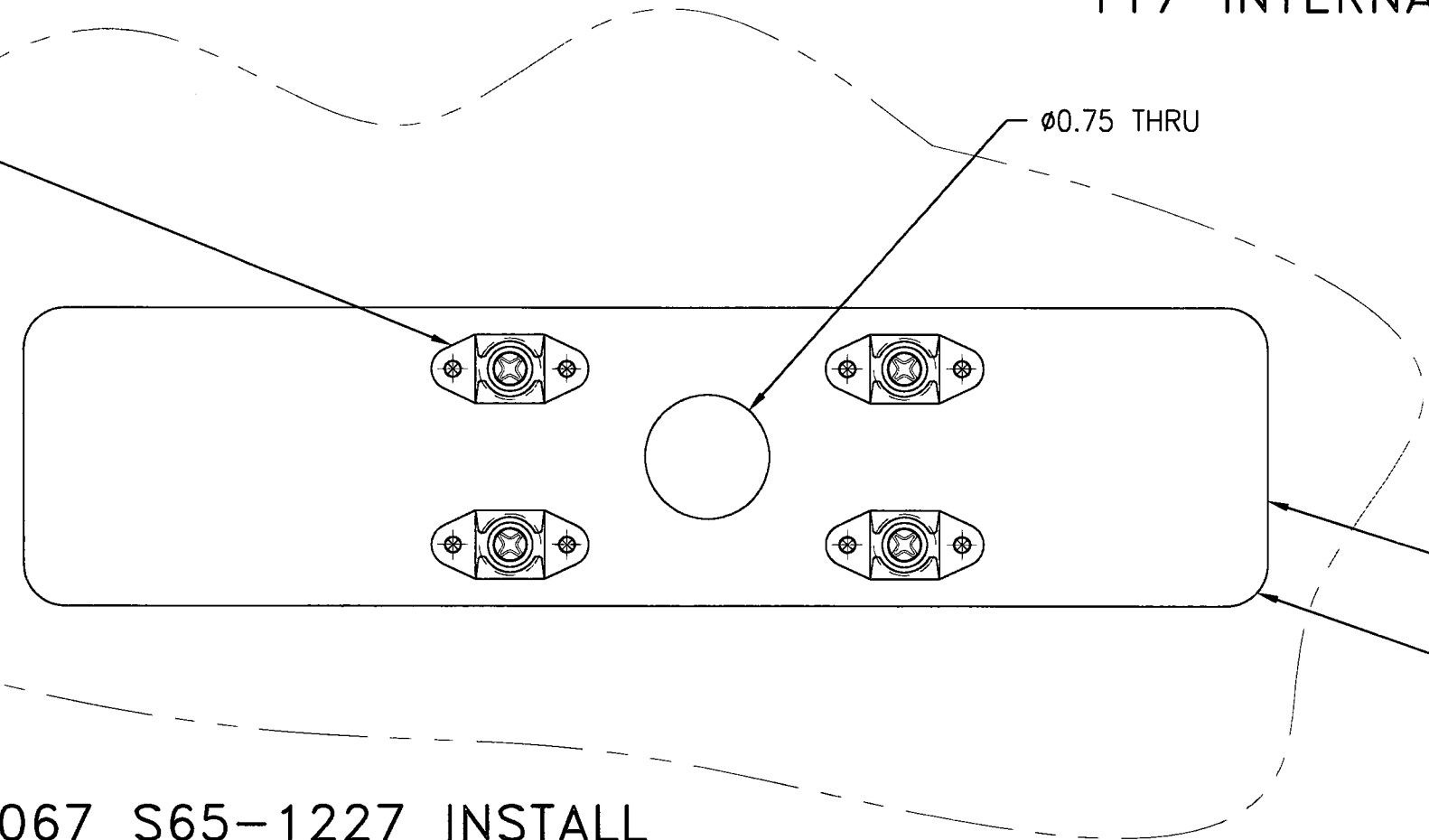
NOTE: $\triangle 12$ $\triangle 13$
DRILL $\phi 0.309$ HOLE FOR ITEM 211/212 INSERT ON COMPOSITE PANEL. APPLY PRESSURE TO OPPOSING SIDES OF INSERT USING A HAND ARBOR PRESS. PRESSURE NOT TO EXCEED 1800 LBS. SKIN WILL DIMPLE AUTOMATICALLY.

TYPICAL INSERT CROSS SECTION



-117 INTERNAL DOUBLER, S65-1227

X2
201 205 207 211 212
4 PL.
MATCH TO ITEM
ANTENNA FOOTPRINT



$\triangle 14$ 117 INTERNAL SIDE
320 OR 321 EXTERNAL SIDE



RHS
FWD

-067 S65-1227 INSTALL

INTERNAL VIEW
LKG AT DOUBLER

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TDFM 9000 ANTENNA INSTALLATION - AS350		
SIZE B	DWG NUMBER: 5004272	REV D
SCALE: NTS	NCAGE: L6518	SHEET 17 OF 19