



INSTRUCTION – DOOR KIT

Subject: P/N: TD03095
2-Place Door Kit

Document No: TN03095

Revision: G

Date: OCT-17-2019

RECORD OF REVISIONS

When revised document changed in its entirety.

REV	DATE	DESCRIPTION	BY	CKD
G	OCT-17-2019	Add door switch.	DNE	GDO
F	DEC-31-2015	Update Fig. 2 and add stud retaining washers	DNE	DNE
E	MAY-21-2015	Update per install	GDO	DJE

Current revision approval: _____

1. PURPOSE

This instruction provides guidance for installation of subject kit listed above on Bell model 407 helicopters.

2. REQUIREMENTS

Standard tools, rivets, consumables, and finish materials not supplied.

- P/N: TD03095, 2-Place Door Kit.
- P/N: TU03273, Door Switch.
- Drawing: 03095, Door Kit (primary material list and installation guide).
- Instruction: TN03273, Switch installation.
- Instruction: TNH3083, Preheat Kit Instruction.

3. INSTALLATION

 **CAUTION: DO NOT BUCK SOLID RIVETS IN COMPOSITE PANEL.**

Door kit includes aluminum doublers, blanking plate, hinge, door, and latch assemblies. Annunciator switch supplied through next higher assembly (NHA). Rivets and adhesives source separately. As required refer to drawing and instructions listed in § 2, BHT-ALL-SRM and installation guide TNG1000 Composite Alterations (AC 43.13-1 Ch 3).

1. Position doublers on panel parallel with rivet lines or level doublers with ground. Verify coring edge distance for inner cutaways at longerons is maintained. Refer to Figures 3.1, through 3.3.
2. Continue installation with reference to door kit drawing 03095, switch instruction TN03273, and individual component instruction for light and plug as called out in preheat kit instruction TNH3083.
3. Note: Winged latch studs may be replaced with appropriate slotted or cross recess pan head studs (V26S or 26S) sized accordingly. Required when float equipped.

PROPRIETARY DATA

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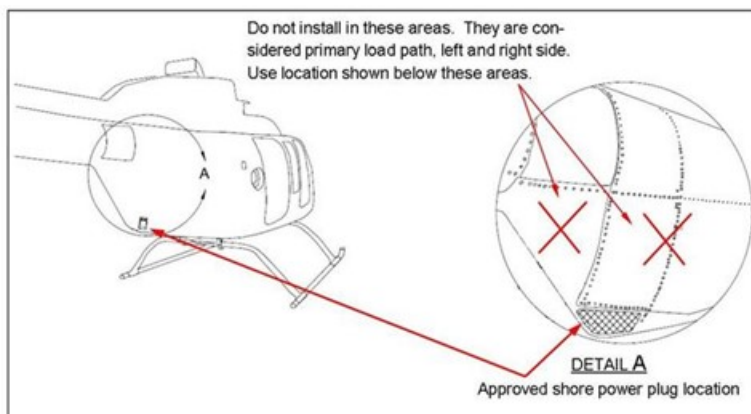


Figure 3.1. Locate door Kit TD03095 or alternate TD02840 in lower aft fairing, Detail A.

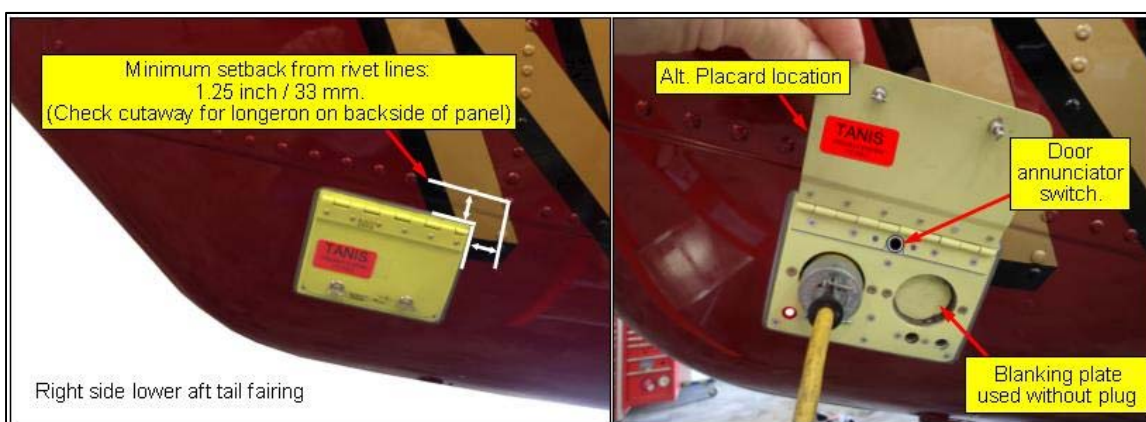


Figure 3.2. Align door on aft right side of lower tail fairing as shown. Measurements from rivet line for clearance of inner core edge set back. Door kit may be located level with ground, before cutting verify inner core edge clearance and ability to conform to panel contour.

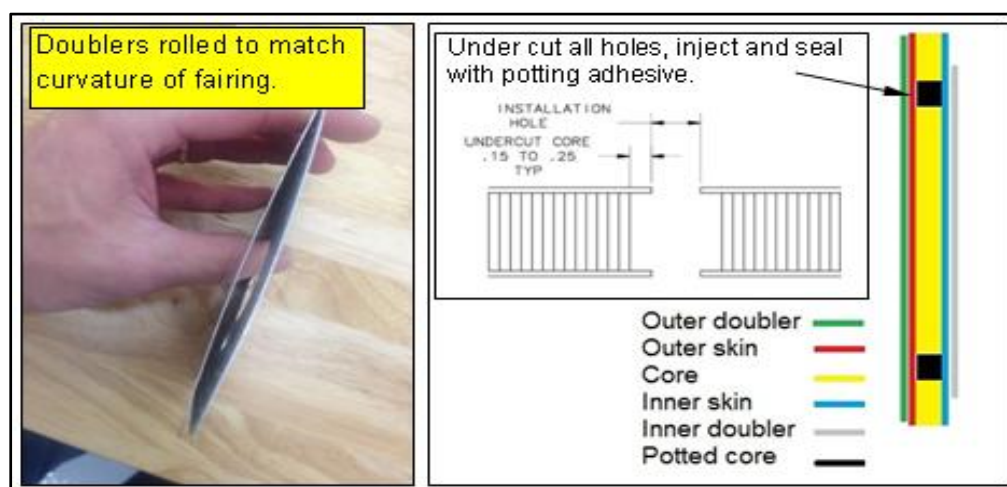


Figure 3.3. Doublers and composite panel preparation. Fit/roll doublers and door to match contour of fairing (doublers shown opposite of each other as example of required contour), undercut composite panel and pot/seal all open edges.

***** NOTHING FOLLOWS *****