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NOTES:

1. INSTALLATION INSTRUCTIONS:
- a.

GAIN ACCESS TO ACTUATORS BY REMOVING THE APPROPRIATE PANELS. REFERENCE G150 MAINTENANCE MANUAL.
- b.

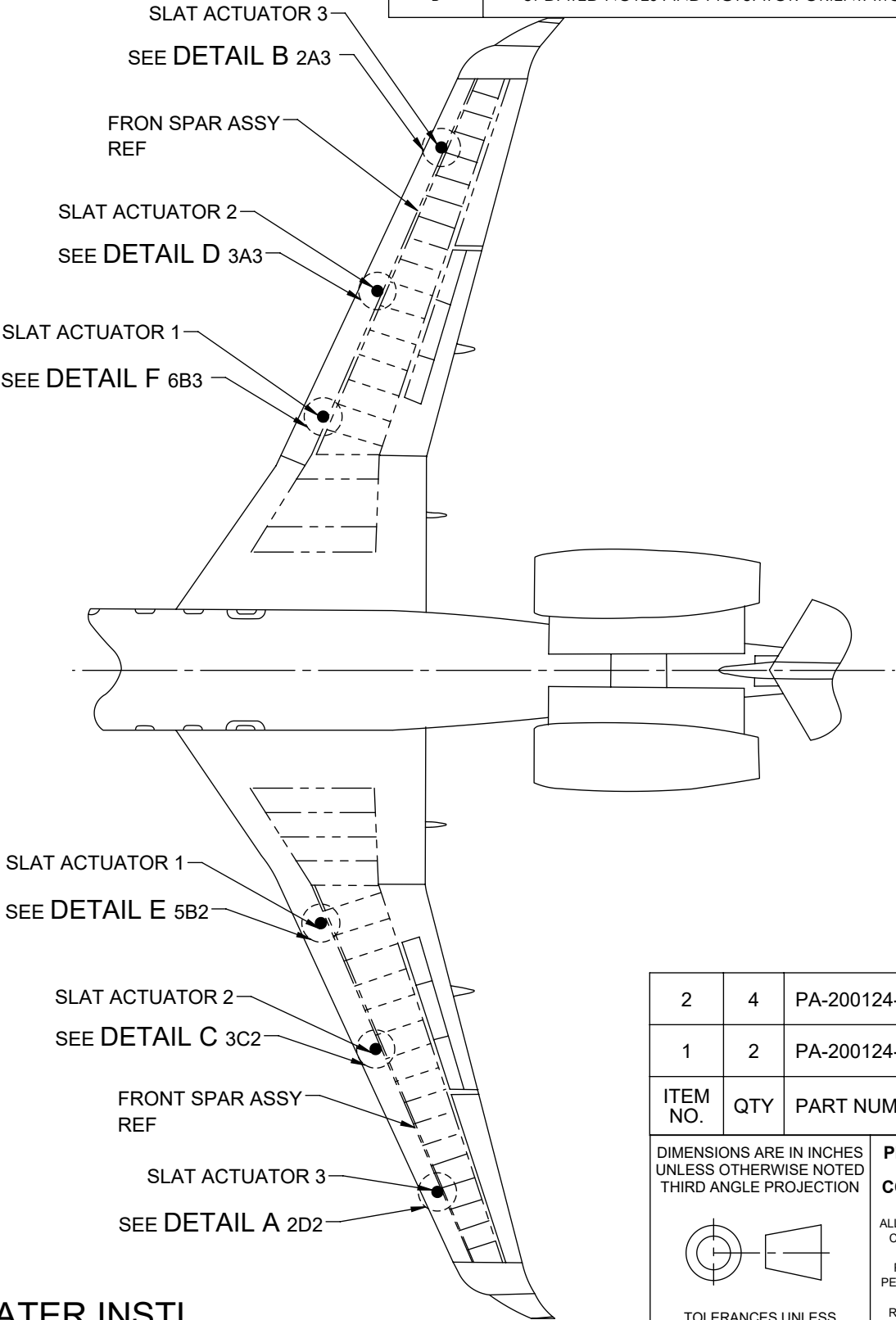
PREPARE THE ACTUATOR SURFACE WHERE THE HEATER WILL BE MOUNTED. THE SURFACE SHOULD BE CLEAN AND SMOOTH AND FREE FROM SHARP EDGES, PROTRUSIONS, LUBRICANTS, AND SEALANTS. THE HEATERS MAY BE INSTALLED ON PAINTED SURFACE.
- c.

INSTALL THE HEATERS AND TORQUE 6-32 SELF-LOCKING NUTS TO 9 +/-2 IN. LBS. ENSURE CLAMP GAP IS MINIMIZED AND HEATER IS SECURED TO ACTUATOR WITH NO MOVEMENT. ORIENTATION OF HEATER AND HARNESS MAYBE ADJUSTED ON ACTUATOR FOR AVAILABLE CLEARANCE, SECURE WITH SINGLE-STRAND, DOUBLE WRAP 0.025 SAFETY WIRE BETWEEN CLAMP HALVES.
- d.

OPERATE FLAPS/SLATS THROUGH SEVERAL CYCLES. ENSURE NO ACTUATOR BINDING IS NOTED WHILE THE SLATS ARE IN MOTION. ENSURE THE HEATERS DO NOT RESTRICT ACTUATOR MOVEMENT. PERFORM A VISUAL INSPECTION OF THE HEATER WIRING AND CONFIRM THAT NO CHAFING OR RUBBING IS OBSERVED.

2

ACCEPTABLE TO INSTALL NEXT LENGTH CAP SCREWS IF NO THREADS PROTRUDE FROM NUTPLATE

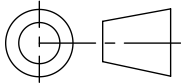


CLAMP HEATER INSTL

| REV. | DESCRIPTION                            | DRAWN          | CHECKED           | APPROVED          |
|------|--|----------------|-------------------|-------------------|
| IR   | INITAL RELEASE                         | -              | -                 | -                 |
| A    | UPDATED NOTES, ACTUATOR PART NUMBERS   | M BAIG 9/18/20 | L WILDING 9/30/20 | J KISTLER 10/1/20 |
| B    | UPDATED NOTES AND ACTUATOR ORIENTATION | M BAIG 10/8/20 | L WILDING 10/8/20 | J KISTLER 10/8/20 |

| 2        | 4   | PA-200124-817 | CLAMP HEATER (S1,S2) | COX & COMPANY |
|----------|-----|---------------|----------------------|---------------|
| 1        | 2   | PA-200124-806 | CLAMP HEATER (S3)    | COX & COMPANY |
| 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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7385 SOUTH PEORIA STREET  
UNIT C4  
ENGLEWOOD, CO 80112

TITLE:  
**SLAT ACTUATOR  
HEATERS INSTL**

DWG. NO. **PA-200124-507**

REV. **B**

DWG SIZE: B

SCALE: 1:1

SHEET 1 OF 6

|          |                     |
|----------|---------------------|
| APPROVED | J KISTLER 05/26/20  |
| CHECKED  | M BAIG 05/26/20     |
| DRAWN    | B CHILDERS 05/26/20 |

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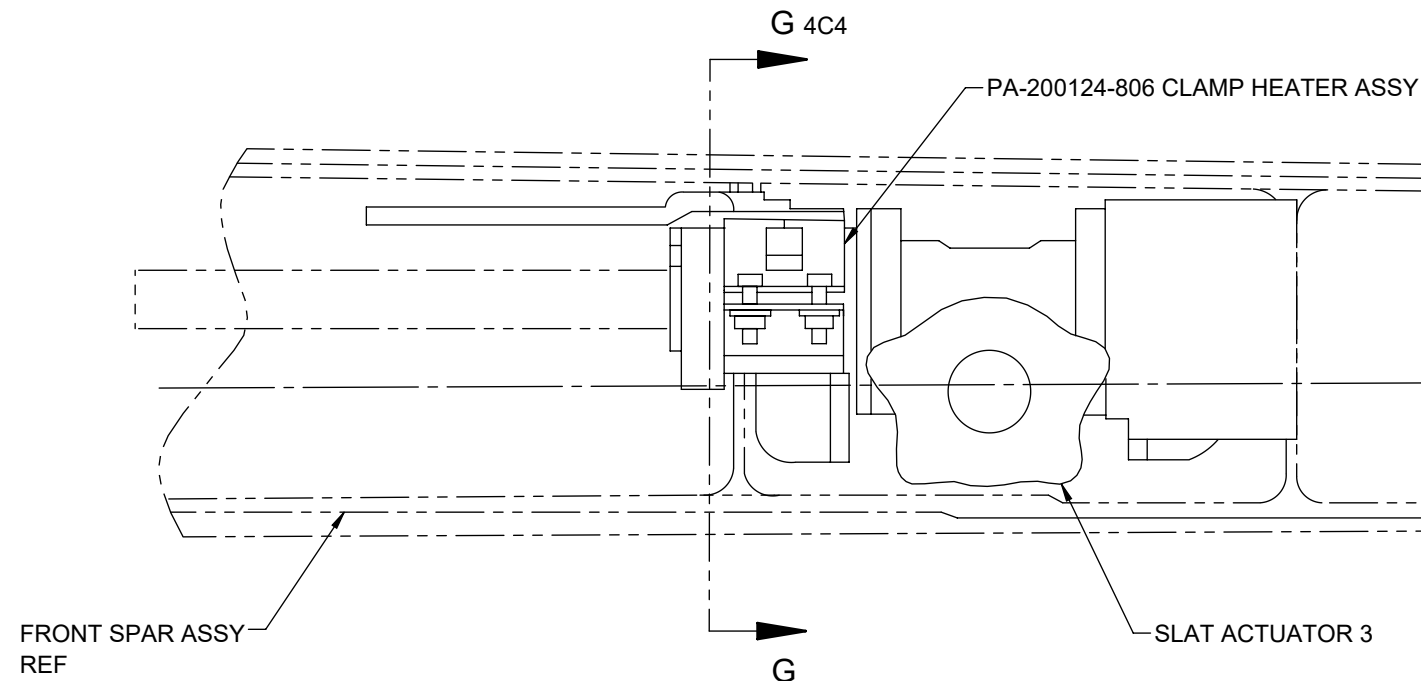
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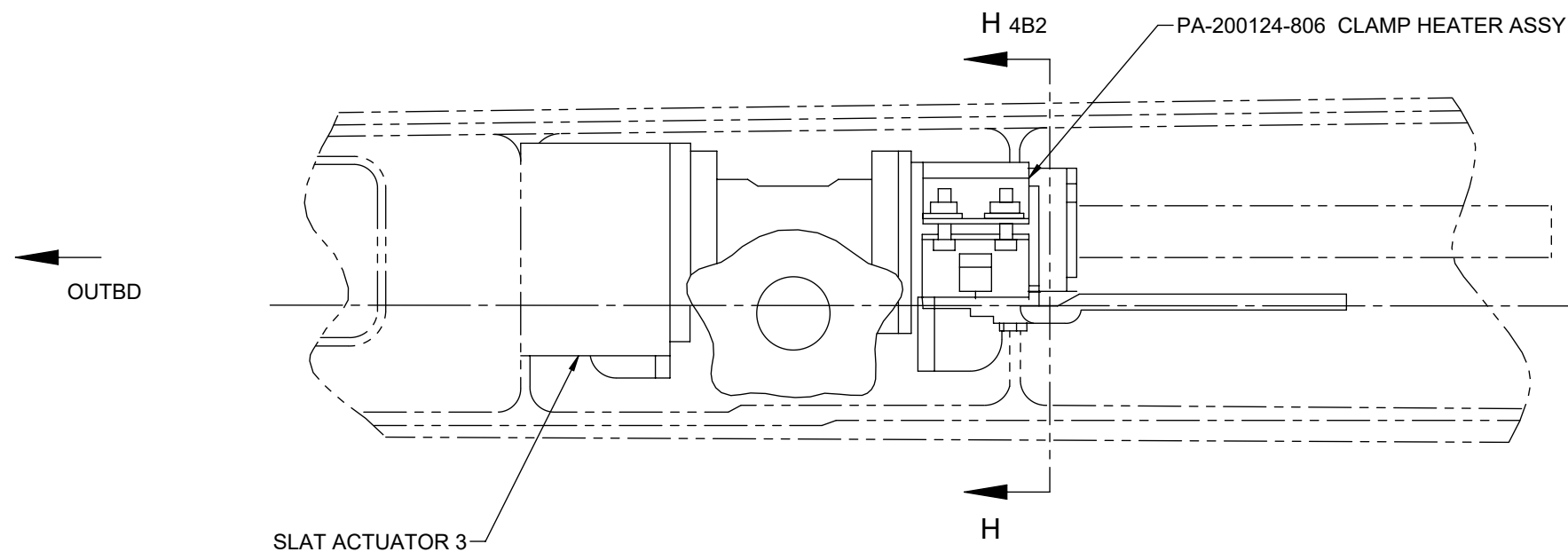
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**DETAIL A 1A4**  
LKG AFT. NORMAL TO FR SPAR ON THE LS ACFT  
STRUCTURE OMITTED FOR CLARITY



**DETAIL B 1D4**  
LKG AFT. NORMAL TO FR SPAR ON THE RS ACFT  
STRUCTURE OMITTED FOR CLARITY



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7385 SOUTH PEORIA STREET  
UNIT C4  
ENGLEWOOD, CO 80112

TITLE: **SLAT ACTUATOR  
HEATERS INSTL**

DWG. NO. **PA-200124-507**

REV. **B**

DWG SIZE: B

SCALE: 1:1

SHEET 2 OF 6

4

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2

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D

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J 4A3

PA-200124-817 CLAMP HEATER ASSY

FRONT SPAR ASSY  
REF

OUTBD

SLAT ACTUATOR 2

DETAIL C 1B4  
LKG AFT. NORMAL TO FR SPAR ON THE LS ACFT  
STRUCTURE OMITTED FOR CLARITY

J 4A3

PA-200124-817 CLAMP HEATER ASSY

FRONT SPAR ASSY  
REF

OUTBD

SLAT ACTUATOR 2

DETAIL D 1D4  
LKG AFT. NORMAL TO FR SPAR ON THE RS ACFT  
STRUCTURE OMITTED FOR CLARITYPROPRIETARY  
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7385 SOUTH PEORIA STREET  
UNIT C4  
ENGLEWOOD, CO 80112TITLE: **SLAT ACTUATOR  
HEATERS INSTL**DWG.  
NO. **PA-200124-507**REV. **B**

DWG SIZE: B

SCALE: 1:1

SHEET 3 OF 6

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PA-200124-806 REF

SLAT ACTUATOR 3

FWD

SECTION G-G 2D2  
LKG OUTBD ON LS ACFT  
STRUCTURE OMITTED FOR CLARITY

FWD

SLAT ACTUATOR 3

PA-200124-806 REF

SECTION H-H 2B3  
LKG OUTBD ON RS ACFT  
STRUCTURE OMITTED FOR CLARITY

FWD

SLAT ACTUATOR 2

PA-200124-817 REF

SECTION J-J 3D2, 3B3  
LKG OUTBD ON LS ACFT  
LKG INBD ON RS ACFT  
STRUCTURE OMITTED FOR CLARITY

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UNIT C4  
ENGLEWOOD, CO 80112

TITLE:

**SLAT ACTUATOR  
HEATERS INSTL**

DWG. NO. **PA-200124-507**REV. **B**

DWG SIZE: B

SCALE: 1:1

SHEET 4 OF 6

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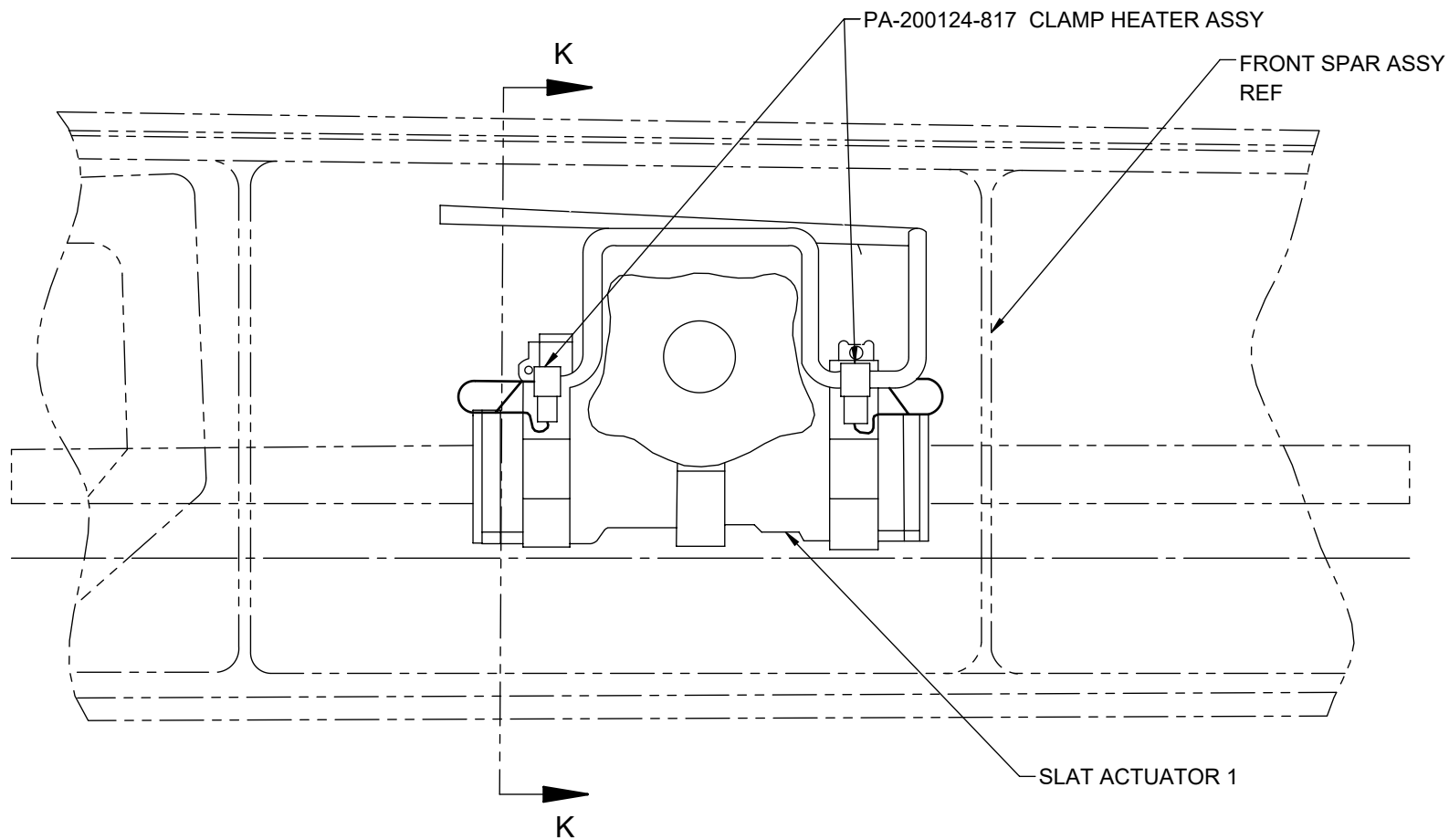
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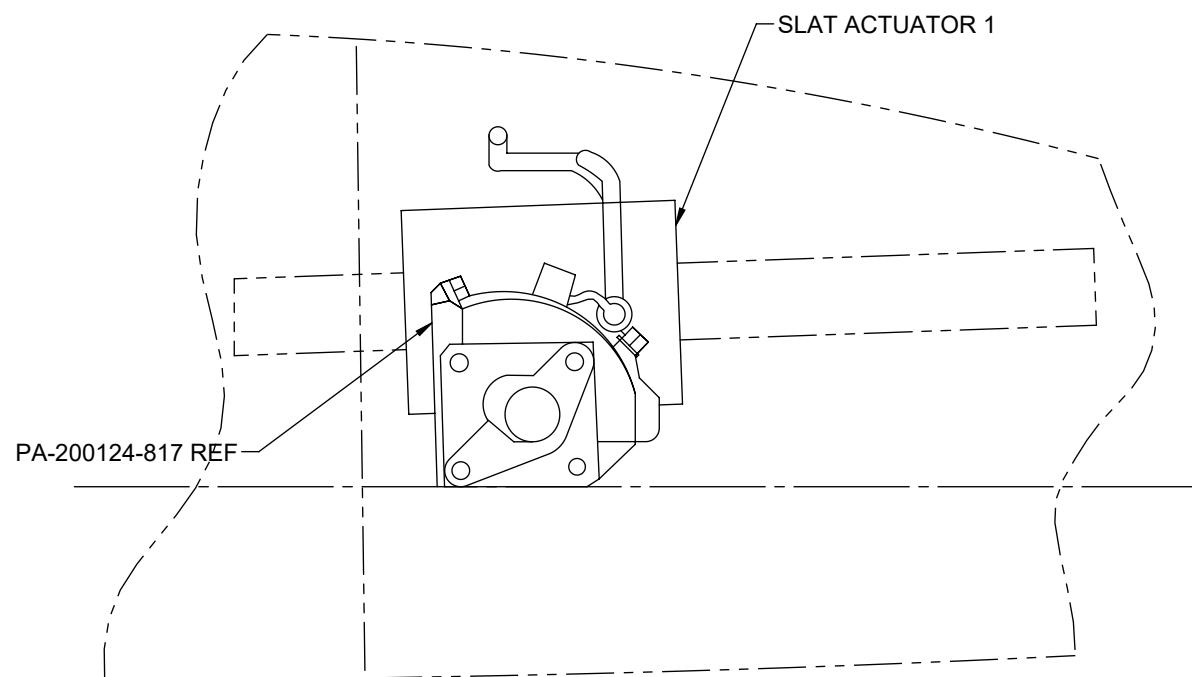
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**DETAIL E 1B4**  
LKG AFT. NORMAL TO FR BEAM ON THE LS ACFT  
STRUCTURE OMITTED FOR CLARITY



**SECTION K-K 6D3**  
LKG OUTBD ON LS ACFT  
LKG INBD ON RS ACFT  
STRUCTURE OMITTED FOR CLARITY

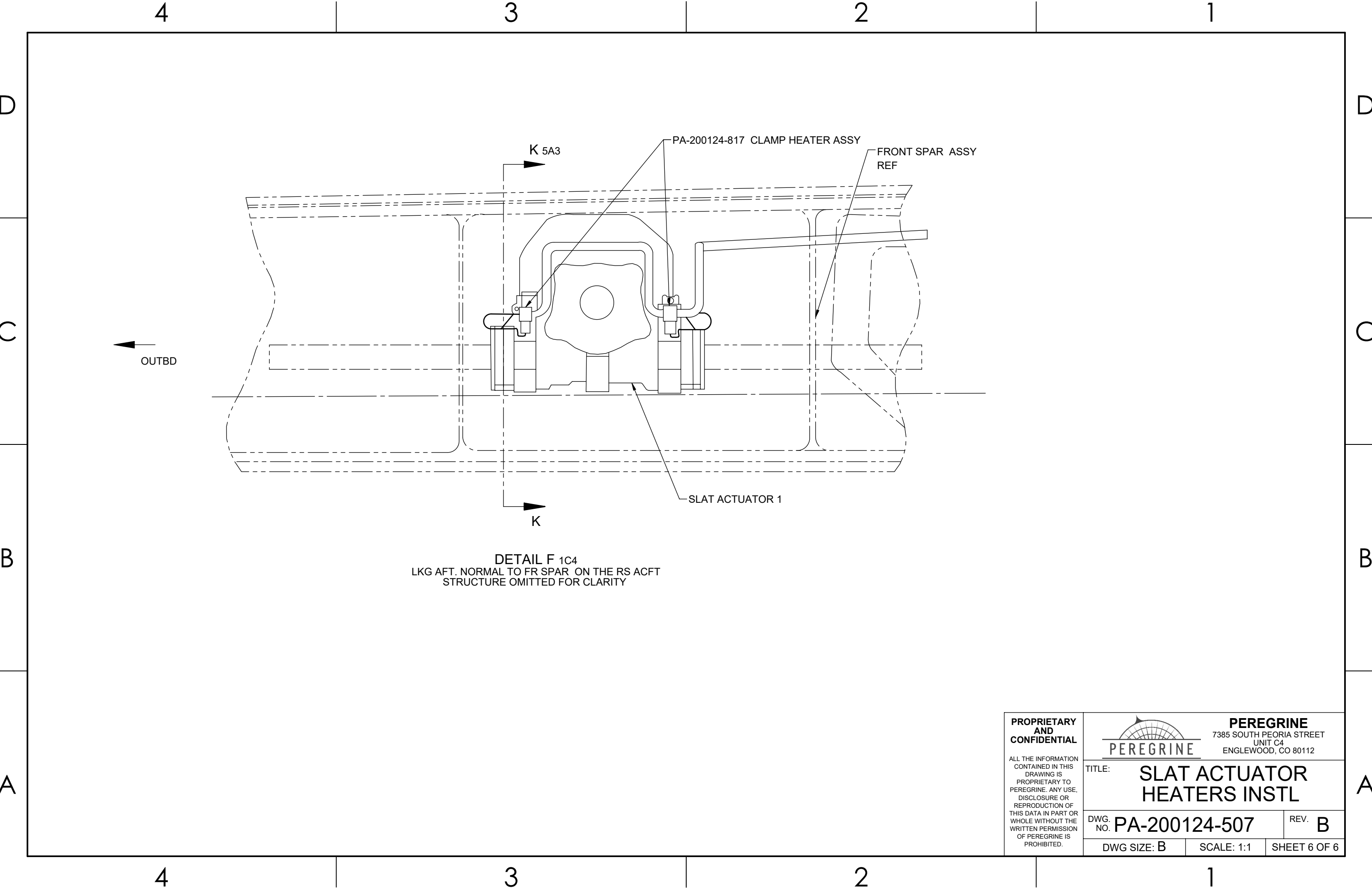
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|   | TITLE: <b>SLAT ACTUATOR<br/>HEATERS INSTL</b>  |               |              |
|   | DWG.<br>NO. <b>PA-200124-507</b>   | REV. <b>B</b> |              |
|   | DWG SIZE: B  | SCALE: 1:1    | SHEET 5 OF 6 |

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DETAIL F 1C4  
LKG AFT. NORMAL TO FR SPAR ON THE RS ACFT  
STRUCTURE OMITTED FOR CLARITY

|  |  |               |              |
|--|--|---------------|--------------|
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|  | TITLE: <b>SLAT ACTUATOR<br/>HEATERS INSTL</b>  |               |              |
|  | DWG.<br>NO. <b>PA-200124-507</b>   | REV. <b>B</b> |              |
|  | DWG SIZE: B  | SCALE: 1:1    | SHEET 6 OF 6 |