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## **Installation Instructions #180WB-3 All Composite Extended Baggage Cessna 180 Series A/C**

### **Tools You Will Need:**

- Cordless drill
- 3/16" drill bit
- 1/4" drill bit
- Rivnut® installation tool
- #2 Phillips screwdriver
- small round file
- adjustable open end wrench
- 3/8" wrench
- 3M® Super 77 spray adhesive or equivalent upholstery glue
- dust mask
- vacuum

*CAUTION: These parts are constructed of carbon fiber and epoxy. Carbon fiber dust is hazardous to your respiratory system. Wear approved dust mask or respirator. Vacuum up all dust and/or wipe up with damp paper towel to keep it from getting airborne.*

### **Procedure**

1. Remove fuselage interior panels to expose the front side of the bulkhead assembly @ fuselage station (F.S.) 108.
2. Remove the headliner from the stringer that goes across the middle of the opening in the bulkhead assembly @ F.S.108. Remove the stringer from across the middle and the doublers on both sides of the opening in F.S.108 by drilling out the rivets that attach them to the bulkhead assembly (See Note 3 on ACI Installation Dwg. #2000-3). Trim the headliner material so that it wraps around the bulkhead assembly and glue it to the aft side of the bulkhead assembly using 3M Super 77 spray adhesive or equivalent .

3. Take the composite bulkhead (ACI P/N2000-1) and place it against the FWD side of the bulkhead assembly @ F.S.140 (See Notes 2 and 4 on ACI installation drawing 2000-3).
4. Using the composite bulkhead as a template, mark and drill six mounting holes in the F.S.140 bulkhead assembly with a 1/4" drill bit.
5. Remove the composite bulkhead and install six (6) size A10-80 B.F. Goodrich Rivnuts® provided, one in each of the six mounting holes
6. Measure and mark the locations for two (2) Cessna I-bolts on the F.S.140 bulkhead assembly (Ref.: Detail 1 on installation drawing). Drill the holes using a 3/16" drill bit, and install 2 Cessna I-bolts using 2 (ea.) AN970-3 washers, and an AN365-1032 lock nut. (Ref.: section B-B on installation drawing)
7. Install the composite bulkhead on the F.S. 140 bulkhead assembly using six (6) AN526-1032R8 recessed truss head screws provided.
8. Set the floor panel (ACI P/N 2000-2) in place so that it rests on the bottom flanges of the F.S. 108 and composite bulkhead flange. Using the floor panel as a template, mark and drill seven (7) mounting holes in the bulkhead assemblies (4 in F.S. 108 doubler – 3 in the composite bulkhead flange) using a 1/4" drill bit. Remove the floor panel and install seven (7) size A10-80 B.F. Goodrich Rivnuts®, one in each of the mounting holes.
9. Install the composite floor panel using seven (7) AN526-1032R8 recessed truss head screws.
10. Measure and mark the locations for two (2) Cessna I-bolts on the F.S. 108 bulkhead assembly (Reference Detail 2 on Installing Drawing). Drill the holes using a 3/16" drill bit, and install two (2) Cessna I-bolts using 2 (ea.) AN970-3 washers, and an AN365-1032 lock nut. (Reference Section A-A on Installation Drawing).