



SERVICE BULLETIN

FUJI HEAVY INDUSTRIES LTD.

HEAD OFFICE

: SUBARU BLDG,

SHINJUKU, TOKYO, JAPAN

NO : FAS-048

DATE : June 14, 1971.

1. SUBJECT : Addition of Sliding Canopy Ceiling Window.
2. AIRCRAFT AFFECTED : All FA-200 Series Aircraft.
3. PRIORITY : Optional.
4. REASON : In order to provide ceiling windows in the sliding canopy for improving upward visibility during acrobatic maneuver.
5. DESCRIPTION : Colored glass windows to be provided in the sliding canopy.
6. ACCOMPLISHMENT : Optional.
7. APPROVAL : JCAB Approval (NO-TOKYO-023) May 19, 1971.
8. PART REQUIRED : The following parts are required to perform the modification:

PART NO.	PART NAME	QTY
200-420005-141	GLASS	1
200-420005-142	GLASS	1
200-420005-119	SUPPORT GLASS	1
200-420005-120	SUPPORT GLASS	1
200-534105-21	COVER	1
200-534105-22	COVER	1

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8. PART REQUIRED : (cont.)

PART NO.	PART NAME	QTY
200-420005-33	STIFFENER	1
200-420005-34	STIFFENER	1
F-0486-1200	SEAL	2
F-0486-1000	SEAL	2
EC-1239 TYPE 1	PRO SEAL	AR
MS20470AD4	RIVET	AR
MS20600AD4W1	RIVET	4
CEMEDINE #540	ADHESIVE	AR

9. SPECIAL TOOL : None required.

10. WEIGHT AND BALANCE: Negligible.

11. REFERENCE : None.

12. MANHOUR REQUIRED : 15 manhours required.

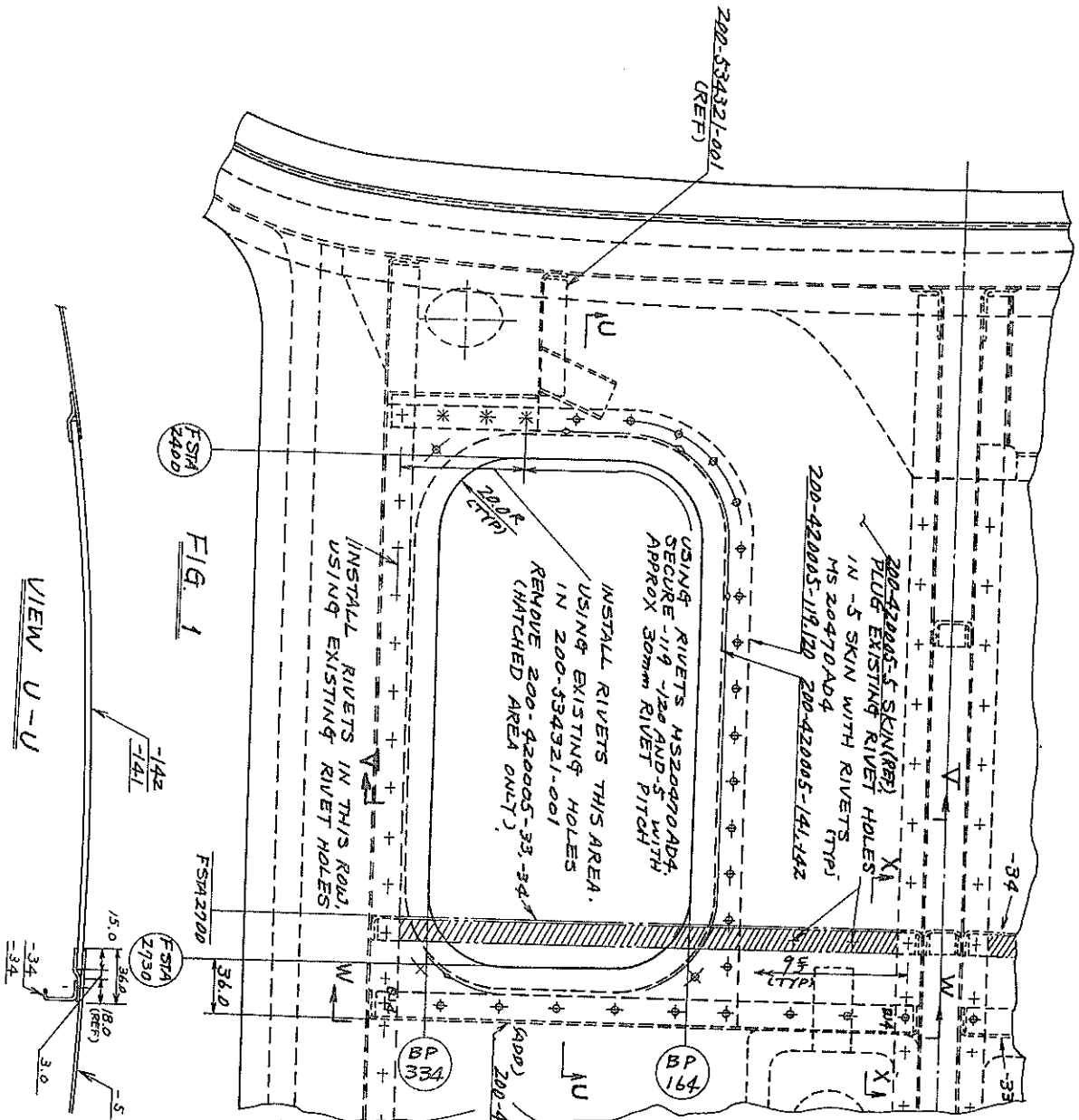
13. DETAILED INSTRUCTIONS:

- (1) Remove sliding canopy assy in accordance with Service Manual para.7-4-1.
- (2) Remove screws attaching ceiling covers and remove the covers, 200-534105-3 and -5.
- (3) Remove soundproof blankets, 200-534102-055 and -056 (1 each), and 200-534102-057 (2 each).
- (4) Make two holes in ceiling skin: One in the left and the other in the right. Dimensions for the cutout are shown in the figure 1.
- (5) Remove attaching rivets and cut off the hatched portion of stiffeners, 200-420005-33 and -34, as illustrated in figure 1 and in view X-X.
- (6) Cut off stiffener, 200-420210-017, to dimensions as shown in view X-X.

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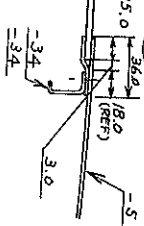
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- (7) Position stiffeners, 200-420005-33 and -34, at F. STA 2776 against skin with stiffener flange forward.
- (8) Remove * marked rivets attaching bracket, 200-534321-001, and rivets securing stiffener at BP370, between F. STA 2400 and F. STA 2776, as illustrated in figure 1.
- (9) Position glass supports, 200-420005-119 and -120, as shown in figure 1. Using existing holes in the skin as a guide, and also referring to hole locations shown in figure 1, drill rivet holes through skin, glass supports, and stiffeners.
- (10) Position glasses, 200-420005-141 and -142, on the skin, and install glass supports, stiffeners, and bracket with rivets. Apply pro seal, EC 1239 Type 1, around the circumference of glass.
- (11) Install rivets to secure stiffer to skin as illustrated in figure 1 and in view X-X.
- (12) Plug remaining rivet holes with rivets, MS20470AD4.
- (13) Cut out ceiling covers, 200-534105-3 and -5, and install seal, F-0416-1200, with cemedine #540 as illustrated in figure 2.
- (14) Install covers, 200-534105-21 and -22, in place with rivets, and bond seal, F-0486-1000, as illustrated in figure 2.
- (15) Cut out ceiling soundproof blankets, 200-534102-055, -056, and -057 as illustrated in figure 3.
- (16) Install the above blankets in place, using cemedine #540.
- (17) Install ceiling covers.
- (18) Install sliding canopy assy.

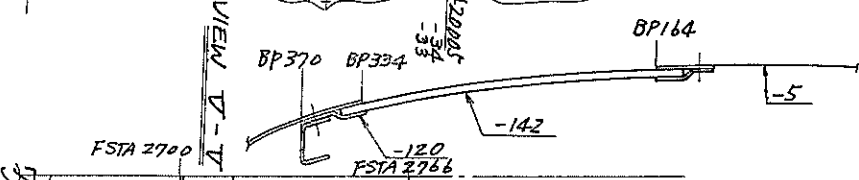


VIEW U-U

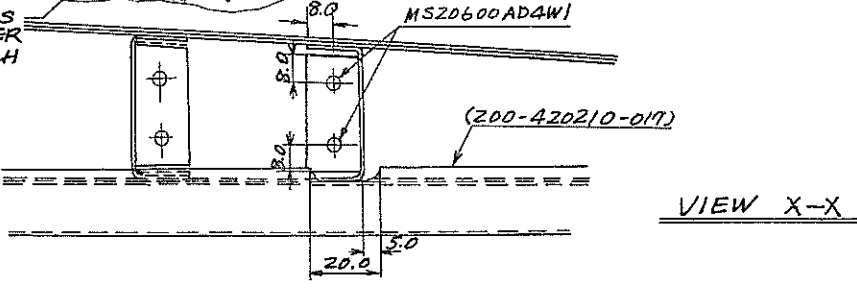
FIG. 1



VIEW V-V



DO NOT REMOVE THIS PORTION OF STIFFENER -33-34. REMOVE HATCH AREA ONLY



VIEW X-X

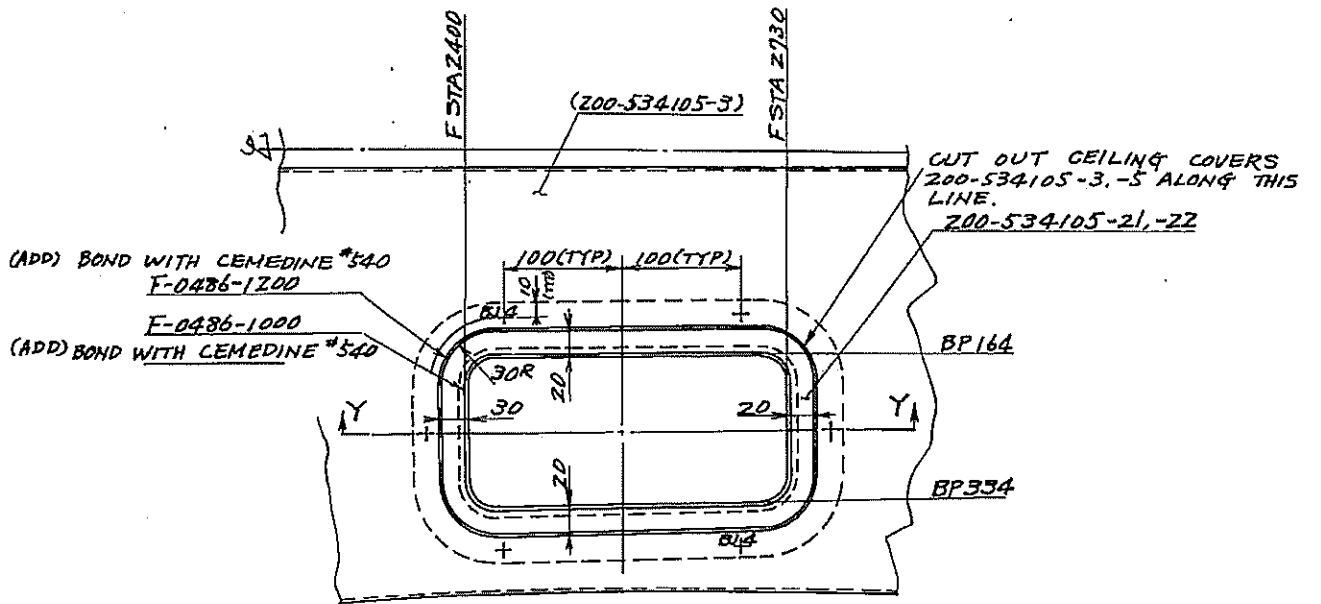
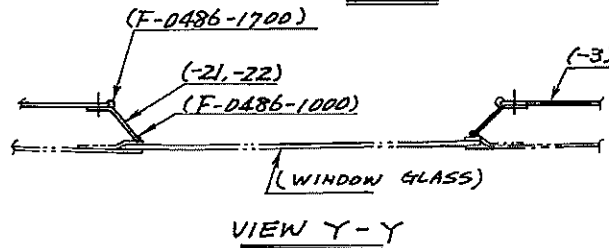


FIG. 2



VIEW Y-Y

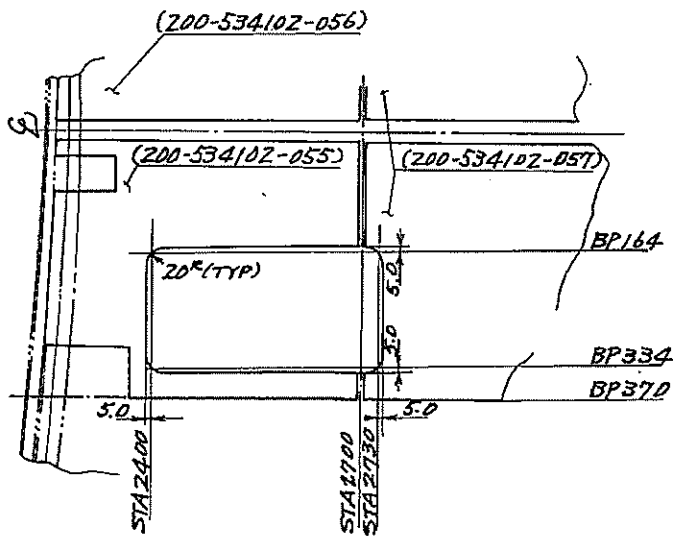


FIG. 3