

INSTALLATION ELIGIBILITY

The GAA588B Panel Fastener Insert is qualified for installation in aircraft floor panels manufactured to the following specifications:

BOEING	DOUGLAS
BMS 4-17 All Types	BZZ 7002 All Types
BMS 4-20 All Types	7954400 All Types
BMS 4-23 All Types	

* Adhesives shall meet BMS 5-107, or other FAA approved adhesive.

- A. Store and handle inserts in a manner that does not cause damage or contamination from water, oil, grease, dirt, fingerprints, or other foreign material detrimental to bonding. If inserts become contaminated, degrease or solvent clean in an appropriate manner with MEK, alcohol or Citra Safe.
- B. Before installing inserts, it is recommended to solvent clean the bonding areas on the panel surfaces with a clean, lint-free cloth wetted (but not saturated) with MEK, alcohol or Citra Safe. Immediately wipe the surface dry with a clean dry cloth. Do not allow the solvent to evaporate from the surface without wiping. Do not touch or otherwise contaminate the cleaned surface.
- C. Mix the adhesive according to the supplier's recommended ratio. Thoroughly blend the adhesive and use within the supplier's allowed pot life and temperature. Retain the mix container to verify that the adhesive has set-up within 12 hours.
- D. Apply the adhesive in a manner that will ensure it completely covers the faying surface between the insert flange and panel after insert installation. If adhesive is applied to the panel, try not to apply it outside the area covered by the insert flange. See figure 1.
- E. Assemble the inserts to the panel so the two insert parts are aligned with each other to match the lead-in of the insert. See figure 2.
- F. Press the inserts together until they bottom out on the panel surfaces. See figure 3.
- G. Visually inspect each insert to see that there is a squeezed-out fillet of adhesive completely around the periphery of the flange. Do not remove this squeeze-out. Visible fillets of adhesive are required. Smooth those areas where the adhesive extends more than 0.015 inch above the surface of the insert flange. See figure 4. A wiper dampened with alcohol may be used for post assembly cleanup. Do not allow solvent to wet the bondline. Remove any adhesive from inside bore of the insert before it cures.
- H. Cure adhesive by supplier's specification. Handle the panels carefully to prevent movement of the inserts during the first 12 hours if cured below 140 F.
- I. When an insert flange overhangs the edge of the part or planned step cut, trim the flange back flush with the edge of the part or step cut. Do not trim the insert until at least 12 hours after installation.

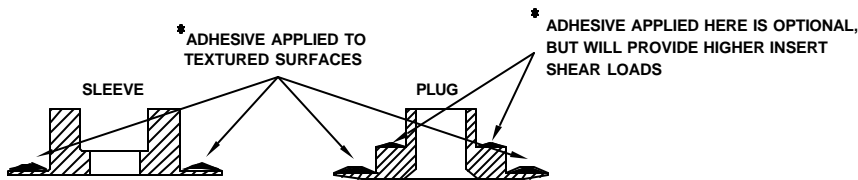


FIGURE 1

APPLY ADHESIVE TO TEXTURED FLANGE SURFACES OR DIRECTLY TO PANEL

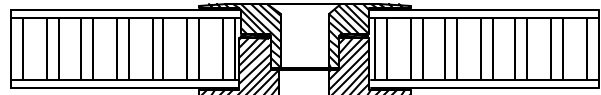


FIGURE 3

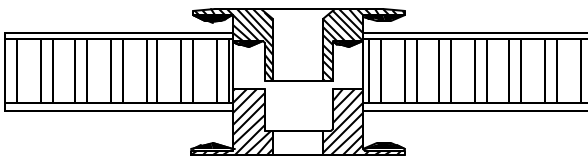


FIGURE 2

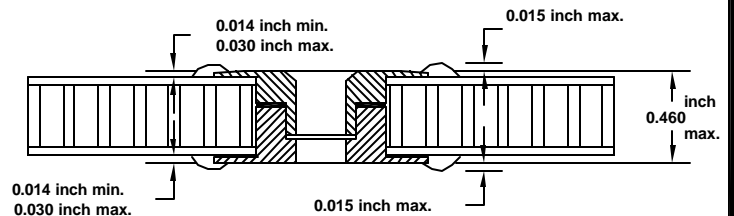


FIGURE 4

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCE ON DECIMALS

- .X = ±0.02
- .XX = ±0.01
- .XXX = ±0.005
- ANGLES = ±2°

CODE IDENT.
08ST2



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SCALE	NTS
DATE	09/23/96
DRAWN	JPG
REVISED	12/21/01

**TYPICAL INSTALLATION PROCEDURE
FOR GAA588 2 PIECE INSERT
(NON METALLIC) PLUG & SLEEVE**

APPROVED	Richard F. Gauron	DWG NO.	GAA588B SHT 2/2	REV.	M
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