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# Pre-cut metal instrument panel

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**Classification** Optional

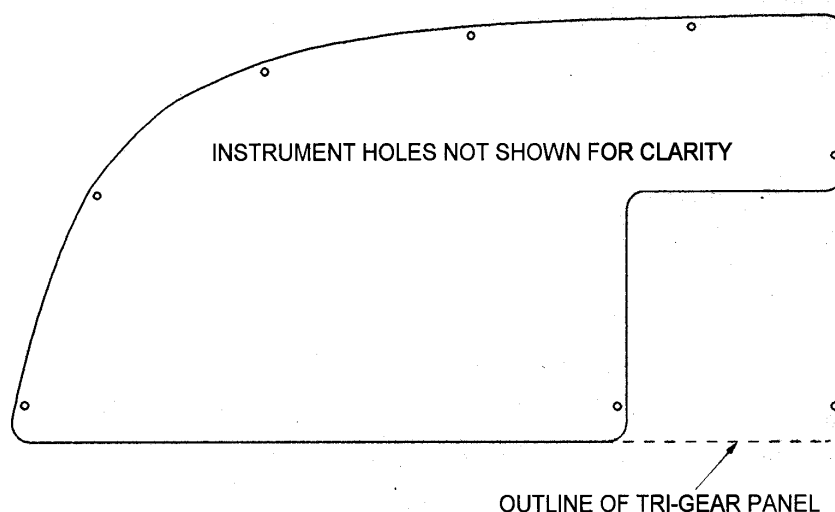
**Applicability** All Europas

## Introduction

Provided with the metal instrument panel are bolts, anchor nuts and rivets for its attachment to the glassfibre instrument panel. 6-32 bolts are also provided for the attachment of flight instruments to the panel. Where flight instruments are not equipped with integral nuts, instrument mounting nuts will be required. A quantity of these nuts are provided, which are to be inserted into the instrument mounting hole from the rear of the flange.

## Installation

A minimum of 7 bolts are required with which to attach the panel to the instrument module, their positions being shown in figure 1. An additional 3 bolts and anchor nuts with rivets are supplied, should they be found necessary.



*Fig 1. Mounting hole positions,*

Each hole is centred 5mm (3/16") from the panel edge.

Their exact positions should take into account where the flanges of the instruments lie, so it would be prudent to install each instrument first before drilling the holes. Also take into account the position of the anchor nut lugs relative to instruments, etc.



Mark and drill the 10 holes in the panel using a 4.0mm (5/32") drill. Next position the panel onto the face of the instrument module and drill through the holes into the glassfibre. Then position the MS21047-6 anchor nuts on the front side of the module and, using the lugs as a guide, drill the 2.4mm (3/32") holes for the rivets.

Rivet the anchor nuts to the rear face of the module, having countersunk the holes in the front face by spinning a drill in them, using your fingers (don't use a power drill).

Leaving a flange of about 5mm (3/16") of glassfibre all around for the panel to rest against, and leaving lugs where the anchor nuts are fitted, cut out the face of the module. You may find that you need to file the flange away further in places to avoid conflict with instruments later.