

**GENERAL NOTES**  
(UNLESS OTHERWISE SPECIFIED)

1. Fabricate per AC 43.13.
2. Assembly shop practice per AC 43.13.
3. Flange corner radii are to be R .25.
4. Alodine all aluminum parts per Mil-C-5541.
5. Epoxy prime per Mil-P-23377.
6. Remove all burrs and sharp edges.
7. Torque per AC 43.13-1A or MIL-N-25027.
8. Surface finish of parts to be 125 microinches
9. Install safety wire per AC 43.13-1A or MS33540.
10. All dimensions are prior to finish applications.
11. Equally spaced attachment tolerance to be +/- 0.100".
12. Minimum attachment spacing to be 4D+.060" center to center.
13. Attachments located from part edge 2D+.060" for details, 2D minimum on assembly, 2D from joggles and adjacent structure.
14. Identify per MIL-STD-130 using rubber stamp or and written with indelible ink. Small assemblies may be tagged.
15. Symbols + between end fastener symbols indicate identical fasteners equally spaced.
16. Install solid rivets per AC 43.13-1A. Install all other fasteners per manufacturer's instructions.
17. Faying surface seal all external skin mating joints and install fasteners wet using PR1431G or P/S 870C sealant.
18. Fillet or brush coat edges of mating parts using PR1422-B2, CS3204 class B, or P/S 890 class B sealant.
19. Mix all sealants and adhesives per the Mfg's instructions.
20. Antenna must be bonded to airframe for P-static and lightning protection. Reference AC 43.13-1B Chapter 12 Section 2 Paragraph 12-9 (b) for inspection antenna guideline & Chapter 11 Section 15 Paragraph 11-193 for lightning protection. Also reference a/c manufacturer's maintenance manual for recommended antenna bonding practices.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED
	-	Initial Release	2011-0X	J.BROWN

**INSTALLATION NOTES**

- A. Install the S67-1575-109 Antenna at FS xxx BL 0.0 per the manufacturer's instructions.
- B. Doubler may be larger, and fastener spacing greater than shown. Flanges may be added. Nuts and washers may be used in place of nutplates.
- C. Install item 4 in item 2 only, NOT in skin.

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	4		8-32UNC-2A	Screw				7
	1		S67-1575-109 Single-Channel	Iridium Satcom Data Antenna				6
	AR		NAS109XAD4	Rivet				5
	8	C	MS20426AD3	Rivet				4
	4	B	MS21062-3 or MS20059-3	Nutplate				3
	1	4, 5	-02	Doubler	0.040 2024-T3, AMS-QQ-A-250/5	0.040 x 5 x 4		2
			-01	Installation				1
	-01	NOTE	PART NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL/SPECIFICATION	STOCK SIZE		ITEM NO.

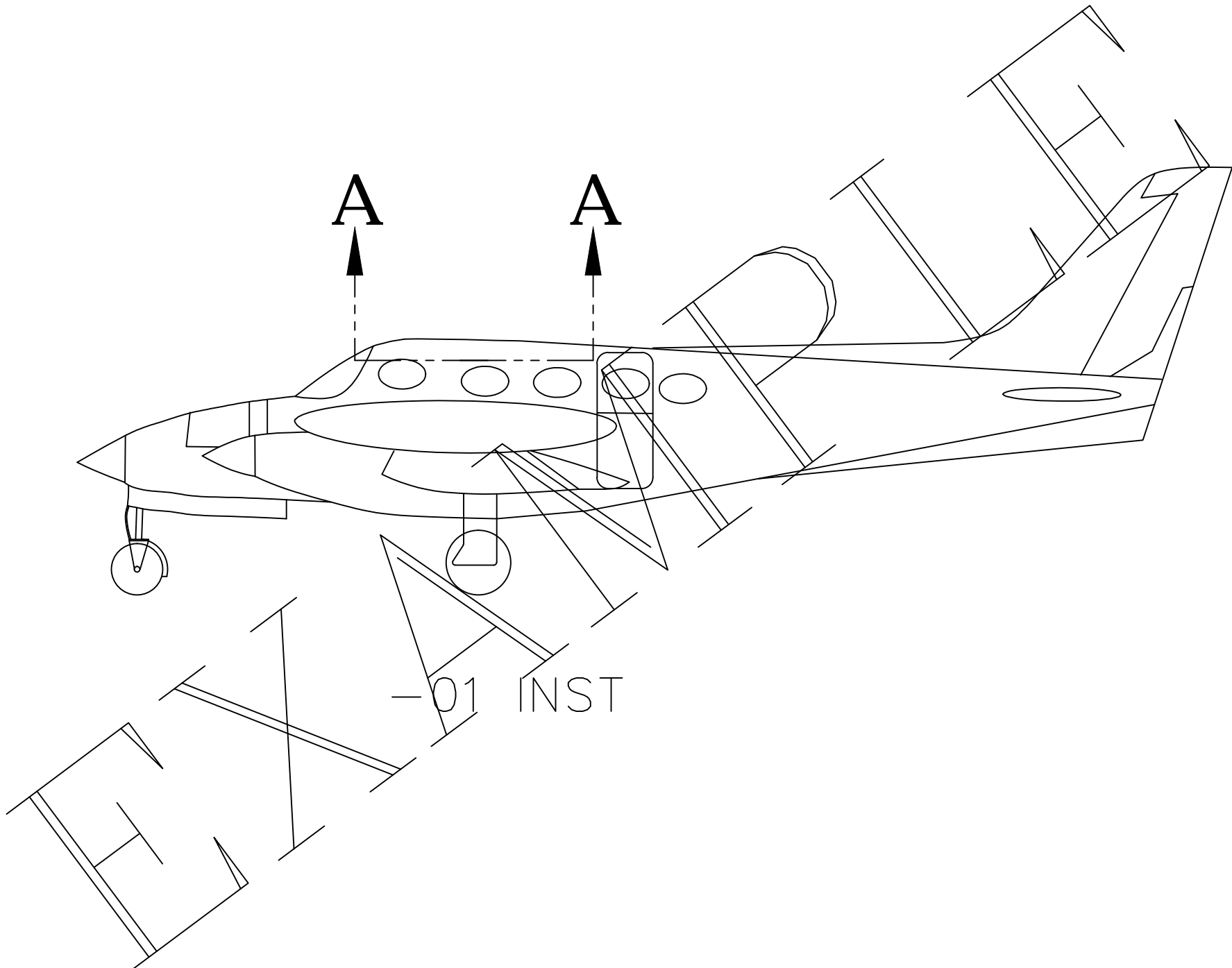
**PARTS LIST**

DIMENSIONS ARE IN INCHES  
TOLERANCES:  
.XX = ±.03  
.XXX = ±.015  
ANGLES ±0°-30'

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TITLE: S67-1575-109 SINGLE-CHANNEL ANTENNA INST  
APPRVD *J.BROWN* 2011-0X DWG. NO. 00-1500-03-03-xxx SHEET 1 OF 3



DIMENSIONS ARE IN INCHES  
 TOLERANCES:  
 .X = ±.1, .XX = ±.03  
 .XXX = ±.015  
 ANGLES ±0°-30'

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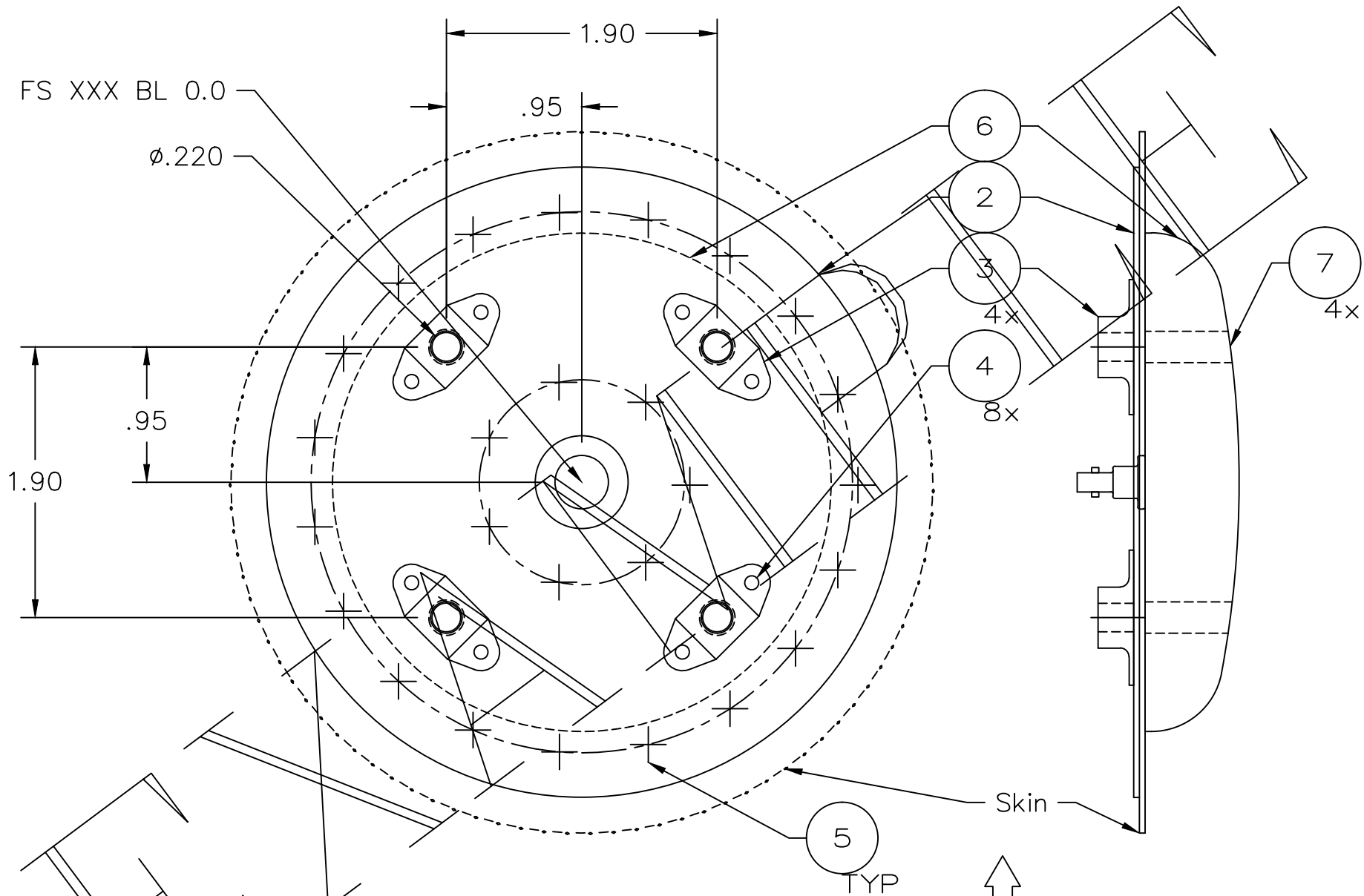


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TITLE S67-1575-109 SINGLE-CHANNEL ANTENNA INST

DWG. NO. 00-1500-03-03-XXX

Rev. - SHEET 2



Section A-A  
Rotated 90°CW

DIMENSIONS ARE IN INCHES  
TOLERANCES:  
.X = ±.1, .XX = ±.03  
.XXX = ±.015  
ANGLES ±0°-30'

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Rev. - SHEET 3