

Fig. 1

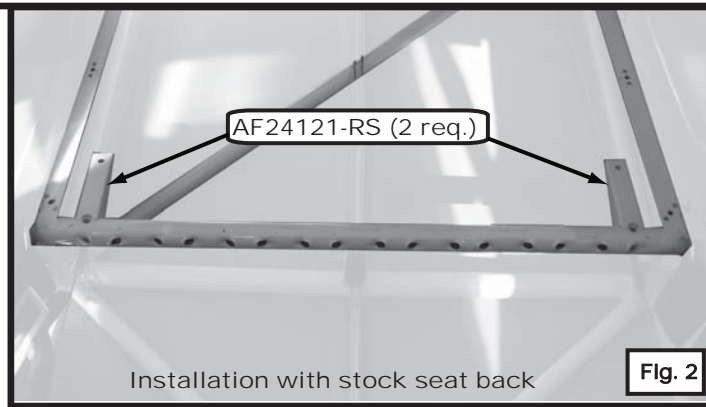


Fig. 2

Installation with stock seat back

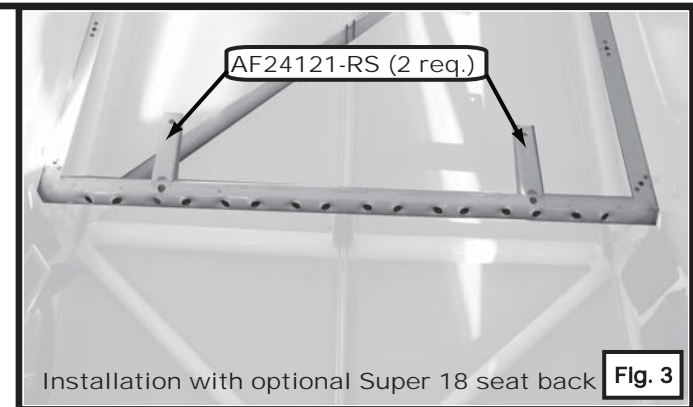


Fig. 3

Installation with optional Super 18 seat back

Ensure the top of the rear seat fitting and the top of the baggage floor mounting tab are in line, so that the floor panel can be re-installed properly.

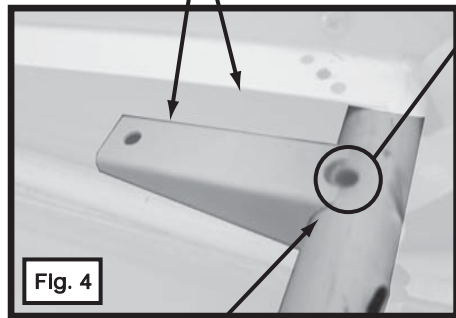


Fig. 4

NOTE:

Depending on installation, the top forward edge of the rear seat fitting (AF24121-RS) may need to be notched in order to provide clearance for the hole.

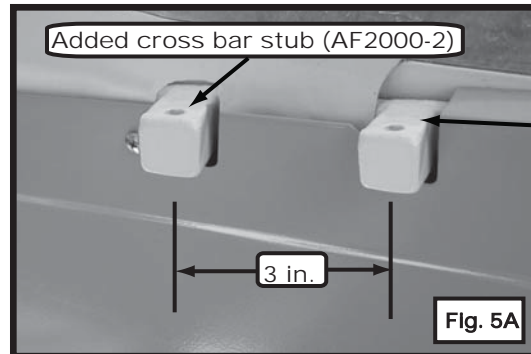


Fig. 5A

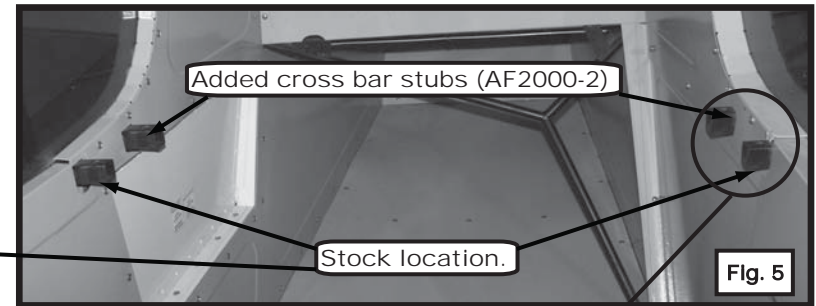


Fig. 5

See Fig. 5A

Weld here (both sides) DO NOT weld top

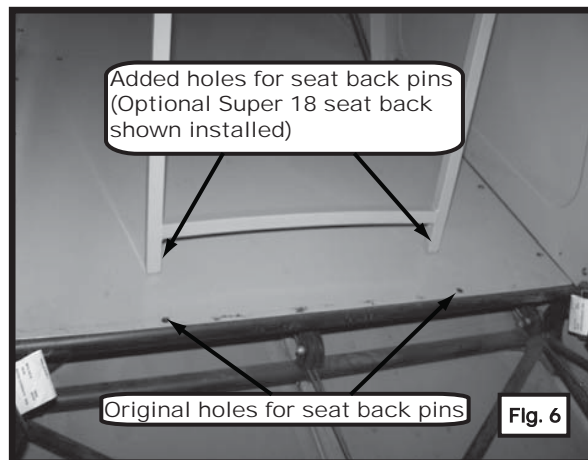


Fig. 6

1. Remove rear seat and forward baggage compartment floor (See Fig. 1).
2. Install & weld rear seat fittings (AF24121-RS, 2 req.) in appropriate location (See Figs. 2 & 3). The holes in the fittings should line up with the existing holes, as seen in Figs. 2 & 3. The seat back may be used as a jig. DO NOT weld the top edge of the fitting. Parts should be TIG welded, in accordance with AC43.13-1B 4-75. Note that depending on the installation, the forward edge of the fittings may need to be notched to provide clearance for the seat back (See Fig. 4). Ensure that the top of the fittings are in line with the baggage floor mounting tab (See Fig. 4). Note that this STC may be installed in either the standard or widebody fuselage.
3. Install two additional cross bar stubs (AF2000-2) 3 inches behind the originals (See Fig. 5 & 5A). This is done by welding the new part to the existing fuselage longerons. The side panel and / or upholstery will have to be notched in order to accommodate the new cross bar stubs. Note that this STC requires STC SA681AL (removeable rear seat cross bar kit - F. Atlee Dodge P/N 3146) be installed. It is important that both new cross bar stubs are lined up correctly, so that the cross bar may be easily installed and removed. This may require trimming of the rear portion of the cross bar stubs such that the stubs are parallel.
4. Drill the baggage compartment floor to match the holes in the new rear seat fittings. The baggage compartment floor may now be re-installed. (See Fig. 6)
5. The crossbar, rear seat back, and seat bottom may now be installed. The position of the rear seat is adjusted as follows: Remove pins holding the seat back to the cross bar. Remove the seat back. Remove the cross bar, and re-install in desired location. Slide the seat back down, guiding the pins into the desired locations. Re-install the pins holding the seat back to the cross bar, and safety pin them using two AN416-1 pins. Verify security of seatback / crossbar.

ALL DATA PROPRIETARY TO DAKOTA CUB AIRCRAFT			
Part No.	No. Req'd.	Description	Material
4	2	Safety pin - cross bar	
3	2	FITTING - REAR SEAT BACK ATTACHMENT	
2	2	Cross Bar Stub	
1	1	Cross Bar Assembly (Optional)	
1			

UNLESS OTHERWISE SPECIFIED	Scale: NONE
Angles = ± 2°	
Fractions = ± 32	
0 = ± .032	
.00 = ± .020	
.000 = ± .010	

LET	REVISION	DATE	BY

DWG.	WH	Check -	MDE	Drawing No. -
DATE	1-5-10	DATE	1-5-10	DC-RS-INSL

DAKOTA CUB AIRCRAFT Box 797 Brandon, SD