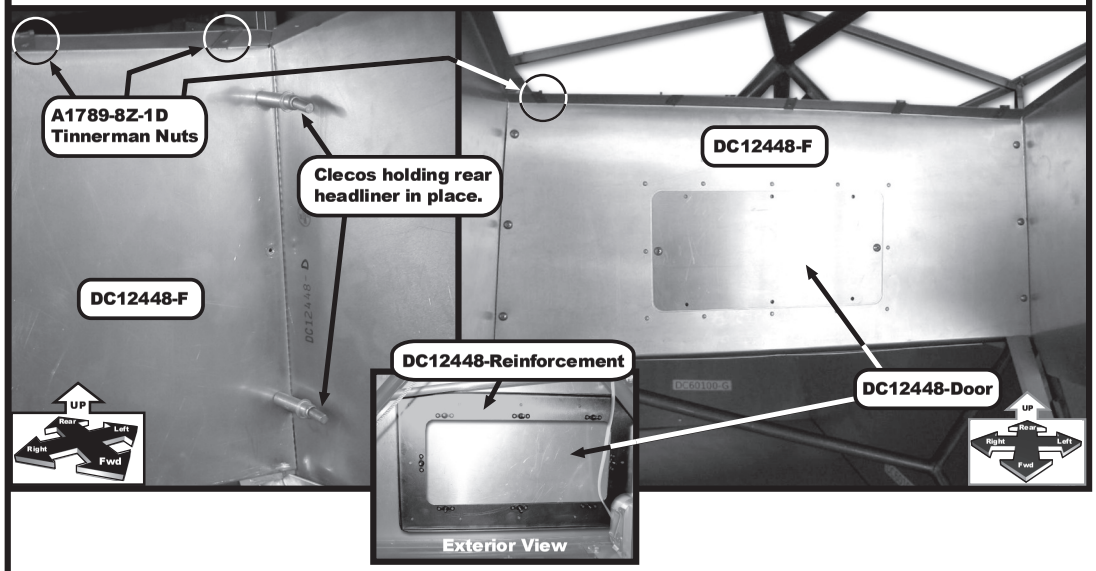
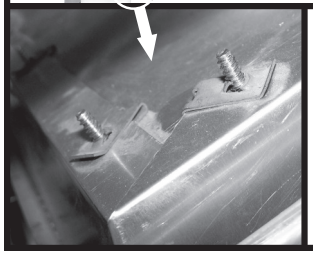
Step Three

With the side headliners secured, place the rear headliner and drill all attach holes with a 1/4" drill. Use Clecos to hold it in position until the screws are inserted, as noted previously in Step Two. Place A1789-8Z-1D Tinnerman Nuts on top edge of rear headliner after drilling holes with a 1/4" drill.



Step Four

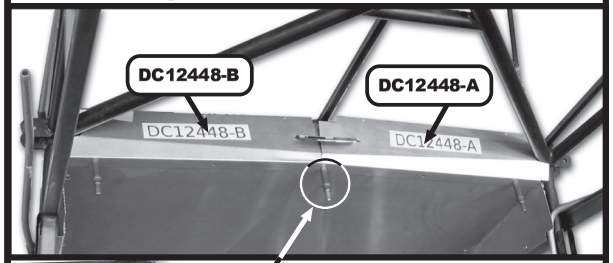
Before placing headliner top, drill all holes with 1/4" drill. Then, place headliner top and use Clecos to temporarily secure the panel. Start screws in all open holes, and then remove Clecos and insert remaining screws.

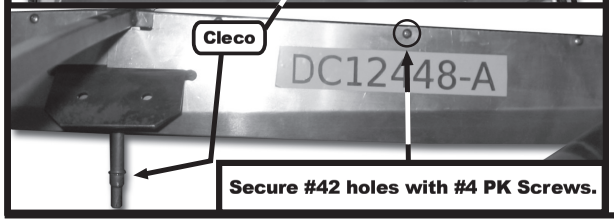


Exterior View of A1789-8Z-1D Tinnerman application for top, rear, and side headliner panel installation upon completion.

Step Five

When installing DC12448-A and DC12448-B, Cleco the bottom holes to the top headliner (as shown below). Clamp the top edge of the panel using spring clamps. Drill three #42 holes evenly spaced across top edge of both DC12448-A and DC12448B, making certain to hit the fuselage channel.





COMPLETE ASSEMBLY

SUPER 18

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10				
9				
8	DC12448-H	1		Headliner - Strip, LH
7	DC12448-G	1		Headliner - Strip, RH
6	DC12448-F	1		Headliner - Rear Panel
5	DC12448-E	1		Headliner - Window Right
4	DC12448-D	1		Headliner - Window Left
3	DC12448-C	1		Headliner - Top Panel
2	DC12448-B	1		Headliner - Top Right Front
1	DC12448-A	1		Headliner - Top Left Front
ITEM	Part No.	No. Req.	Size / Material	Description

DIRECTION OF FLIGHT INDICATOR

MFG PRACTICES / DCA GENERAL MECHANICAL - 1

ALL DATA PROPRIETARY TO DAKOTA CUB AIRCRAFT

Unless Otherwise Specified Tolerances - Angles = ±2° Fractions = ±1/32 .0 = ±.032 .00 = ±.020 .000 = ±.010

LET	REVISION	DATE	BY

DAKOTA CUB AIRCRAFT Box 797 Brandon, SD

Scale: 1=1

MFG Practices - DCA Spec. No. 9 - Finish - DCA Spec. No. 10

Headliner Assembly - Installation

DWG.	MDE	Check	MDE	Drawing No.
DATE	2-18-05	DATE	2-18-05	DC12448-INST