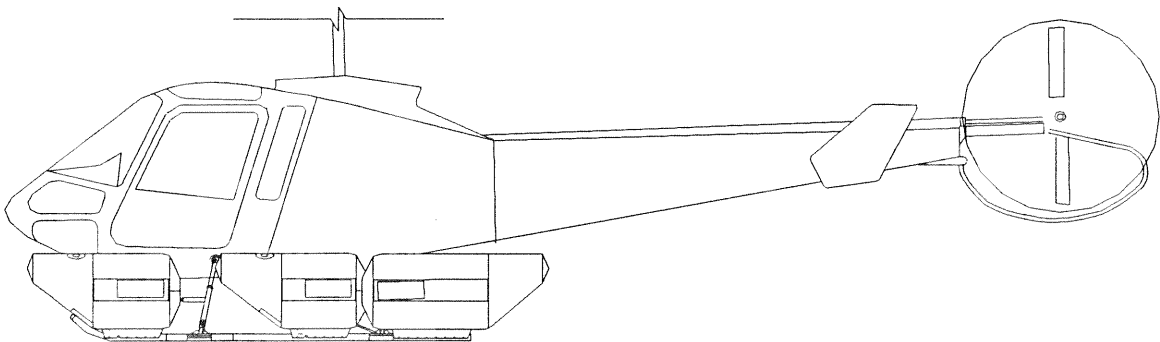


II 480-100

480/TH28 Installation and Packing Instructions

REV. B
DATE: April 24 , 1997



Enstrom Float Installation Instructions

Note: Installation of fwd, mid and aft bags will be identical.

Reference: Enstrom Drawing 4220091

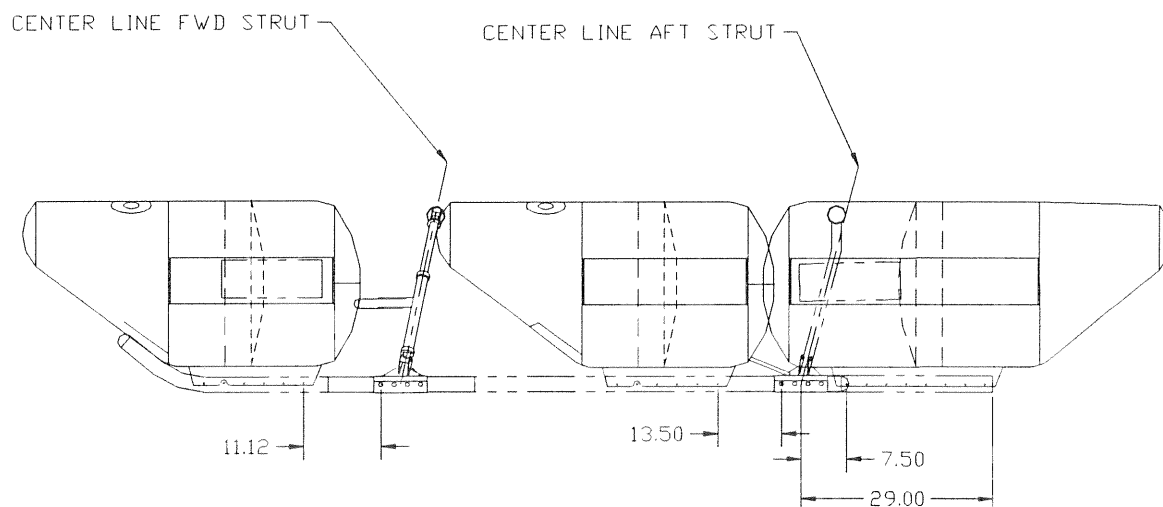


Figure A

Cover Installation

- 1) Align cover panel 27 to girt (Figure B) locating holes designated "A" (Figure C).
- 2) Place cover attaching screws from the inside of the girt towards the outside of the girt (Figure B).
- 3) Locate backup plate over cover panel and install washers and nuts (Figure B), hand tighten all nuts until secure.
- 4) Torque all nuts to 35 to 45 inch lbs, starting from the front moving to the rear.
- 5) Align panel 25 to opposite side and repeat steps 2 through 4 (Figure B).

Float Installation

- 6) Place the float on skid and align holes on float designated "B" to skid holes per Figure A.
- 7) Install the bolts through the skid so that it extends past the inboard side of the girt and backup plate (Figure E).
- 8) After installing all the bolts through the skid, position the washer and nut, as shown in Figure E.
- 9) Hand tighten all the nuts so that they are secure.
- 10) With a torque wrench, tighten the nuts from the forward end of the float to the aft, using the specified torque values.

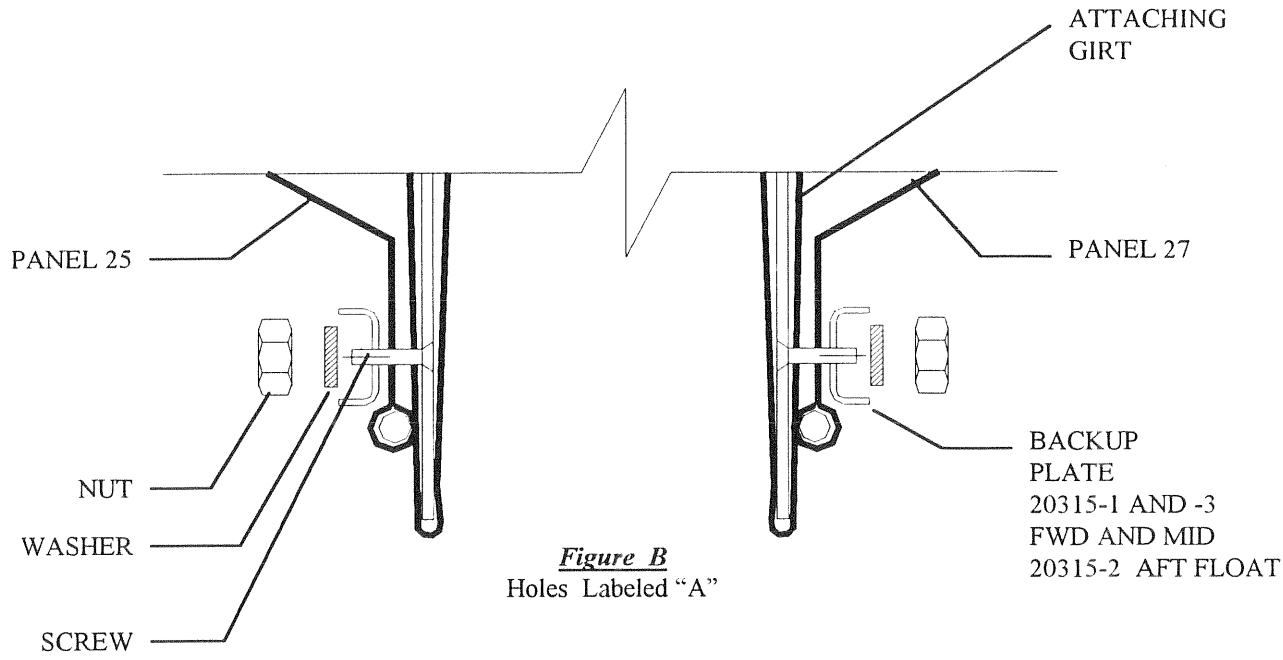


Figure B
Holes Labeled "A"

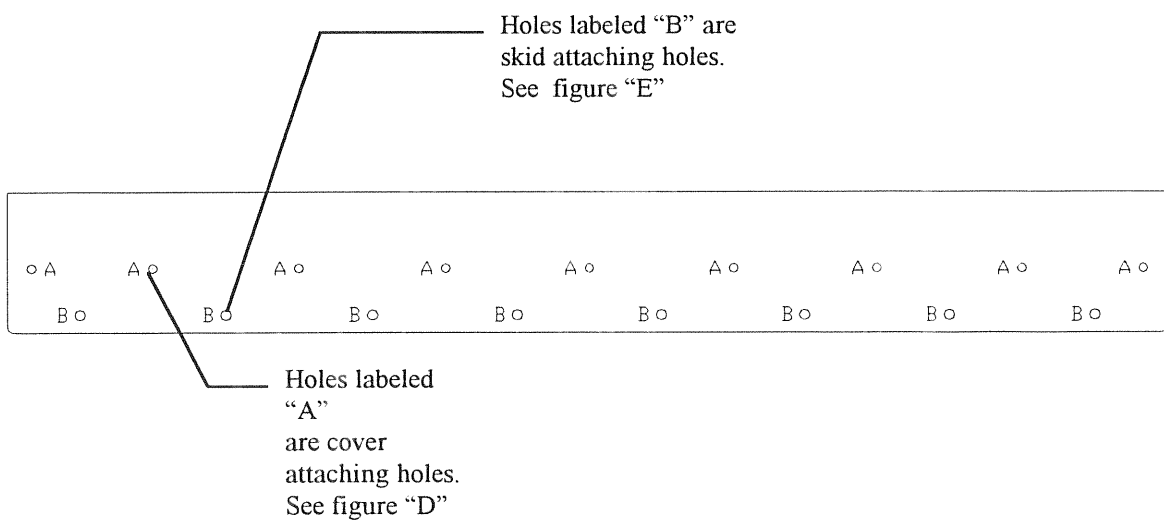


Figure C
Attaching Girt
Float removed from girt for clarity
20312 shown, 20311 configuration similar except longer

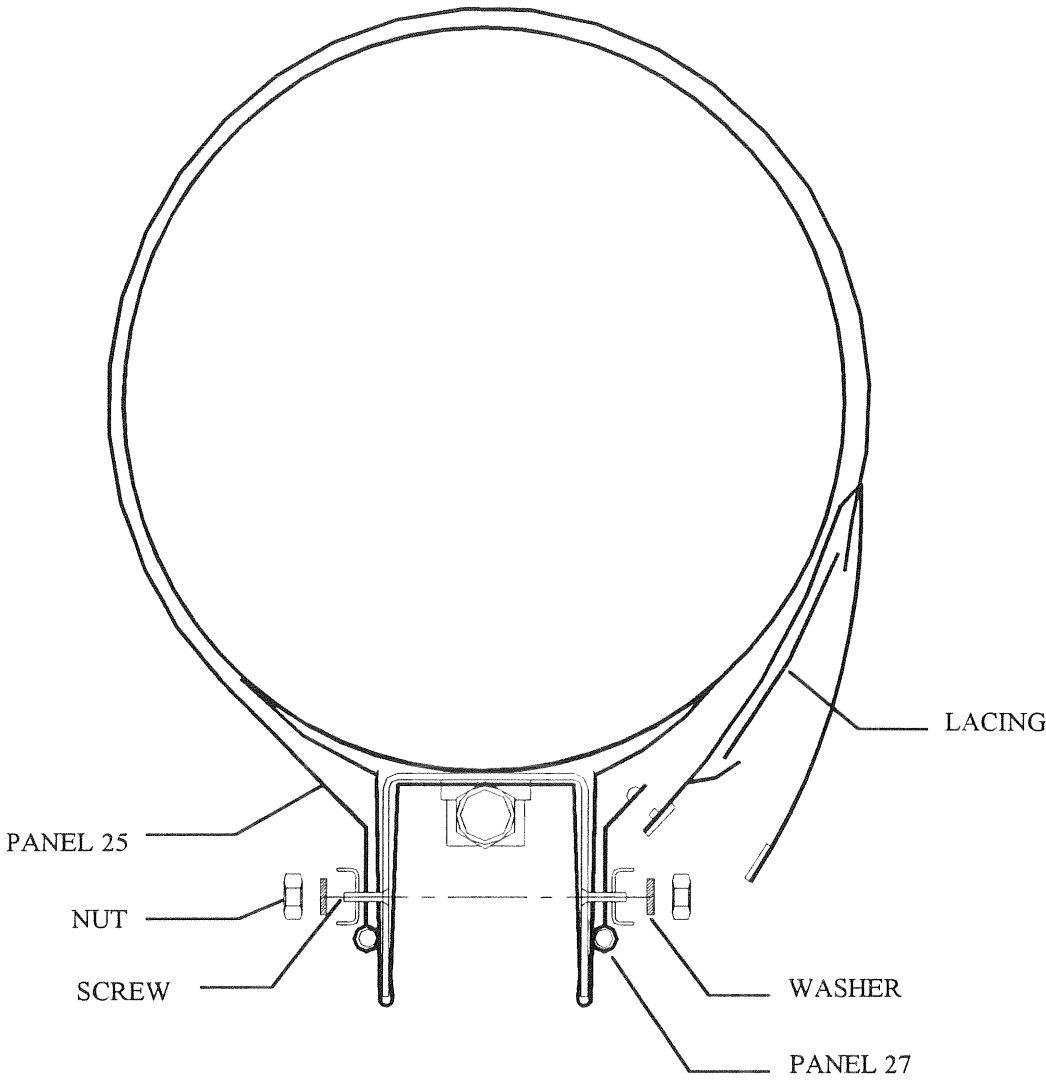


Figure D

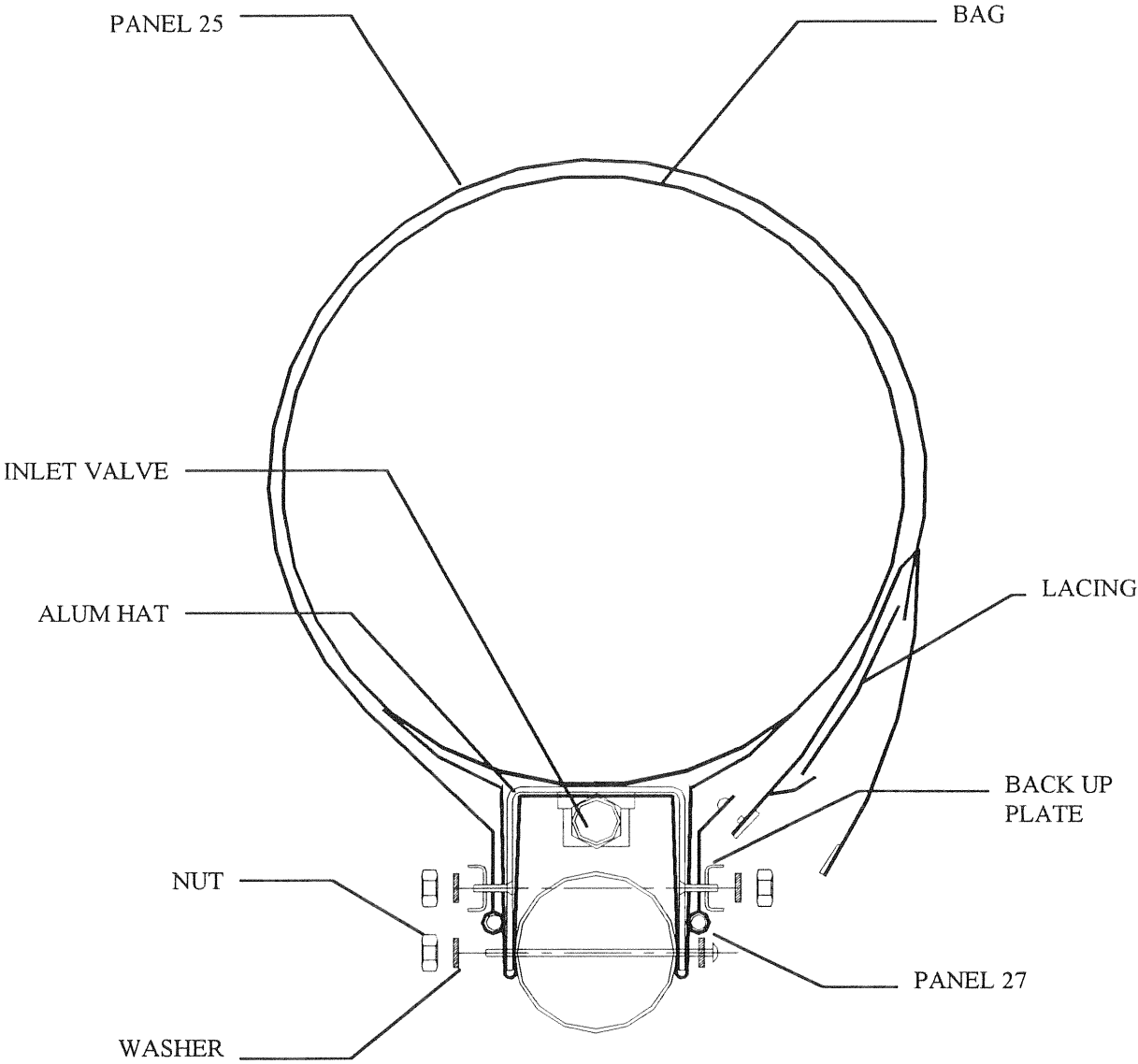
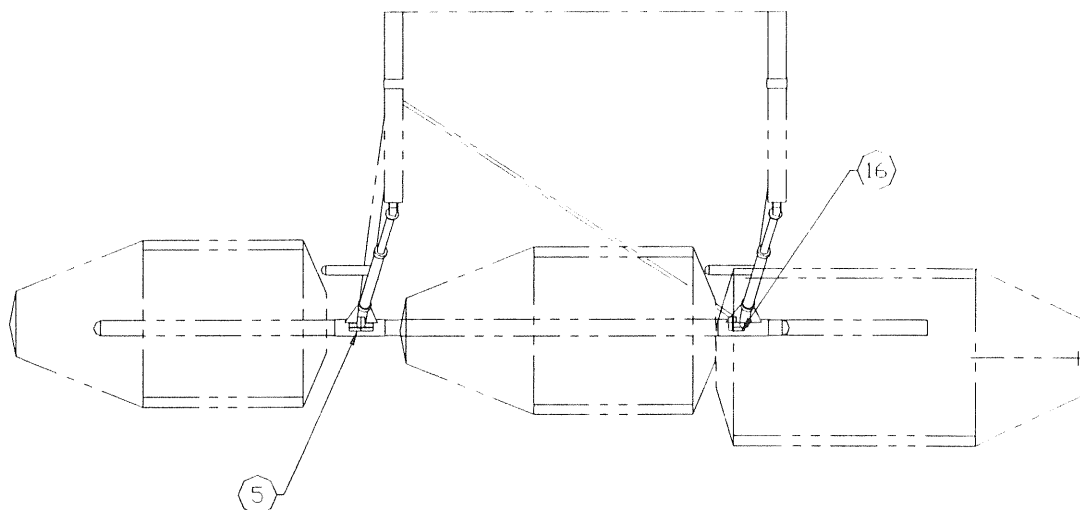


Figure E



HOSE AND FITTING CONFIGURATION

Figure F

- 11) Attach the hoses to the Tee fitting which is connected to the cylinder (Figure F). Tighten to the torque values specified on Table 1.

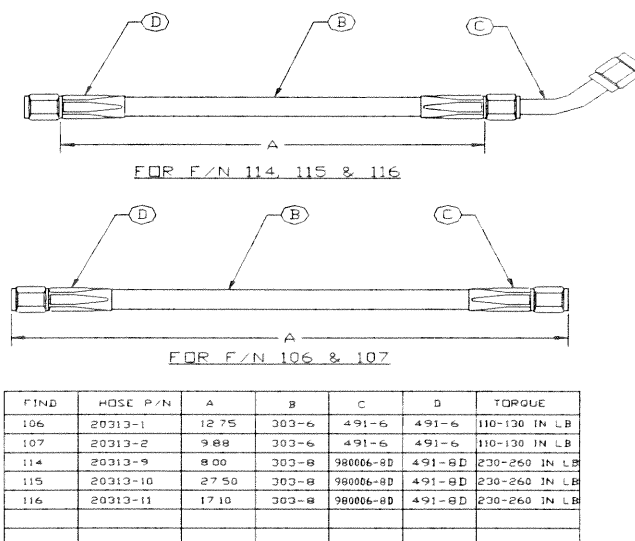
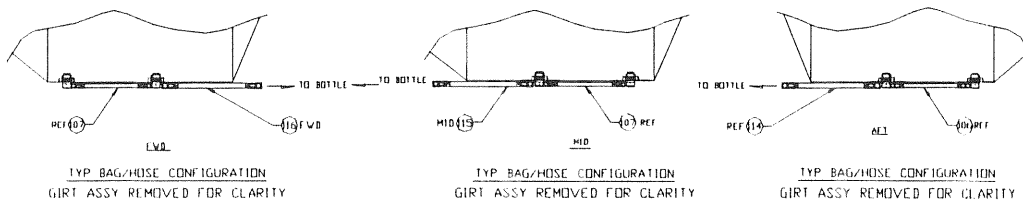
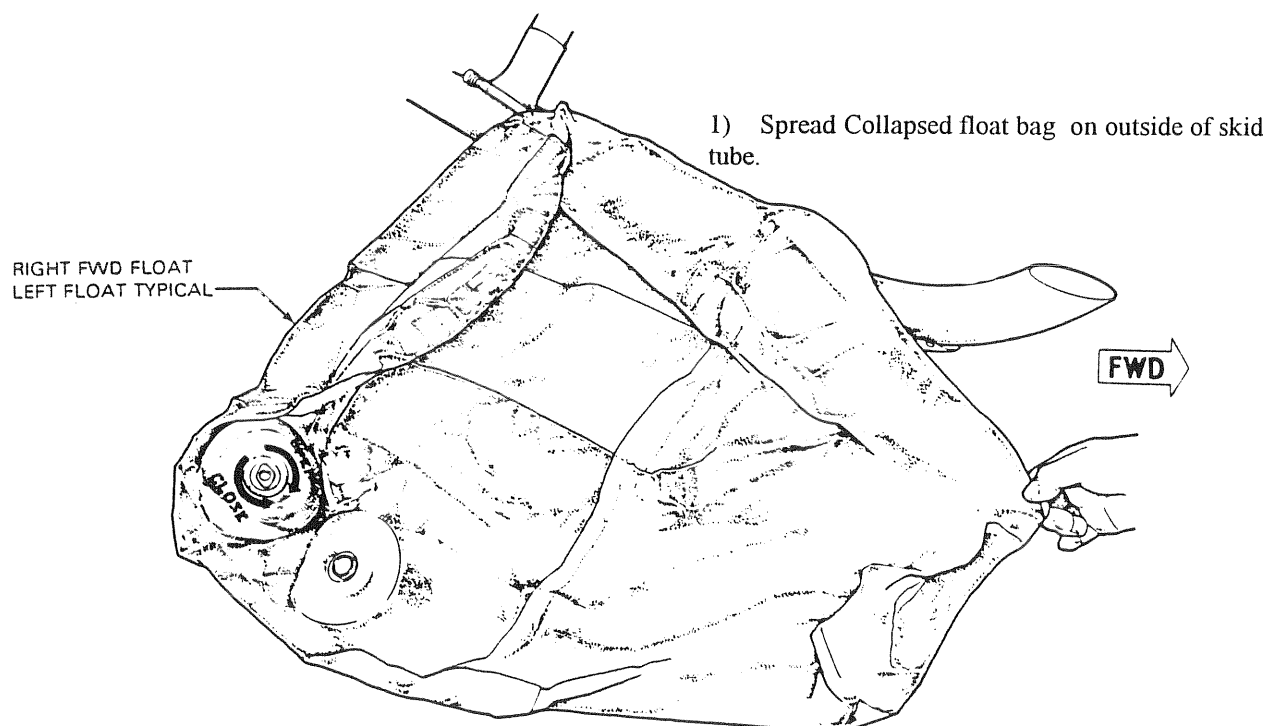


Table 1



Enstrom Float Packing Instructions

- 1) After the float is attached to the girt and the hoses are connected, spread collapsed float on outside of skid tube.
- 2) Vacuum down each chamber of the float for 15 minutes so as to get out as much of the air as possible. Place 4" diameter discs of scrap fabric over PRV valves as anti-chafing pads. Use two 2" strips of electric tape to hold each pad in place.
- 3) Lightly talc the entire float as well as the inside of the covers.
- 4) Fold the front end of the float back until the fold line reaches the girt, then fold it forward again until the front end cap lines up with the front end of the girt.
- 5) Roll the float from the outer edge toward the skid tube as tightly as possible.
- 6) Hold the float on top of the skid tube, and install the cover around the bag.
- 7) Secure the inside hook fasteners and snap fasteners on cover to corresponding pile and snap fasteners on girt on the outboard side.
- 8) Install lacing cord through the grommets in the cover using crossover method, and pull taut and tie to close gap in cover. It will take several tightenings to get the float as firmly packed as possible.
- 9) Tuck in loose ends of lacing cord, close out side hook and pile fasteners along length of cover, and close end flaps with hook and pile fasteners.

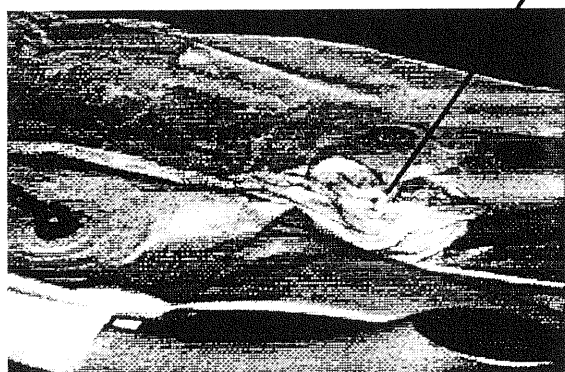




FLOAT

TOPPING
VALVE

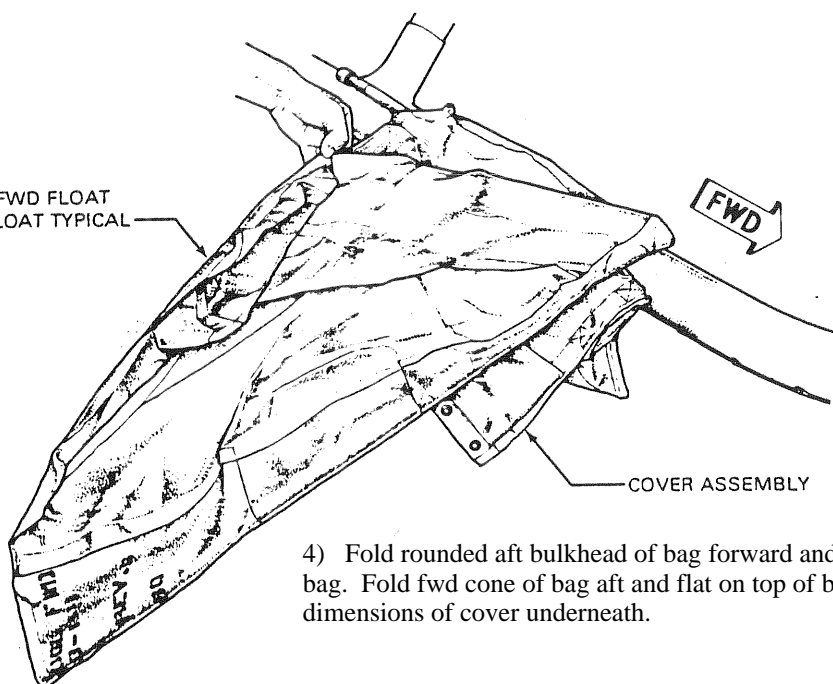
- 2) Vacuum down each chamber of the float for 15 minutes so to get out as much of the air as possible.



TALC RAG

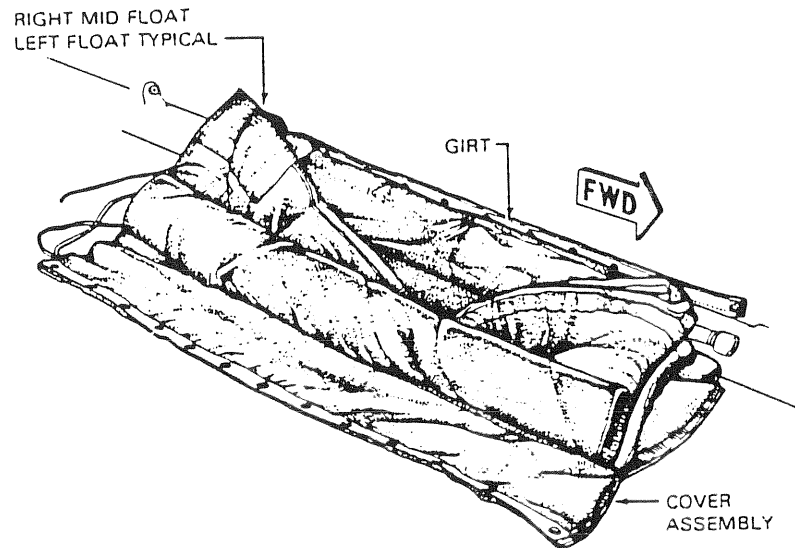
- 3) Lightly talc the entire float as well as the inside of the covers.

RIGHT FWD FLOAT
LEFT FLOAT TYPICAL

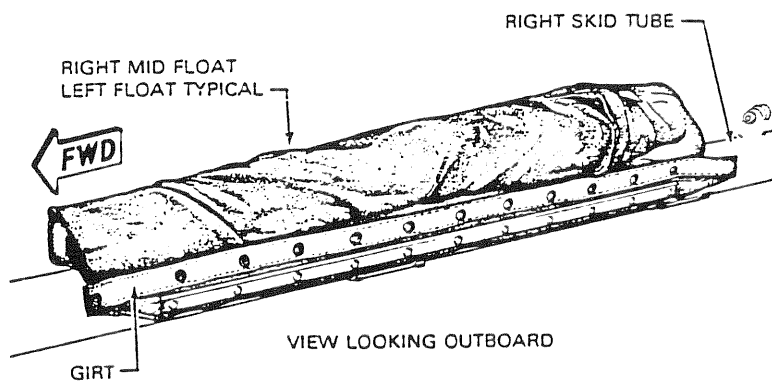


COVER ASSEMBLY

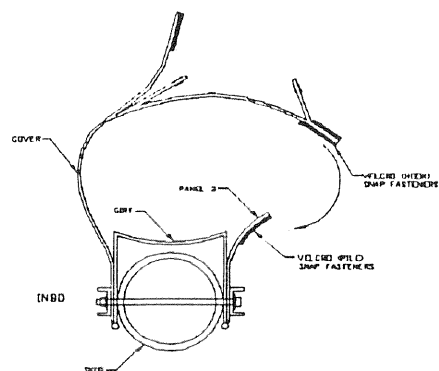
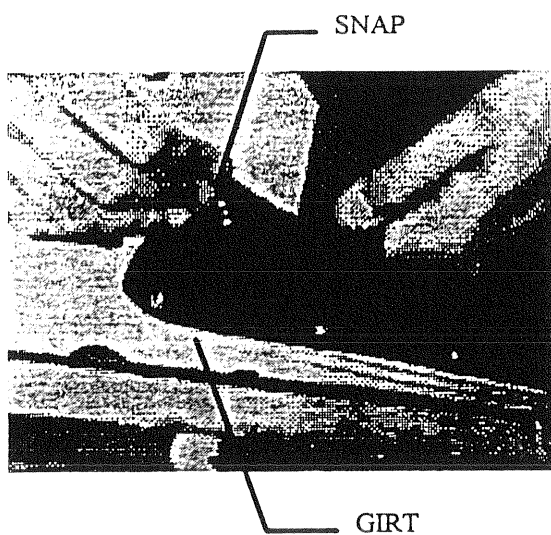
- 4) Fold rounded aft bulkhead of bag forward and flat on top of bag. Fold fwd cone of bag aft and flat on top of bag within dimensions of cover underneath.



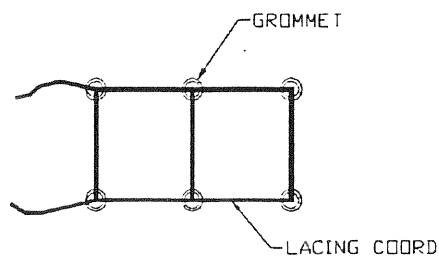
- 5) Roll the float from the outer edge toward the skid tube as tightly as possible.



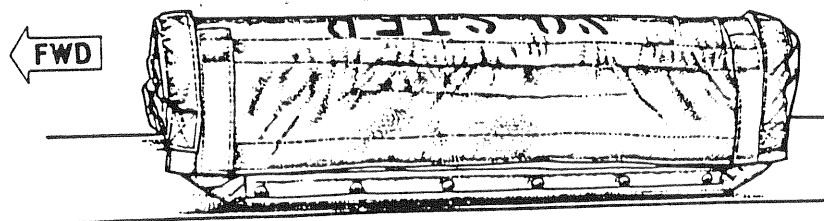
- 6) Hold the float on top of the skid tube, and install the cover around the bag.



- 7) Secure the inside hook fasteners and snap fasteners on cover to corresponding pile and snap fasteners on panel 3.



- 8) Install lacing cord in cover , using crossover method, and pull taut and tie to close gap in cover.



- 9) Tuck in loose ends of lacing cord , close out side hook and pile fasteners along length of cover, and close end flaps with hook and pile fasteners.