



Installation Instructions AF18-II
AF18 & AF18-4 Fuselages

Rev. A 6/17/2013

AF18 and AF18-4 Fuselages:

Install new fuselage in accordance with Piper L-21-A Erection and Maintenance Handbook Technical Order 1L-21A-2.

AF18-4 Fuselage only:

Remove & replace Piper parts with parts supplied by Northern Airframes, LLC as listed in Attachment B.

Special instructions:

- A. For fuselage with baggage area floor reinforced with tubing:
 - 1. Floorboard material is to be either plywood 3/16" minimum thickness or 2024 T3 aluminum .032 minimum thickness.
 - 2. Attach placard denoting 180 lbs. max capacity to interior panel of baggage on either port or starboard side just below rear side window.

- B. For fuselages with extended baggage areas:
 - 1. Floorboard material is to be either plywood 3/16" minimum thickness or 2024 T3 aluminum .016 minimum thickness.
 - 2. Install placard above extended baggage area opening limiting baggage area capacity to ten pounds.
 - 3. Aft bulkhead of extended baggage to be constructed of 2024 T3 aluminum .016 in. minimum thickness.

- C. For cowl, flap handle & windshield modifications, see Attachment A.

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ATTACHMENT A AF18-4 "Widebody" Specific Instructions

Fuselage Cowl Modification

1. Remove rivets that attach aluminum side, top and bottom of boot cowl from firewall and attach brackets. Remove no fasteners from firewall itself. Be careful to save upper portion to use as location template for windshield strip.
2. With firewall in position on fuselage, fabricate "boot cowl" from .032 2024 T3 aluminum to fit closely around top of instrument panel, lateral and vertical formers on fuselage. Rivet to firewall using existing holes and MS 20470A4 rivets or equivalent.
3. Carefully cut lower windshield attach strip into two pieces of equal length and attach as close to original position as possible using portion of old boot cowl as a location guide and leaving 4" space in center.
4. Fabricate 4" long extension for windshield strip from .032 soft aluminum to closely follow contour of existing pieces. Attach fabricated extension between original pieces of windshield attach strip with identical fasteners to existing pieces.
5. Fabricate and perform all work in accordance with FAA AC 43.13-1B/2B.

Flap Handle Modification

Replace existing flap handle torque tube with 3/4 x .058 x 10" 4130 steel tube. Reinstall in original location relative to outside of fuselage using 2" long spacer bushing fabricated from 7/8 x .058 4130 tubing. Spacer is located on inboard side of the flap handle. Fabricate and perform all work in accordance with FAA AC 43.13-1B/2B.

Windshield

When using widened fuselage, AF18-4, use Piper PA12 windshield P/N 10680-000 or equivalent. Install in accordance with practices set forth in FAA AC 43.13-1B/2B.

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Attachment B

Part Name	Piper P/N	Northern Airframes P/N
Cabane Vee	30602	AF30602-4
Shock Strut – Lower	12844	AF12844-4
Panel - Instrument	9214844	AF9214844-4
Extension – Control Cable	81262-36	AFCCS1

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