TEMPORARY REVISION

Manual: **Owner's Manual (INSTRUCTIONS FOR CONTINUED AIRWORTHINESS) P/N 6AB1WNM-2-8 (INSTALLATION MANUAL, MAINTENANCE MANUAL AND ILLUSTRATED PARTS BREAKDOWN)**

First Issue: 02 August 2006

Revision AB: 12 November 2021

TR 2022-001: 14 February 2022

INSTRUCTIONS

1. Before adding present change be sure that manual is valid.
   Check existing List of Effective Page of the manual to be sure that all previous revisions are inserted.
   (Do not insert this change if previous revisions are not inserted).

2. Insert this page before the LOEP.

3. Insert present change removing pages superseded and insert new pages as listed:

Temporary Revision

Number/ Data	Section/Appendix	Page	Page Revision
* TR 2021-002 / 14th February 2022	**APPENDIX Q**		
	SECTION 02	2-41	Rev.O
	SECTION 02	2-42	TR-2022-001
	SECTION 02	2-45	Rev.O
	SECTION 02	2-46	TR-2022-001
	APPENDIX U		
	SECTION 02	2-39	TR-2022-001
	SECTION 02	2-40	Rev.V
	SECTION 02	2-43	TR-2022-001
	SECTION 02	2-44	Rev.V
	SECTION 02	2-59	TR-2022-001
	SECTION 02	2-60	Rev.V
	APPENDIX X		
	SECTION 02	2-35	TR-202-001
	SECTION 02	2-36	Rev.Y
	SECTION 02	2-39	TR-2022-001
	SECTION 02	2-40	Rev.Y
	SECTION 02	2-55	TR-2022-001
	SECTION 02	2-56	Rev.Y
	APPENDIX Z		
	SECTION 02	2-35	TR-2022-001
	SECTION 02	2-36	Rev.Z
	SECTION 02	2-39	TR-2022-001
	SECTION 02	2-40	Rev.Z
	SECTION 02	2-55	TR-2022-001
	SECTION 02	2-56	Rev.Z

* Shows the last issued Temporary Revision

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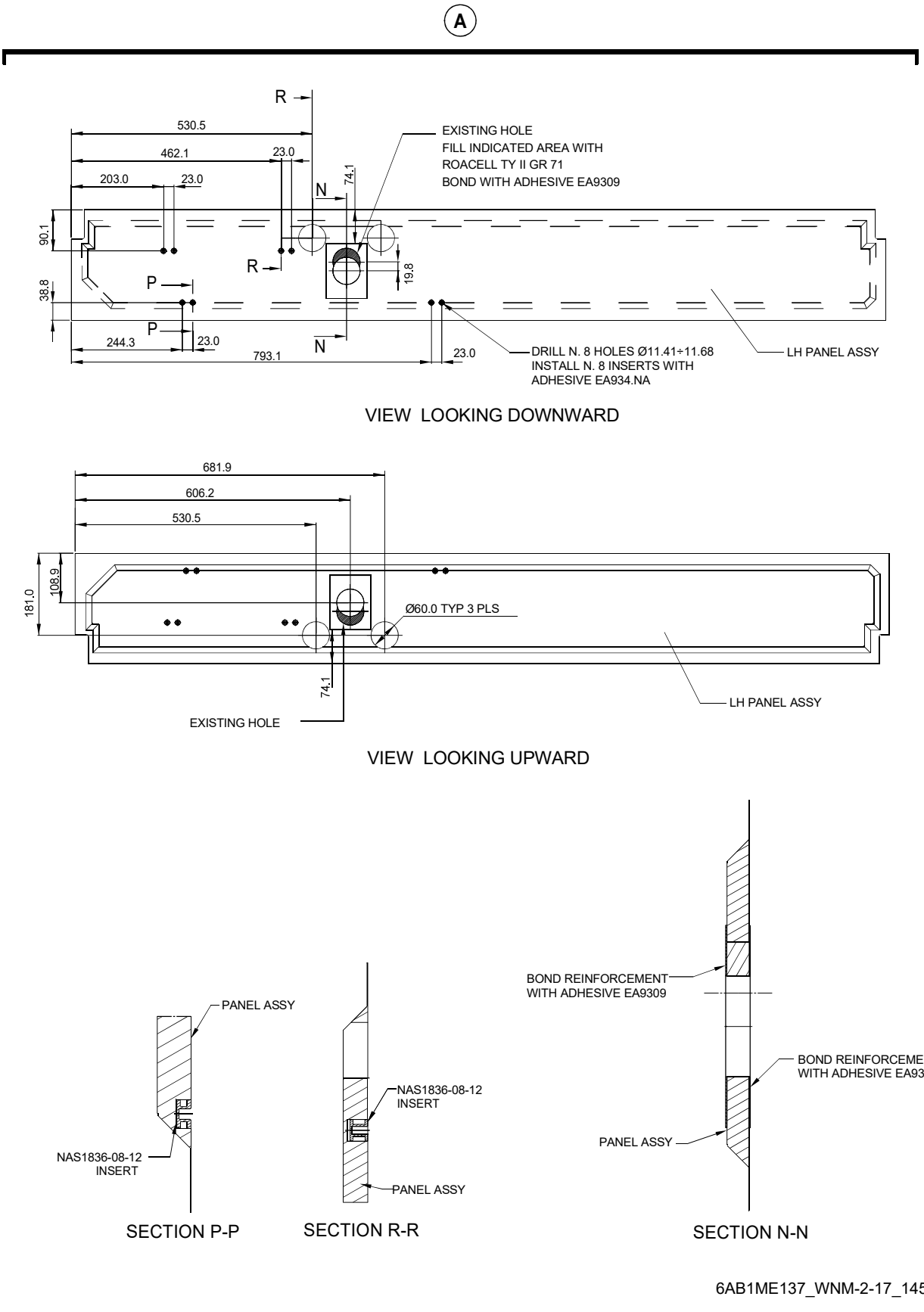


Figure 2-10 Ceiling lower cover modification (Sheet 2 of 2).

2 - 15 [A][C] STRUCTURE SOUNDPROOFING INSTALLATION

2 - 15 - 1 GENERAL

The cabin noise and vibration reduction system called "SILENS" (short for Speech Interference Level ENhanced System) is able to dramatically improve passenger comfort, reducing noise levels and distribution in all flight conditions. The system minimizes cabin noise and vibration levels using a self-supported separation barrier between the passenger cabin and the fuselage, allowing normal conversations between passengers without using headsets.
The "SILENS" System Liners kit installation requires the installation of several layers of soundproofing materials:

- Damping materials: ADC006, ADC322.
- Soundproofing materials (A199FOIL, Lead).
- Acoustic insulation materials (ECOZEROF).

The cabin soundproofing shall be accomplished by stacking coats of materials on helicopter cabin structure.

2 - 15 - 2 LIGHTENING HOLE SOUNDPROOFING INSTALLATION

Table 2-8. Supplies.

DESCRIPTION	SPECIFICATION	Q.ty
Aluminium adhesive tape 3M 363 (50 Height)	6SPEC-033-PRD	AR

NOTE

Apply Aluminium adhesive tape (25 high) on the A199FOIL piece boundaries in order to have proper fixing of the piece to the helicopter structure.

1. Apply A199FOIL piece (3, Figure 2-11) to both right and the left brackets, according to the lightening holes (see detail B).
2. Install No. 5 pieces (2) to the lightening holes of wall STA 3120 as indicated in detail A.
3. Install No. 5 pieces (1) to the wall STA 3120 lightening holes according to detail A.
4. Apply No. 2 A199FOIL pieces (4) to the frame STA 3900 according to the lightening holes (see detail C).
5. Apply No. 2 A199FOIL pieces (3) to the frame STA 3900.
6. Apply No. 10 A199FOIL pieces (4) to the LH and the RH frame STA 3900 according to the lightening holes.
7. Apply A199FOIL pieces (4, 2,6) on lightening holes of RH and LH walls BL 800, as shown in detail D and detail E.

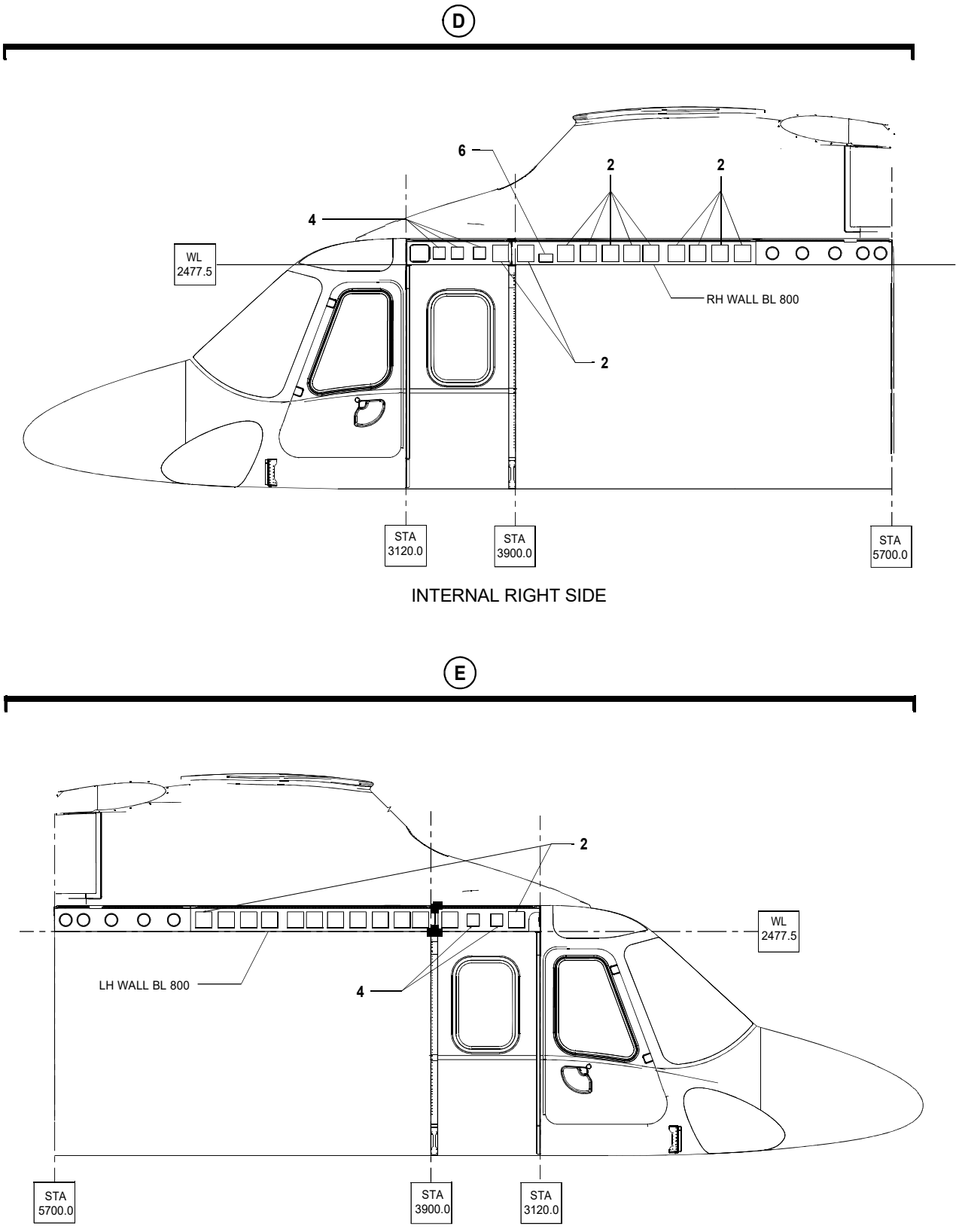


Figure 2-11 Soundproofing installation (Sheet 3 of 3).

2 - 15 - 3 UPPER DOOR CAVITY SOUNDPROOFING INSTALLATION

2 - 15 - 3 - 1 Upper door cavity soundproofing installation instructions

Table 2-9. Supplies.

DESCRIPTION	SPECIFICATION	Q.ty
Adhesive Trinchero 2015-E	—	AR
Aluminium adhesive tape 3M 363 (50 Height)	6SPEC-033-PRD	AR

CAUTION

ADC006 Damping pieces shall be completely adherent to the surface to be treated in order to have maximum damping effect. It shall not have air bubbles.

NOTE

The ADC006 and SIRA200 damping material is self-adhesive.

NOTE

In order to ensure a strong fixation of soundproofing apply aluminium adhesive tape along A199FOIL boundaries.

NOTE

The following soundproofing installation procedure is valid for both right and left upper door frame.

1. Apply the ADC006 damping piece (5, 6 of Figure 2-12) onto upper door frame assy (7, 8) as indicated in section B-B and section C-C.
2. Apply the panel (7, 8) to the structure with adhesive Trinchero 2015-E.
3. Install the lead (3, 4) on the ADC006 damping piece (5, 6).
4. Apply the ADC006 damping pieces (27, 28 of section F-F) on the lateral door structure.
5. Apply the ADC006 damping pieces (9, 10 of section C-C) on the lateral door structure.
6. Apply the SIRA200 piece (11 of section C-C) on ADC006 damping pieces (27, 28 of section F-F).
7. Bond the A199FOIL (14 of section C-C) on the ECOZEROF panels (12, 13 of section C-C) and on the ECOZEROF lower panels (29, 30 of section F-F) with aluminium adhesive tape.
8. Bond the ECOZEROF panels (12, 13, 29, 30) to the ADC006 pieces with Trinchero 2015-E.
9. Apply the ADC006 frame LH (19, 20 of section G-G).
10. Pre assemble the upper soundproofing door panel assy (15, 16) of section E-E as follows, bonding ECOZEROF panels, A199FOIL and a layer of Trinchero 2015-E.
11. Bond the assembly (15, 16) to the upper structure with Trinchero 2015-E.
12. Pre assemble the upper soundproofing door panel assy (21, 21) of section E-E as follows, bonding ECOZEROF panels, A199FOIL and a layer of Trinchero 2015-E.
13. Bond the assembly (21, 22) to the upper structure with Trinchero 2015-E.
14. Install the A199FOIL (18 of section D-D) and the lead (17 of section D-D).

2 - 15 STRUCTURE SOUNDPROOFING INSTALLATION

2 - 15 - 1 GENERAL

The cabin noise and vibration reduction system called "SILENS" (short for Speech Interference Level ENhanced System) is able to dramatically improve passenger comfort, reducing noise levels and distribution in all flight conditions. The system minimizes cabin noise and vibration levels using a self-supported separation barrier between the passenger cabin and the fuselage, allowing normal conversations between passengers without using headsets.
The "SILENS" System Liners kit installation requires the installation of several layers of soundproofing materials:

- Damping materials: ADC006, ADC322.
- Soundproofing materials (A199FOIL, Lead).
- Acoustic insulation materials (ECOZEROF).

The cabin soundproofing must be accomplished by stacking coats of materials on helicopter cabin structure.

2 - 15 - 2 LIGHTENING HOLE SOUNDPROOFING INSTALLATION

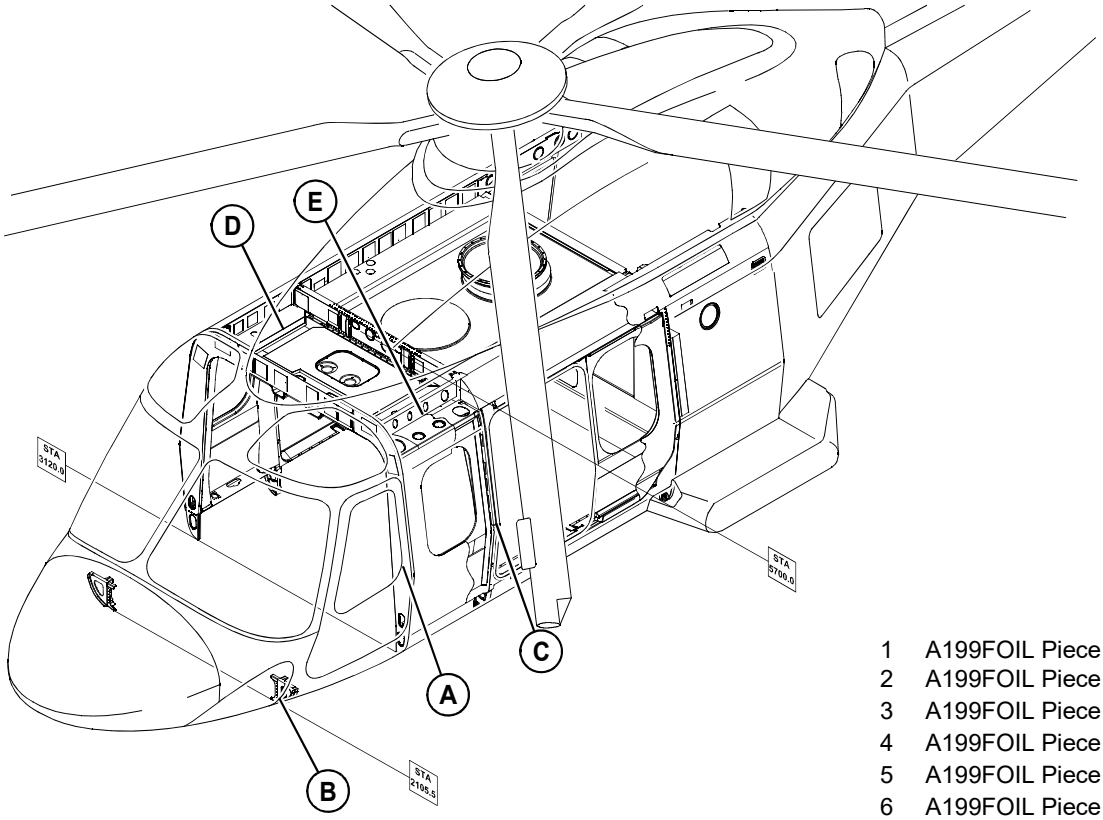
Table 2-6. Supplies.

DESCRIPTION	SPECIFICATION	Q.ty
Aluminium adhesive tape 3M 363 (50 Height)	6SPEC-033-PRD	AR

NOTE

Apply Aluminium adhesive tape (25 high) on the A199FOIL piece boundaries in order to have proper fixing of the piece to the helicopter structure.

1. Apply A199FOIL piece (3, Figure 2-11) to both right and the left brackets, according to the lightening holes (see detail B).
2. Install No. 5 pieces (2) to the lightening holes of wall STA 3120 as indicated in detail A.
3. Install No. 5 pieces (1) to the wall STA 3120 lightening holes according to detail A.
4. Apply No. 2 A199FOIL pieces (4) to the frame STA 3900 according to the lightening holes (see detail C).
5. Apply No. 2 A199FOIL pieces (3) to the frame STA 3900.
6. Apply No. 10 A199FOIL pieces (4) to the LH and the RH frame STA 3900 according to the lightening holes.
7. Apply A199FOIL pieces (4, 2,6) on lightening holes of RH and LH walls BL 800, as shown in detail D and detail E.



1 A199FOIL Piece
2 A199FOIL Piece
3 A199FOIL Piece
4 A199FOIL Piece
5 A199FOIL Piece
6 A199FOIL Piece

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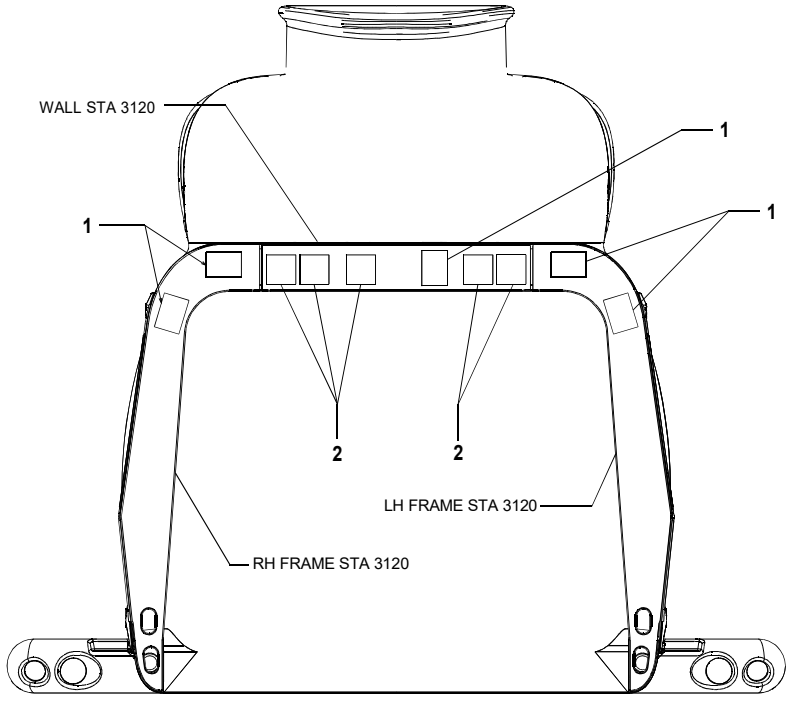

VIEW LOOKING AFTWARD

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Figure 2-11 Soundproofing lightening hole installation (Sheet 1 of 3).

2 - 15 - 3 UPPER DOOR CAVITY SOUNDPROOFING INSTALLATION

2 - 15 - 3 - 1 Upper door cavity soundproofing installation instructions

Table 2-7. Supplies.

DESCRIPTION	SPECIFICATION	Q.ty
Adhesive Trinchero	6SPEC-036-PRD TY II	AR
Aluminium adhesive tape 3M 363 (50 Height) (If required)	6SPEC-033-PRD	AR

CAUTION

ADC006 Damping pieces must be completely adherent to the surface to be treated in order to have maximum damping effect. It must not have air bubbles.

NOTE

The ADC006 and SIRA200 damping material is self-adhesive.

NOTE

In order to ensure a strong fixation of soundproofing apply aluminium adhesive tape along A199FOIL boundaries.

NOTE

The following soundproofing installation procedure is valid for both right and left upper door frame.

1. With reference to Figure 2-12 assemble fwd access door soundproofing (P/N 6AB1ME144-231/-232) as follows:
   a. Bond damping material piece (1) and barrier piece (2) to 3G5330A24151/ 3G5330A24151 (3) with Trinchero 2015-E adhesive.
2. Assemble soundproofing aft door frame cavity assy (P/N 6AB1ME144-245/-246) as follows:
   a. Bond ECOZEROF aft door frame pieces (4, 5) and A199 FOIL (6) with Trinchero 2015-E adhesive.
6. Position and install the ADC006 aft door frame cavity assy (P/N 6AB1ME144-395/-396) on structure as shown in detail A.
7. With reference to section B-B position and install fwd access door soundproofing (P/N 6AB1ME144-231/-232) and aft door frame cavity assy (P/N 6AB1ME144-245/-246) in accordance with ADC006 aft door frame cavity assy (P/N 6AB1ME144-395/-396).

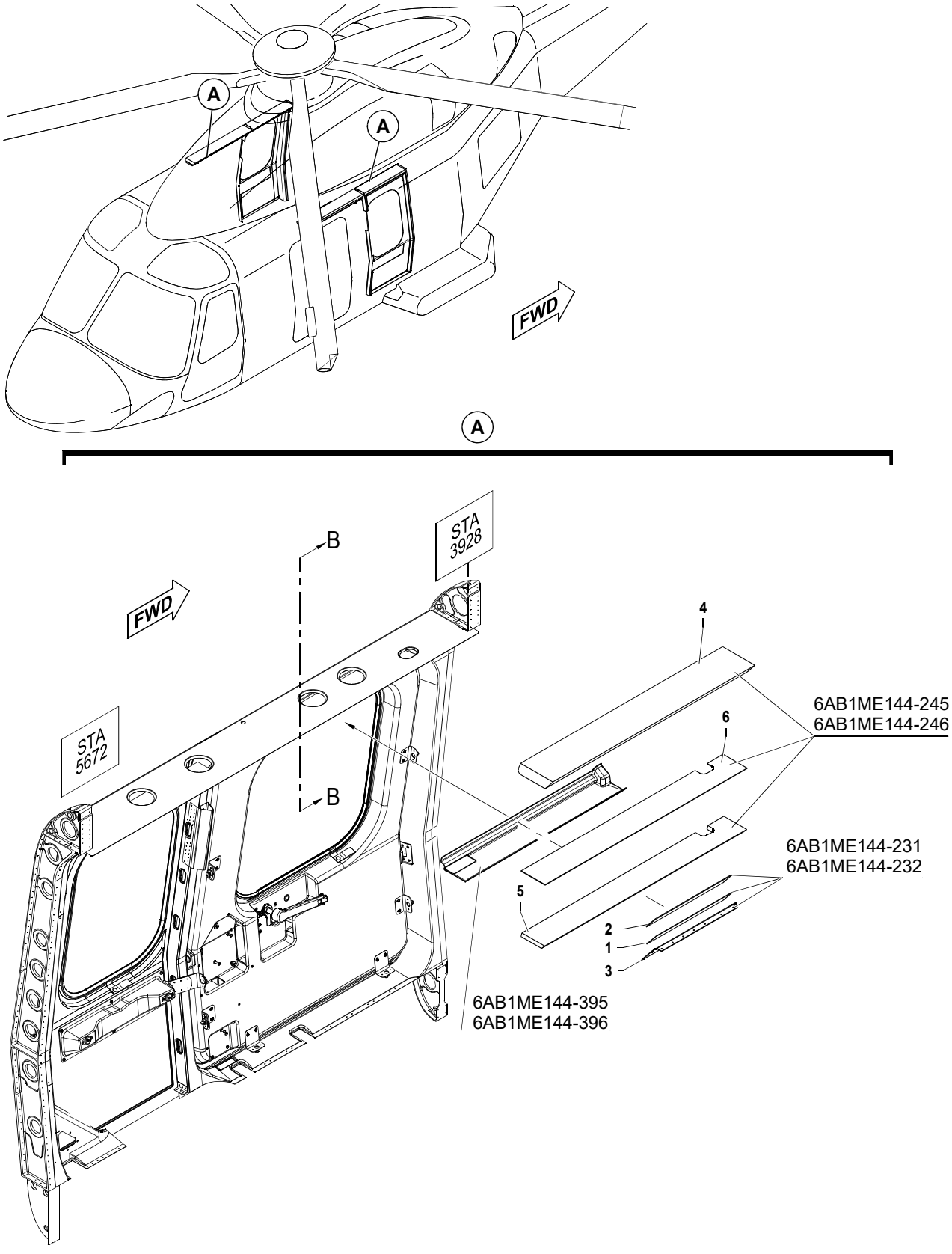

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Figure 2-12 Upper door cavity soundproofing installation (Sheet 1 of 4).

2 - 15 - 6 LATERAL WALLS SOUNDPROOFING INSTALLATION

Table 2-13. Supplies.

DESCRIPTION	SPECIFICATION	Q.ty
Trinchero Adhesive 2015-E	—	AR
BOND 7705	6SPEC-036-PRD	AR
Aluminium adhesive tape 3M 363 (50 Height)	6SPEC-033-PRD	AR

CAUTION

ADC006 damping pieces must be completely adherent to the surface to be treated in order to have maximum damping effect. It must not have air bubbles.

NOTE

The following soundproofing installation procedure is valid for both right and left lateral walls structure.

NOTE

In order to ensure a strong fixation of soundproofing apply aluminium adhesive tape along A199FOIL boundaries and lead pieces edges.

NOTE

Acoustic barrier pieces must be bonded to damping material pieces with 6SPEC-036-PRD "BOND 7705" adhesive.

NOTE

The ADC006 damping material is self-adhesive.

2. Perform soundproofing of access door assy applying ADC006 pieces (1, Figure 2-15) and lead (2) as indicated. See detail B.
3. Apply ADC006 door frame piece (3) with lead (4) on side wall. See detail B.
4. Apply ADC322 LH side wall piece of soundproofing as shown in detail C.
5. Apply LH hydraulic pipes soundproofing piece (6) as shown in detail D.
6. With reference to detail E bond LH A199 FOIL (8) to LH ADC332 piece (9) using BOND 7705 as follows:
   a. Add diluent, MAG code "020100000302", at the rate of 5% minimum;

   NOTE

   Spray using cup spray gun, pump or double membrane pump or submersion pump.

   b. Apply it with a spray gun having 1,8/2,0 nozzle diameter and air pressure not lower than 4/5 atm;
   c. Make sure that materials to be bonded are free from dust traces or residuals of other workings;
   d. In presence of metal sheets it is recommended to degrease;
   e. Spray at about 50 cm distance a uniform thin coat of adhesive on both supports;

   NOTE

   Bonding must be considered as completed only after 48 hour.

   f. Wait about 15 minutes until solvent evaporates, then join together the two parts applying pressure;
7. Bond A199 FOIL (28) to ADC332 (27) as per steps a. thru g. above. See detail E.

8. Apply LH enveloped blanket assy (7) to structure with velcro strips in accordance with 6SPEC-087-PRC, procedure B.
9. With reference to detail F bond A199 FOIL (15) to ADC332 (14) with BOND 7705 adhesive as per steps a. thru g. above and apply to upper door frame as shown.
10. Apply ADC332 piece (10).
11. Bond Enveloped blanket assy (11) with velcro strips in accordance with 6SPEC-087-PRC, procedure B.
12. Apply ADC332 piece (12).
13. Apply damping material (13) to frame structure.
14. With reference to detail G, apply ADC332 piece (17) on door structure.
15. Bond enveloped blanket assy (16) to ADC332 piece (17) with velcro strips in accordance with 6SPEC-087-PRC, procedure B.
16. Apply enveloped blanket assy pieces (18, 19, 20) with velcro strips in accordance with 6SPEC-087-PRC, procedure B.
17. With reference to detail H, bond acoustic barrier (21) to damping material (22) and apply to 3G5330A54831 structure.
18. Bond acoustic barrier (23) to damping material (24) and apply to 3G5330A54631 structure.
19. With reference to detail J apply damping material pieces (25, 26) as shown.

2 - 15 - 7 STRUCTURE CAVITY SOUNDPROOFING INSTALLATION

Table 2-14. Supplies.

DESCRIPTION	SPECIFICATION	Q.ty
Adhesive Trinchero	6SPEC-036-PRD TY II	AR

NOTE

The following soundproofing installation procedure is valid for both right and left structure cavity.

1. Gain access to the passengers compartment.
2. Fill the cavity with ECOZEROF as indicated in Figure 2-16, view A, from section B-B through section E-E.

2 - 14 STRUCTURE SOUNDPROOFING INSTALLATION

2 - 14 - 1 GENERAL

The cabin noise and vibration reduction system called "SILENS" (short for Speech Interference Level ENhanced System) is able to dramatically improve passenger comfort, reducing noise levels and distribution in all flight conditions. The system minimizes cabin noise and vibration levels using a self-supported separation barrier between the passenger cabin and the fuselage, allowing normal conversations between passengers without using headsets.
The "SILENS" System Liners kit installation requires the installation of several layers of soundproofing materials:

- Damping materials: ADC006, ADC322.
- Soundproofing materials (A199FOIL, Lead).
- Acoustic insulation materials (ECOZEROF).

The cabin soundproofing must be accomplished by stacking coats of materials on helicopter cabin structure.

2 - 14 - 2 LIGHTENING HOLE SOUNDPROOFING INSTALLATION

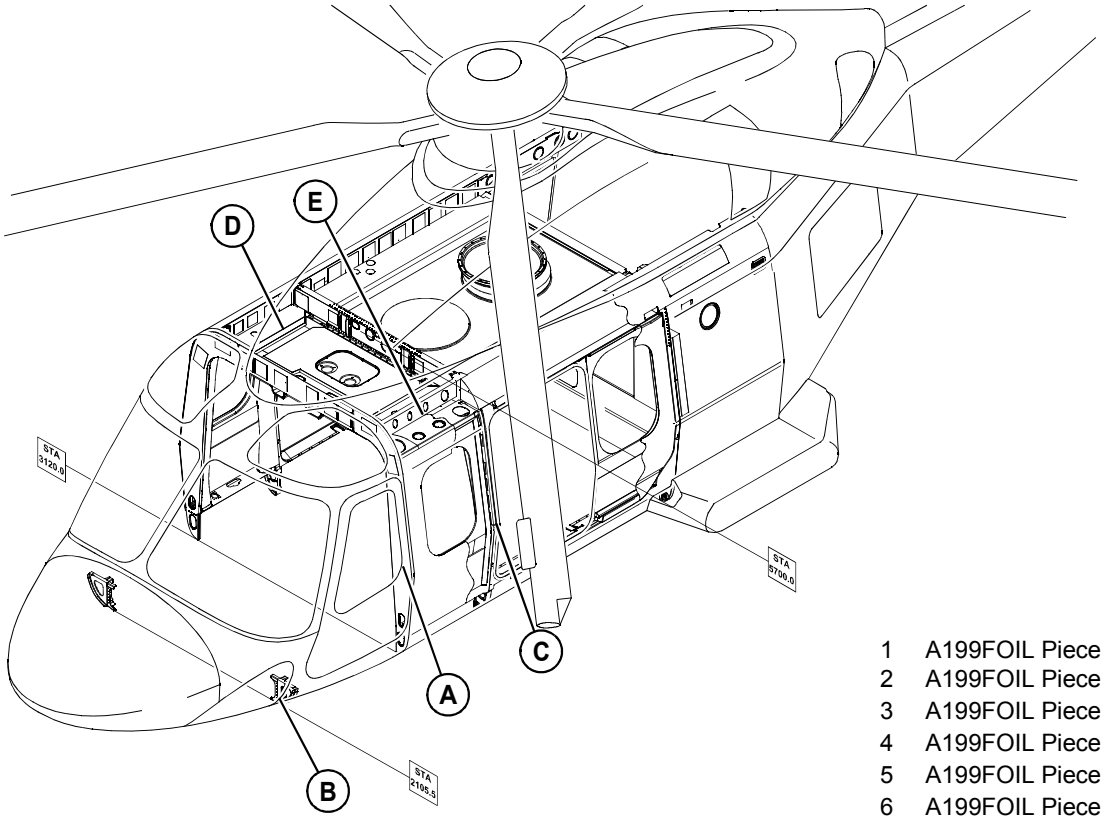
Table 2-4. Supplies.

DESCRIPTION	SPECIFICATION	Q.ty
Aluminium adhesive tape 3M 363 (50 Height)	6SPEC-033-PRD	AR

NOTE

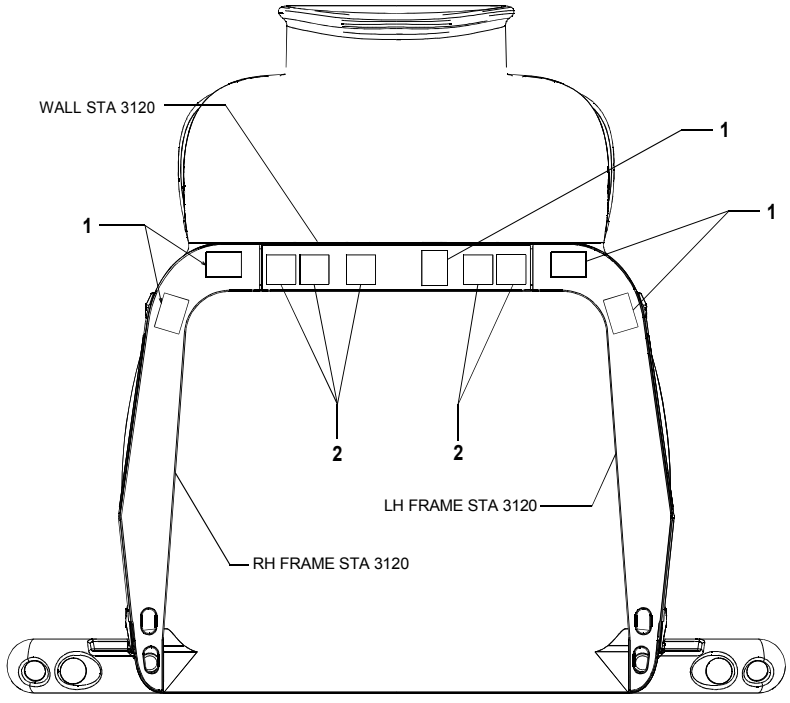
Apply Aluminium adhesive tape (25 high) on the A199FOIL piece boundaries in order to have proper fixing of the piece to the helicopter structure.

1. Apply A199FOIL piece (3, Figure 2-10) to both right and the left brackets, according to the lightening holes (see detail B).
2. Install No. 5 pieces (2) to the lightening holes of wall STA 3120 as indicated in detail A.
3. Install No. 5 pieces (1) to the wall STA 3120 lightening holes according to detail A.
4. Apply No. 2 A199FOIL pieces (4) to the frame STA 3900 according to the lightening holes (see detail C).
5. Apply No. 2 A199FOIL pieces (3) to the frame STA 3900.
6. Apply No. 10 A199FOIL pieces (4) to the LH and the RH frame STA 3900 according to the lightening holes.
7. Apply A199FOIL pieces (4, 2,6) on lightening holes of RH and LH walls BL 800, as shown in detail D and detail E.



1 A199FOIL Piece
2 A199FOIL Piece
3 A199FOIL Piece
4 A199FOIL Piece
5 A199FOIL Piece
6 A199FOIL Piece

A



VIEW LOOKING AFTWARD

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Figure 2-10 Soundproofing lightening hole installation (Sheet 1 of 3).

2 - 14 - 3 UPPER DOOR CAVITY SOUNDPROOFING INSTALLATION

2 - 14 - 3 - 1 Upper door cavity soundproofing installation instructions

Table 2-5. Supplies.

DESCRIPTION	SPECIFICATION	Q.ty
Adhesive Trinchero	6SPEC-036-PRD TY II	AR
Aluminium adhesive tape 3M 363 (50 Height) (If required)	6SPEC-033-PRD	AR

CAUTION

ADC006 Damping pieces must be completely adherent to the surface to be treated in order to have maximum damping effect. It must not have air bubbles.

NOTE

The ADC006 and SIRA200 damping material is self-adhesive.

NOTE

In order to ensure a strong fixation of soundproofing apply aluminium adhesive tape along A199FOIL boundaries.

NOTE

The following soundproofing installation procedure is valid for both right and left upper door frame.

1. With reference to Figure 2-11 assemble fwd access door soundproofing (P/N 6AB1ME144-231/-232) as follows:
   a. Bond damping material piece (1) and barrier piece (2) to 3G5330A24151/ 3G5330A24151 (3) with Trinchero 2015-E adhesive.
2. Assemble soundproofing aft door frame cavity assy (P/N 6AB1ME144-245/-246) as follows:
   a. Bond ECOZEROF aft door frame pieces (4, 5) and A199 FOIL (6) with Trinchero 2015-E adhesive.
7. Position and install the ADC006 aft door frame cavity assy (P/N 6AB1ME144-395/-396) on structure as shown in detail A.
8. With reference to section B-B position and install fwd access door soundproofing (P/N 6AB1ME144-231/-232) and aft door frame cavity assy (P/N 6AB1ME144-245/-246) in accordance with ADC006 aft door frame cavity assy (P/N 6AB1ME144-395/-396).

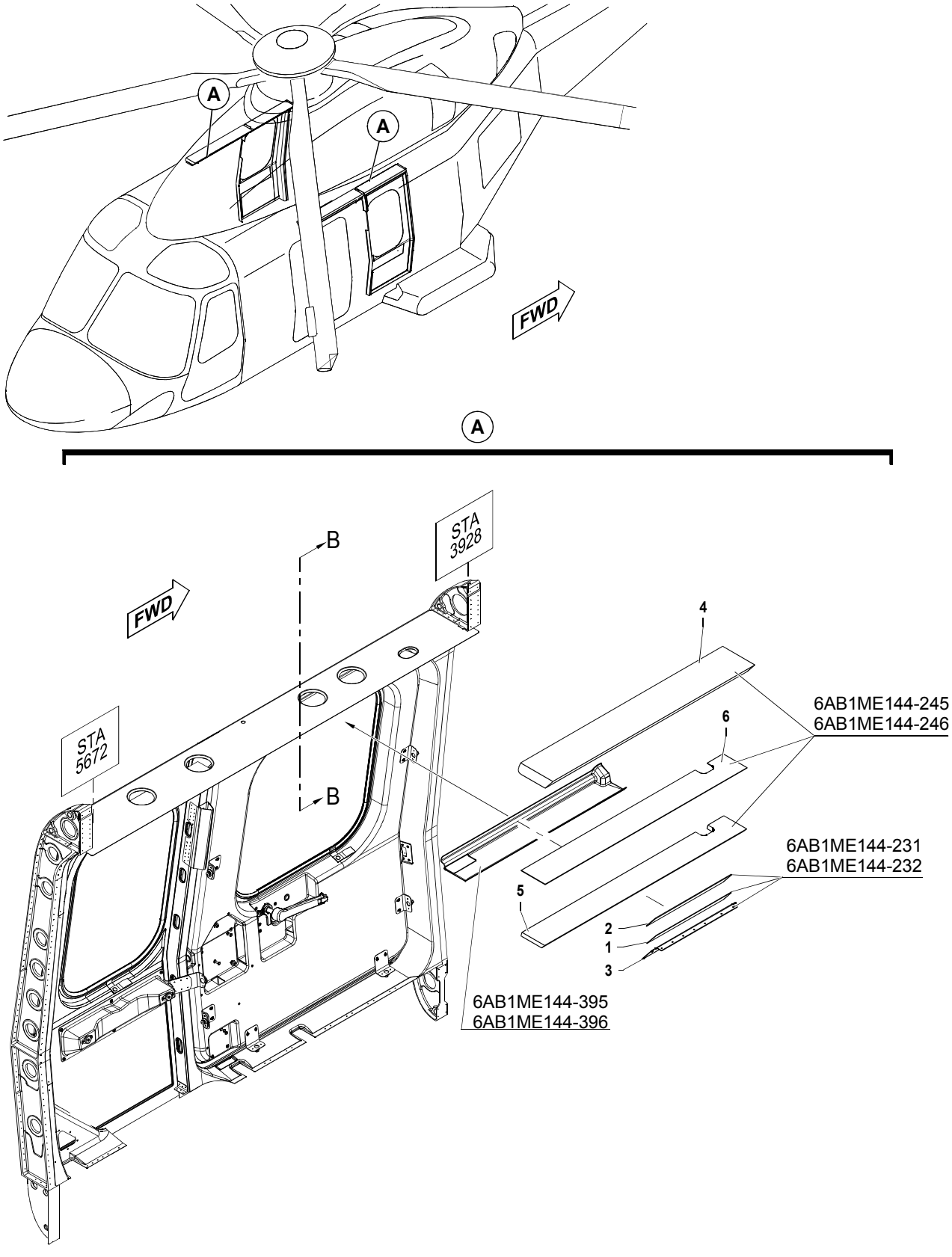


Figure 2-11 Upper door cavity soundproofing installation (Sheet 1 of 4).

2 - 14 - 6 LATERAL WALLS SOUNDPROOFING INSTALLATION

Table 2-11. Supplies.

DESCRIPTION	SPECIFICATION	Q.ty
Trinchero Adhesive 2015-E	—	AR
BOND 7705	6SPEC-036-PRD	AR
Aluminium adhesive tape 3M 363 (50 Height)	6SPEC-033-PRD	AR

CAUTION

ADC006 damping pieces must be completely adherent to the surface to be treated in order to have maximum damping effect. It must not have air bubbles.

NOTE

The following soundproofing installation procedure is valid for both right and left lateral walls structure.

NOTE

In order to ensure a strong fixation of soundproofing apply aluminium adhesive tape along A199FOIL boundaries and lead pieces edges.

NOTE

Acoustic barrier pieces must be bonded to damping material pieces with 6SPEC-036-PRD "BOND 7705" adhesive.

NOTE

The ADC006 damping material is self-adhesive.

2. Perform soundproofing of access door assy applying ADC006 pieces (1, Figure 2-14) and lead (2) as indicated. See detail B.
3. Apply ADC006 door frame piece (3) with lead (4) on side wall. See detail B.
4. Apply ADC322 LH side wall piece of soundproofing as shown in detail C.
5. Apply LH hydraulic pipes soundproofing piece (6) as shown in detail D.
6. With reference to detail E bond LH A199 FOIL (8) to LH ADC332 piece (9) using BOND 7705 as follows:
   a. Add diluent, MAG code "020100000302", at the rate of 5% minimum;

      NOTE

      Spray using cup spray gun, pump or double membrane pump or submersion pump.

   b. Apply it with a spray gun having 1,8/2,0 nozzle diameter and air pressure not lower than 4/5 atm;
   c. Make sure that materials to be bonded are free from dust traces or residuals of other workings;
   d. In presence of metal sheets it is recommended to degrease;
   e. Spray at about 50 cm distance a uniform thin coat of adhesive on both supports;

      NOTE

      Bonding must be considered as completed only after 48 hour.

   f. Wait about 15 minutes until solvent evaporates, then join together the two parts applying pressure;
7. Bond A199 FOIL (28) to ADC332 (27) as per steps a. thru g. above. See detail E.

8. Apply LH enveloped blanket assy (7) to structure with velcro strips in accordance with 6SPEC-087-PRC, procedure B.
9. With reference to detail F bond A199 FOIL (15) to ADC332 (14) with BOND 7705 adhesive as per steps a. thru g. above and apply to upper door frame as shown.
10. Apply ADC332 piece (10).
11. Bond Enveloped blanket assy (11) with velcro strips in accordance with 6SPEC-087-PRC, procedure B.
12. Apply ADC332 piece (12).
13. Apply damping material (13) to frame structure.
14. With reference to detail G, apply ADC332 piece (17) on door structure.
15. Bond enveloped blanket assy (16) to ADC332 piece (17) with velcro strips in accordance with 6SPEC-087-PRC, procedure B.
16. Apply enveloped blanket assy pieces (18, 19, 20) with velcro strips in accordance with 6SPEC-087-PRC, procedure B.
17. With reference to detail H, bond acoustic barrier (21) to damping material (22) and apply to 3G5330A54831 structure.
18. Bond acoustic barrier (23) to damping material (24) and apply to 3G5330A54631 structure.
19. With reference to detail J apply damping material pieces (25, 26) as shown.

2 - 14 - 7 STRUCTURE CAVITY SOUNDPROOFING INSTALLATION

Table 2-12. Supplies.

DESCRIPTION	SPECIFICATION	Q.ty
Adhesive Trinchero	6SPEC-036-PRD TY II	AR

NOTE

The following soundproofing installation procedure is valid for both right and left structure cavity.

1. Gain access to the passengers compartment.
2. Fill the cavity with ECOZEROF as indicated in Figure 2-15, view A, from section B-B through section E-E.

2 - 14 STRUCTURE SOUNDPROOFING INSTALLATION

2 - 14 - 1 GENERAL

The cabin noise and vibration reduction system called "SILENS" (short for Speech Interference Level ENhanced System) is able to dramatically improve passenger comfort, reducing noise levels and distribution in all flight conditions. The system minimizes cabin noise and vibration levels using a self-supported separation barrier between the passenger cabin and the fuselage, allowing normal conversations between passengers without using headsets.
The "SILENS" System Liners kit installation requires the installation of several layers of soundproofing materials:

- Damping materials: ADC006, ADC322.
- Soundproofing materials (A199FOIL, Lead).
- Acoustic insulation materials (ECOZEROF).
- Microlite (enveloped blanked assy)

The cabin soundproofing must be accomplished by stacking coats of materials on helicopter cabin structure.

2 - 14 - 2 LIGHTENING HOLE SOUNDPROOFING INSTALLATION

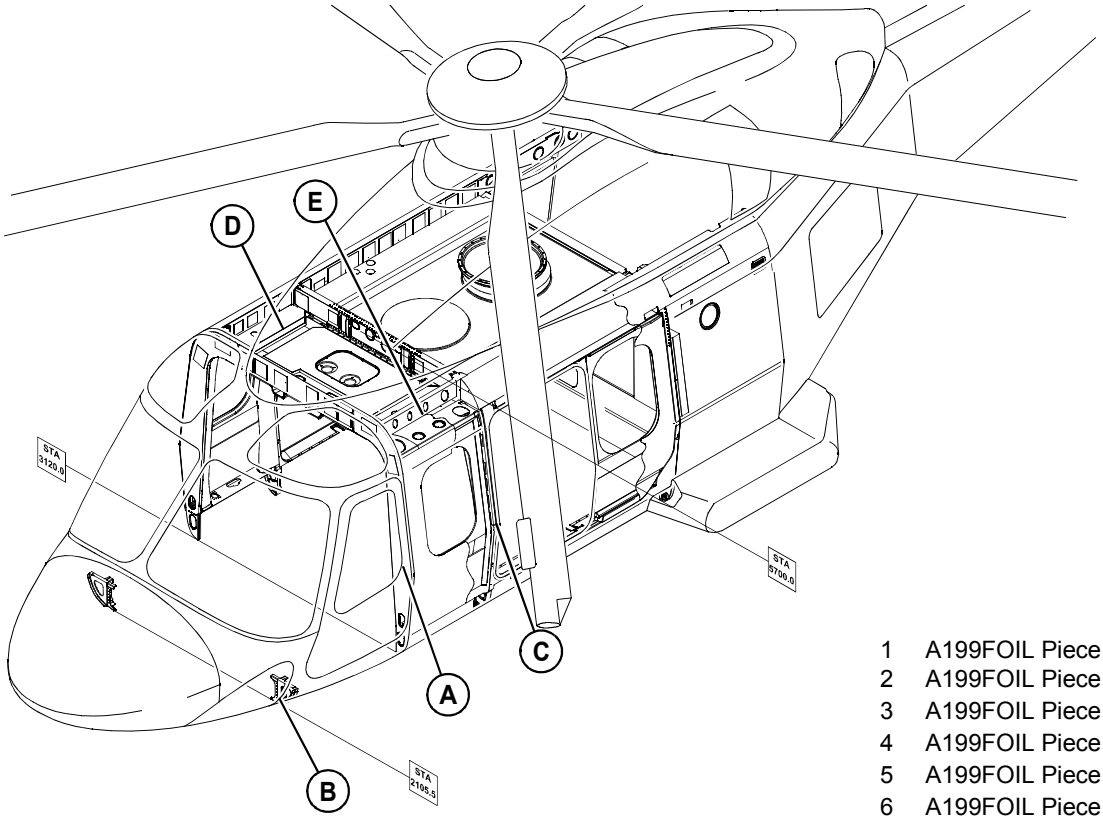
Table 2-4. Supplies.

DESCRIPTION	SPECIFICATION	Q.ty
Aluminium adhesive tape 3M 363 (50 Height)	6SPEC-033-PRD	AR

NOTE

Apply Aluminium adhesive tape (25 high) on the A199FOIL piece boundaries in order to have proper fixing of the piece to the helicopter structure.

1. Apply A199FOIL piece (3, Figure 2-10) to both right and the left brackets, according to the lightening holes (see detail B).
2. Install No. 5 pieces (2) to the lightening holes of wall STA 3120 as indicated in detail A.
3. Install No. 5 pieces (1) to the wall STA 3120 lightening holes according to detail A.
4. Apply No. 2 A199FOIL pieces (4) to the frame STA 3900 according to the lightening holes (see detail C).
5. Apply No. 2 A199FOIL pieces (3) to the frame STA 3900.
6. Apply No. 10 A199FOIL pieces (4) to the LH and the RH frame STA 3900 according to the lightening holes.
7. Apply A199FOIL pieces (4, 2,6) on lightening holes of RH and LH walls BL 800, as shown in detail D and detail E.



1 A199FOIL Piece
2 A199FOIL Piece
3 A199FOIL Piece
4 A199FOIL Piece
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6 A199FOIL Piece

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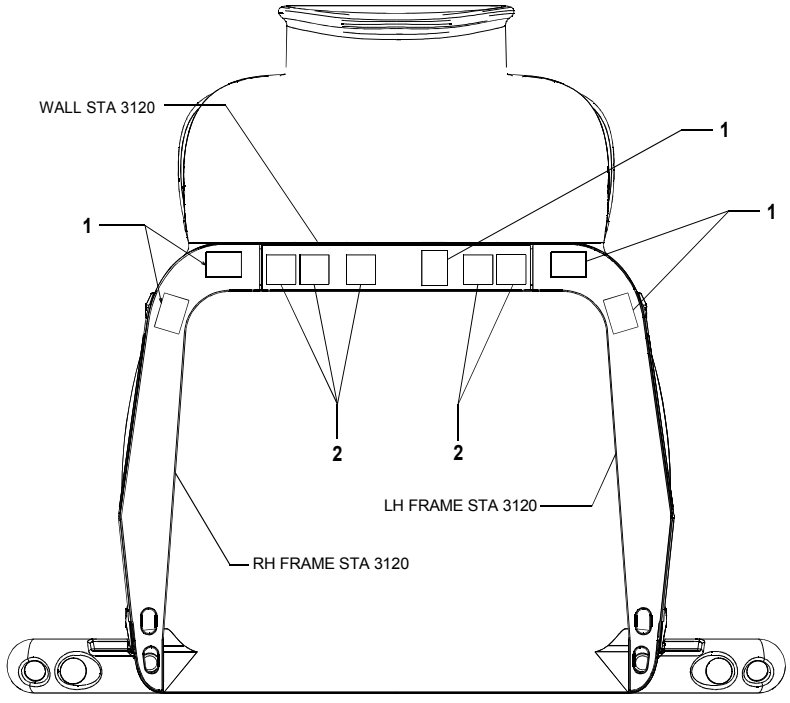

VIEW LOOKING AFTWARD

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Figure 2-10 Soundproofing lightening hole installation (Sheet 1 of 3).

2 - 14 - 3 UPPER DOOR CAVITY SOUNDPROOFING INSTALLATION

2 - 14 - 3 - 1 Upper door cavity soundproofing installation instructions

Table 2-5. Supplies.

DESCRIPTION	SPECIFICATION	Q.ty
Adhesive Trinchero	6SPEC-036-PRD TY II	AR
Aluminium adhesive tape 3M 363 (50 Height) (If required)	6SPEC-033-PRD	AR

CAUTION

ADC006 Damping pieces must be completely adherent to the surface to be treated in order to have maximum damping effect. It must not have air bubbles.

NOTE

The ADC006 and SIRA200 damping material is self-adhesive.

NOTE

In order to ensure a strong fixation of soundproofing apply aluminium adhesive tape along A199FOIL boundaries.

NOTE

The following soundproofing installation procedure is valid for both right and left upper door frame.

1. With reference to Figure 2-11 assemble fwd access door soundproofing (P/N 6AB1ME144-231/-232) as follows:
   a. Bond damping material piece (1) and barrier piece (2) to 3G5330A24151/ 3G5330A24151 (3) with Trinchero 2015-E adhesive.
2. Assemble soundproofing aft door frame cavity assy (P/N 6AB1ME144-245/-246) as follows:
   a. Bond ECOZEROF aft door frame pieces (4, 5) and A199 FOIL (6) with Trinchero 2015-E adhesive.
7. Position and install the ADC006 aft door frame cavity assy (P/N 6AB1ME144-395/-396) on structure as shown in detail A.
8. With reference to section B-B position and install fwd access door soundproofing (P/N 6AB1ME144-231/-232) and aft door frame cavity assy (P/N 6AB1ME144-245/-246) in accordance with ADC006 aft door frame cavity assy (P/N 6AB1ME144-395/-396).

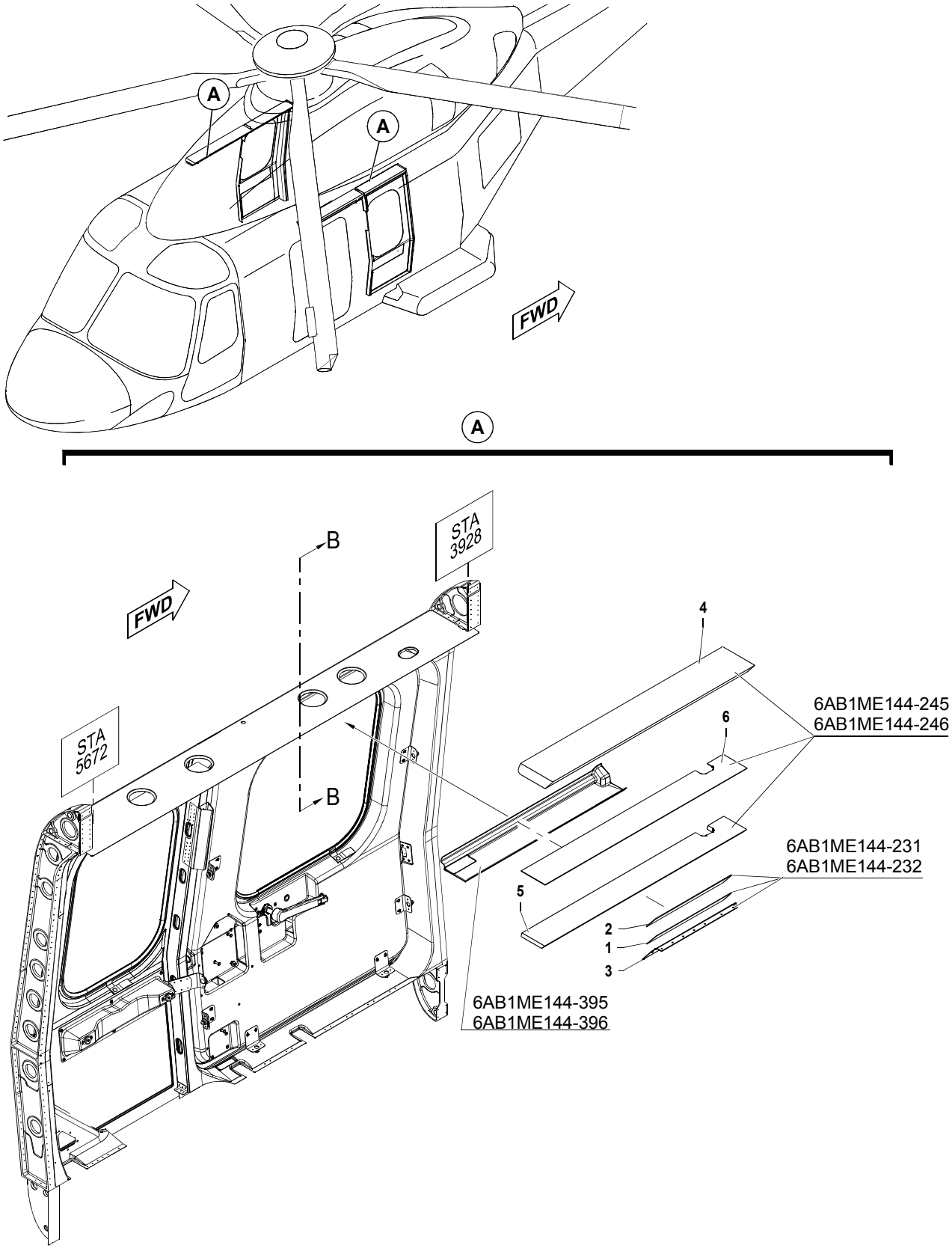

Figure 2-11 Upper door cavity soundproofing installation (Sheet 1 of 4).

2 - 14 - 6 LATERAL WALLS SOUNDPROOFING INSTALLATION

Table 2-11. Supplies.

DESCRIPTION	SPECIFICATION	Q.ty
Trinchero Adhesive 2015-E	—	AR
BOND 7705	6SPEC-036-PRD	AR
Aluminium adhesive tape 3M 363 (50 Height)	6SPEC-033-PRD	AR

CAUTION

ADC006 damping pieces must be completely adherent to the surface to be treated in order to have maximum damping effect. It must not have air bubbles.

NOTE

The following soundproofing installation procedure is valid for both right and left lateral walls structure.

NOTE

In order to ensure a strong fixation of soundproofing apply aluminium adhesive tape along A199FOIL boundaries and lead pieces edges.

NOTE

Acoustic barrier pieces must be bonded to damping material pieces with 6SPEC-036-PRD "BOND 7705" adhesive.

NOTE

The ADC006 damping material is self-adhesive.

2. Perform soundproofing of access door assy applying ADC006 pieces (1, Figure 2-14) and lead (2) as indicated. See detail B.
3. Apply ADC006 door frame piece (3) with lead (4) on side wall. See detail B.
4. Apply ADC322 LH side wall piece of soundproofing as shown in detail C.
5. Apply LH hydraulic pipes soundproofing piece (6) as shown in detail D.
6. With reference to detail E bond LH A199 FOIL (8) to LH ADC332 piece (9) using BOND 7705 as follows:
   a. Add diluent, MAG code "020100000302", at the rate of 5% minimum;

      NOTE

      Spray using cup spray gun, pump or double membrane pump or submersion pump.

   b. Apply it with a spray gun having 1,8/2,0 nozzle diameter and air pressure not lower than 4/5 atm;
   c. Make sure that materials to be bonded are free from dust traces or residuals of other workings;
   d. In presence of metal sheets it is recommended to degrease;
   e. Spray at about 50 cm distance a uniform thin coat of adhesive on both supports;

      NOTE

      Bonding must be considered as completed only after 48 hour.

   f. Wait about 15 minutes until solvent evaporates, then join together the two parts applying pressure;
7. Bond A199 FOIL (28) to ADC332 (27) as per steps a. thru g. above. See detail E.

8. Apply LH enveloped blanket assy (7) to structure with velcro strips in accordance with 6SPEC-087-PRC, procedure B.
9. With reference to detail F bond A199 FOIL (15) to ADC332 (14) with BOND 7705 adhesive as per steps a. thru g. above and apply to upper door frame as shown.
10. Apply ADC332 piece (10).
11. Bond Enveloped blanket assy (11) with velcro strips in accordance with 6SPEC-087-PRC, procedure B.
12. Apply ADC332 piece (12).
13. Apply damping material (13) to frame structure.
14. With reference to detail G, apply ADC332 piece (17) on door structure.
15. Bond enveloped blanket assy (16) to ADC332 piece (17) with velcro strips in accordance with 6SPEC-087-PRC, procedure B.
16. Apply enveloped blanket assy pieces (18, 19, 20) with velcro strips in accordance with 6SPEC-087-PRC, procedure B.
17. With reference to detail H, bond acoustic barrier (21) to damping material (22) and apply to 3G5330A54831 structure.
18. Bond acoustic barrier (23) to damping material (24) and apply to 3G5330A54631 structure.
19. With reference to detail J apply damping material pieces (25, 26) as shown.

2 - 14 - 7 STRUCTURE CAVITY SOUNDPROOFING INSTALLATION

Table 2-12. Supplies.

DESCRIPTION	SPECIFICATION	Q.ty
Adhesive Trinchero	6SPEC-036-PRD TY II	AR

NOTE

The following soundproofing installation procedure is valid for both right and left structure cavity.

1. Gain access to the passengers compartment.
2. Fill the cavity with ECOZEROF as indicated in Figure 2-15, view A, from section B-B through section E-E.