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INSTALLATION INSTRUCTION #3157 FOR

REPLACING THE REAR SEAT BACK SUPPORT TRUSS WITH A REMOVABLE CROSS BAR ON PIPER MODELS: PA-18, PA-18S, "105" (Special), PA-18S "105" (Special), PA-15 "125", PA-18S "125", PA-18 "135", PA-18 "150", PA-18S "150", PA-19 (Army L-18C) , PA-19S

DATE: November 19, 1979

PROCEDURE

- 1 Remove rear seat back.
- 2 Find the exact center of the rear seat back support truss (truss trans-verses upper longerons at fuselage station +75). Mark the truss 10 13/16" inches left and right of center using a combination square to assure a square cut. A piece of tubing 21 5/8" + 1/16" or - 3/32" inches long will be removed after cutting leaving a stub on each side approximately 2" inches in length.
- 3 File sawed edges of stub true and smooth, removing all sharp edges and burrs.
- 4 Insert the tapered end of wood plug P/N 3146-2 into L. H. truss stub and drive it in until it bottoms on
- 5 Measure 1/2" + - 3/32" inch from the inboard end of the stubs and center punch each on top center. Check to see that the distance between the punch marks is the same as that for the pins welded on Cross Bar P/N 3146-1.
- 6 Drill a #30 pilot hole in each stub and ream holes to size with a 1/4" inch drill. Be very careful to make the holes 90° to the surface of the stubs to assure a good fit of the cross bar. Deburr holes.
- 7 Install the removable Cross Bar P/N 3146-1. The Cross Bar should fit over the stubs very tightly. Squeeze ends of Cross Bar at the bottom edges until a solid rap with the hands is required to snap it into place on each side. A good solid rap of the hand should also be required to remove the bar.
- 8 Safety Cross Bar
- 9 Reinstall standard Piper Rear Seat.
- 10 Keep bar installed when flying.
- 11 Negligible weight change.
- 12 Submit form 337 and make logbook entry.