



Installation Manual

for

Dual Stack, Reduced Outer + Reduced Center Rail Tray Mount Kit RK2025

Document P/N RKD2025-2
Revision A

August 21, 2003

List of Revisions

Revision	Date	Description	Pages
NC	06/19/03	Original Disposition	All
A	08/21/03	Removed Experimental kits, split Dual/Triple Stack Installation Manuals, changed original RK2025 kit to RK2020, added hyperlinks	All

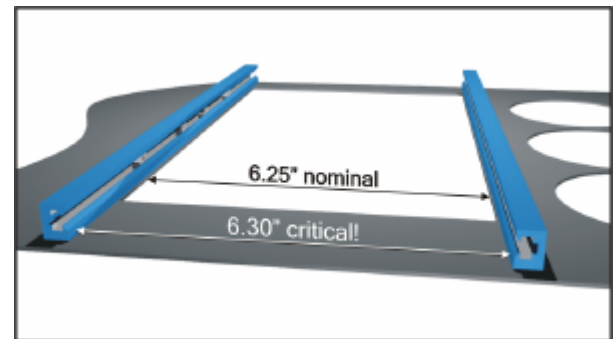
Introduction

The Radorax avionic support strut installation kit provides a straightforward retrofit for almost any aircraft. The following documentation is provided to install the Radorax p/n RK2025 Dual Stack, Reduced Outer + Reduced Dimension Center Kit in your aircraft.

Document #	Description	Used With: RK2025
RKD2025-1	Packing List / Certificate of Conformance	X
RKD2025-2	Installation Manual	X
RKD2025-3	Parts Manual	X
RKD2025-4	Instructions for Continued Airworthiness	X
SA01330LA	STC Front Sheet	X

General Notes

- A. **IMPORTANT:** The distance between the faces (inside dimension) of installed Radorax support struts **MUST** be 6.30 inches. This spacing provides maximum compatibility with all avionic trays and facilitates the use of other Radorax products, such as Radorax [Tray Cams](#), [Closeout Panels](#), and [Dzus Adapters](#). Use the RK400 [Installation Spacer Tool](#) for simple, precise alignment of the rails.
- B. Tag all parts, including attaching hardware (unless otherwise noted), removed to gain access to work areas. Protect all parts from damage during the installation process.
- C. Following any drilling or cutting operation, remove burrs and metal particles. Apply a thin coat of zinc chromate, epoxy, or equivalent primer to bare metal surfaces except when the hole is used as a grounding point.
- D. When reinstalling ground wires, or components requiring grounding, clean the structure surface to provide good electrical contact.



For an original installation not involving the removal of existing avionics tray attachments, please proceed to step 2.1. All item numbers in parentheses (eg. item xx) refer to item listed in RAS Parts Manual p/n RKD2025-3.

Removal of Existing Support Struts (Step 1)

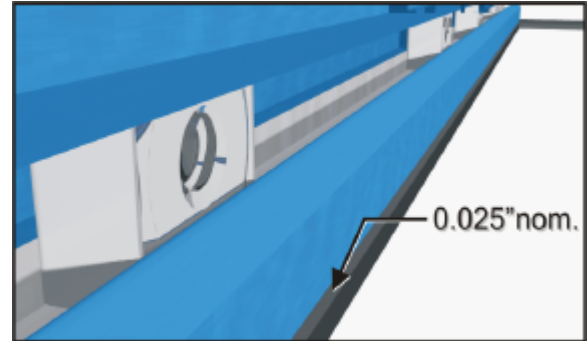
- 1.1 Remove avionics equipment from their trays. Remove screws attaching trays to the existing brackets. Remove all back-straps and attaching hardware supporting the forward end of the trays.
- 1.2 Remove any Pilot and Copilot instrument panel overlays. Remove avionics bay sub-panel, if applicable.
- 1.3 Remove the LH and RH tray attaching angles/devices from the instrument panel.

Assembly and Installation of Avionics Support Struts (Step 2)

-The following guidelines are based on a 6.25" wide avionics bay cutout and 6.30" ID strut spacing. This provides a 0.025" lip to facilitate hiding the avionics trays:

-The new struts are mounted to the instrument panel using the included structural NAS514P632-4P (item 7) screws.

-Included with the kit is enough hardware to install 12 sliding nut assemblies in EACH slot.

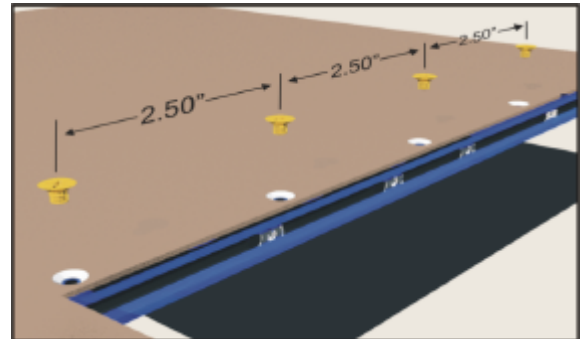


- 2.1 Cut struts to length. Match to the length of the removed LH angle, center U-channel(s) (angles), and RH angles, if applicable. Trim the strut so as to leave the engraved part number attached and on the forward-facing (visible) side of the strut, when installed.

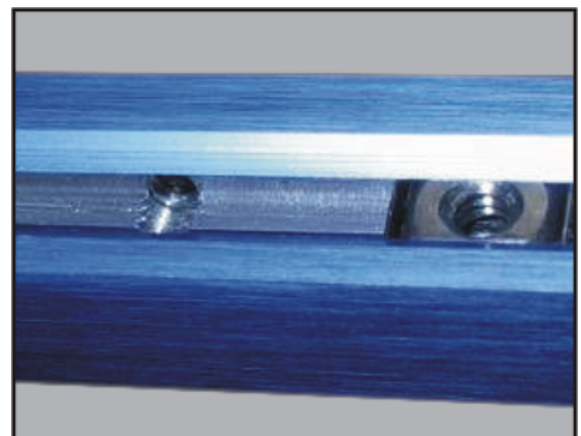
- 2.2 Instrument panel/strut fastener hole pattern layout.

Reference the RKD2025-3 Parts Manual for permissible fastener locations. Temporarily fasten all of the struts in place, 6.30" ID apart, and centered on the avionics bay cutout. Verify an inside dimension of 6.30" between the strut faces. Use the Radorax RT400 Rail Installation Spacer to lock the struts together and to facilitate the installation of the struts as an assembly.

-If using existing holes for mounting, verify that the hole positions do not exceed the dimensions noted in the enclosed Parts Manuals (RKD2025-3), and that the screw spacing is ≤ 2.50 ".



- 2.3 Drill and tap avionic support struts. Drill a #36 hole at each fastener location. Thread each hole with a 6-32 tap. In regards to p/n's RP1020-P & RP1110-P : While possible to drill a blind hole and use a bottoming tap, it is permissible to drill and tap a through-hole. Some deburring will be necessary for the nut assemblies to move freely, and care should be exercised not to drill and tap deeper than the center of the slot to avoid unnecessary burring on the opposite side.



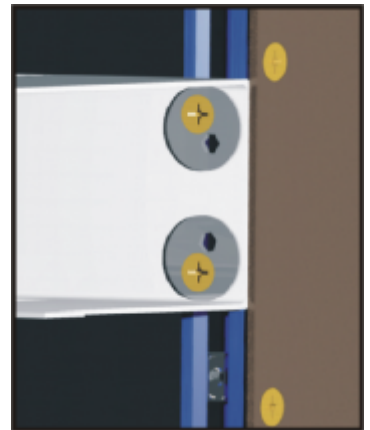
Assembly and Installation of Avionics Support Struts (Step 2), cont.

- 2.4 Verify the installation of the total number of sliding nut assemblies (Items 2, 3a, 3, 4) used for the installation, plus 4-6 extra assemblies in each strut before final installation of the strut to the structure.
- 2.5 Install the LH, Center(s), and RH struts to the instrument panel using the screws (Item 7) supplied with the kit. A small amount of Loctite (or equivalent) may be used to secure the screws.
- 2.6 Install the avionics trays. Radiator avionic support struts are designed to take advantage of the increased rigidity offered by the use of countersunk screws and dimpled screw receptacles. Because of the integrity of mounting offered by this system, back-strapping the avionic trays is not necessary, provided the Radiator support struts are affixed in a way which will bear the ultimate load factors of your aircraft.

For trays not supplied with countersunk holes, dimple each mounting hole with a #6 dimple-die, or equivalent means. Trays which are to be mounted to the offset center rails will require modification with the Radiator RT100 [Tray Modification Tool](#), or equivalent means. To achieve perfect face alignment of all avionics, use Radiator RK5000-P [Tray Cams](#).

After each tray is prepared for installation, stack the tray in its respective position, pushed forward far enough to access the sliding nut assemblies. Slide all the nut assemblies (Items 2,3a,3,4) into place that are being used to mount the top tray.

Move the tray into position and fasten using the supplied screws (Item 5). Do not fully tighten the screws until the tray is verified level in its proper position. Tighten screws to lock in place.



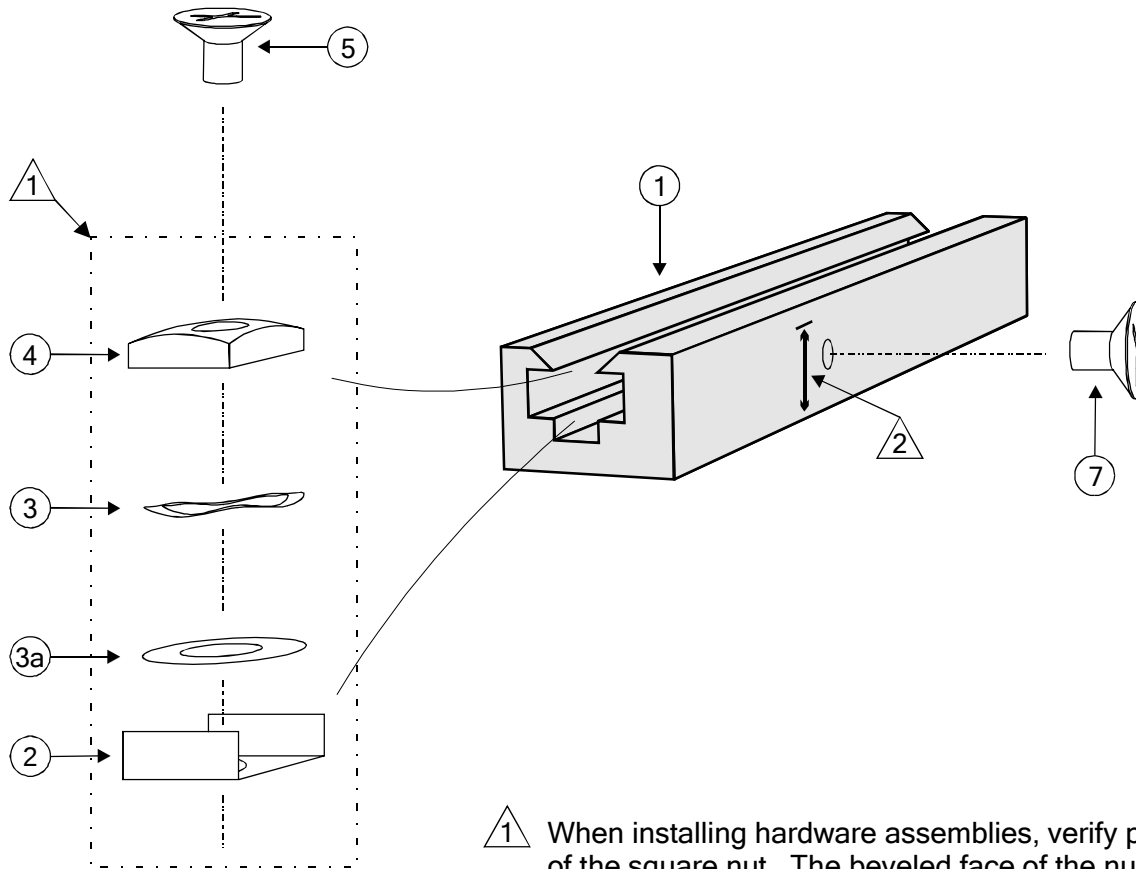
Each additional tray is mounted by positioning the nut assemblies, installing the mounting screws, sliding the tray into position beneath the last permanently affixed tray, and tightening the screws.

Nut assemblies for future use may be stored between the nuts used to mount trays, or grouped toward one end of the strut.

Use a Radiator RK4000-(x) [Closeout Panel Kit](#) to close out any remaining space.



Please visit www.radiator.com for more information, including kit documents.



1 When installing hardware assemblies, verify proper orientation of the square nut. The beveled face of the nut should be visible when the assembly is installed.

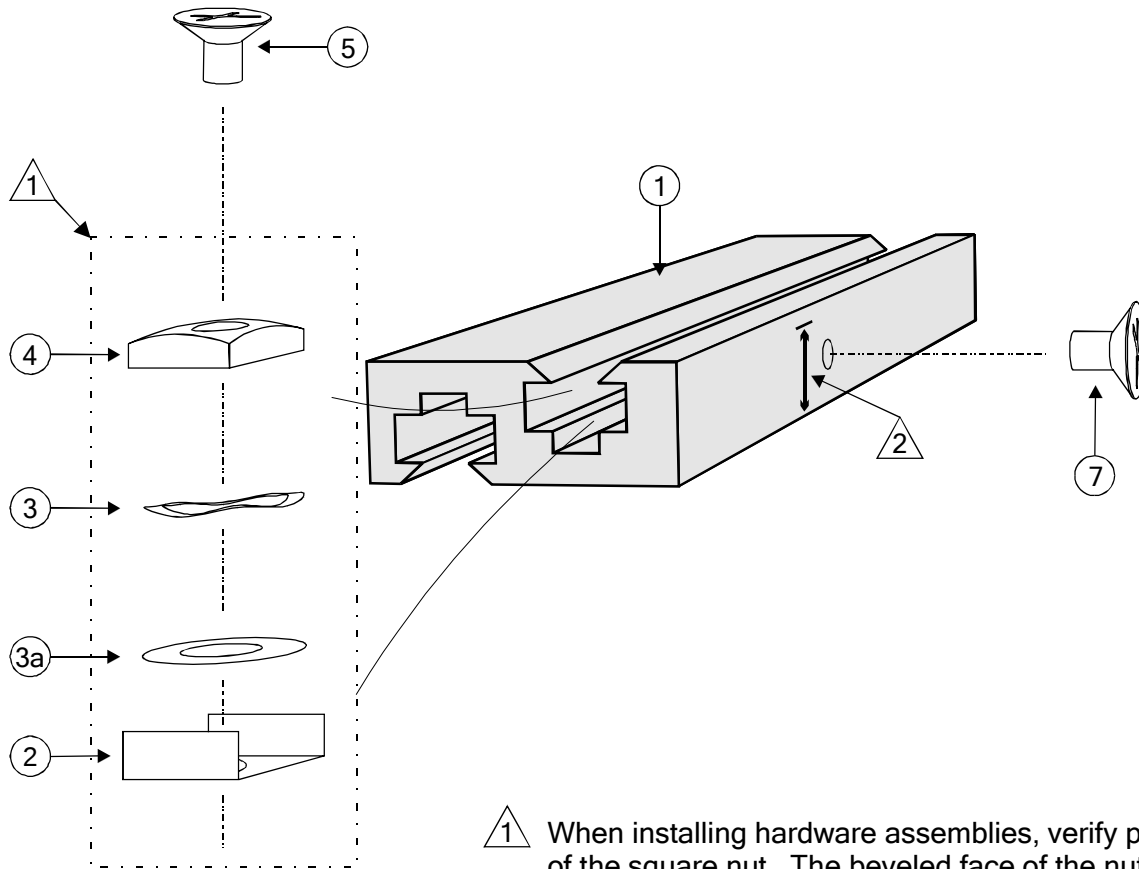
2 Maximum dimension .320"

Note: It is permissible to pierce the hardware assembly track when drilling the tap holes. Before installing, insure that all burrs are removed from the track.

Tip: Hand turn a 6-32 tap chucked in a drill press to achieve perfect thread alignment.

Revisions			
REV	DESCRIPTION	DATE	APPROVED
A	Added shim washer to accommodate upgraded wave washer.	03/07/03	M. Landes

8	NAS514P632-4P	6-32 STEEL SCREW C/SUNK HEAD	-	100 degree x .250	7		
12	NAS514P632-4P	6-32 STEEL SCREW C/SUNK HEAD	-	100 degree x .250	5		
12	RP3030-P	6-32 STAINLESS SQUARE NUT	-	.310 x .310 x .105	4		
12	RP3020-P	THREE-WAVE WASHER	Stainless	-	3		
12	RP3010-P	SHIM WASHER	Stainless	-	3a		
12	RP3000-P-4	RETAINER	Stainless	.350 x .310 x .140	2		
1	RP1020-P	AVIONIC SUPPORT STRUT	6061-T6	.385 x 1.000 x 18.0	1		
1	RP1020-X	AVIONIC SUPPORT STRUT	6061-T6	.385 x 1.000 x 18.0	1		
QTY.	PART NO.	DESCRIPTION	MATERIAL	SIZE/SPECIFICATION	ITEM NO.		
N/A	EXPERIMENTAL FAA/PMA	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: DECIMALS ANGLES .XX + .02 ±.50" .XXX ±.010	CONTRACT NO.	Radiorax Aviation Systems www.radiorax.com			
			APPROVALS	DATE	TITLE		
			DRAWN M. J. Landes	3/07/03	RADIORAX 1020 SERIES		
			CHECKED V. D. L'Esperance	3/07/03	STRUT ASSEMBLY DETAIL		
			ENGINEER M. J. Landes	3/07/03	SIZE D	CAGE CODE RDK1020-3	DWG. CODE -
			APPROVED V. D. L'Esperance	3/07/03	SCALE NONE	DWG. NO. FILE: RKD1020-3revA.cdr	REV. A
NEXT ASSY	USED ON	N/A	SHEET 1 of 1				
APPLICATION		DO NOT SCALE ON DRAWING					



△ 1 When installing hardware assemblies, verify proper orientation of the square nut. The beveled face of the nut should be visible when the assembly is installed.

△ 2 Maximum dimension .320"

Note: It is permissible to pierce the hardware assembly track when drilling the tap holes. Before installing, insure that all burrs are removed from the track. A small amount of lubricant applied to the hardware slot prior to final assembly is recommended.

Tip: Hand turn a 6-32 tap chucked in a drill press to achieve perfect thread alignment.

8	NAS514P632-4P	6-32 STEEL SCREW C/SUNK HEAD	-	100 degree x .250	7
24	NAS514P632-4P	6-32 STEEL SCREW C/SUNK HEAD	-	100 degree x .250	5
24	RP3030-P	6-32 STAINLESS SQUARE NUT	-	.310 x .310 x .105	4
24	RP3020-P	THREE-WAVE WASHER	Stainless	-	3
24	RP3010-P	SHIM WASHER	Stainless	-	3a
24	RP3000-P-4	RETAINER	Stainless	.350 x .310 x .140	2
1	RP1110-P	AVIONIC SUPPORT STRUT	6061-T6	.385 x 1.000 x 18.0	1
1	RP1110-X	AVIONIC SUPPORT STRUT	6061-T6	.385 x 1.000 x 18.0	1
QTY.	PART NO.	DESCRIPTION	MATERIAL	SIZE/SPECIFICATION	ITEM NO.
N/A		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:	Radiator Aviation Systems www.radiator.com		
		DECIMALS ANGLES .XX ± .02 .XX ± .010	CONTRACTOR	DATE	TITLE
		MATERIAL	APPROVALS	DATE	DRWG. CODE
		FINISH	ENGINEER	DATE	REV
NEXT ASSY	USED ON	N/A	M. J. Landes	6/19/03	NC
APPLICATION	DO NOT SCALE ON DRAWING	V. D. L'Esperance	6/19/03	SCALE	1 of 1

Revisions			
REV	DESCRIPTION	DATE	APPROVED