MONOGRAM SYSTEMS

1500 Glenn Curtiss Street
Carson, California 90746-4012 – USA

SERVICE BULLETIN

MODEL: Global Express/Global Express XRS (BD-700-1A10) and Global 5000 (BD-700-1A11) NO: 871500-25-2147

ATA SYSTEM: 25-10 DATE: May 23/08

Subject:

GLOBAL EXPRESS CREW SEATS – FORE/AFT ADJUSTMENT CABLE REPLACEMENT

1. Planning Information

A. Effectivity

This service bulletin affects Global Express/Global Express XRS (BD-700-1A10) and Global 5000 (BD-700-1A11) Pilot Seats (P/N's 871500-602 thru 608) and the Co-Pilot Seat Assemblies (P/N's 871500-603 thru -609). For effectivity, refer to the following page for Table 1.

B. Concurrent Requirements

Not affected.

C. Reason

Monogram Systems developed a thicker cable for the fore/aft adjustment as a product improvement.

D. Description

On both the Pilot/Co-Pilot Seats the service bulletin replaces the existing lever assembly and the bellcrank on the fore/aft control installation with new ones. The SP Kits 120SP018 contains all the parts necessary to complete this job. (Refer to Table 1 for effectivity).

E. Compliance

Compliance with this service bulletin is optional, and entirely at the discretion of the user.

Effectivity
Table 1

SEAT	Seat Assy P/N	Serial Numbers	Pre-Service Bulletin Fore/AFt Adjustment & Control Instl	SP Kit
PILOT	871500-602	0010 thru 0056	**871528-401 FORE/AFT ADJUSTMENT & CONTROL INSTL	**120SP018**
	871500-604	0057 thru 0073 0075 thru 0088 0090 thru 0103 0109 thru 0129		
	871500-604-001	0104 thru 0108		
	871500-604-003	0074 Only		
	871500-604-004	0089 Only		
CO-PILOT	871500-603	0009 thru 0056	**871528-402 FORE/AFT ADJUSTMENT & CONTROL INSTL	**120SP018**
	871500-605	0057 thru 0072 0074 thru 0096 0098 thru 0122		
	871500-605-002	0123 thru 0128		
	871500-605-003	0073 Only		
	871500-605-004	0097 Only		
NOTE: IF PREVIOUS SERVICE BULLETINS 871500-25-2071 & 871500-25-2087 HAVE BEEN INCORPORATED INTO THE ABOVE SEATS, THE FORE/AFT ADJUSTMENT & CONTROL INSTL P/N'S BECOME 871528-405/-406 AND THE SEAT PART NUMBER BECOMES 871500-608/-609 PILOT/CO-PILOT SEAT ASSEMBLY.				
PILOT	871500-606	0130 thru 0139 0141 thru 0162	**871528-403 FORE/AFT ADJUSTMENT & CONTROL INSTL	**120SP018**
	871500-606-001	0140 Only		
Co-Pilot	871500-607	0129 thru 0132 0134 thru 0160	**871528-404 FORE/AFT ADJUSTMENT & CONTROL INSTL	**120SP018**
	871500-607-001	0133 Only		
NOTE: IF PREVIOUS SERVICE BULLETIN 871500-25-2109 HAS BEEN INCORPORATED INTO THE ABOVE SEATS, THE FORE/AFT ADJUSTMENT & CONTROL INSTL P/N BECOMES 871528-405/-406 AND THE SEAT PART NUMBER BECOMES 871500-608/-609 PILOT/CO-PILOT SEAT ASSEMBLY.				
Pilot	871500-608	0163 thru 0315	**871528-405	**120SP018**
Co-Pilot	871500-609	0161 thru 0309	**871528-406	
**TO ENABLE YOUR SEAT TO UTILIZE THE LATEST CONFIGURATION OF THE FORE/AFT ADJUSTMENT & CONTROL INSTL P/N 871528-405/-406, YOU WILL NEED TO IMPLEMENT SERVICE BULLETIN 871500-25-2146, AS WELL AS THE RESPECTIVE PRECEDING SERVICE BULLETINS REFERENCED ABOVE THAT ARE APPLICABLE TO YOUR SEAT CONFIGURATION. IN ORDER TO INCORPORATE THIS SERVICE BULLETIN INTO YOUR SEAT CONFIGURATION, IT IS NOT NECESSARY TO IMPLEMENT ANY OF THE PREVIOUS SERVICE BULLETINS; IT IS ONLY A SUGGESTION. IF YOU DECIDE NOT TO INSTALL THE PREVIOUS SERVICE BULLETINS, YOUR SEAT CONFIGURATION WILL STAY THE SAME, IT JUST BECOMES A MODIFIED SEAT.				

Effectivity (Continued)
Table 1

SEAT	Seat Assy P/N	Serial Numbers	Pre-Service Bulletin Fore/AFt Adjustment & Control Instl	SP Kit
Pilot	871500-608	0316 thru 0357	**871528-405	**120SP018**
Co-Pilot	871500-609	0310 thru 0351	**871528-406	
** THIS PARTICULAR SEAT CONFIGURATION UTILIZES THE LATEST CONFIGURATION OF THE FORE/AFT ADJUSTMENT & CONTROL INSTL P/N 871528-405/-406. ONCE THIS SERVICE BULLETIN 871500-25-2147 HAS BEEN INCORPORATED THE FORE/AFT ADJUSTMENT & CONTROL INSTL P/N 871528-405/-406 WILL BECOME P/N 871528-407/-408.				

NOTE: Previous Service Bulletins may have been implemented into your seat, changing some of the configurations. Check your seat to see if any Modification Plates exist, the new part number of the seat will be identified on the modification plate, but the original serial number will stay the same.

All previous service bulletins are not necessary to incorporate this New Service Bulletin, but the various conditions will be noted throughout this service bulletin. Check your seat prior to implementing this Service Bulletin to see if any of the following service bulletins may apply:

(1) 871500-25-2071 “Global Express Track Pin Used for Fore/Aft Adjustment Modification.” This service bulletin replaces the existing track pin used for for/aft adjustment with a new track pin. This service bulletin affected the 871500-604 Pilot and 871500-605 Co-Pilot Seat Assemblies.

(2) 871500-25-2087 “Global Express New Adjustable-Lock Assembly and Lever Mechanism.” This service bulletin replaces the existing lever assembly used on the fore/aft adjustment and control installation with a new lever mechanism on both the Pilot and Co-Pilot Seat Assembly. The service bulletin was revised to prevent FWD/AFT handle activation when the seat is in a lateral position. The revision replaced the 871528-1 Plate on the 871528-403/-404 Fore/AFt Adjustment and Control Installation, with a 871528-3 Plate, therefore rolling the 871500-604 Pilot and 871500-605 Co-Pilot Seat Assemblies to 871500-608/609. If you have already incorporated Revision No. 3 of this service bulletin please refer to Service Bulletin 871500-25-2109 for incorporation of 871528-3 Plate only.

(3) 871500-25-2109 “Global Express Lateral Movement Modification”. This service bulletin was intended for customers who had already incorporate Service Bulletin 871500-25-2087 Revision 3; converting their 871500-604/-605 Pilot/Co-Pilot Seat Assemblies to 871500-606/-607 Pilot/Co-Pilot Seat Assemblies. The service bulletin replaces the existing 871528-1 Plate and attaching hardware used on the 871528-403/-404 Fore/Aft Adjustment and Control Installation with a new 871528-3 Plate and attaching hardware on both the 871500-606 Pilot and 871500-607 Co-Pilot Seat Assembly. Once the change is incorporated the 871528-403/-404 becomes 871528-405/-406 and the 871500-606/-607 becomes 871500-608/-609.

(4) 871500-25-2146 “Global Express Crew Seats – Fore/Aft Adjustment Cable Stop”. This service bulletin attaches a stop handle to the lever assembly on the fore/aft control installation on both the Pilot/Co-Pilot Seats. This service bulletin affects Global Express/Global Express XRS (BD-700-1A10) and Global 5000 (BD-700-1A11) Pilot Seats (P/N’s 871500-602 thru 608 covering serial numbers 0010 thru 0315) and the Co-Pilot Seat Assemblies (P/N’s 871500-603 thru -609 covering serial numbers 0009 thru 0309).

F. Approval

This service bulletin has been reviewed by the appropriate governmental authority and the repairs and modifications herein comply with the applicable Aviation Regulations and are APPROVED for installation in the Model Global Express/Global Express XRS (BD-700-1A10) and Global 5000 (BD-700-1A11).

G. Manpower

The work phases and estimated time to accomplish the modifications per seat that are outlined in this service bulletin are shown in Table 2.

Manpower
Table 2

REWORK PHASE	ESTIMATED TIME
120SP018	
a. Disassembly	0.75 man-hour(s)
b. Assembly	0.75 man-hour(s)
TOTAL	1.50 man-hour(s)

NOTE: The above estimates do not include time for setup, planning, and familiarization.

H. Weight and Balance

Not affected.

I. Electrical Load Data

Not affected.

J. References

(1) Monogram Systems (Formerly Weber Aircraft) blueprints 871500 Rev AB, 871528 Rev P. 871550 Rev E.

(2) Monogram Systems (Formerly Weber Aircraft) Component Maintenance Manual with Illustrated Parts List ATA 25-10-42, covering Global Express Seat Assembly Pilot and Co-Pilot, Part Numbers 871500-602 thru -609.

K. Other Publication Affected

None.

2. Material Information

A. Material - Price and Availability

The kit assembly identified in Table 3 may be obtained from Monogram Systems within the terms and conditions described herein. Price and delivery data will be provided upon request. When source capacity is limited and material availability is the pacing factor, customer purchase orders will receive an allocation from available quantities based upon the receipt date of purchase orders by the Spares Department. Delivery dates will be computed from the expiration date of this quotation if the order is received prior to the expiration date. Information regarding improved delivery dates at increased prices may be obtained by request through normal procurement channels.

Address purchase orders pertaining to this service bulletin to:

Monogram Systems
1500 Glenn Curtiss Street, Carson CA. 90746-4012 USA.
Attn: Manager, Customer Services.
Telephone: (310) 884-7000 Fax: (310) 884-7300

Material - Monogram Systems Furnished
Table 3

Kit Number	Description	Delivery	Pricing
120SP018	Global Express Crew Seats Fore/Aft Adjustment Cable Replacement	Request quote	Request quote

B. Bill of Materials

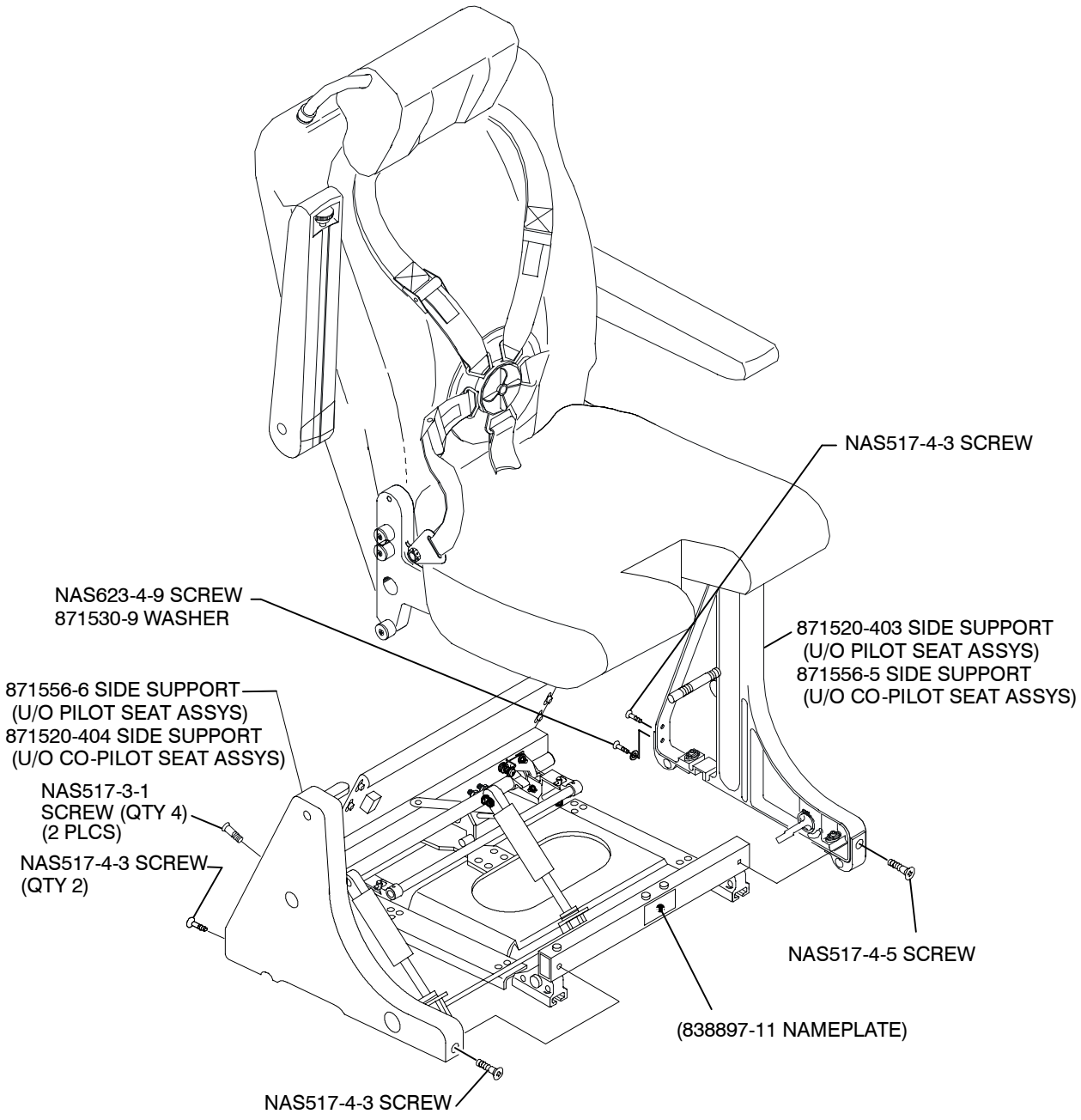
The following kit contains parts and hardware necessary to modify the Global Express/Global Express XRS (BD-700-1A10) and Global 5000 (BD-700-1A11)) for Pilot Seats (P/N's 871500-602 thru 608) and the Co-Pilot Seat Assemblies (P/N's 871500-603 thru -609). One SP kit is required per Seat.

Material Information Parts Tabulation
Table 4

New Part Number	Qty/ Seat	Unit List Price	Keyword	Old Part Number	Instr. Disp.
120SP018	REF	*	Global Express Crew Seats Fore/Aft Adjustment Cable Replacement		
			CONSISTING OF		
MS20995C20	24 inches	N/A	Lockwire	MS20995C20	Scrap
MS24665-132	1	N/A	Cotter Pin	MS24665-132	Scrap
MS39086-41	1	N/A	Spring Pin	MS39086-41	Scrap
NAS1149FN616P	1	N/A	Washer	NAS1149FN632P	Scrap
871550-5	1	N/A	Bellcrank	871550-1	Scrap
871528-205	1	N/A	Lever Assy	871528-203	Scrap
816929-17	1	N/A	Modification Plate	None	N/A
Note: *See paragraph 2.A "Material - Cost and Availability for prices.					

C. Tooling - Price and Availability

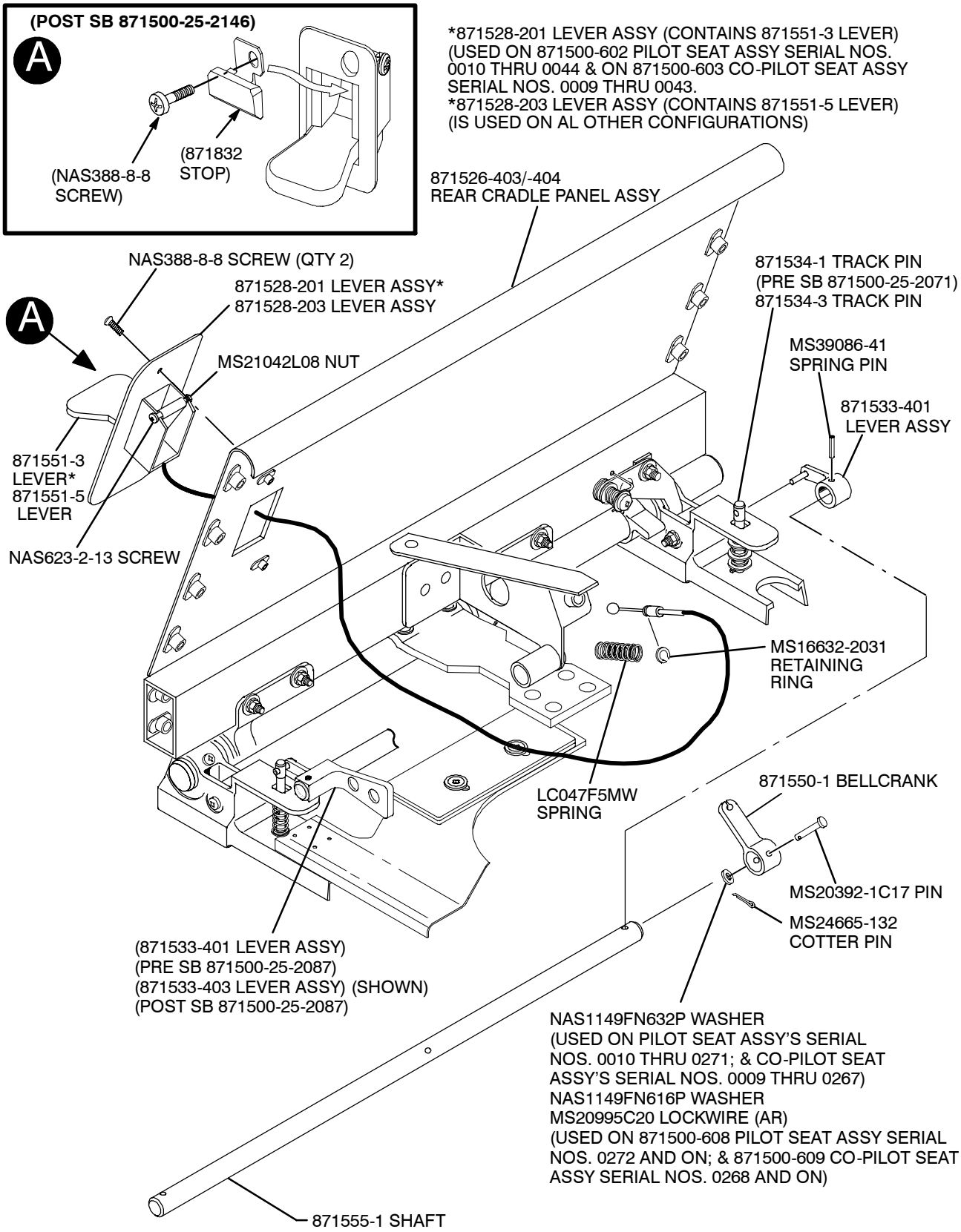
No special tools are required.



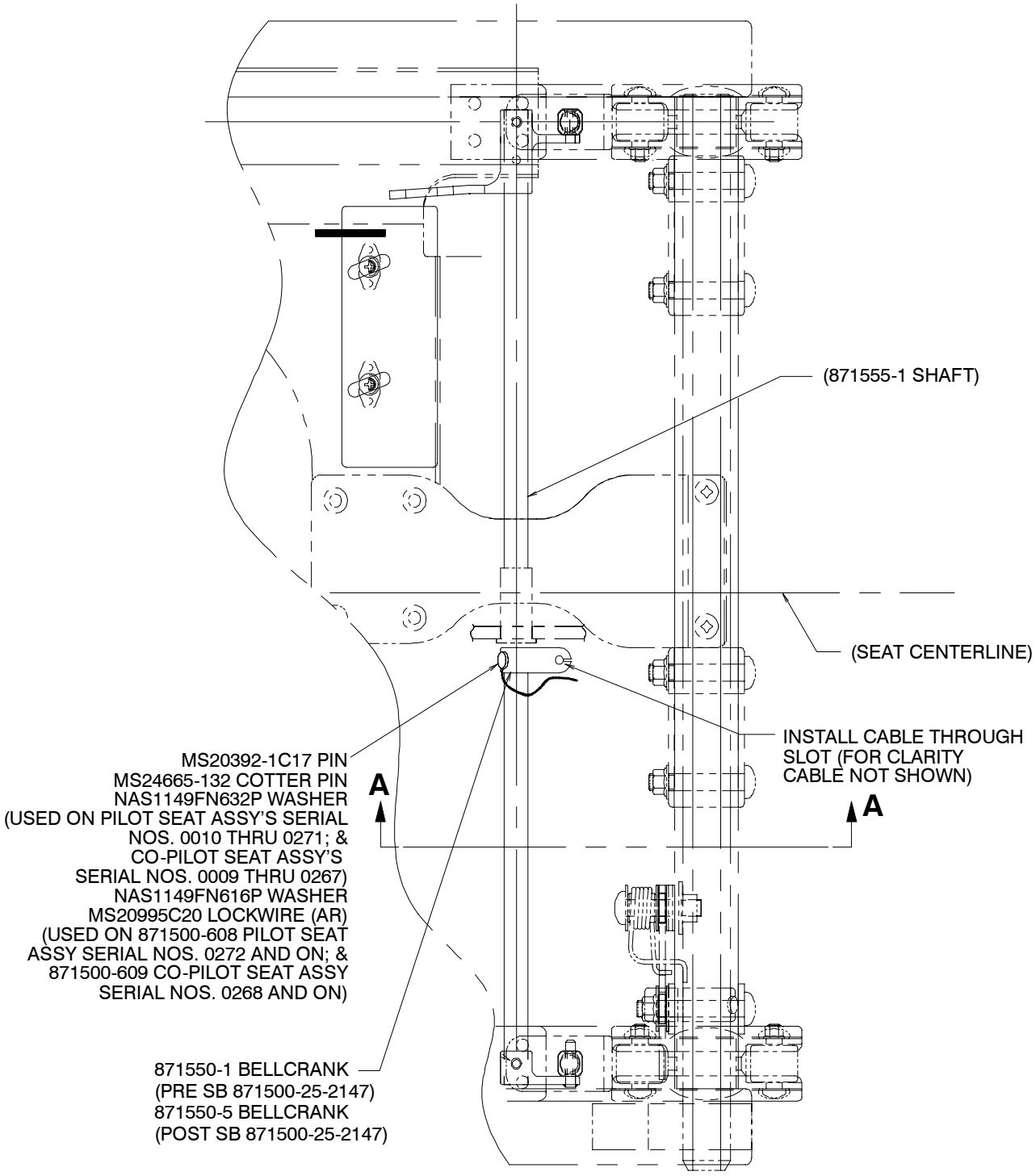
871500-602 THRU -608 PILOT SEAT ASSY (SHOWN)
871500-603 THRU -609 CO-PILOT SEAT ASSY (OPPOSITE)

PRE/POST-SERVICE BULLETIN CONDITION
FIGURE 1

SERVICE BULLETIN



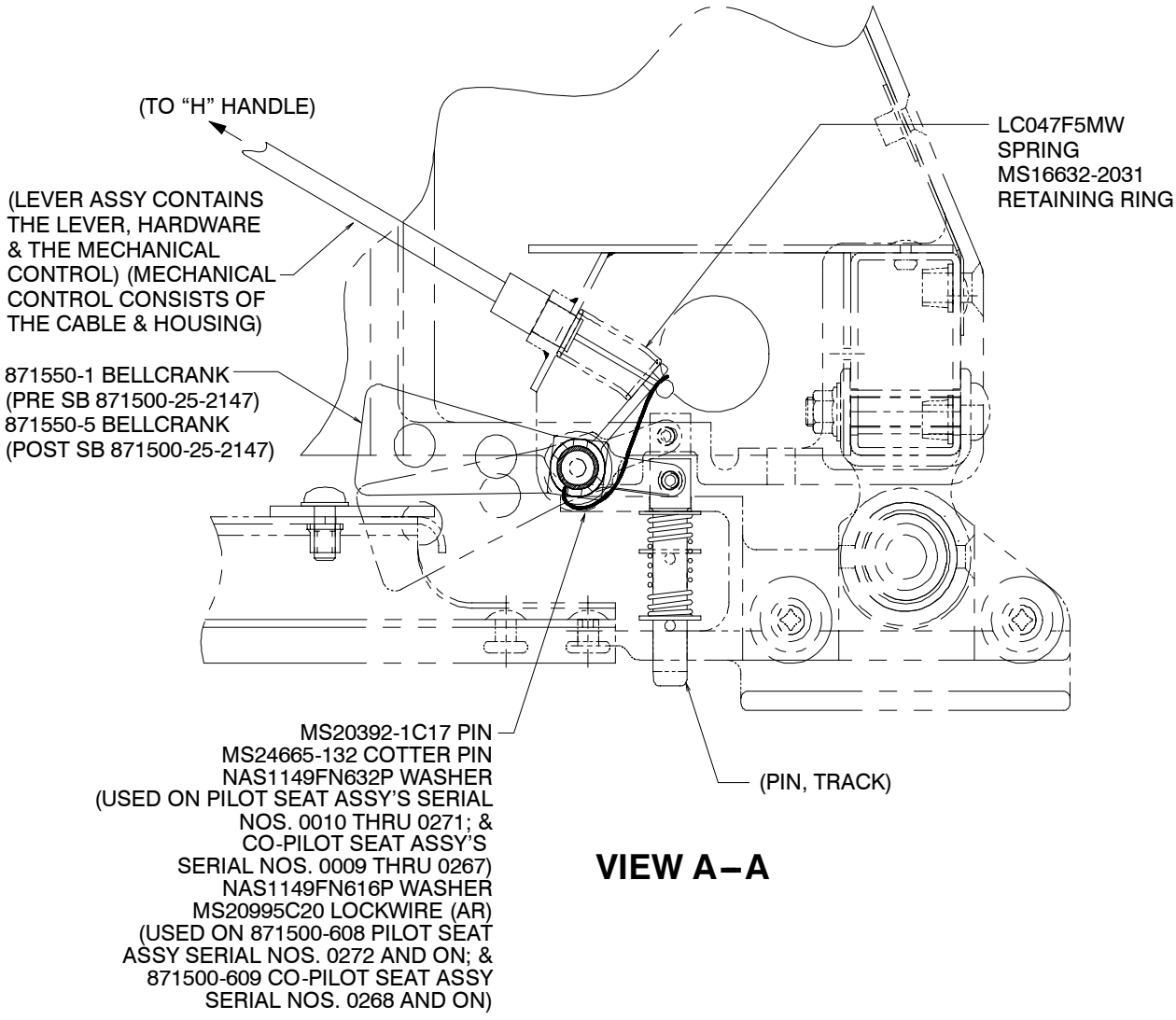
871528-401/-403/-405 (R.H. HANDLE, SHOWN) FORE/AFT ADJUSTMENT & CONTROL INSTL
871528-402/-404/-406 (L.H. HANDLE, OPPOSITE) FORE/AFT ADJUSTMENT & CONTROL INSTL
PRE-SERVICE BULLETIN CONDITION
FIGURE 2



(BOTTOM OF SEAT DETAIL)

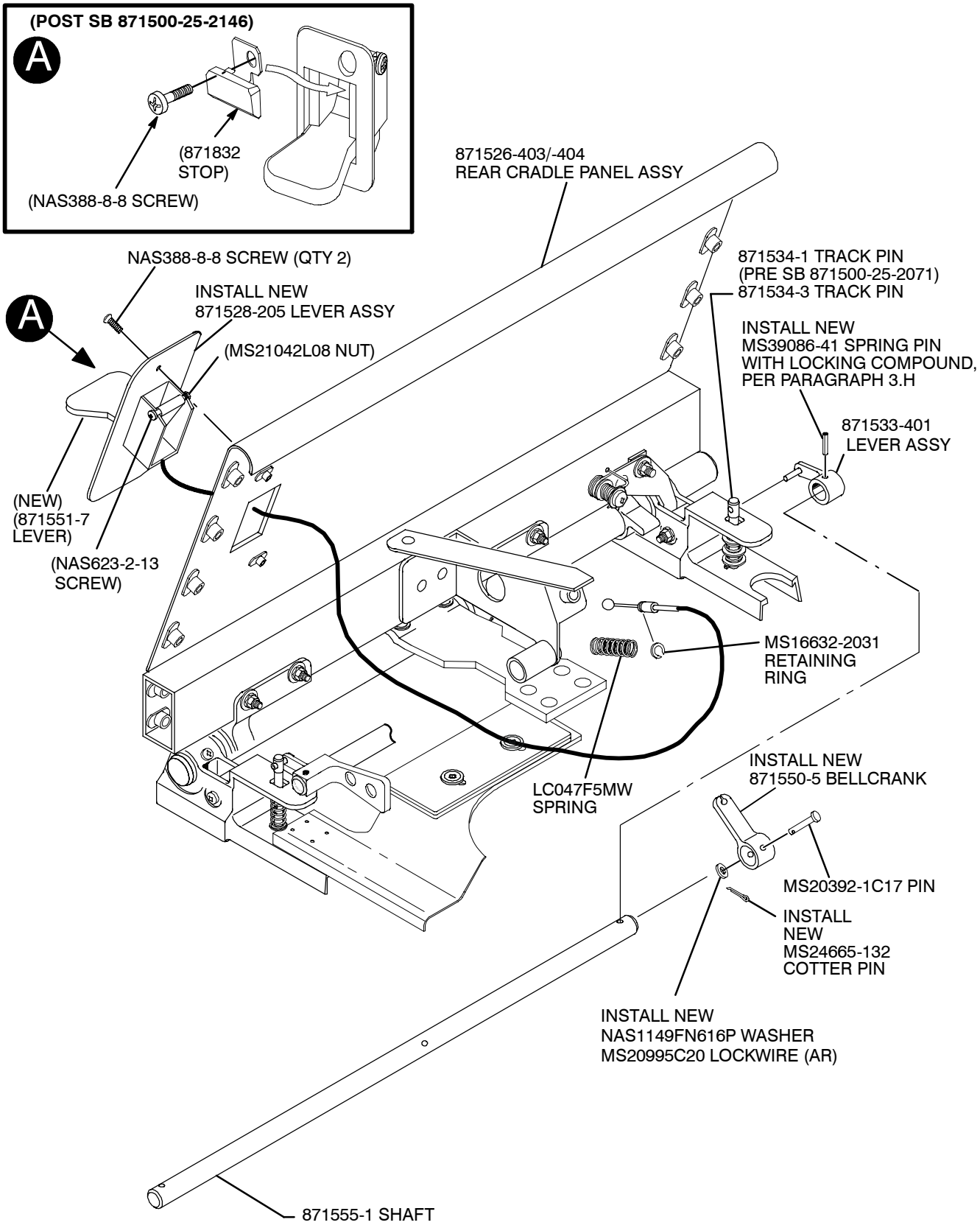
871528-405/-407 FORE/AFT ADJUSTMENT & CONTROL INSTALLATIONS (SHOWN)
871528-406/-408 FORE/AFT ADJUSTMENT & CONTROL INSTALLATIONS (OPP)

PRE/POST-SERVICE BULLETIN CONDITION
FIGURE 3 (SHEET 1 OF 2)



871528-405/-407 FORE/AFT ADJUSTMENT & CONTROL INSTALLATIONS (SHOWN)
871528-406/-408 FORE/AFT ADJUSTMENT & CONTROL INSTALLATIONS (OPP)

PRE/POST-SERVICE BULLETIN CONDITION
FIGURE 3 (SHEET 2 OF 2)



871528-407/-408 FORE/AFT ADJUSTMENT & CONTROL INSTL
POST-SERVICE BULLETIN CONDITION
FIGURE 4

3. Accomplishment Instructions

NOTE: Previous Service Bulletins may have been implemented into your seat, changing some of the configurations. These service bulletins are not necessary to incorporate this particular Service Bulletin, but the various conditions will be noted throughout the following procedures. (Refer to Effectivity, Table 1).

A. General Instructions.

NOTE: In order to gain adequate accessibility to the seat it is necessary to perform the following procedures prior to disassembly or assembly.

(1) Refer to Figure 1.

(2) Move the seat to the highest vertical position.

(3) On the 871500-602/-604/-604-001/-604-003/-604-004/-606/-606-001/-608 Pilot Seat Assemblies perform the following procedures:

(a) Remove NAS517-4-5 Screw securing the 871520-403 Side Support to the 871529-401 Front Tube Assembly. Retain the screw for reinstallation.

(b) Remove the four NAS517-3-1 Screws, one NAS623-4-9 Screw, one 871530-9 Washer, and one NAS517-4-3 Screw securing the 871520-403 Side Support to the 871526-403 Rear Cradle Panel Assembly. Separate the rear portion of the side plate from the aft tube. Retain the screws and washer for reinstallation.

(4) On the 871500-603/-605/-605-002/-605-003/-605-004/-607/-607-001/-609 Co-Pilot Seat Assemblies perform the following procedures:

(a) Remove NAS517-4-3 Screw securing the 871520-404 Side Support to the 871529-401 Front Tube Assembly. Retain the screw for reinstallation.

(b) Remove the four NAS517-3-1 Screws and two NAS517-4-3 Screws securing the 871520-404 Side Support to the 871526-404 Rear Cradle Panel Assembly. Separate the rear portion of the side plate from the aft tube. Retain the screws for reinstallation.

B. Disassembly Procedures for 871500-602/-603/-604 thru -604-004/-605 thru -605-004 Pilot/Co-Pilot Seat Assemblies utilizing the 871528-401/-402 Fore/Aft Adjustment & Control Installation. (Pre Service Bulletin 871500-25-2071 and 871500-25-2087).

(1) Refer to Figure 2.

(2) On the pilot seat assemblies remove two NAS388-8-8 Screws securing the 871528-201/-203 Lever Assembly to the 871526-403 Rear Cradle Panel Assembly. Retain the screws for reinstallation.

NOTE: The 871528-201 Lever Assembly is used on 871500-602 Pilot Seat Assembly Serial Numbers 0010 thru 0044 and on 871500-603 Co-Pilot Seat Assembly Serial Numbers 0009 thru 0043. The 871528-203 Lever Assembly is used on all other configurations.

(3) On the co-pilot seat assemblies remove two NAS388-8-8 Screws securing the 871528-201/-203 Lever Assembly to the 871526-404 Rear Cradle Panel Assembly. Retain the screws for reinstallation.

(4) On the 871528-201/-203 Lever Assembly disconnect the ball-end of the cable from the 871550-1 Bellcrank.

(5) Remove the LC047F5MW Spring from the cable on the 871528-201/-203 Lever Assembly. Retain the spring for reinstallation.

(6) On the pilot seat assemblies do the following:

(a) Remove the MS16632-2031 Retaining Ring securing the 871528-201/-203 Lever Assembly to the panel assembly bracket on the 871526-403 Rear Cradle Panel Assembly. Discard the retaining ring.

(b) Remove and discard the NAS623-2-13 Screw and MS21042L08 Nut securing the 871551-3/-5 Lever to the 871526-403 Rear Cradle Panel Assembly.

NOTE: The 871528-201 Lever Assembly consists of the 871551-3 Lever and the 871528-203 Lever Assembly contains 871551-5 Lever.

(c) Remove and discard the 871528-201/-203 Lever Assembly.

(7) On the co-pilot seat assemblies do the following:

(a) Remove the MS16632-2031 Retaining Ring securing the 871528-201/-203 Lever Assembly to the panel assembly bracket on the 871526-404 Rear Cradle Panel Assembly. Discard the retaining ring.

(b) Remove and discard the NAS623-2-13 Screw and MS21042L08 Nut securing the 871551-3/-5 Lever to the 871526-404 Rear Cradle Panel Assembly.

NOTE: The 871528-201 Lever Assembly consists of the 871551-3 Lever and the 871528-203 Lever Assembly contains 871551-5 Lever.

(c) Remove and discard the 871528-201/-203 Lever Assembly from the .

(8) Move the seat in the lateral position, disengaging the two 871533-401 Lever Assemblies from the two 871534-1 Track Pins (Pre-Service Bulletin 871500-25-2071).

(9) Using best shop practice, remove and discard the bonded MS39086-41 Spring Pin securing the 871533-401 Lever Assembly to the 871555-1 Shaft. Remove and retain the lever assembly for reinstallation.

NOTE: It is not necessary to remove the other 871533-401 Lever Assembly. (Pre-Service Bulletin 871500-25-2087).

(10) Remove MS24665-132 Cotter Pin, NAS1149FN632P Washer and MS20392-1C17 Pin securing 871550-1 Bellcrank to 871555-1 Shaft. Retain only the MS20392-1C17 Pin for reinstallation.

(11) Remove the 871550-1 Bellcrank off the 871555-1 Shaft. Discard the bellcrank.

C. Disassembly Procedures for 871500-606/-606-001/-607/-607-001 Pilot/Co-Pilot Seat Assemblies utilizing the 871528-403/-404 Fore/Aft Adjustment & Control Installation. (Pre Service Bulletin 871500-25-2109).

(1) Refer to Figure 2.

(2) On the pilot seat assemblies remove two NAS388-8-8 Screws securing the 871528-203 Lever Assembly to the 871526-403 Rear Cradle Panel Assembly. Retain the screws for reinstallation.

(3) On the co-pilot seat assemblies remove two NAS388-8-8 Screws securing the 871528-203 Lever Assembly to the 871526-404 Rear Cradle Panel Assembly. Retain the screws for reinstallation.

(4) On the 871528-203 Lever Assembly disconnect the ball-end of the cable from the 871550-1 Bellcrank.

(5) Remove the LC047F5MW Spring from the cable on the 871528-203 Lever Assembly. Retain the spring for reinstallation.

(6) On the pilot seat assemblies do the following:

(a) Remove the MS16632-2031 Retaining Ring securing the 871528-203 Lever Assembly to the panel assembly bracket on the 871526-403 Rear Cradle Panel Assembly. Discard the retaining ring.

(b) Remove and discard the NAS623-2-13 Screw and MS21042L08 Nut securing the 871551-5 Lever to the 871526-403 Rear Cradle Panel Assembly.

(c) Remove and discard the 871528-203 Lever Assembly.

(7) On the co-pilot seat assemblies do the following:

(a) Remove the MS16632-2031 Retaining Ring securing the 871528-203 Lever Assembly to the panel assembly bracket on the 871526-404 Rear Cradle Panel Assembly. Discard the retaining ring.

(b) Remove and discard the NAS623-2-13 Screw and MS21042L08 Nut securing the 871551-5 Lever to the 871526-404 Rear Cradle Panel Assembly.

(c) Remove and discard the 871528-203 Lever Assembly.

(8) Move the seat in the lateral position, disengaging the two 871533-401/-403 Lever Assemblies from the two 871534-3 Track Pins.

(9) Using best shop practice, remove and discard the bonded MS39086-41 Spring Pin securing the 871533-401 Lever Assembly to the 871555-1 Shaft. Remove and retain the lever assembly for reinstallation.

NOTE: It is not necessary to remove the 871533-403 Lever Assembly.

(10) Remove MS24665-132 Cotter Pin, NAS1149FN632P Washer and MS20392-1C17 Pin securing 871550-1 Bellcrank to 871555-1 Shaft. Retain only the MS20392-1C17 Pin for reinstallation.

D. Disassembly Procedures for 871500-608 Pilot Seat Assembly Serial Numbers 0163 thru 0315 and 871500-609 Co-Pilot Seat Assembly Serial Numbers 0161 thru 0309 utilizing the 871528-405/-406 Fore/Aft Adjustment & Control Installation. (Pre Service Bulletin 871500-25-2146).

(1) Refer to Figure 2.

(2) On the pilot seat assemblies remove two NAS388-8-8 Screws securing the 871528-203 Lever Assembly to the 871526-403 Rear Cradle Panel Assembly. Retain the screws for reinstallation.

(3) On the co-pilot seat assemblies remove two NAS388-8-8 Screws securing the 871528-203 Lever Assembly to the 871526-404 Rear Cradle Panel Assembly. Retain the screws for reinstallation.

(4) On the 871500-608 Pilot Seat Assembly serial numbers 0272 and on, remove and discard the MS20995C20 Lockwire secured to the cable ball-end on the 871528-203 Lever Assembly and the MS20392-1C17 Pin on the 871550-1 Bellcrank. (Refer to Figure 3).

(5) On the 871500-609 Co-Pilot Seat Assembly serial numbers 0268 and on, remove and discard the MS20995C20 Lockwire secured to the cable ball-end on the 871528-203 Lever Assembly and the MS20392-1C17 Pin on the 871550-1 Bellcrank. (Refer to Figure 3).

(6) On the 871528-203 Lever Assembly disconnect the ball-end of the cable from the 871550-1 Bellcrank. (Refer to Figure 2).

(7) Remove the LC047F5MW Spring from the cable on the 871528-203 Lever Assembly. Retain the spring for reinstallation.

(8) On the pilot seat assemblies do the following:

(a) Remove the MS16632-2031 Retaining Ring securing the 871528-203 Lever Assembly to the panel assembly bracket on the 871526-403 Rear Cradle Panel Assembly. Discard the retaining ring.

(b) Remove and discard the NAS623-2-13 Screw and MS21042L08 Nut securing the 871551-5 Lever to the 871526-403 Rear Cradle Panel Assembly.

(c) Remove and discard the 871528-203 Lever Assembly.

(9) On the co-pilot seat assemblies do the following:

(a) Remove the MS16632-2031 Retaining Ring securing the 871528-203 Lever Assembly to the panel assembly bracket on the 871526-404 Rear Cradle Panel Assembly. Discard the retaining ring.

(b) Remove and discard the NAS623-2-13 Screw and MS21042L08 Nut securing the 871551-5 Lever to the 871526-404 Rear Cradle Panel Assembly.

(c) Remove and discard the 871528-203 Lever Assembly.

(10) Move the seat in the lateral position, disengaging the two 871533-401/-403 Lever Assemblies from the two 871534-3 Track Pins.

(11) Using best shop practice, remove and discard the bonded MS39086-41 Spring Pin securing the 871533-401 Lever Assembly to the 871555-1 Shaft. Remove and retain the lever assembly for reinstallation.

NOTE: It is not necessary to remove the 871533-403 Lever Assembly.

(12) Remove MS24665-132 Cotter Pin, NAS1149FN616P Washer and MS20392-1C17 Pin securing 871550-1 Bellcrank to 871555-1 Shaft. Retain only the MS20392-1C17 Pin for reinstallation. You may retain the NAS1149FN616P Washer for spares, a new one is provided in the SP Kit.

E. Disassembly Procedures for 871500-608 Pilot Seat Assembly Serial Numbers 0316 and On; and 871500-609 Co-Pilot Seat Assembly Serial Numbers 0310 and On; utilizing the 871528-405/-406 Fore/Aft Adjustment & Control Installation.

(1) Refer to Figure 2.

(2) On the pilot seat assemblies remove two NAS388-8-8 Screws securing the 871832 Stop and the 871528-203 Lever Assembly to the 871526-403 Rear Cradle Panel Assembly. Retain the screws and 871832 Stop for reinstallation.

(3) On the co-pilot seat assemblies remove two NAS388-8-8 Screws securing the 871832 Stop and the 871528-203 Lever Assembly to the 871526-404 Rear Cradle Panel Assembly. Retain the screws and 871832 Stop for reinstallation.

(4) Remove and discard the MS20995C20 Lockwire secured to the cable ball-end on the 871528-203 Lever Assembly and the MS20392-1C17 Pin on the 871550-1 Bellcrank. (Refer to Figure 3).

(5) On the 871528-203 Lever Assembly disconnect the ball-end of the cable from the 871550-1 Bellcrank. (Refer to Figure 2).

(6) Remove the LC047F5MW Spring from the cable on the 871528-203 Lever Assembly. Retain the spring for reinstallation.

(7) On the pilot seat assemblies do the following:

(a) Remove the MS16632-2031 Retaining Ring securing the 871528-203 Lever Assembly to the panel assembly bracket on the 871526-403 Rear Cradle Panel Assembly. Discard the retaining ring.

(b) Remove and discard the NAS623-2-13 Screw and MS21042L08 Nut securing the 871551-5 Lever to the 871526-403 Rear Cradle Panel Assembly.

(c) Remove and discard the 871528-203 Lever Assembly.

(8) On the co-pilot seat assemblies do the following:

(a) Remove the MS16632-2031 Retaining Ring securing the 871528-203 Lever Assembly to the panel assembly bracket on the 871526-404 Rear Cradle Panel Assembly. Discard the retaining ring.

(b) Remove and discard the NAS623-2-13 Screw and MS21042L08 Nut securing the 871551-5 Lever to the 871526-404 Rear Cradle Panel Assembly.

(c) Remove and discard the 871528-203 Lever Assembly.

(9) Move the seat in the lateral position, disengaging the two 871533-401/-403 Lever Assemblies from the two 871534-3 Track Pins.

(10) Using best shop practice, remove and discard the bonded MS39086-41 Spring Pin securing the 871533-401 Lever Assembly to the 871555-1 Shaft. Remove and retain the lever assembly for reinstallation.

NOTE: It is not necessary to remove the 871533-403 Lever Assembly.

(11) Remove MS24665-132 Cotter Pin, NAS1149FN616P Washer and MS20392-1C17 Pin securing 871550-1 Bellcrank to 871555-1 Shaft. Retain only the MS20392-1C17 Pin for reinstallation. You may retain the NAS1149FN616P Washer for spares, a new one is provided in the SP Kit.

F. Assembly Procedures for all 871500-602 thru 609 Pilot/Co-Pilot Seat Assemblies.

(1) Refer to Figure 4.

(2) Slide new 871550-5 Bellcrank on the existing 871555-1 Shaft.

(3) Slide the existing 871533-401 Lever Assembly on 871555-1 Shaft, secure with the new MS39086-41 Spring Pin. Install the new MS39086-41 Spring Pin with locking compound per Paragraph 3.H.

NOTE: The new MS16632-2031 Retaining Ring comes as part of the new 871528-205 Lever assembly.

(4) On the pilot seat assemblies install the cable used on the new 871528-205 Lever Assembly through the 871526-403 Rear Cradle Panel Assembly and the panel assembly bracket.

NOTE: On the new 871528–205 Lever Assembly, remove and retain the NAS623–2–13 Screw and MS21042L08 Nut to allow the housing to be installed thru the rear panel assembly. Re–install the screw and nut after the housing is thru the rear panel assembly.

(5) Secure the cable end to the panel assembly bracket with the new MS16632-2032 Retaining Ring.

NOTE: On the 871528-205 Lever Assembly at the end of the cable, there is a notch, secure the MS16632-2032 Retaining Ring to the notch on the cable.

(6) On the co-pilot seat assemblies install the cable used on the new 871528-205 Lever Assembly through the 871526-404 Rear Cradle Panel Assembly and the panel assembly bracket.

NOTE: On the new 871528–205 Lever Assembly, remove and retain the NAS623–2–13 Screw and MS21042L08 Nut to allow the housing to be installed thru the rear panel assembly. Re–install the screw and nut after the housing is thru the rear panel assembly.

(7) Secure the cable end to the panel assembly bracket with the existing MS16632-2032 Retaining Ring.

(8) Install the LC047F5MW Spring on the cable end of the 871528-205 Lever Assembly.

(9) Install the cable end of the 871528-205 Lever Assembly through the slot on the new 871550-5 Bellcrank.

(10) Secure the new 871550-5 Bellcrank to the existing 871555-1 Shaft with the existing MS20392-1C17 Pin, new NAS1149FN616P Washer and new MS24665-132 Cotter Pin. Cut excess cotter pin material.

(11) Use the new MS20995C20 Lockwire (as required), safety wire around the MS20392-1C17 Pin on the 871550-5 Bellcrank and secure the other end around the ball end on the cable used on the 871528-205 Lever Assembly.

(12) On the pilot seats assemblies install two NAS388-8-8 Screws securing the new 871528-205 Lever Assembly to the 871526-403 Rear Cradle Panel Assembly.

(13) On the 871500-608 Pilot Seat Assembly serial numbers 0316 and on; install two NAS388-8-8 Screws securing the existing 871832 Stop and the new 871528-205 Lever Assembly to the 871526-403 Rear Cradle Panel Assembly. Only the top screw secures both the 871832 Stop and the 871528-205 Lever Assembly.

(14) On the co-pilot seat assemblies install two NAS388-8-8 Screws securing the new 871528-205 Lever Assembly to the 871526-404 Rear Cradle Panel Assembly.

(15) On the 871500-609 Co-Pilot Seat Assembly serial numbers 0310 and on; install two NAS388-8-8 Screws securing the existing 871832 Stop and the new 871528-205 Lever Assembly to the 871526-404 Rear Cradle Panel Assembly. Only the top screw secures both the 871832 Stop and the 871528-205 Lever Assembly.

(16) Once the above modification is completely installed, the new 871528-205 Lever Assembly may need adjusting to obtain proper usage. Adjust the nut at the end of the cable on the lever assembly to ensure the pins on the 871533-401/-403 Lever Assemblies line up with the center hole of the 871534-1/-3 Track Pins. Adjustment of the nut clockwise rotates the 871533-401/-403 Lever Assemblies (pins) down and counter-clockwise rotates the 871533-401/403 Lever Assemblies (pins) up.

G. General Reassembly Procedures applies to all seats.

(1) Refer to Figure 1.

(2) On the 871500-602/-604/-604-001/-604-003/-604-004/-606/-606-001/-608 Pilot Seat Assemblies perform the following procedures:

(a) Reinstall the four NAS517-3-1 Screws, one NAS623-4-9 Screw, one 871530-9 Washer, and one NAS517-4-3 Screw securing the 871520-403 Side Support to the 871526-403 Rear Cradle Panel Assembly.

(b) Reinstall the NAS517-4-5 Screw securing the 871520-403 Side Support to the 871529-401 Front Tube Assembly.

(3) On the 871500-603/-605/-605-002/-605-003/-605-004/-607/-607-001/-609 Co-Pilot Seat Assemblies perform the following procedures:

(a) Reinstall the four NAS517-3-1 Screws and two NAS517-4-3 Screws securing the 871520-404 Side Support to the 871526-404 Rear Cradle Panel Assembly.

(b) Reinstall the NAS517-4-3 Screw securing the 871520-404 Side Support to the 871529-401 Front Tube Assembly.

H. Application of Locking Compounds.(Reference WPS-818).

(1) Materials and Equipment.

(a) Locking and retaining compound, per MIL-S-22473 and Table 5, Loctite Corp., Rocky Hill, CT; or equivalent.

Locking and Retaining Compounds
Table 5

MIL-S-22473 GRADE (4)	COLOR	VISCOSITY, Centipoises	LOCKING TORQUE in-lb	LOCTITE PROD. NO. (1)	GAP FILL in.	CURE TIME, hrs (2)		USED FOR
						UN-PRIMED	PRIMED	
	Green	100-150 7,000 2,000	3000 (3) 3000 (3) 4000 (3)	609 620 635	.005 .015 .010	1 2 4	1/2 1 2	Retaining compounds for non-threaded cylindrical assemblies
N T	Green Green or Yellow	– –	– –	7649 7471	– –	– –	– –	Primer – activators for above compounds

NOTES: (1) List for convenience. Equivalent materials from alternate sources are acceptable.
(2) At 70 degrees - 77 degrees F. Given times are to develop handling strength, fully cure per Paragraph 3.H.(3)(i) before stressing significantly.
(3) Shear strength, psi
(4) Do not us locking compounds of one manufacturer in contact with primers from another source.

(b) Wiping materials, cotton swabs, pipe cleaners.

(2) General Requirement

(a) Avoid prolonged contact of locking compounds and primers with skin, and avoid contact of retaining compounds with fingers which may become stuck together.

(b) Lubricants containing silicone oils, molybdenum disulfide or graphite shall not be used for machining, drilling or tapping parts to be retained or sealed.

(c) All heat treatments and process involving temperatures above 350 degrees F shall be accomplished prior to surface preparation for the application of locking compounds.

(d) Locking surfaces shall be free of foreign materials prior to application of primer or locking compound.

(e) Locking compounds are applicable to metal parts only. Refer to Table 5 for retention strengths.

(f) Primers are required on plated parts and passivated stainless steel. All other parts may be primed when accelerated cure is required.

(3) Procedures

(a) Remove all foreign materials such as oils, greases, waxes and powders prior to application of primers or locking compounds

(b) Solvent clean using acetone.

(c) Primers may be applied by spray, dip or brush when required, or desired, according to Paragraph 3.H.(2)(f). Do not allow primers or locking compounds to enter moving parts such as bearing races, etc.

(d) Use primer Grade T on threaded components and primer Grade N for retaining and sealing applications.

(e) Allow primers to dry a minimum of five minutes before application of locking compounds.

(f) Apply locking compound by nozzle application, brushing, dipping, tumbling or other suitable means. In the case of primed surfaces, assemble parts or tighten fasteners immediately as locking compound will harden finger tight within five to ten minutes.

(g) For viscosity grades, parts may be assembled and locking compound applied to edge of joint until compound wicks through joint. If parts are primed, compound must be applied within 24 hours of priming.

(h) Excess compound shall be immediately removed from oil holes and other unwanted locations using wiping materials selected from Paragraph 3.(H)(1)(b).

(i) Cure time to achieve full strength is attained after 24 hours at 70 degrees - 77 degrees F.

I. Installation of Modification Plate

(1) Use MEK or isopropyl alcohol to clean an area approximately the size of modification plate near the data plate. Let cleaned area air dry.

(2) On the face of the 816929-17 Modification Plate, carefully remove the protective cover. Use a typewriter or engraving tool to mark the service bulletin number 871500-25-2147, the SP Kit number (120SP018) and the current date on the 816929-17 Modification Plate.

(3) Peel off the protective backing attached to the pressure sensitive adhesive off the back of 816929-17 Modification Plate. Use care not to touch the adhesive or contaminate it in any way, carefully locate the 816929-17 Modification Plate near the original 838897-11 Nameplate on the Pilot Seats (P/N's 871500-602 thru 608) and the Co-Pilot Seat Assemblies (P/N's 871500-603 thru -609). Press down on the modification plate to secure it. Relieve any air pockets and smooth down. (Refer to Figure 1, Sheet 1, for location of original nameplate).

(4) Do not remove the original 838897-11 Nameplate from the seat.