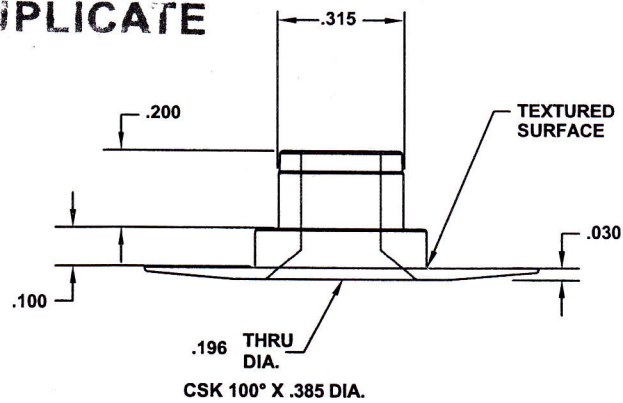
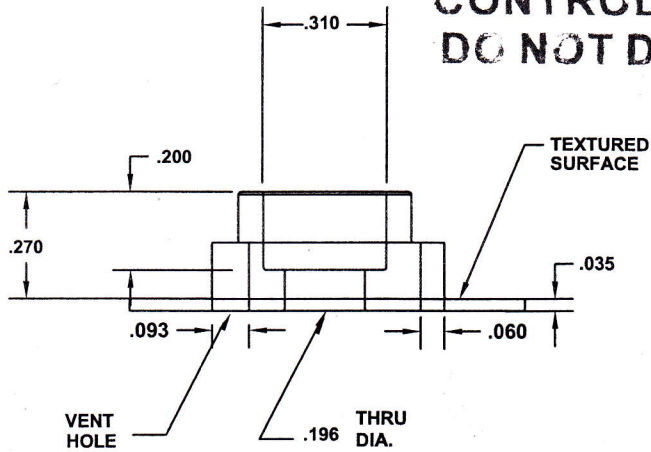


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**G2002A-3S**  
SLEEVE

**GAA588A-3**  
ASSEMBLY PART NUMBER

**G2001A-3P**  
PLUG

MATERIAL: POLYAMIDE-IMIDE (TORLON) 4203L

**NOTES:**

- STANDARD INSERT ASSEMBLY SHALL ACCOMODATE A PANEL THICKNESS RANGE OF .364 TO .384; PROVIDING A GRIP LENGTH OF .374 INCHES.
- OTHER GRIP LENGTHS AVAILABLE TO FIT A VARIETY OF PANEL THICKNESS RANGES. DETERMINE PANEL THICKNESS & SEE TABLE II FOR PROPER DASH NO.
- APPROXIMATE WEIGHT FOR -3P (PLUG) IS .80 GRAMS, FOR -3S (SLEEVE) IS 1.1 GRAMS.

**APPLICATION:**

PLUG AND SLEEVE USED IN NON-METALLIC SANDWICH STRUCTURE FLOOR PANELS INSTALLED FROM BOTH SIDES OF PANEL. REQUIRES ADHESIVE BONDING OF SLEEVE AND PLUG TO PANEL FACE SKINS AND POTTING THRU SLEEVE VENT HOLES. INSTALLATION INSTRUCTIONS ON AEP DWG GAA588A 2/2.

**INSTALLATION:**

INSTALLATION HOLE SIZE SHOULD BE 0.590 in. (15 mm or 19/32")

**TABLE II** GRIP LENGTH

SECOND DASH NUMBER "L" = XXX (IN INCHES) IS GRIP LENGTH	
ADD SECOND DASH NUMBER TO BASIC P/N FOR NON-STANDARD GRIP LENGTHS STANDARD GRIP LENGTH = .374"	
BASIC P/N	NON STANDARD P/N EXAMPLES
GAA588A-3 (STANDARD ASSY) = G2002A-3S & G2001A-3P (.374 GRIP LENGTH)	GAA588A-3-500 = G2002A-3S-500 & G2001A-3P-500 (.500 GRIP LENGTH)

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES



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

**TOLERANCE ON DECIMALS**

- .X =
- √X = ±.02
- ∓X = ±.010
- ANGLES = 2°

SCALE	2:1
DATE	3/28/00
DRAWN	JPG
REVISED	12/31/02

**INSERT, PANEL FASTENER  
NON-METALLIC, PLUG, SLEEVE**

**CODE IDENT.  
08ST2**

APPROVED *Richard F. Gauron*

DWG NO. **GAA588A SHT 1 OF 2**

REV. **F**

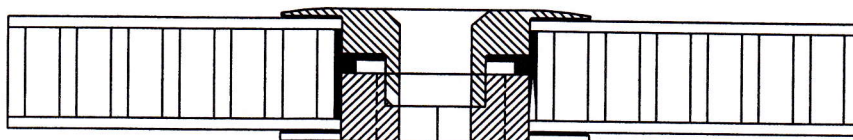
**INSTALLATION ELIGIBILITY**

The GAA588A Panel Fastener Insert is intended for installation in aircraft floor panels manufactured to the following specifications:

TL53/5000/79	<u>AIRBUS</u>	5360 M1B 000600
5360 M1B 000100		5360 M1M 000500

\* Adhesives shall meet Airbus specifications.

- 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, clean each hole of any debris or loose core caused by the drilling operation. Remove any debris from the surface of the panel, taking special care to keep the area adjacent to the holes clean. If the area is contaminated, wipe it clean with a clean dry cloth.
- C. Using a small spatula, spread a thin layer of adhesive on the panel skin surfaces surrounding the installation hole (area to encompass the entire insert flange).
- D. Use enough adhesive such that a small amount squeezes out from underneath the flange when the insert is seated.
- E. Install the insert sleeve first, in the bottom of the panel, then place the insert plug in the top. The two insert parts can be pressed together by means of an arbor press, or by tapping gently with a hammer with the assembly supported by a sound surface.
- F. Using a small nozzle, inject adhesive into one of the vent holes (this is the potting process) filling in the honeycomb voids. Inject enough adhesive in the hole to pot the insert barrel. Adhesive should exit out of the vent hole opposite the one being injected through.
- G. Clean excess adhesive from the surface with a cloth dry or dampened with a suitable solvent. Remove excess adhesive from the hole through the assembled insert with a cotton swab. Take care not to wet the bondline.
- 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.



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Potting Nozzle

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES



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425/451-0514 Fax 425/454-2932

TOLERANCE ON DECIMALS

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

SCALE	NTS
DATE	03/28/00
DRAWN	JPG
REVISED	12/31/02

**TYPICAL INSTALLATION PROCEDURE  
FOR GAA588A 2 PIECE INSERT  
(NON METALLIC) PLUG & SLEEVE**

**CODE IDENT.  
08ST2**

APPROVED *Richard F. Gauron*

DWG NO. **GAA588A SHT 2/2** REV. **F**