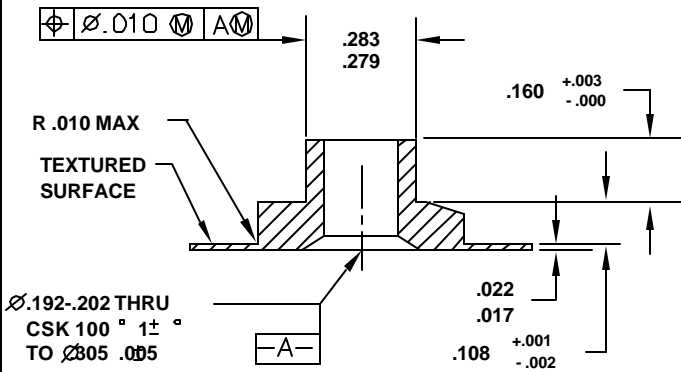
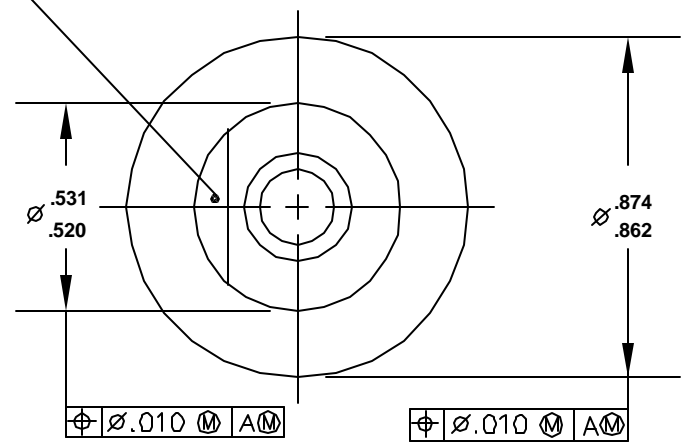
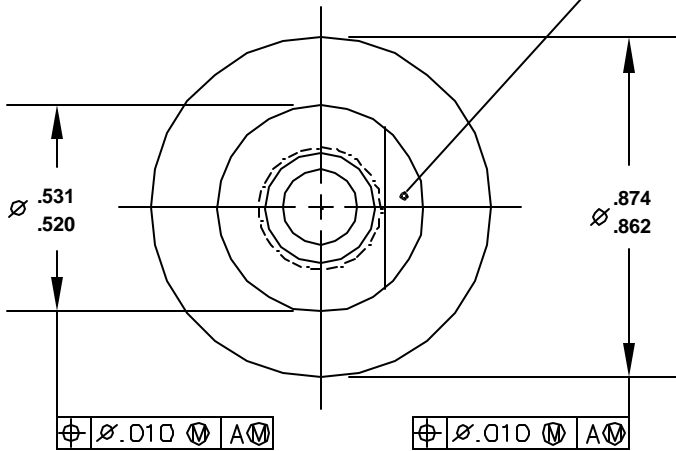
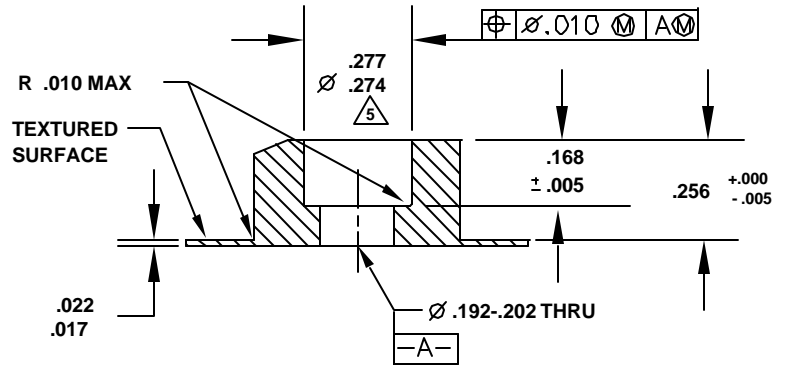




GATE RELIEF
MANUFACTURERS OPTION



PLUG
G2001MD-3P



SLEEVE
G2002MD-3S

ASSEMBLY PART NUMBER

NOTES:

1. CONSULT ADVANCED ENGINEERED PRODUCTS TECHNICAL DEPARTMENT FOR RECOMMENDED ADHESIVES AND INSTRUCTIONS.

2. INJECTION GATE BURR PERMISSABLE, BURR SHALL NOT INTERFERE WITH ASSEMBLY OF INSERT IN PANEL.

3. INSTALLATION HOLE SIZE $\varnothing .536-.540$.

4. MATERIAL: ENGINEERING POLYMER POLYAMIDE-IMDE.

5. LEAD-IN TAPER .310 MAX DIA., .060 MAX DEEP

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCE ON DECIMALS

.X =
.XX = $\pm .02$
.XXX = $\pm .010$
ANGLES = 2°

CODE IDENT.
08ST2



ADVANCED ENGINEERED PRODUCTS, INC.
1871 NW Gilman Blvd., Issaquah, WA 98027
425/451-0514 Fax 425/454-2932

SCALE	NONE
DATE	04/26/96
DRAWN	JPG
REVISED	08/06/02

**ASSEMBLY
COMPOSITE (NON-METALLIC)
THRU HOLE FLOOR INSERT**

APPROVED Richard F. Gauron

DWG NO. GAA588MD SH 1/2

Rev. N

INSTALLATION ELIGIBILITY

The GAA588MD Panel Fastener Insert is designed for installation in aircraft floor panels of nominal dimension .380 to .400, using flush-mount installation procedures only.

- 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, do not 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. 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 unless at least 12 hours after installation.

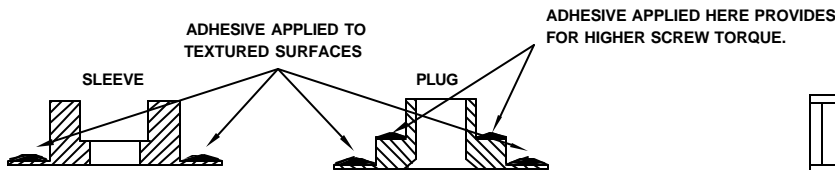


FIGURE 1

APPLY ADHESIVE TO TEXTURED FLANGE SURFACES

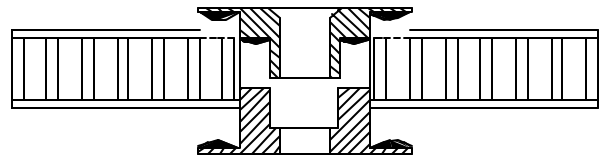


FIGURE 2

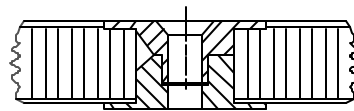


FIGURE 3

UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN INCHES

TOLERANCE ON DECIMALS

.X =
 .XX = ±.02
 .XXX = ±.010
 ANGLES = ±2°

CODE IDENT.
08ST2



ADVANCED ENGINEERED PRODUCTS, INC.
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SCALE	NTS
DATE	09/23/96
DRAWN	JPG
REVISED	01/14/00

**TYPICAL INSTALLATION PROCEDURE
 FOR GAA588MD 2 PIECE INSERT
 (NON METALLIC) PLUG & SLEEVE**

APPROVED	Richard F. Gauron	DWG NO.	GAA588MD	SHT 2/2	REV.	N
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