

REVISION RECORD			
LTR.	CHANGES	BY	DATE
NC	RELEASED	D. B.	08/30/11

D' Shannon Products, LTD

INSTALLATION MANUAL

DSPMM-01, Rev. A

STC No. SA2200SW

**INSTALLATION DRAWINGS
AND
INSTRUCTIONS FOR
MODIFICATION- NOSE GEAR TUNNEL
STRUCTURE**

**BEECH BONANZA A35, B35, C35,
D35, E35, F35, G35**

D' SHANNON PRODUCTS, LTD
800-291-7616, INT'L 763-559-5998

NEXT ASSY: DRAWN BY: D. B. ENGINEER: D. BRAUN CHECKED BY: D. B.		COVER SHEET	
<u>TOLERANCES</u> X_.10 .XXX_.01 XX_.03 .XXX_.001 ANGLES ±5% UNLESS STATED		<i>D' SHANNON PRODUCTS, LTD</i>	
DWG. No. DSPMM-01-1		REVISION	NC
SCALE: NONE		DATE 08/30/11	SH 1 OF 1

NUMERICAL DRAWING LIST CONTROL

REVISION RECORD			
LTR.	CHANGES	BY	DATE
NC	RELEASED	D. B.	08/30/11

DWG. No.	DATED	REV.		No. SHTS	EFF.	EO	EO	EO	DESCRIPTION
DSPMM-01-1	08/30/11	NC		1					COVER SHEET
DSPMM-01-2	08/30/11	NC		1					NUMERICAL DWG. LIST
DSPMM-01-3	08/30/11	NC		1					INSTALLATION BILL OF MATERIAL
DSPMM-01-4	08/30/11	NC		1					GENERAL NOTES
DSPMM-01-5	08/30/11	NC		1					REMOVAL OF ORIGINAL BEECH RIVETS
DSPMM-01-6	08/30/11	NC		3					INSTALLATION SIDE REINFORCEMENT
DSPMM-01-8	08/30/11	NC		2					INSTALLATION TOP COVER FRONT
DSPMM-01-10	08/30/11	NC		3					INSTALLATION TOP COVER REAR
DSPMM-01-12	08/30/11	NC		3					INSTALLATION MOUNT REINFORCEMENT
DSPMM-01-13	08/30/11	NC		2					INSTALLATION MOUNT HOLES REAR
DSPMM-01-14	08/30/11	NC		2					TUNNEL REINFORCEMENT FORWARD
DSPMM-01-15	08/30/11	NC		1					INSTALLATION ENGINE MOUNTS REAR

NEXT ASSY: DRAWN BY: D. B. ENGINEER: D. BRAUN CHECKED BY: D. B.	NUMERICAL DRAWING LIST
TOLERANCES X_.10 .XXX_.01 XX_.03 .XXX_.001 ANGLES ±5% UNLESS STATED	D' SHANNON PRODUCTS, LTD
DWG. No. DSPMM-01-2 SCALE: NONE	REVISION NC DATE 08/30/11 SH 1 OF 1

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LTR.	CHANGES	BY	DATE
NC	RELEASED	D. B.	08/30/11

27	DSPMM-01-14	48	MS2470AD3-5.5	SOLID RIVET (SEE NOTE 4)
26	DSPMM-01-12	14	MS2470AD3-4	SOLID RIVET (SEE NOTE 4)
25	DSPMM-01-12	4	CR32126-3	CHERRYMAX RIVET
24	DSPMM-01-12	4	MS2470AD3-5	SOLID RIVET (SEE NOTE 4)
23	DSPMM-01-6/-8/-10	155	MS2470AD3-3.5	SOLID RIVET (SEE NOTE 4)
22	DSPMM-01-6	147	MS2470AD3-4.5	SOLID RIVET (SEE NOTE 4)
21	DSPMM-01-15	12	MS20365-428	NUT
20	DSPMM-01-15	12	AN960D416L	WASHER (CUSTOMER SUPPLIED)
19	DSPMM-01-15	12	AN960D416	WASHER (CUSTOMER SUPPLIED)
18	DSPMM-01-15	12	AN4-11A/M/	BOLT (SEE NOTE 2)
17	DSPMM-01-15	1	35-910019-3	RHS MOTOR MOUNT (SEE NOTE 1)
16	DSPMM-01-15	1	35-910019-1	LHS MOTOR MOUNT (SEE NOTE 1)
15	DSPMM-01-13	1	71-20-01-12Z-2	RHS DRILL PATTERN ASSY (SEE NOTE 3)
14	DSPMM-01-13	1	71-20-01-12Z-1	LHS DRILL PATTERN ASSY (SEE NOTE 3)
13	DSPMM-01-14	1	71-20-01-11	REINFORCEMENT TEE
12	DSPMM-01-6	1	71-20-01-37-B-2	RHS INSIDE REINFORCEMENT REAR
11	DSPMM-01-6	1	71-20-01-37-A-2	RHS INSIDE REINFORCEMENT FRONT
10	DSPMM-01-6	1	71-20-01-37-B-1	LHS INSIDE REINFORCEMENT REAR
9	DSPMM-01-6	1	71-20-01-37-A-1	LHS INSIDE REINFORCEMENT FRONT
8	DSPMM-01-10	1	71-20-01-10	TOP COVER REAR
7	DSPMM-01-6	1	71-20-01-09-2	RHS SHIM
6	DSPMM-01-6	1	71-20-01-09-1	LHS SHIM
5	DSPMM-01-12	1	71-20-01-08-2	RHS MOUNT REINFORCEMENT
4	DSPMM-01-12	1	71-20-01-08-1	LHS MOUNT REINFORCEMENT
3	DSPMM-01-8	1	71-20-01-07	TOP COVER FRONT
2	DSPMM-01-6	1	71-20-01-06-2	SIDE REINFORCEMENT RIGHT
1	DSPMM-01-6	1	71-20-01-06-1	SIDE REINFORCEMENT LEFT
ITEM	LOCATION OF ITEMS	QTY.	PART NUMBER	DESCRIPTION

4. - RIVET LENGTHS ARE TO BE DETERMINED BY THE INSTALLER. RIVETS ARE NOT SUPPLIED WITH THE KIT. WHERE SOLID RIVETS ARE CALLED OUT, BLIND RIVETS CAN BE SUBSTITUTED. ACCEPTABLE SUBSTITUTES INCLUDED CHERRY CR163-4-6 AND CR162-4CSK, CHERRY MAX CR3214 AND CR3224. AVEX RR-64 AND RV-14, AS WELL AS AD44H AND AK44H POP RIVETS.
3. - DRILL FIXTURES ARE NOT PART OF THIS KIT. THEY MAY BE RENTED AT THE TIME OF INSTALLATION. CONTACT D' SHANNON PRODUCTS FOR RENTAL INFORMATION.
2. - THE INSTALLER MUST DETERMINE THE CORRECT LENGTH AND GRIP LENGTH AS NO MORE THAN TWO ADDITIONAL WASHERS MAY BE USED UNDER THE HEAD OF THE BOLT OR UNDER THE NUT. TORQUE BOLTS PER BEECH MAINTENANCE MANUAL.
1. - ENGINE MOUNTS MUST BE IN SETS OF CANTED OR STRAIGHT AS CALLED OUT IN BEECH PARTS MANUAL OR STC SA2200SW.

NEXT ASSY: DRAWN BY: D. B. ENGINEER: D. BRAUN CHECKED BY: D. B.		INSTALLATION BILL OF MATERIAL	
TOLERANCES X_.10 .XXX_.01 XX_.03 .XXX_.001 ANGLES ±5% UNLESS STATED		D' SHANNON PRODUCTS, LTD	
DWG. No. DSPMM-01-3		REVISION NC	
SCALE: NONE		DATE 08/30/11 SH 1 OF 1	

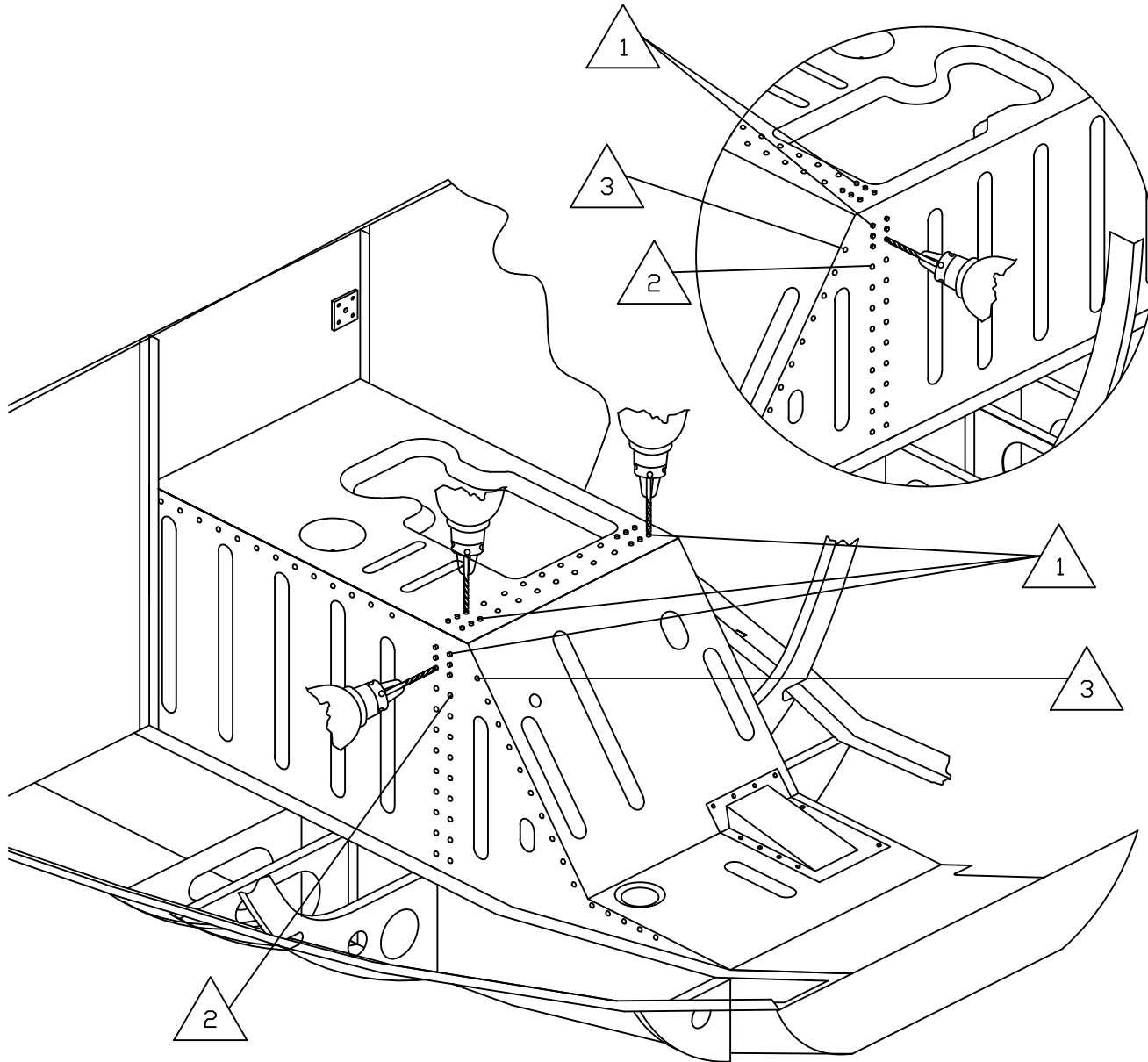
REVISION RECORD			
LTR.	CHANGES	BY	DATE
NC	RELEASED	D. B.	08/30/11

GENERAL NOTES: MODIFICATION - NOSE GEAR TUNNEL STRUCTURE

1. THE INSTALLATION DOES NOT REQUIRE THE USE OF THE DRILL PATTERN ASSEMBLIES ITEM (14) 70-20-01-12Z-1 (LH) OR ITEM (15) 70-20-01-12Z-2 (RH). THERE ARE SEVERAL WAYS TO DRILL THE REAR ENGINE MOUNT HOLES IN THE KEEL. RENTAL OF THESE DRILLING FIXTURES IS AT THE DISCRETION OF THE STC HOLDER.
2. INSIDE THE TUNNEL ON THE STRUCTURAL BULKHEAD FRAME AT THE REAR ENGINE MOUNT BOLTS IS A FORMED BRACKET. THE BRACKET HOUSED AND GUIDED THE CABLE THAT TRAVELS FROM THE STEP TO THE NOSE GEAR. THIS CABLE RETRACTS THE STEP WHEN THE NOSE GEAR RETRACTS. REMOVE THE RIVETS THAT ATTACH THE BRACKET AND REPLACE WHEN THE TUNNEL SECTION DOUBLERS ARE INSTALLED. IF A PERMANENT STEP IS INSTALLED, REMOVE THE CABLE BRACKET AND DISCARD BOTH THE CABLE AND THE BRACKET. RECORD THE CHANGE IN THE APPROPRIATE PAPERWORK.
3. THE BOLTS THAT HOLD THE ENGINE MOUNT BRACKETS TO THE AIRFRAME ARE AN960-4-A-M. THE LENGTH OF THE BOLT IS TO BE DETERMINED BY THE INSTALLER. THERE MAY BE A TOTAL OF SIX (6) THICK WASHERS USED AS LONG AS AT LEAST ONE WASHER IS UNDER EACH END OF THE FASTENER. REFERENCE THE BEECH H-35 OR LATER PARTS CATALOG FOR THE GENERAL LENGTH. WHEN SELECTING THE LENGTH, MAKE SURE THAT THE FASTENER DOES NOT INTERFERE OR CONFLICT WITH CABLES, ETC. DUE TO MINOR VARIATIONS IN KEEL BOX SECTION THICKNESS, AND/OR THE DOUBLERS INSTALLED, MAKE SURE THAT THE BOLT GRIP LENGTH IS CORRECT FOR THE HOLE AT THE TRANSITION POINT WHERE THE BOLT RESTS IN THE MOUNT WHEN THE NUTS ARE SNUGGED UP. THERE WILL BE A SLIGHT INTERFERENCE FIT AT THE GRIP AND THREADS TRANSITION IN THE NEW STRUCTURE. THE BOLT WILL BE LARGER UNDER THE HEAD DUE TO THE MANUFACTURING AND/OR PLATING PROCESS. DO NOT PUSH THE BOLT THROUGH THE NEW DRILLED HOLES IN THE DOUBLERS TO THE HEAD BECAUSE THE SHANK OR GRIP MAY TRY TO EXTRUDE THE NEW DOUBLERS AT THE HEAD OF THE BOLT.
4. USE CLECOS TO INSTALL THE DOUBLERS IN PLACE WHILE DRILLING.
5. IT IS STRONGLY RECOMMENDED THAT PRIOR TO THE INSTALLATION OF ANY OF THE DOUBLERS, CLEAN, ETCH AND FINISH THE AREA USING THE PROPER PRIMER.
6. INSTALL ALL THE DOUBLERS WITH RIVETS AS CALLED OUT IN THE PARTS LIST. FILL ALL HOLES. IT IS PERMISSIBLE TO OVERSIZE TO LARGER RIVET HOLES BUT NO MORE THAN TWO SIZES LARGER, AND ONLY WHEN THE EDGE DISTANCE FROM THE RIVET HOLE IS AT LEAST 1.5 TIMES THE DIAMETER OF THE RIVET HOLE. RIVET LENGTH, SIZE AND TYPE IS DETERMINED BY THE INSTALLER. RIVETS, BOLTS, WASHERS, NUTS, PRIMER AND ETCH ARE NOT FURNISHED BY THE STC OR PMA HOLDER.
7. THE WEIGHT AND C.G. CHANGE OF THIS KIT IS TO BE DETERMINED BY THE INSTALLER DUE TO THE DIFFERENCES IN ALTERNATORS, BAFFLES, CRANKCASE, CYLINDERS, SHAFTS, MAGNETS, ETC. NOTE ITEMS ADDED AND REMOVED FOR WEIGHT AND BALANCE PURPOSES. IT IS RECOMMENDED THAT THE AIRCRAFT IS WEIGHED AFTER COMPLETION.

NEXT ASSY: DRAWN BY: D. B. ENGINEER: D. BRAUN CHECKED BY: D. B.	GENERAL NOTES		
<u>TOLERANCES</u> X_.10 .XXX_.01 XX_.03 .XXX_.001 ANGLES ±5% UNLESS STATED	<i>D' SHANNON PRODUCTS, LTD</i>		
	DWG. No. DSPMM-01-4	REVISION	NC
	SCALE: NONE	DATE 08/30/11	SH 1 OF 1

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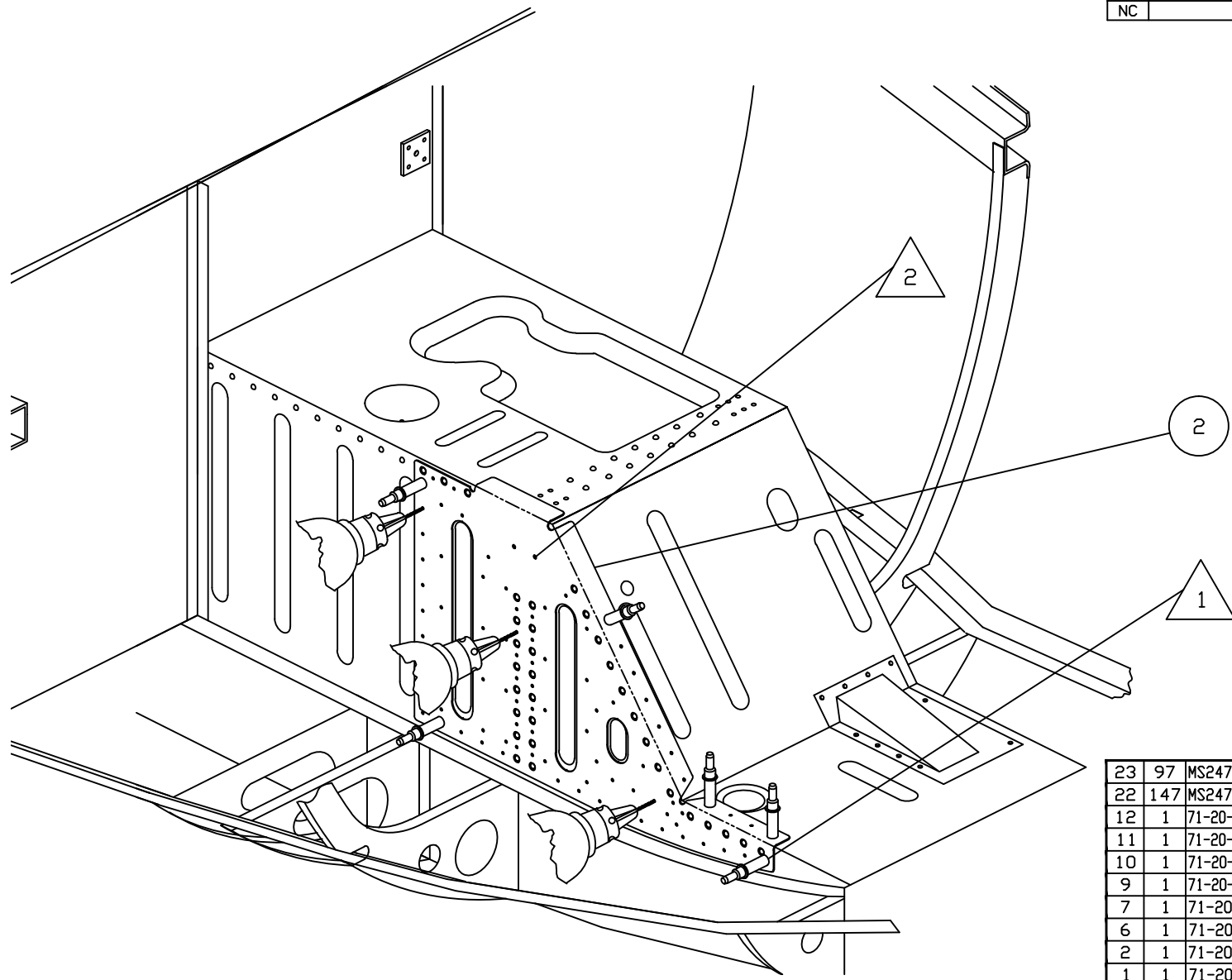


- △ 3 REMOVE EXISTING BEECH RIVET
- △ 2 REMOVE EXISTING BEECH RIVETS (2 PLACES)
- △ 1 REMOVE EXISTING BEECH RIVETS (6 PLACES).

NOTES:

NEXT ASSY: DRAWN BY: D. B. ENGINEER: D. BRAUN CHECKED BY: D. B.		REMOVAL OF ORIGINAL BEECH RIVETS	
TOLERANCES .X_.10 .XXX_.01 .XX_.03 .XXX_.001 ANGLES ±5% UNLESS STATED		D' SHANNON PRODUCTS, LTD	
DWG. No.	DSPMM-01-5	REVISION	NC
SCALE: NONE	DATE 08/30/11	SH	1 OF 1

REVISION RECORD			
LTR.	CHANGES	BY	DATE
NC	RELEASED	D. B.	08/30/11



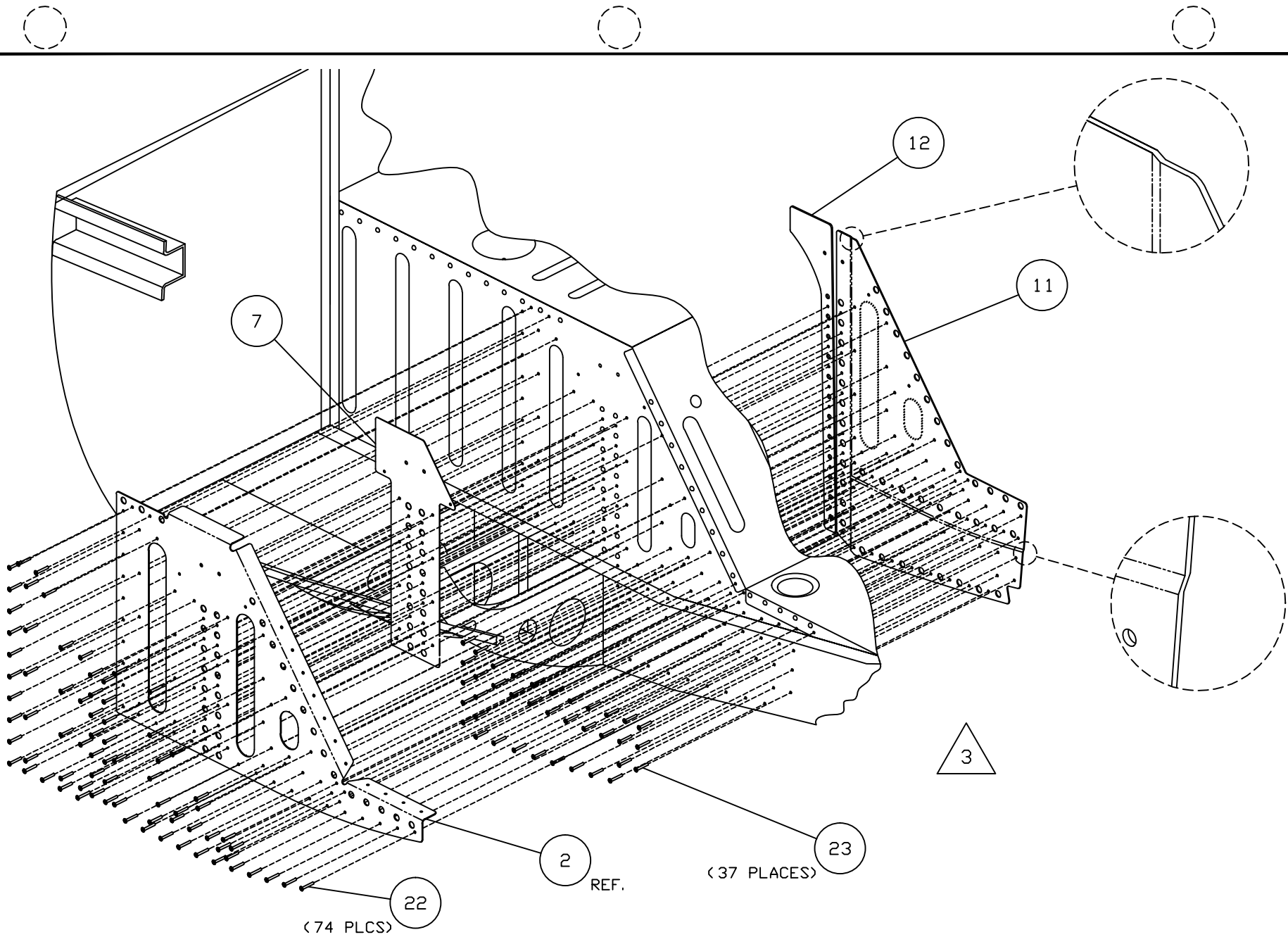
② DRILL TWO #30 HOLES USING HOLES IN ITEM ② OR ITEM ① AS A GUIDE.

① ALIGN ITEM ② SIDE REINFORCEMENT LEFT WITH NOSE GEAR TUNNEL. DRILL SIX #40 HOLES USING HOLES IN ITEM ② AS A GUIDE AND CLECD TO NOSE GEAR TUNNEL STRUCTURE AS SHOWN. DRILL REMAINING 82 HOLES WITH A #40 BIT AS SHOWN.

NOTES:

ITEM	QTY	PART No.	DESCRIPTION
23	97	MS2470AD3-3.5	SOLID RIVET
22	147	MS2470AD3-4.5	SOLID RIVET
12	1	71-20-01-37-B-2	RHS INSIDE REINFORCEMENT REAR
11	1	71-20-01-37-A-2	RHS INSIDE REINFORCEMENT FRONT
10	1	71-20-01-37-B-1	LHS INSIDE REINFORCEMENT REAR
9	1	71-20-01-37-A-1	LHS INSIDE REINFORCEMENT FRONT
7	1	71-20-01-09-2	SHIM RHS
6	1	71-20-01-09-1	SHIM LHS
2	1	71-20-01-06-2	SIDE REINFORCEMENT RIGHT
1	1	71-20-01-06-1	SIDE REINFORCEMENT LEFT

NEXT ASSY:		INSTL SIDE REINFORCEMENT			
DRAWN BY: D. B.		D' SHANNON PRODUCTS, LTD			
ENGINEER: D. BRAUN					
CHECKED BY: D. B.					
TOLERANCES					
X_.10 .XXX_.01		DWG. No.	DSPMM-01-6	REVISION	NC
XX_.03 .XXX_.001		SCALE: NONE	DATE 08/30/11	SH	1 OF 3
ANGLES ±5%		UNLESS STATED			



3 ALIGN ITEMS 7, 11 AND 12 TO TUNNEL STRUCTURE AND ITEM 2 AS SHOWN AND INSTALL RIVET ITEMS 22 AND 23.

NOTES:

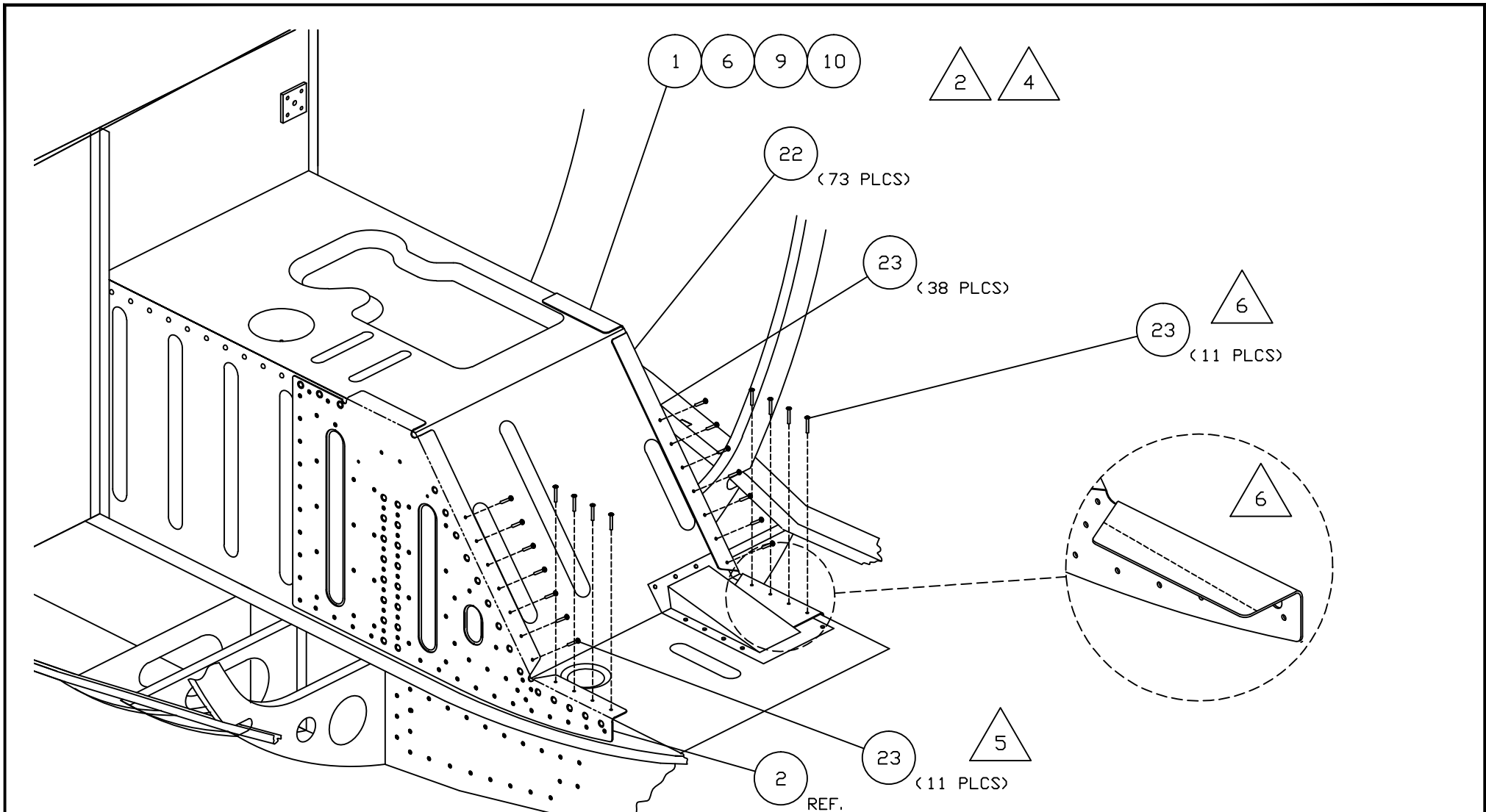
NEXT ASSY:
 DRAWN BY: D. B.
 ENGINEER: D. BRAUN
 CHECKED BY: D. B.

TOLERANCES
 X_.10 .XXX_.01
 XX_.03 .XXX_.001
 ANGLES ±5%
 UNLESS STATED

INSTL SIDE REINFORCEMENT

D' SHANNON PRODUCTS, LTD

DWG. No.	DSPMM-01-6	REVISION	NC
SCALE:	NONE	DATE	08/30/11 SH 2 OF 3

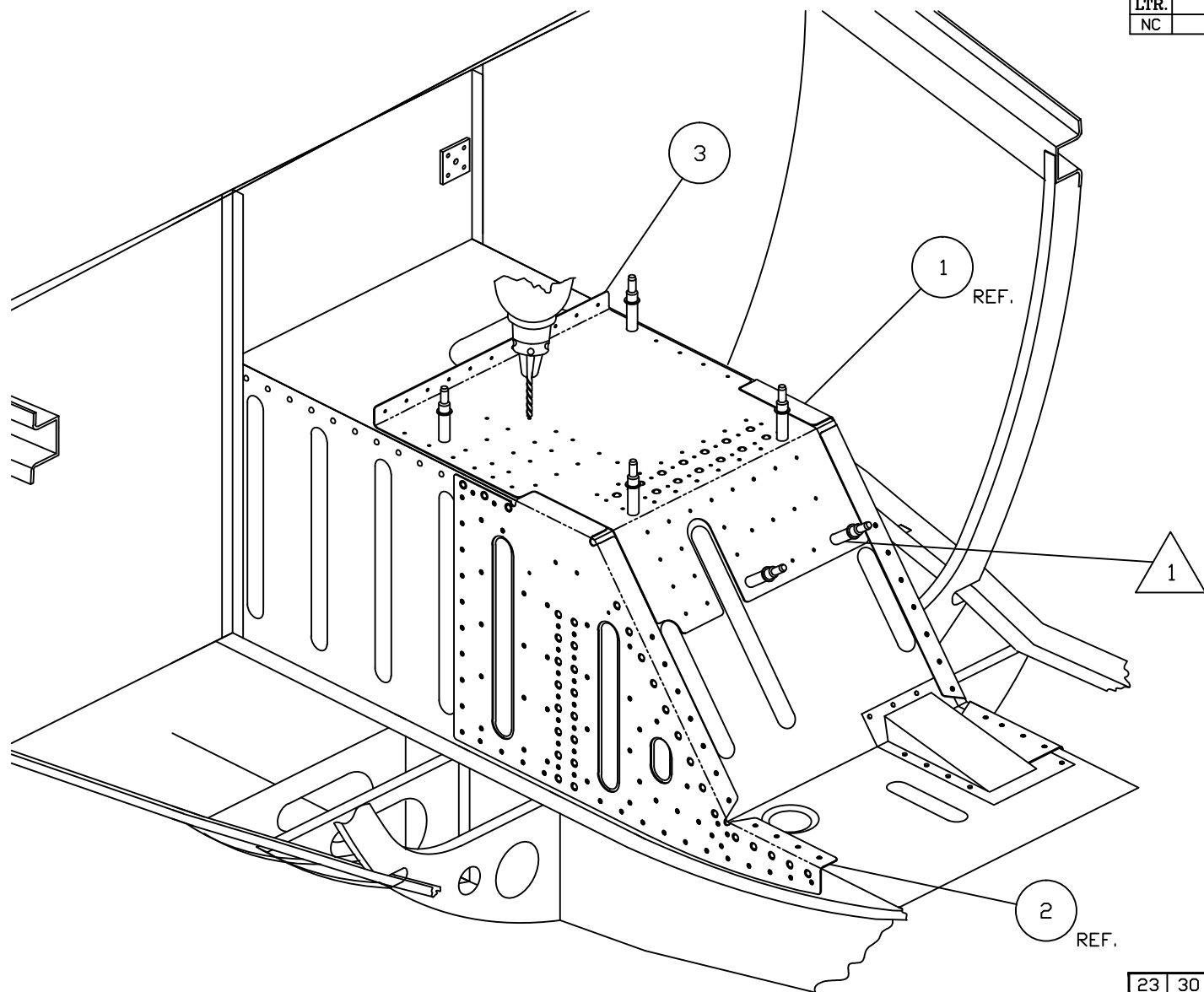


- ② DRILL TWO #30 HOLES USING HOLES IN ITEM ② OR ITEM ① AS A GUIDE.
- ⑥ DRILL FOUR EVENLY SPACED #40 HOLES INTO NOSE GEAR TUNNEL STRUCTURE AND ITEM ① AS SHOWN AND INSTALL RIVET ITEM ②③. TRIM ITEM ① IF NEEDED TO CLEAR STRUCTURE SHOWN.
- ⑤ INSTALL RIVET ITEM ②③ THROUGH ITEM ② AND NOSE GEAR TUNNEL STRUCTURE AS SHOWN.
- ④ REPEAT FOR LHS USING ITEMS ①, ⑥, ⑨ AND ⑩ AND RIVET ITEMS ②② AND ②③.

NOTES:

NEXT ASSY: DRAWN BY: D. B. ENGINEER: D. BRAUN CHECKED BY: D. B.		INSTL SIDE REINFORCEMENT	
TOLERANCES X_.10 .XXX_.01 XX_.03 .XXX_.001 ANGLES ±5% UNLESS STATED		D' SHANNON PRODUCTS, LTD	
DWG. No.	DSPMM-01-6	REVISION	NC
SCALE:	NONE	DATE	08/30/11 SH 3 OF 3

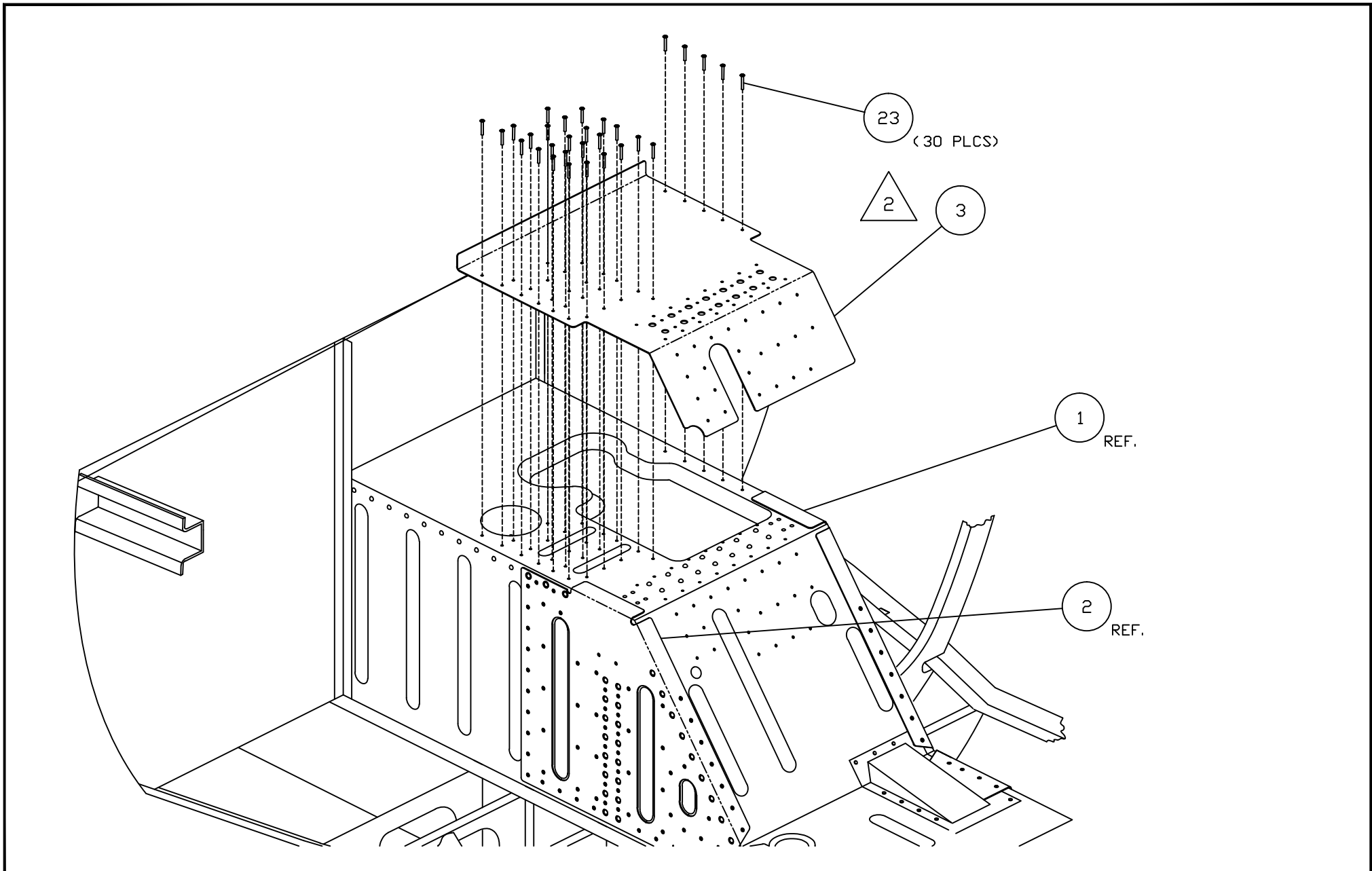
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ALIGN ITEM (3) TOP COVER FRONT WITH NOSE GEAR TUNNEL. DRILL SIX #40 HOLES USING HOLES IN ITEM (3) AS A GUIDE AND CLECO TO NOSE GEAR TUNNEL STRUCTURE AS SHOWN. DRILL REMAINING 76 HOLES WITH A #40 BIT AS SHOWN.

NOTES:

23	30	MS2470AD3-3.5	SOLID RIVET
3	1	71-20-01-07	TOP COVER FRONT
ITEM	QTY	PART No.	DESCRIPTION
NEXT ASSY: DRAWN BY: D. B. ENGINEER: D. BRAUN CHECKED BY: D. B.			INSTL TOP COVER FRONT
TOLERANCES: .X_.10 .XXX_.01 .XX_.03 .XXX_.001 ANGLES ±5% UNLESS STATED			D' SHANNON PRODUCTS, LTD
DWG. No. DSPMM-01-8		REVISION NC	
SCALE: NONE		DATE 08/30/11	SH 1 OF 2

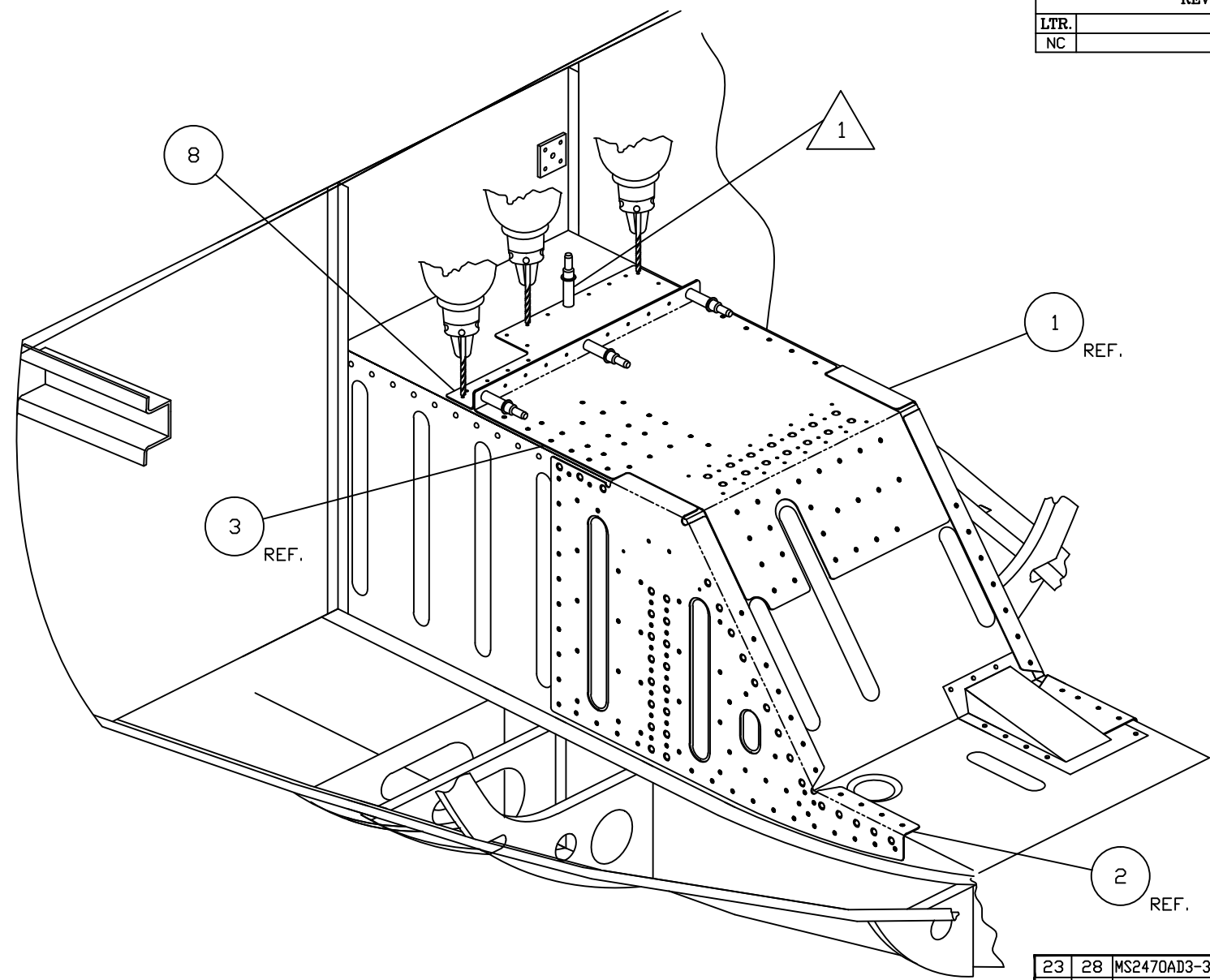


△ 2 ALIGN ITEM ③ TO TUNNEL STRUCTURE AS SHOWN AND INSTALL RIVETS ITEM 23.

NOTES:

NEXT ASSY: DRAWN BY: D. B. ENGINEER: D. BRAUN CHECKED BY: D. B.		INSTL TOP COVER FRONT	
TOLERANCES X_.10 .XXX_.01 XX_.03 .XXX_.001 ANGLES ±5% UNLESS STATED		D' SHANNON PRODUCTS, LTD	
DWG. No.	DSPMM-01-8	REVISION	NC
SCALE:	NONE	DATE	08/30/11 SH 2 OF 2

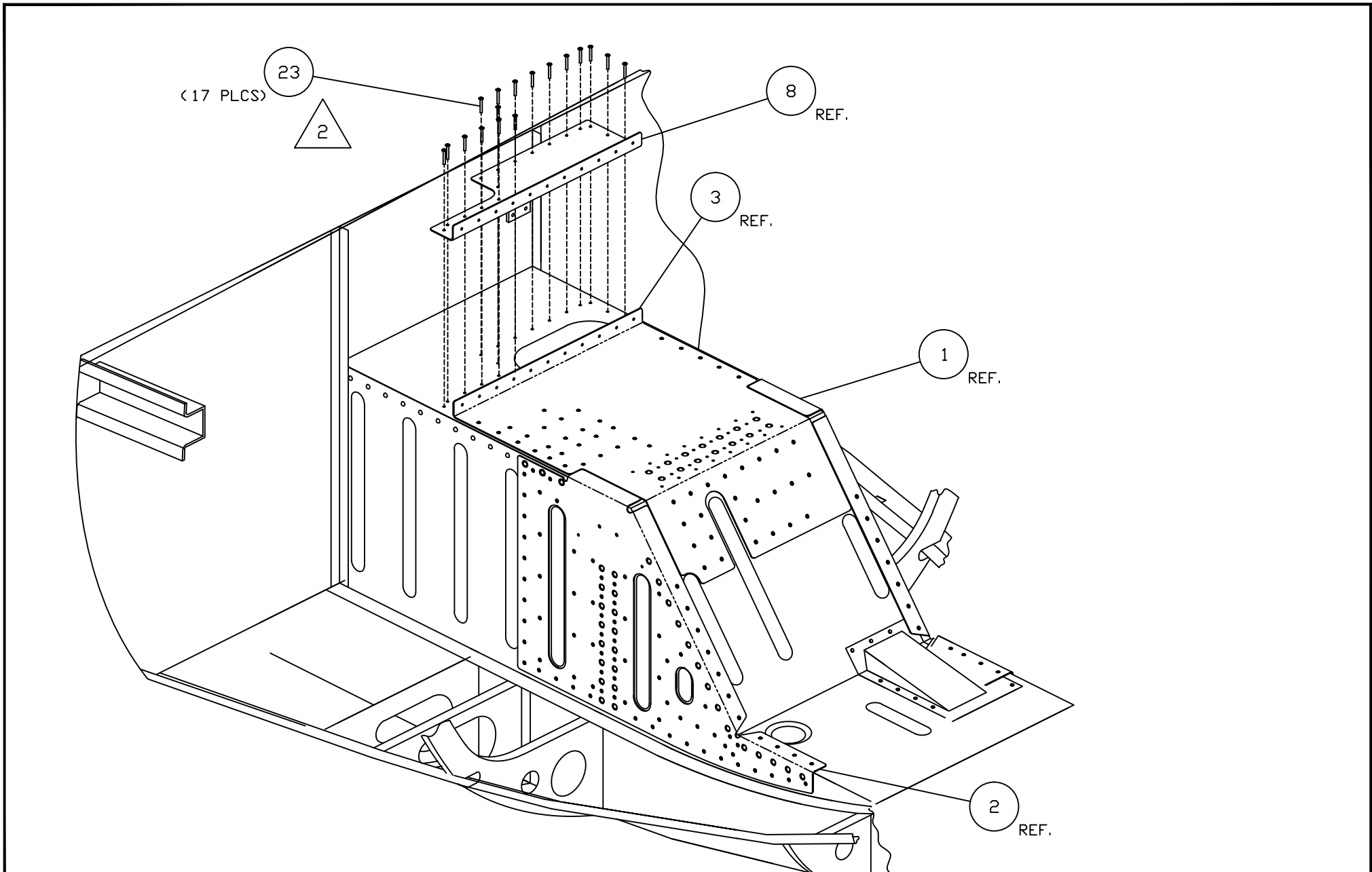
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NC	RELEASED	D. B.	08/30/11



1 ALIGN ITEM ⑧ TOP COVER REAR WITH NOSE GEAR TUNNEL AND ITEM ③.
 DRILL ONE #40 HOLE USING HOLES IN ITEM ⑧ AS A GUIDE AND CLECO TO
 NOSE GEAR TUNNEL STRUCTURE AND ITEM ③ AS SHOWN. DRILL REMAINING 16
 HOLES WITH A #40 BIT AS SHOWN.

NOTES:

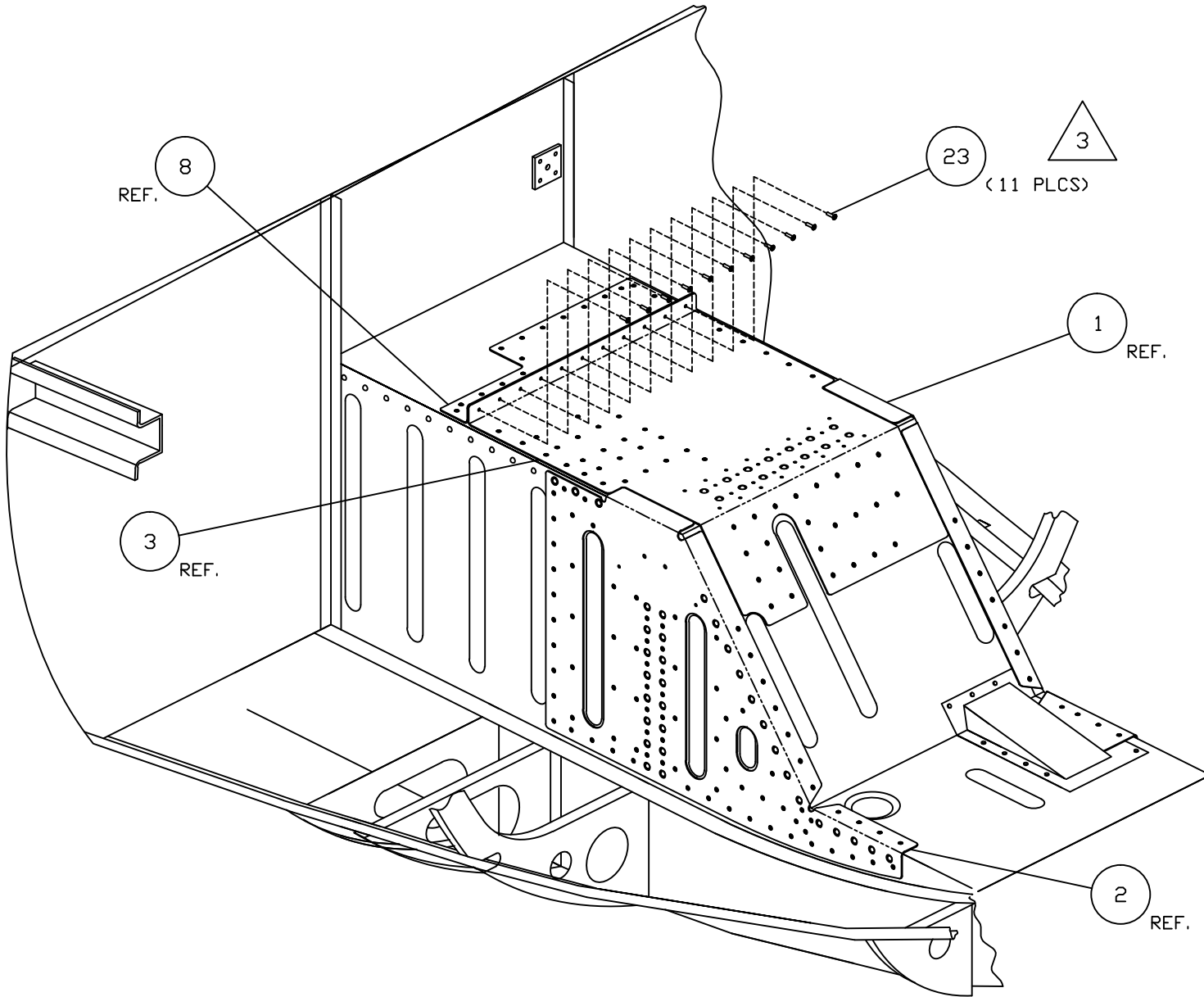
23	28	MS2470AD3-3.5	SOLID RIVET
8	1	71-20-01-10	TOP COVER REAR
ITEM	QTY	PART No.	DESCRIPTION
NEXT ASSY: DRAWN BY: D. B. ENGINEER: D. BRAUN CHECKED BY: D. B.			INSTL TOP COVER REAR
TOLERANCES X_.10 .XXX_.01 XX_.03 .XXX_.001 ANGLES ±5% UNLESS STATED			D' SHANNON PRODUCTS, LTD DWG. No. DSPMM-01-10 REVISION NC SCALE: NONE DATE 08/30/11 SH 1 OF 3



2 ALIGN ITEM 8 TO TUNNEL STRUCTURE AS SHOWN AND INSTALL RIVETS ITEM 23

NOTES:

NEXT ASSY: DRAWN BY: D. B. ENGINEER: D. BRAUN CHECKED BY: D. B.		INSTL TOP COVER REAR	
TOLERANCES X_.10 .XXX_.01 XX_.03 .XXX_.001 ANGLES ±5% UNLESS STATED		D' SHANNON PRODUCTS, LTD	
DWG. No.	DSPMM-01-10	REVISION	NC
SCALE:	NONE	DATE	08/30/11 SH 2 OF 3



REF.

8

23

(11 PLCS)

3

REF.

1

REF.

3

REF.

2

NEXT ASSY:
 DRAWN BY: D. B.
 ENGINEER: D. BRAUN
 CHECKED BY: D. B.

INSTL TOP COVER REAR

TOLERANCES
 X_.10 .XXX_.01
 XX_.03 .XXX_.001
 ANGLES ±5%
 UNLESS STATED

D' SHANNON PRODUCTS, LTD

DWG. No. DSPMM-01-10 REVISION NC

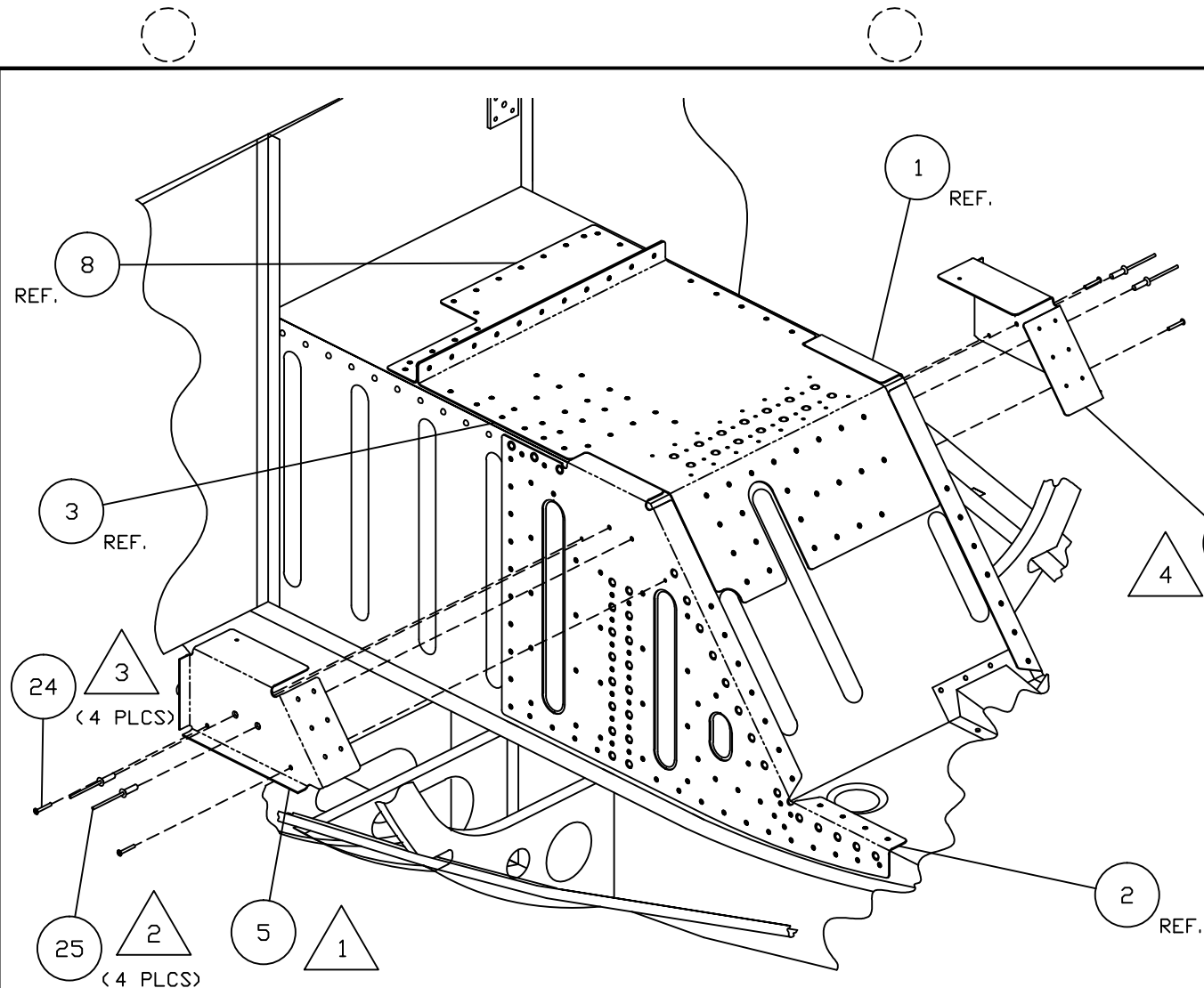
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INSTALL RIVET ITEM 23 IN ITEMS 3 AND 8.

NOTES:

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LTR.	CHANGES	BY	DATE
NC	RELEASED	D. B.	08/30/11

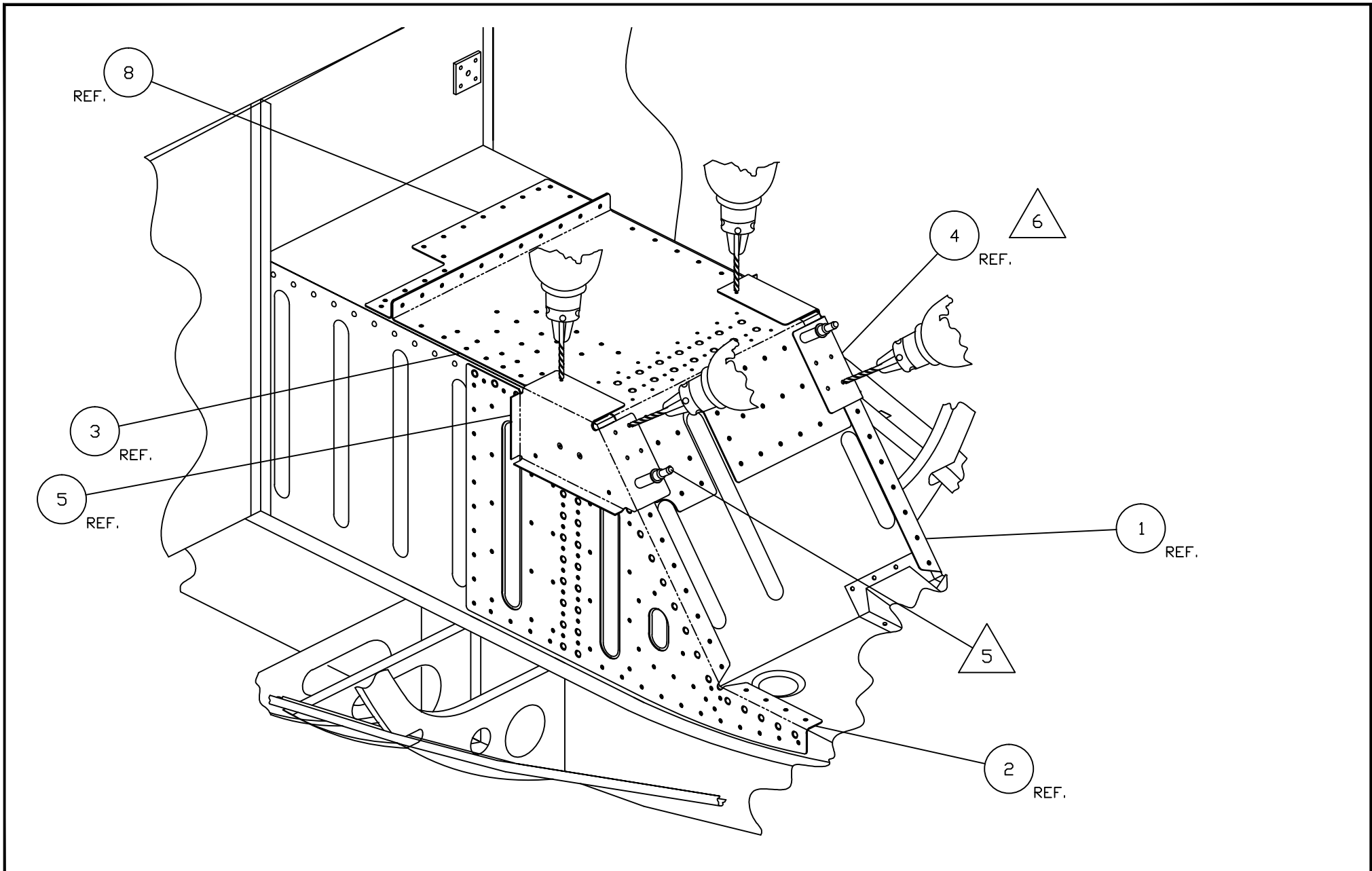


- △ 4 REPEAT THE OPERATIONS FOR THE LHS OF THE NOSE GEAR TUNNEL USING ITEM ④ LHS MOUNT REINFORCEMENT AND ITEMS ②⑤ AND ②④ AS SHOWN.
- △ 3 INSTALL RIVET ITEM ②④ AS SHOWN.
- △ 2 INSTALL RIVET ITEM ②⑤ THROUGH ITEMS ⑤, ②, ⑦, ⑪, ⑫ AND THE NOSE GEAR TUNNEL STRUCTURE. ASSURE THE COUNTERSUNK RIVETS ITEM ②⑤ ARE SET SO THAT THE HEADS DO NOT PROTRUDE AS TO INTERFERE WITH THE INSTALLATION OF THE ENGINE MOUNTS.
- △ 1 ALIGN ITEM ⑤ RHS MOUNT REINFORCEMENT WITH THE NOSE GEAR TUNNEL AND SIDE AND TOP REINFORCEMENTS AS SHOWN. DRILL THE CENTER OF THE COUNTERSUNK HOLES TO THE PROPER SIZE FOR THE RIVETS BEING USED PER THE RIVET MANUFACTURER'S INSTRUCTIONS.

NOTES:

ITEM	QTY	PART No.	DESCRIPTION
26	14	MS2470AD3-4	SOLID RIVET
25	4	CR32126-3	CHERRYMAX RIVET
24	4	MS2470AD3-5	SOLID RIVET
5	1	71-20-01-08-2	RHS MOUNT REINFORCEMENT
4	1	71-20-01-08-1	LHS MOUNT REINFORCEMENT

NEXT ASSY:		INSTL MOUNT REINFORCEMENT
DRAWN BY: D. B. ENGINEER: D. BRAUN CHECKED BY: D. B.		
TOLERANCES		D' SHANNON PRODUCTS, LTD
X_.10 .XXX_.01		
XX_.03 .XXX_.001		
ANGLES ±5%		
UNLESS STATED		DWG. No. DSPMM-01-12 REVISION NC
		SCALE: NONE DATE 08/30/11 SH 1 OF 3



REPEAT OPERATION FOR THE LHS.



DRILL A #40 HOLE IN THE NOSE GEAR TUNNEL STRUCTURE AND REINFORCEMENTS USING HOLES IN ITEMS (5) AS A GUIDE. CLECD AS SHOWN AND DRILL THE SIX REMAINING HOLES USING A #40 BIT.

NOTES:

NEXT ASSY:
 DRAWN BY: D. B.
 ENGINEER: D. BRAUN
 CHECKED BY: D. B.

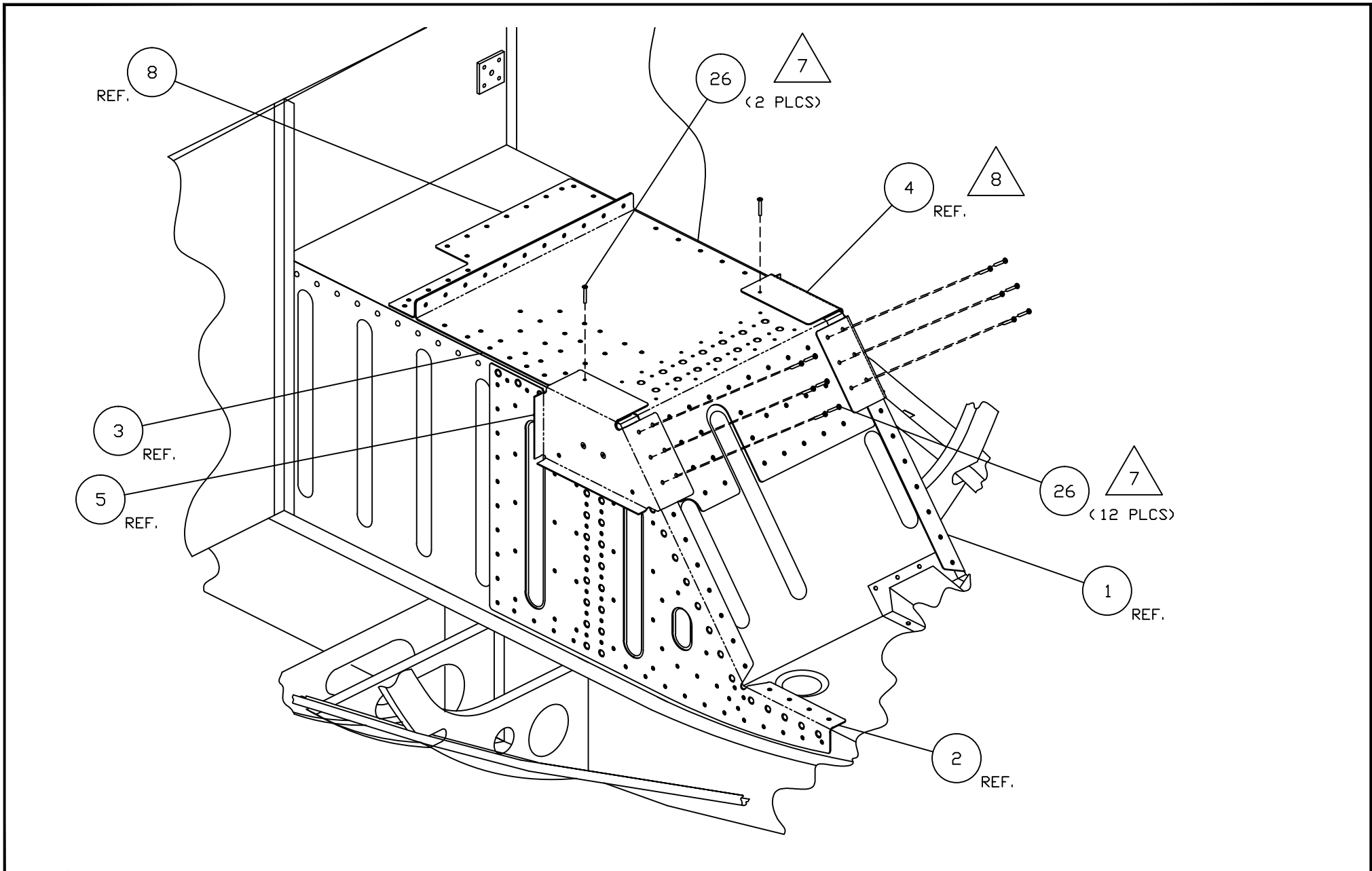
INSTL MOUNT REINFORCEMENT

TOLERANCES
 X_.10 .XXX_.01
 XX_.03 .XXX_.001
 ANGLES ±5%
 UNLESS STATED

D' SHANNON PRODUCTS, LTD

DWG. No. DSPMM-01-12 REVISION NC

SCALE: NONE DATE 08/30/11 SH 2 OF 3



8 REPEAT THE OPERATIONS FOR THE LHS OF THE NOSE GEAR TUNNEL THROUGH ITEM 4 LHS MOUNT REINFORCEMENT USING ITEM 26 AS SHOWN.

7 INSTALL RIVET ITEM 26 THROUGH ITEM 5, 2, 3 AND THE NOSE GEAR TUNNEL STRUCTURE AS SHOWN.

NOTES:

NEXT ASSY:
 DRAWN BY: D. B.
 ENGINEER: D. BRAUN
 CHECKED BY: D. B.

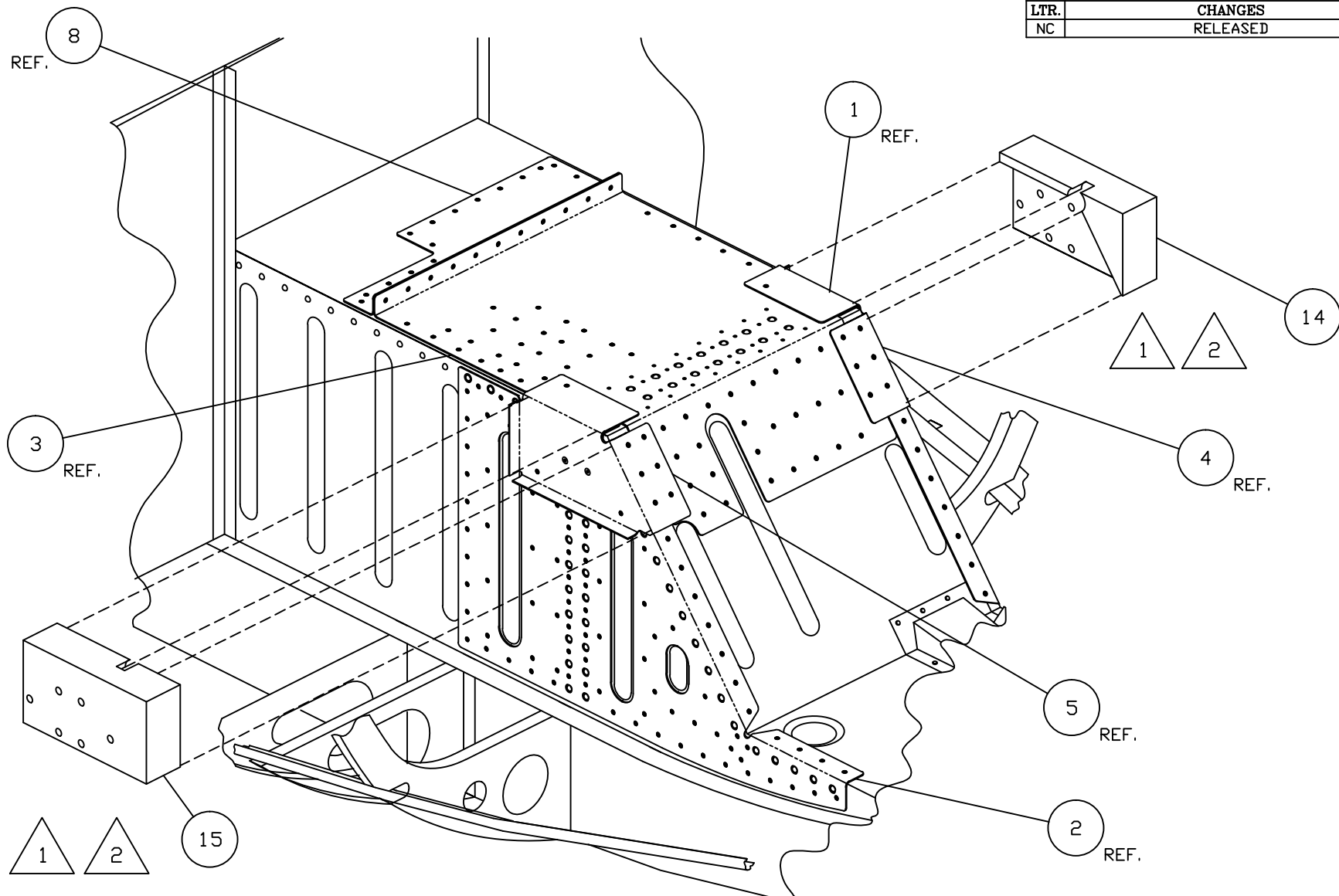
INSTL MOUNT REINFORCEMENT

TOLERANCES
 X_.10 .XXX_.01
 XX_.03 .XXX_.001
 ANGLES ±5%
 UNLESS STATED

D' SHANNON PRODUCTS, LTD

DWG. No. DSPMM-01-12	REVISION NC
SCALE: NONE	DATE 08/30/11 SH 3 OF 3

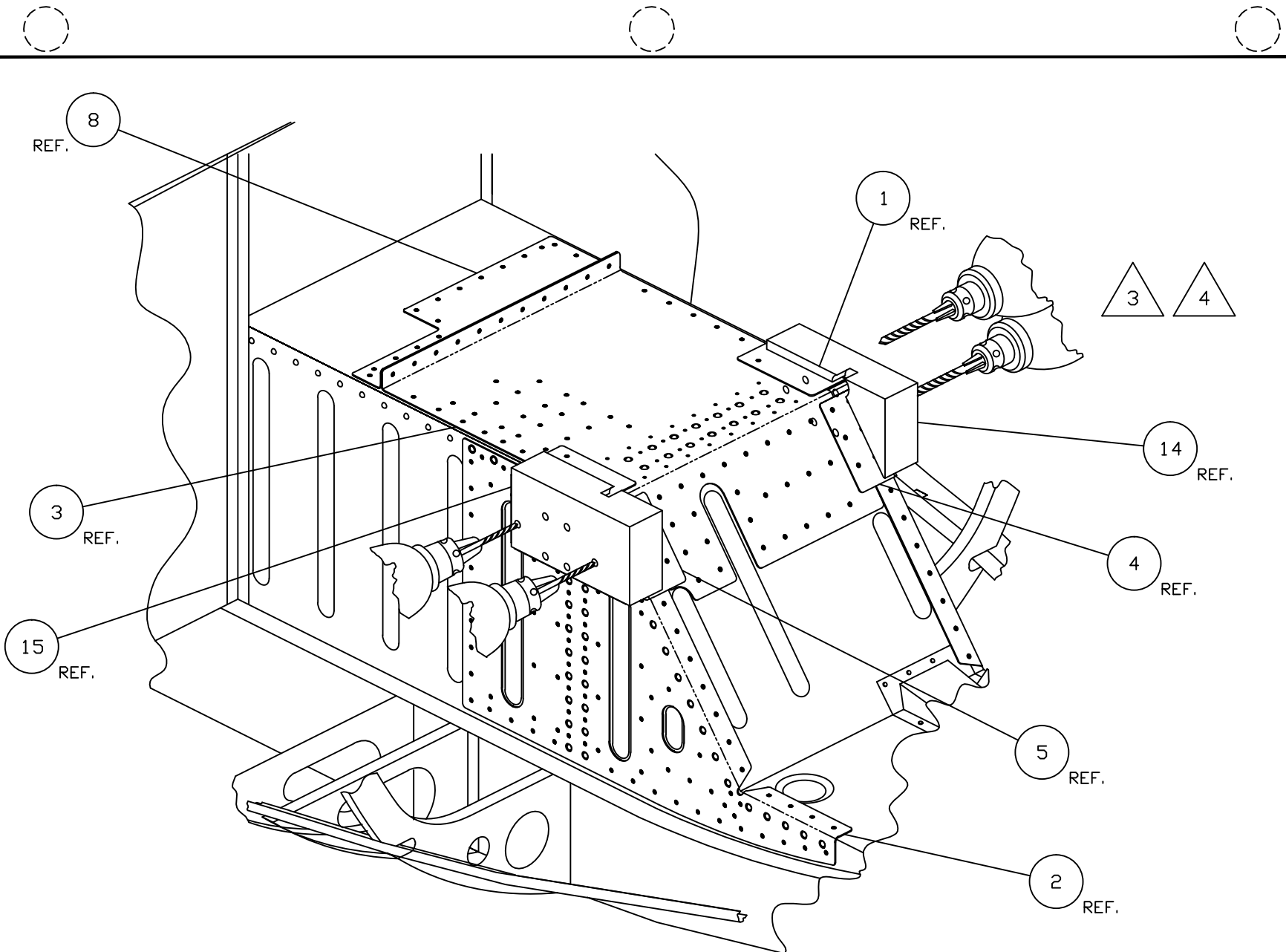
REVISION RECORD			
LTR.	CHANGES	BY	DATE
NC	RELEASED	D. B.	08/30/11



- 2** POSITION ITEM **14** AND **15** AS SHOWN ON THE NOSE GEAR TUNNEL STRUCTURE. ASSURE THAT THE COUNTERSUNK CHERRYMAX RIVETS ARE FLUSH AND WILL NOT INTERFERE WITH THE DRILL PATTERN ASSEMBLY.
- 1** THERE ARE A VARIETY OF WAYS OF ALIGNING THE MOUNTING HOLES FOR THE ENGINE MOUNTS. THE USE OF ITEMS **14** LHS DRILL PATTERN ASSEMBLY AND **15** RHS DRILL PATTERN ASSEMBLY IS OPTIONAL. ITEM **14** AND **15** MAY BE RENTED FROM D'SHANNON PRODUCTS AT THE DISCRETION OF THE INSTALLER.

NOTES:

15	1	71-20-01-12Z-2	RHS DRILL PATTERN ASSEMBLY
14	1	71-20-01-12Z-1	LHS DRILL PATTERN ASSEMBLY
ITEM	QTY	PART No.	DESCRIPTION
NEXT ASSY: DRAWN BY: D. B. ENGINEER: D. BRAUN CHECKED BY: D. B.			INSTL MOUNT HOLES REAR
TOLERANCES X_.10 .XXX_.01 XX_.03 .XXX_.001 ANGLES ±5% UNLESS STATED			D' SHANNON PRODUCTS, LTD
DWG. No. DSPMM-01-13		REVISION NC	
SCALE: NONE		DATE 08/30/11	SH 1 OF 2



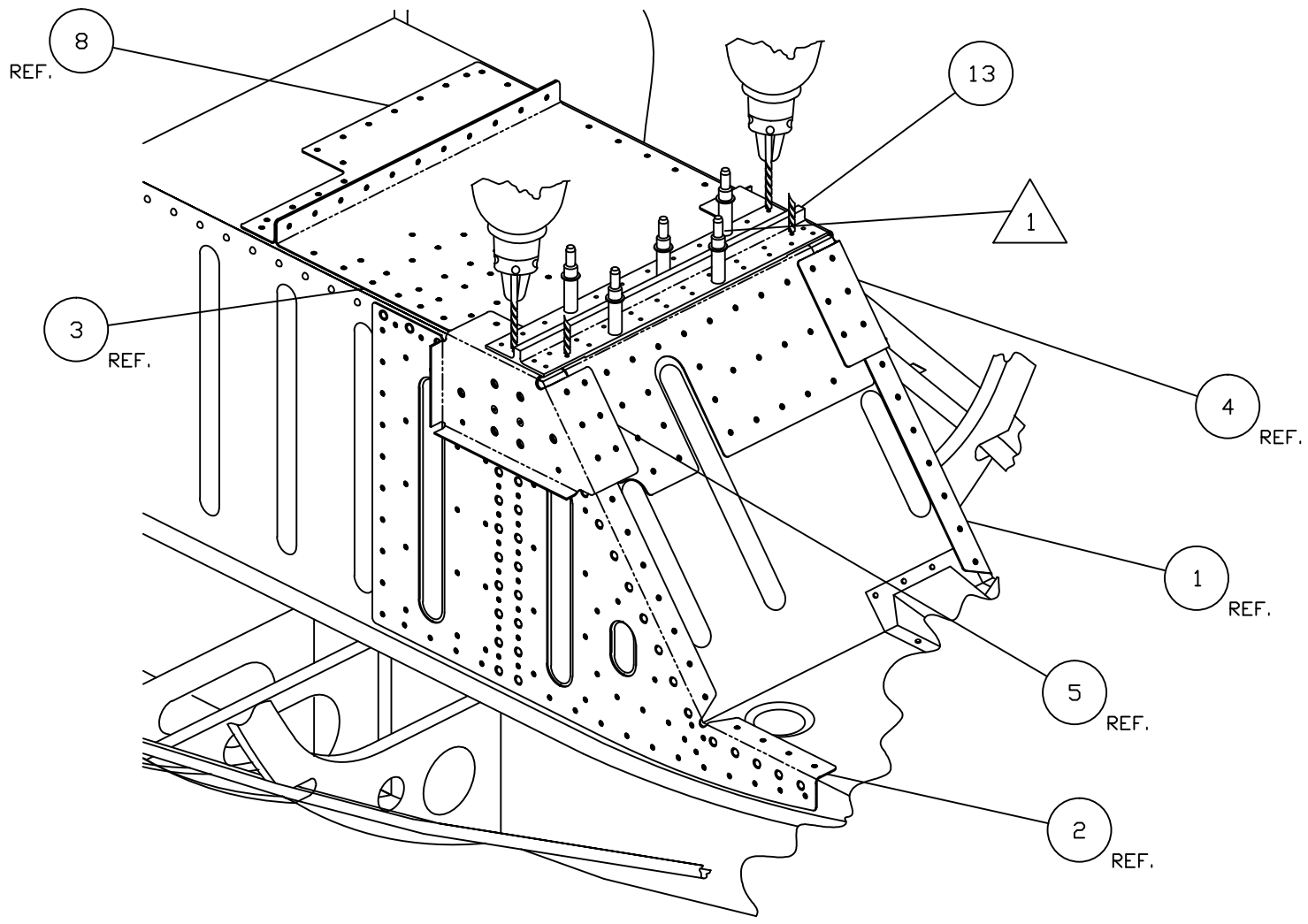
△ 4 REMOVE ITEMS (14) AND (15) AND RETURN TO D'SHANNON PRODUCTS AS DIRECTED.

△ 3 DRILL 12 #D HOLES TAKING CARE THAT THE DRILL PATTERN ASSEMBLY DOES NOT SHIFT DURING THE PROCESS. ONE METHOD IS TO DRILL ONE HOLE AND CLAMP WITH A SUITABLE BOLT, WASHER AND NUT, DRILL A SECOND HOLE AND ADD A SECOND BOLT, WASHER AND NUT, AND THEN DRILL THE REMAINING HOLES.

NOTES:

NEXT ASSY: DRAWN BY: D. B. ENGINEER: D. BRAUN CHECKED BY: D. B.		INSTL MOUNT HOLES REAR	
TOLERANCES X_.10 .XXX_.01 XX_.03 .XXX_.001 ANGLES ±5% UNLESS STATED		D' SHANNON PRODUCTS, LTD	
DWG. No.	DSPMM-01-13	REVISION	NC
SCALE:	NONE	DATE	08/30/11 SH 2 OF 2

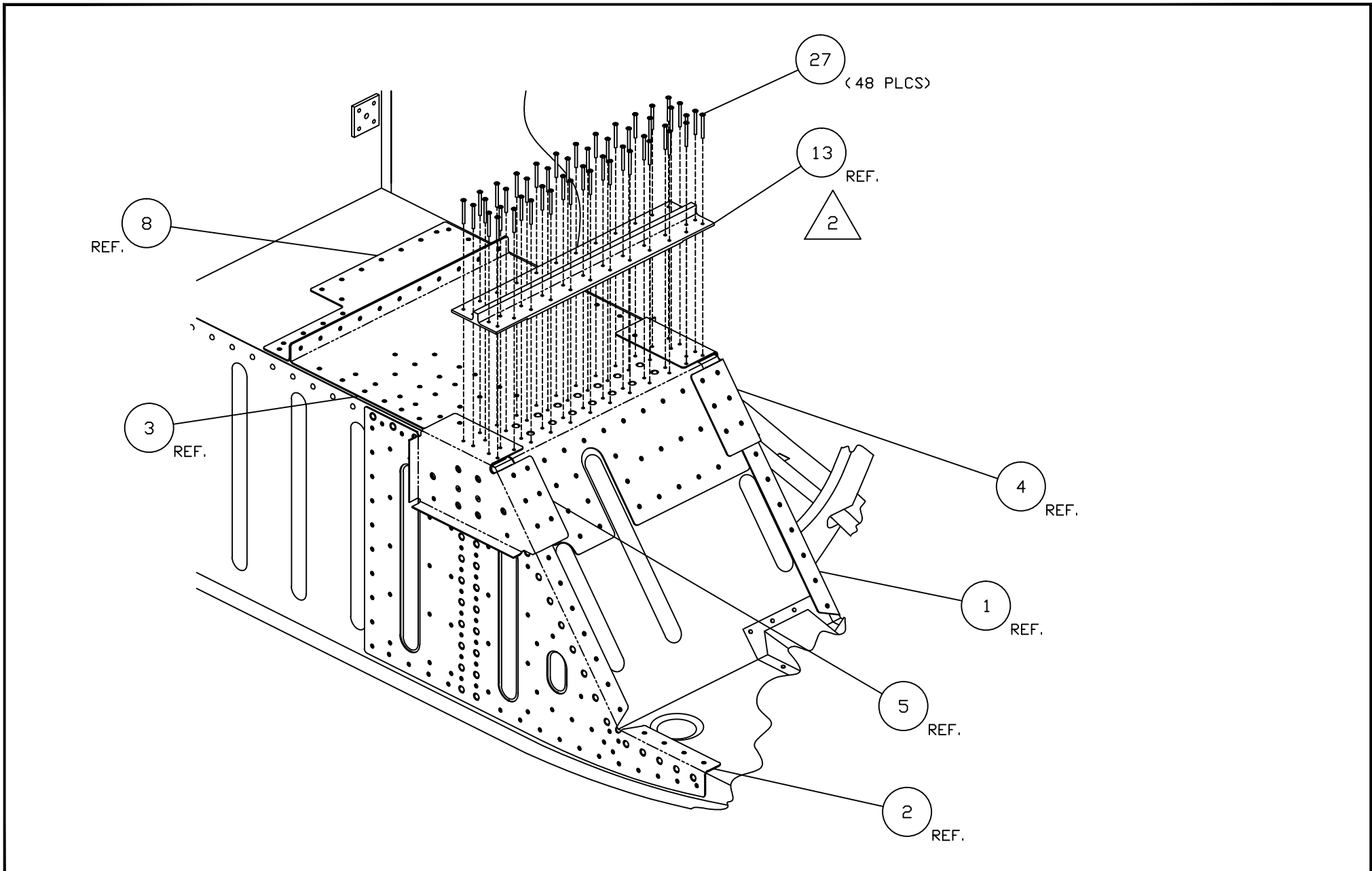
REVISION RECORD			
LTR.	CHANGES	BY	DATE
NC	RELEASED	D. B.	08/30/11



1 ALIGN ITEM 13 REINFORCEMENT TEE WITH THE NOSE GEAR TUNNEL AND SIDE AND TOP REINFORCEMENTS AS SHOWN. DRILL 5 #40 HOLES USING ITEM 13 AS A GUIDE AND CLECO AS SHOWN. DRILL THE REMAINING 43 HOLES THROUGH ITEMS 1, 2, 3, 4, 5 AND NOSE GEAR TUNNEL STRUCTURE.

NOTES:

27	48	MS2470AD3-5.5	SOLID RIVET
13	1	71-20-01-11	REINFORCEMENT TEE
ITEM	QTY	PART No.	DESCRIPTION
NEXT ASSY: DRAWN BY: D. B. ENGINEER: D. BRAUN CHECKED BY: D. B.			TUNNEL REINFORCEMENT FORWARD
TOLERANCES X_.10 .XXX_.01 XX_.03 .XXX_.001 ANGLES ±5% UNLESS STATED			D' SHANNON PRODUCTS, LTD
DWG. No. DSPMM-01-14		REVISION NC	
SCALE: NONE		DATE 08/30/11	SH 1 OF 2

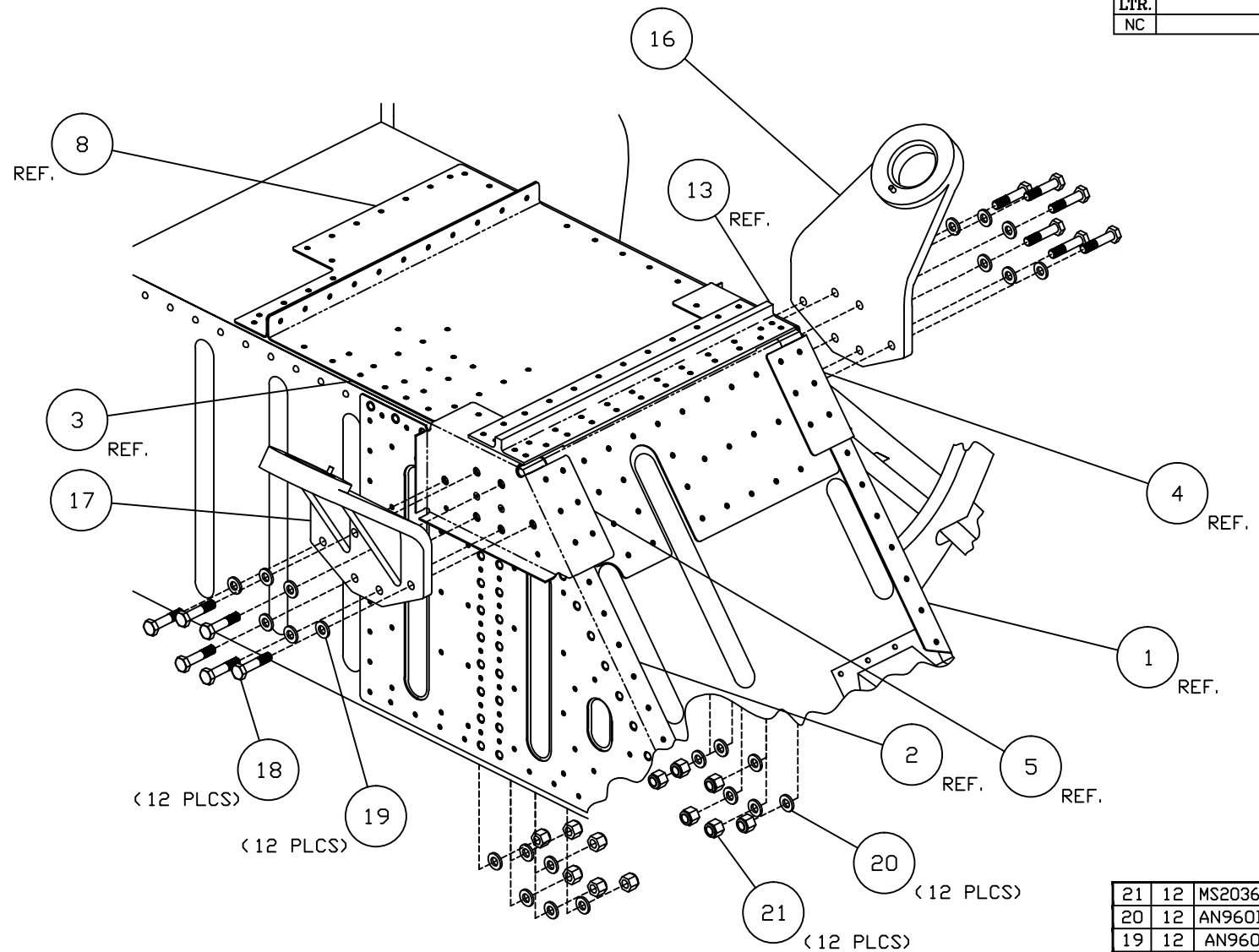


INSTALL RIVET ITEM 27 THROUGH ITEMS 13, 1, 2, 3, 4, 5 AND THE NOSE GEAR TUNNEL STRUCTURE.

NOTES:

NEXT ASSY: DRAWN BY: D. B. ENGINEER: D. BRAUN CHECKED BY: D. B.		TUNNEL REINFORCEMENT FORWARD	
TOLERANCES X_.10 .XXX_.01 XX_.03 .XXX_.001 ANGLES ±5% UNLESS STATED		D' SHANNON PRODUCTS, LTD	
DWG. No.	DSPMM-01-14	REVISION	NC
SCALE:	NONE	DATE	08/30/11 SH 1 OF 2

REVISION RECORD			
LTR.	CHANGES	BY	DATE
NC	RELEASED	D. B.	08/30/11



21	12	MS20365-428	NUT
20	12	AN960D416L	WASHER
19	12	AN960D416	WASHER
18	12	AN4-11A/M/	BOLT
17	1	35-910019-3	RHS MOTOR MOUNT
16	1	35-910019-1	LHS MOTOR MOUNT

ITEM	QTY	PART No.	DESCRIPTION
NEXT ASSY:			INSTL ENGINE MOUNTS REAR
DRAWN BY: D. B.			
ENGINEER: D. BRAUN			D' SHANNON PRODUCTS, LTD
CHECKED BY: D. B.			
TOLERANCES			
X_.10 .XXX_.01			
XX_.03 .XXX_.001			
ANGLES ±5%			
UNLESS STATED			
DWG. No. DSPMM-01-15		REVISION	NC
SCALE: NONE		DATE 08/30/11	SH 1 OF 1

1 INSTALL ITEMS 16 AND 17 LHS AND RHS MOTOR MOUNTS USING ITEMS 18, 19, 20 AND 21. SEE GENERAL NOTE 3 ON DWG. DSPMM-01-4 FOR SPECIFIC INSTALLATION INFORMATION. TORQUE PER BEECH MAINTENANCE SPECIFICATIONS.

NOTES: