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- NOTES:
1.

BREAK SHARP EDGES AND REMOVE ALL BURRS
2.

FINISH OR TOUCH UP BARE ALUMINUM WITH ALODINE PER MIL-DTL-5541 TYPE 1, CLASS 3 OR EQUIVALENT.
3.

INSTALL FASTENERS IN ACCORDANCE WITH AIRCRAFT MAINTENANCE MANUAL. MAINTAIN MINIMUM 2D FASTENER EDGE MARGIN AND 4D TO 6D FASTENER SPACING UNLESS OTHERWISE NOTED.
4.

FASTENER LENGTHS MAY VARY UP OR DOWN ONE GRIP LENGTH IF REQUIRED TO MEET FASTENER INSTALLATION REQUIREMENTS IN AC 43.13-1B CHAPTER 7 SECTION 2.
5.

DIP FASTENER IN PR-1422 B-1/2 (PRC) OR EQUIVALENT BEFORE INSTALLATION..
6.

INSTALLATION INSTRUCTIONS:

a.

LOCATE BRACKETS PER DRAWING REQUIREMENTS. MAINTAIN EDGE MARGIN PER NOTE 3. MATCH DRILL 7 RIVET HOLES  $\varnothing.129\checkmark \varnothing.179 \times 100^\circ$  FROM BRACKET THROUGH SKIN PER BRACKET, TRIM BRACKET TO MATCH EXISTING HI-LOKS

b.

REMOVE PARTS, DEBURR AND TOUCH-UP HOLES WITH CHEMICAL CONVERSION COATING PER MIL-DTL-5541 TYPE 1, CLASS 3 AS REQUIRED.

c.

APPLY SURFACE SEAL BETWEEN BRACKETS AND SKIN USING PR-1422 B-1/2. FASTEN BRACKETS PER DRAWING REQUIREMENTS.

d.

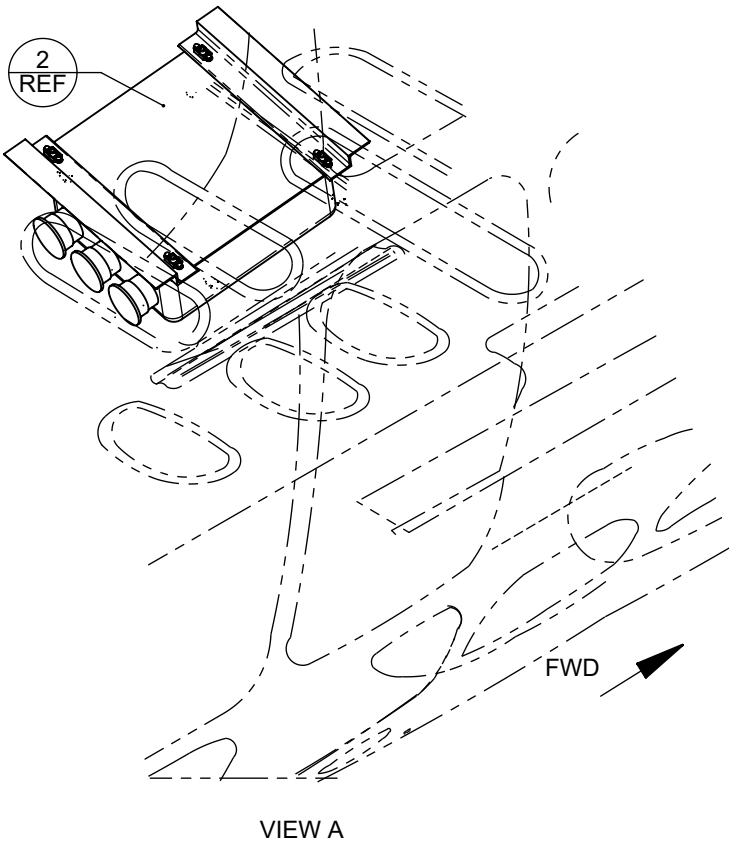
TORQUE 10-32 FASTENERS TO 19±3 IN-LBS.

e.

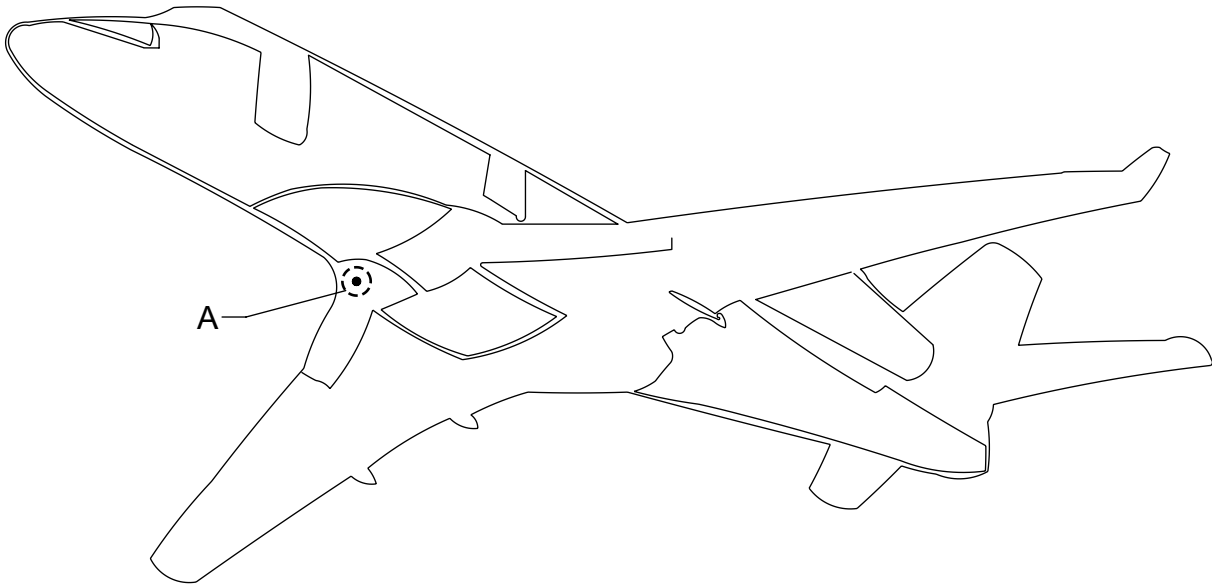
ENSURE ELECTRICAL BONDING AND GROUNDING OF LESS THAN 2.5 MILLIOHMS BETWEEN CONTROL BOX AND AIRCRAFT STRUCTURE PER SAE ARP1870.

f.
- 7

TRIM SHADED AREAS AT INSTALL TO MATCH AIRCRAFT STRUCTURE.



REV.	DESCRIPTION	DRAWN	CHECKED	APPROVED
IR	INITAL RELEASE	-	-	-
A	THE ANGULAR DIRECTION HAS BEEN UPDATED ON SECTION B-B ON SH.2	M BAIG 8/26/20	D SAM 8/26/20	D RANKIN 8/26/20
B	UPDATED NOTES, BRACKET DESIGN AND FRAME NUMBERS FOR CONTROL BOX INSTALL	M BAIG 9/25/20	L WILDING 9/28/20	J KISTLER 10/1/20
C	UPDATED REF LOCATION OF CONTROL BOX ON SH2.	M BAIG 11/18/20	L WILDING 11/18/20	D RANKIN 11/18/20



CONTROLLER INSTL

6	14	HL70-5	HI-LOK, COLLAR	-
5	14	HL18PB5-4	HI-LOK, PIN	-
4	4	NAS1149F0332P	WASHER, FLAT, #10 x .032" THK	-
3	4	MS27039-1-07	SCREW, PAN HEAD, 10-32 X .406" LONG	-
2	1	3463-05	HEATER CONTROL BOX	COX & CO
1	2	PA-200124-321	CONTROL BOX MOUNTING BRACKET ASSEMBLY	-
ITEM NO.	QTY	PART NUMBER	DESCRIPTION	VENDOR

DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED  
THIRD ANGLE PROJECTION

TOLERANCES UNLESS OTHERWISE SPECIFIED:  
X = ± .100 .X = ± .050  
.XX = ± .030 .XXX = ± .010  
X° = ± 2° .X° = ± 1°

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PEREGRINE

7385 SOUTH PEORIA STREET  
UNIT C4  
ENGLEWOOD, CO 80112

TITLE:

FLAP/SLAT ACTUATOR  
HEATER CONTROL BOX INSTL

DWG. NO.

PA-200124-503

REV.

C

DWG SIZE: B

SCALE: NTS

SHEET 1 OF 2

WEIGHT: NA

NEXT ASSEMBLY: NA

4

3

2

1

4

3

2

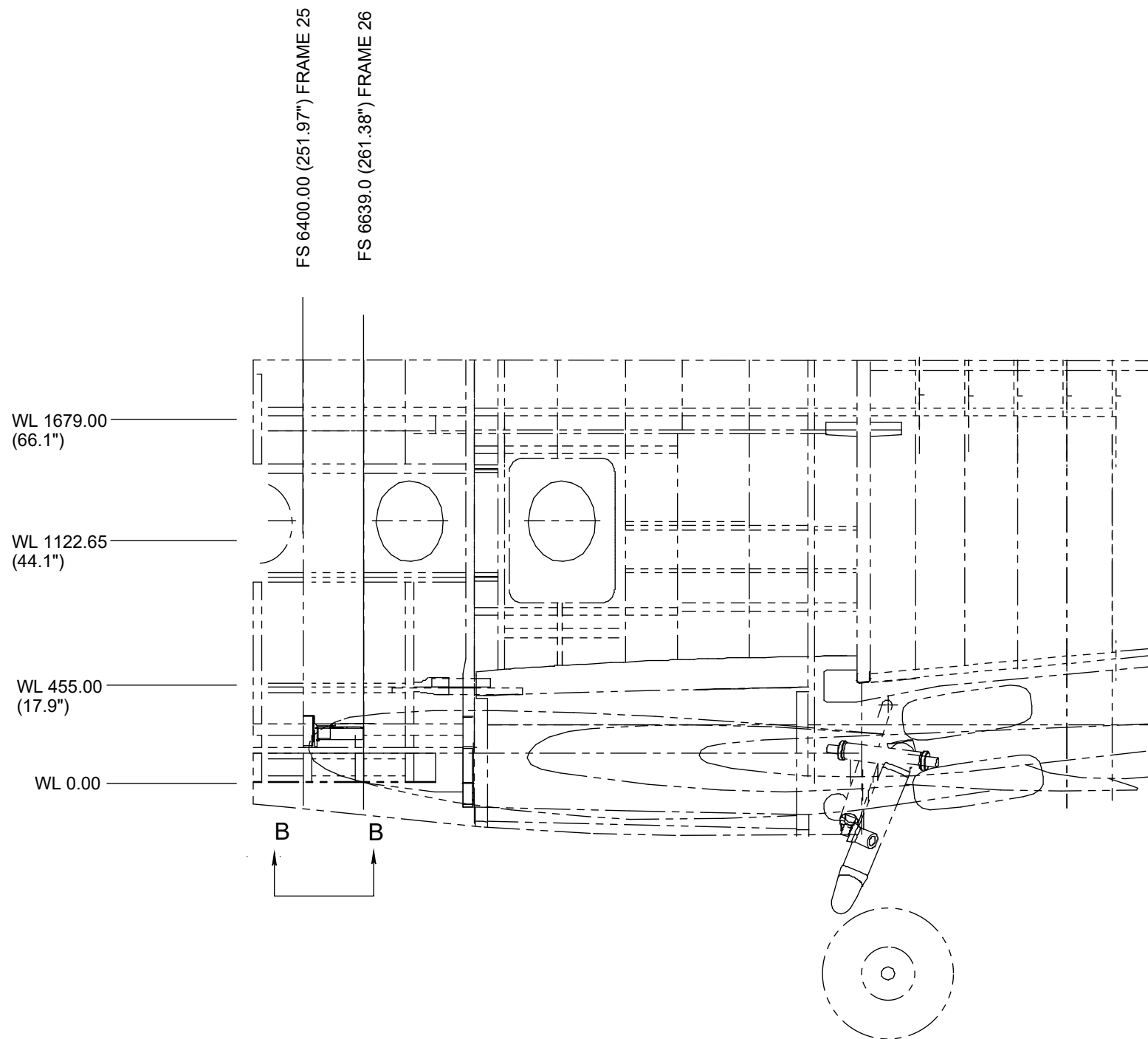
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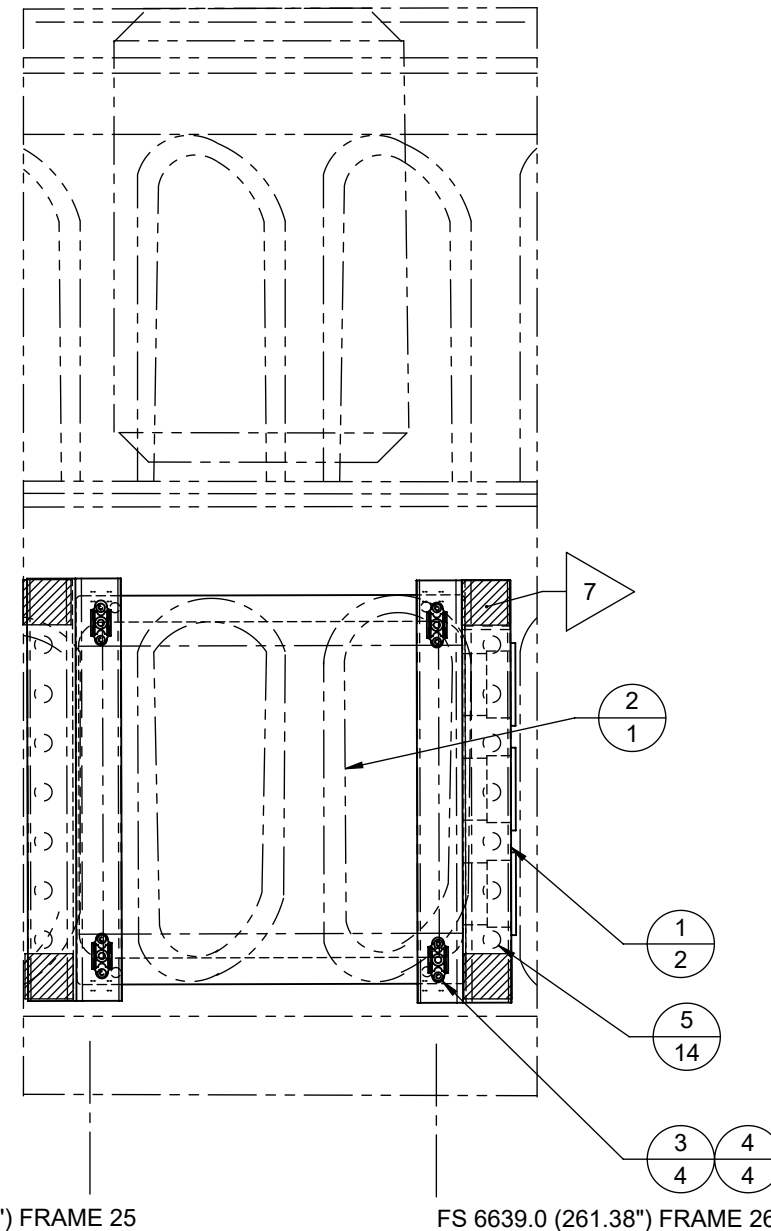
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FWD



SECTION B-B  
VIEWED FROM BELOW

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UNIT C4  
ENGLEWOOD, CO 80112

TITLE: **FLAP/SLAT ACTUATOR  
HEATER CONTROL BOX INSTL**

DWG. NO. **PA-200124-503**

REV. **C**

DWG SIZE: B

SCALE: NTS

SHEET 2 OF 2

4

3

2

1