

INSTALLATION INSTRUCTIONS
FOR EXHAUST CUFF
MODIFICATION

Document # PCA1001-21
Revision LTR: NC
Date: 09/15/08

Notes:

1. The Exhaust Cuff comes assembled with the three attachment brackets secured. We recommend that you paint the cuff assembled to match your aircraft prior to installation.
 2. Care must be exercised when match drilling the brackets to the airframe to ensure that no wires, fluid lines or components are damaged with the drill.
 3. Installation should be accomplished by a FAA Repair Station or a certificated A&P mechanic.
-

Part Number	Description	Qty
Right Exhaust		
SKP2001-1	Support Brace, Outer	1
SKP2002-2	Support Brace, Inner	1
SKP2003	Forward Brace	1
SKP2004-2	Aluminum Cuff	1
Left Exhaust		
SKP2001-2	Support Brace, Outer	1
SKP2002-1	Support Brace, Inner	1
SKP2003	Forward Brace	1
SKP2004-1	Aluminum Cuff	1
Screw	8-32x1/2	8
Screw, csk	8-32x3/8	2
Rivet	CR3213-4-2	14
Rivet	CR3213-4-3	4

Installation

Step 1. Using a felt marker(do not ever use a pencil as it may induce cracking) draw a vertical line parallel to the exhaust pipe tip forward 2 inches as shown below in Photo 1.



Photo 1

Step 2. Obtain the cuff assembly and align the aft edge with the marker line on the pipe as shown in Photo 2.



Photo 2

Step 3. Position the cuff so that a clearance of at least 1.0 inch extends between the pipe and the cuff as shown in Photo 3.



Photo 3

Step 4. Carefully using a non-permanent marker, draw a line about the forward edge of the cuff as shown in photo 4.



Photo 4

Step 5. Install the (3) attachment brackets using the screws supplied as shown in Photo 5-7.



Photo 5

Photo 6

Photo 7

Step 6. Remove the protective backing from the double-sided tape on the forward support bracket (Photo 7) and using care re-position the cuff onto the aircraft aligning the forward edge of the cuff to the drawn line on the aircraft as shown in Photo 8.



Photo 8

Step 7. Push the forward section of the cuff firmly against the aircraft to ensure the tape adheres to the skin of the aircraft. Remove the cuff from the aircraft by removing the flush screw from the bracket as shown in Photo 9.



Photo 9

Step 8. Using a #30 drill, match drill the two attachment holes in the bracket to the aircraft skin. Remove the bracket and remove the tape. Re-install the bracket using a single cleco. Secure the bracket to the aircraft skin using CR3213-4-3 rivets (2pl) as shown in Photo 10.

Photo 10



Step 9. Re-install the cuff to the forward bracket using the flush 8-32 screw provided. Position the outboard aft edge of the cuff so that the outer edge of the attachment bracket mates flush to the forward and aft existing fairing as shown in Photo 11.



Photo 11

Step 10. Using care not to match drill the existing thru-holes in the bracket to rivets attaching the fairings, match drill the aft hole and cleco in place as shown in Photo 12.



Photo 12

Step 11. Ensure the attachment bracket is positioned as in Photo 11, then match drill the aircraft to the most forward hole in the bracket. Install a second cleco as shown in Photo 13. Match drill the aircraft to the remaining 2 holes in the bracket. Remove all chips and rivet into place using (4) CR3213-4-2 rivets as shown in Photo 14.



Photo 13



Photo 14

Step 12. Position the inboard aft edge of the cuff so that it intersects the two skin sections of the lower cowl as shown in Photo 15. Matchdrill the lower skin of the aircraft to the most aft hole in the bracket and cleco as shown in Photo 16.



Photo 15



Photo 16

Step 13. Remove all chips and rivet into place using CR3213-4-2 rivets (3pl) as shown in Photo 17.

Photo 17



Step 14. Verify that all the fasteners are secure and that a 1.0 inch gap between the pipe and the cuff exists.

Step 15. Enter a logbook entry in the airframe logbook stating the installation of the exhaust cuff as a minor alteration per the Installation Instructions provided.

CONTINUED MAINTENANCE INSPECTION CRITERIA

Maintenance Inspection Intervals: Each Annual Inspection

Inspection Criteria:

Component	Type of Discrepancy	Action
Aluminum Cuff	Cracks	Replace
Support Brackets	Cracks	Replace
