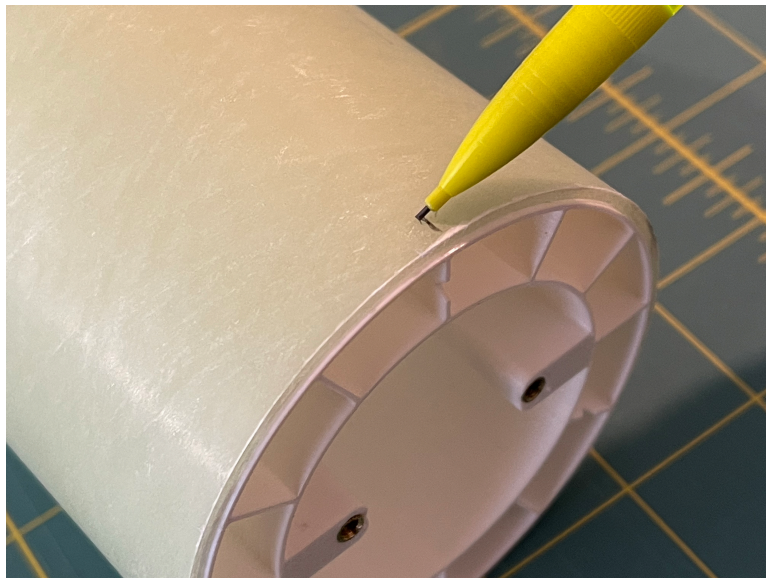


## INSTALLING A MACH 1 NOSE BAY SLEEVE



- 1) INSERT THE SLEEVE INTO THE NOSE CONE COUPLER - FLUSH WITH THE END THAT WILL BE INSERTED INTO THE NOSECONE. **DO NOT EPOXY THE SLEEVE IN PLACE YET!**



- 2) IF INSTALLING (3) GROMMETS, UTILIZE THE NOTCHED RIBS ON THE INSIDE OF THE SLEEVE FOR EVEN SPACING. IF INSTALLING (2) GROMMETS, UTILIZE THE RIBS LOCATED IN LINE WITH THE SLED MOUNTING ARMS. MARK THESE LOCATIONS ON THE COUPLER.

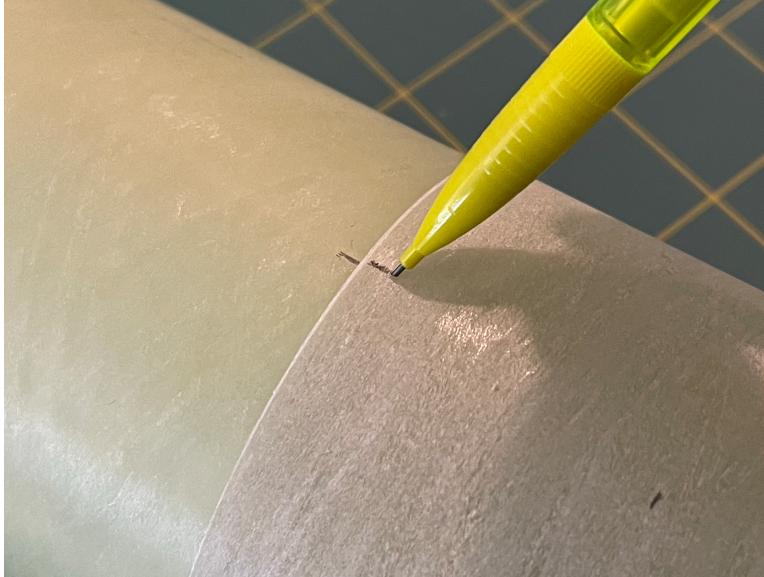


3) APPLY A LIGHT COAT OF EPOXY TO THE INSIDE OF THE COUPLER - APPROXIMATELY AN INCH WIDE BAND WORTH (CAREFUL - A LITTLE GOES A LONG WAY!) AND INSTALL THE SLEEVE INTO THE COUPLER, AGAIN FLUSH WITH THE END. A CLEAR THIN 30-MIN EPOXY WORKS GREAT.

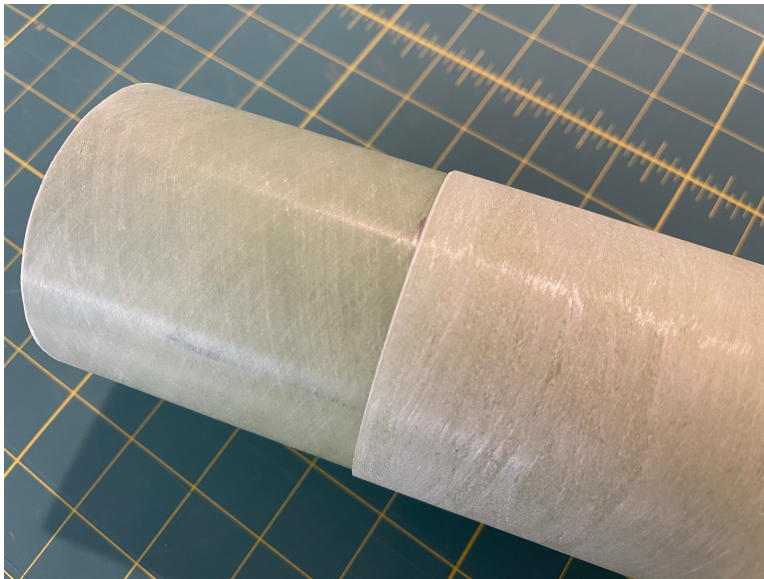
**PRIOR TO THE EPOXY CURING**, ROTATE THE SLEEVE INSIDE OF THE COUPLER A SMALL AMOUNT AND ENSURE THE MARKINGS ON THE COUPLER ALIGN WITHIN AN OPEN SPACE ON THE SLEEVE. (THIS ONLY APPLIES TO 76MM & 98MM NOSE BAY SLEEVES - ON 65MM BAYS AND SMALLER, ENSURE THE MARKINGS WILL NOT IMPEDE WITH THE LATER INSTALLATION OF RIVETS AND THE SLED)



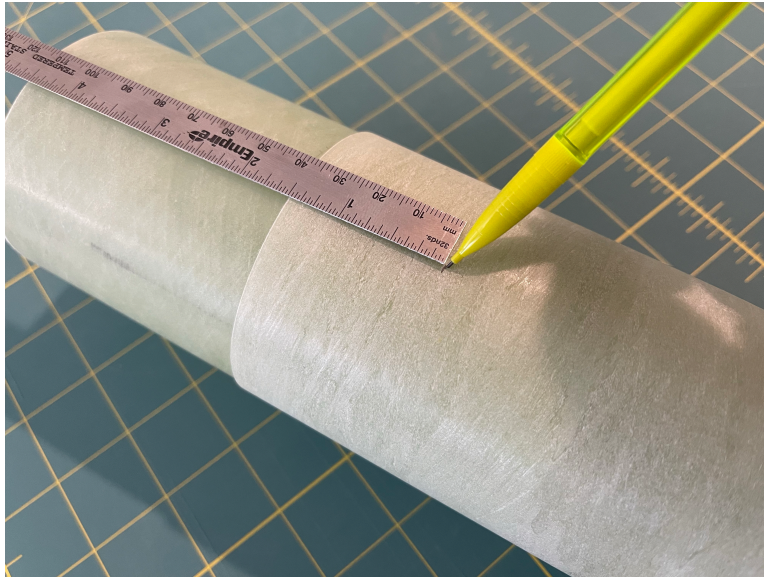
4) MEASURE AND MARK THE HALFWAY POINT ON THE OUTSIDE OF THE COUPLER.



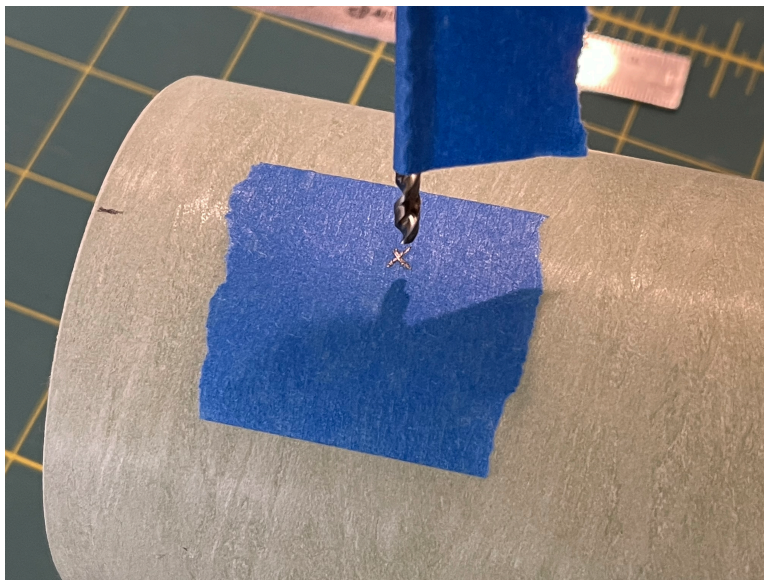
5) TRANSFER THE COUPLER MARKINGS TO THE NOSECONE. **IT IS HELPFUL TO MAKE ONE SET OF THESE MARKINGS UNIQUE OR BOLD TO SET A HOLE ALIGNMENT REFERENCE FOR ALL FUTURE RE-INSTALLATIONS.** PRIOR TO PAINTING, TRANSFER THIS REFERENCE MARK TO THE INSIDE OF THE NOSECONE WITH PERMANENT MARKER.



6) INSERT THE COUPLER INTO THE NOSECONE UP TO THE MARKED HALFWAY POINT.



7) MEASURE AND MARK APPROXIMATELY 1.5 INCHES UP ON THE NOSECONE FROM THE NOSECONE BOTTOM. THIS WILL BE THE DRILL LOCATION OF THE RIVETS. IT IS STRONGLY RECOMMENDED THAT PAINTERS TAPE BE APPLIED TO BOTH THE NOSECONE AND COUPLER TO PREVENT ANY MOVEMENT DURING DRILLING.



8) PAINTERS TAPE CAN BE APPLIED TO THE NOSECONE TO PREVENT FIBERGLASS SPLITTING. USE A  $5/32$ " DRILL BIT FOR LARGE 4MM RIVETS (76MM & 98MM BAYS) OR A  $1/8$ " DRILL BIT FOR SMALL 3MM RIVETS (65MM, 54MM, BT60 & 38MM BAYS). PLACING PAINTERS TAPE ON THE DRILL BIT MATCHED WITH THE DESIRED DEPTH HELPS PREVENT DRILLING TOO FAR.

**THIS COMPLETES THE INSTALL OF A MACH 1 NOSE BAY.  
HAPPY FLYING!**