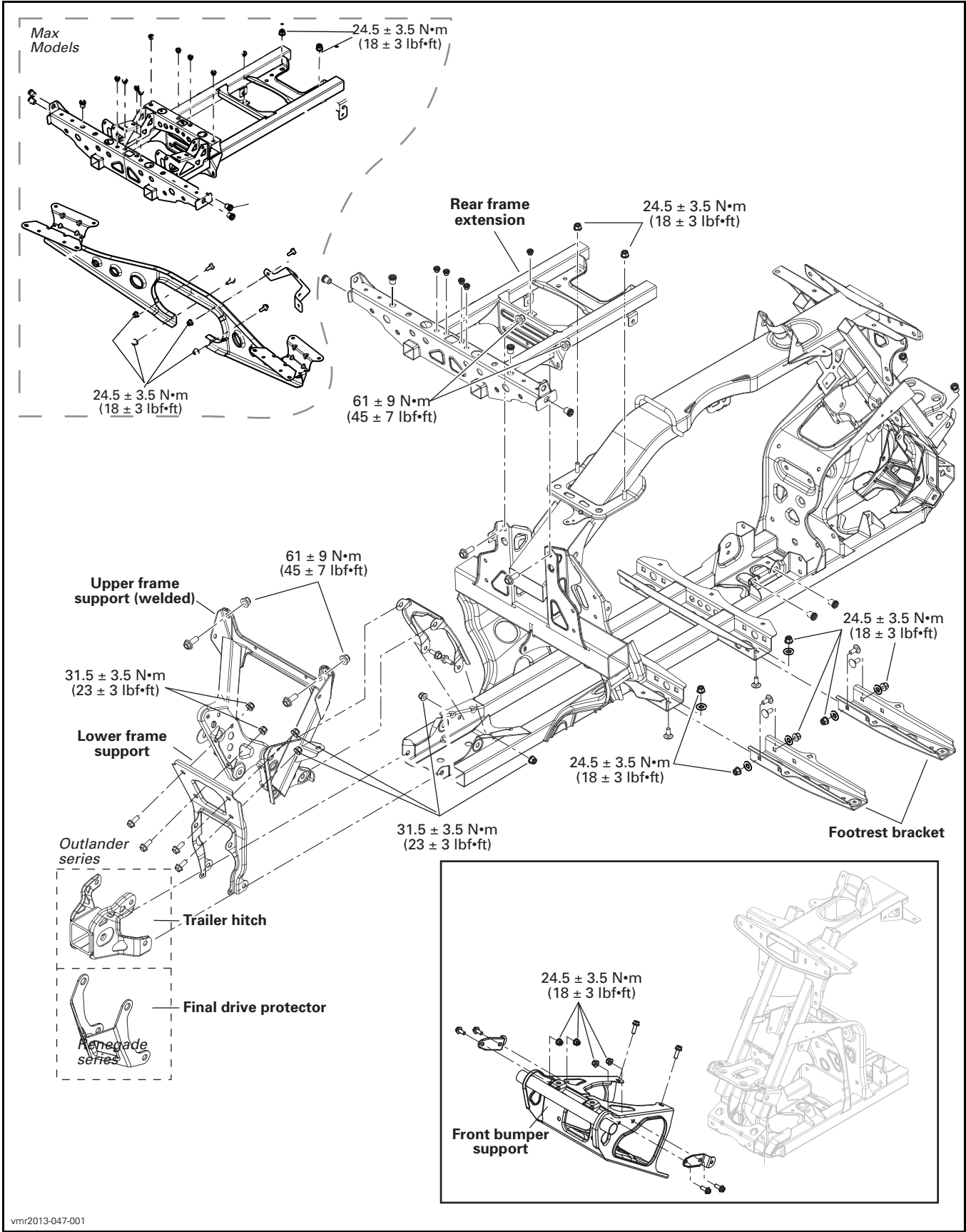


FRAME

SERVICE TOOLS – OTHER SUPPLIER

Description	Part Number	Page
BLIND THREADED INSERT INSTALLER.....	model 9600	3

Subsection XX (FRAME)



vmr2013-047-001

PROCEDURES

FRAME

Frame Inspection

Check frame for bending, cracks, weld damages or any other damage. Replace frame as necessary.

Frame Welding

No welding should be done on frame except if mentioned or required on an approved BRP Bulletin.

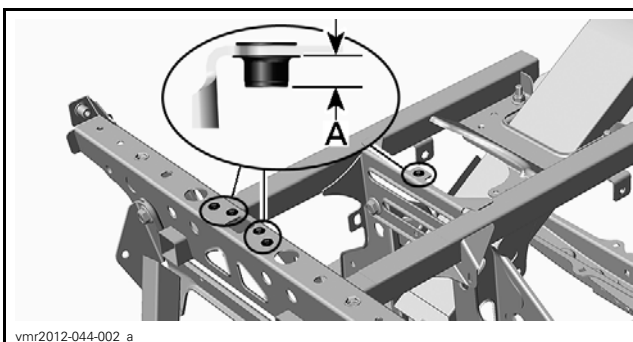
Frame Insert Replacement

To install a new blind threaded insert, use the following tool: BLIND THREADED INSERT INSTALLER (P/N MODEL 9600) from Textron. See their web site at: www.textronfasteningsystems.com.



After insert installation, ensure insert can hold the torque applied to the screw it retains and measure the compressed length of the frame insert. Otherwise, install a new insert.

INSERT	COMPRESSED LENGTH
Insert for M6 bolt	9 mm $\pm$ 0.5 mm (.354 in $\pm$.02 in)
Insert for M8 bolt	11.5 mm $\pm$ 0.5 mm (.453 in $\pm$.02 in)



INSERT FOR M6 BOLT SHOWN
A. 9 mm $\pm$ 0.5 mm (.354 in $\pm$.02 in)

Frame Replacement

Blind threaded inserts are not installed on replacement frames. Make sure to order enough inserts when replacing frame. Refer to *ELECTRONIC PARTS CATALOG*.