

# SERVICE BULLETIN



Service Bulletin No.: DA20-56-1, Rev. 0

Date Issued: January 10, 1996

Title: Canopy, Side Window Water Drain

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1. **ATA Code:** 5610
2. **Effectivity:** All DA 20 Katana Aircraft serial number 10002 thru 10075.
3. **General:** Operators have reported that water enters the cabin area through the seal around the small windows and the key hole located in the knob of both sliding windows. This service bulletin requires sealing of the key hole and introduces a drain hole through the canopy that allows water to drain to the outside of the aircraft.
4. **Compliance:** Incorporation of this Service Bulletin is recommended and should be accomplished at the operator's earliest opportunity.
5. **Approval:** Engineering data referenced or contained in this bulletin is Transport Canada approved.
6. **Labor:** Approximately 1.5 hours will be required to incorporate this service bulletin.
7. **Material:**
- | <u>Description</u>             | <u>P/N</u>       |
|--------------------------------|------------------|
| Silicone Sealant               | RTV 108          |
| Hand Router Fixture (template) | HRF20-5690-01-01 |
8. **Special Tools:** 6mm (ref. 15/64") drill dressed as shown in Figure 2a, page 2  
1/16" or 1/8" tapered router bit  
masking tape 2" wide  
scriber (preferably dull)  
small round file
9. **References:** DA 20 Katana Maintenance Manual Doc. No. DA201
10. **Accomplishment Instructions:**
- 10.1 Determine the trough style installed on the aircraft, either Figure 1a or 1b.
  - 10.2 If the style shown in Figure 1b is installed, a 6mm (ref 15/64") drill will need to be dressed as shown in Figure 2a. The hole is to be located as shown in Figure 2b.  
**CAUTION:** It is **very important** to remember that when drilling the acrylic:
    - (a) the drill must be dressed as shown in Figure 3 and,
    - (b) to press lightly all the way through. Let the dressed drill melt/cut its way through the acrylic. Carefully remove any sharp edges with a small round file.

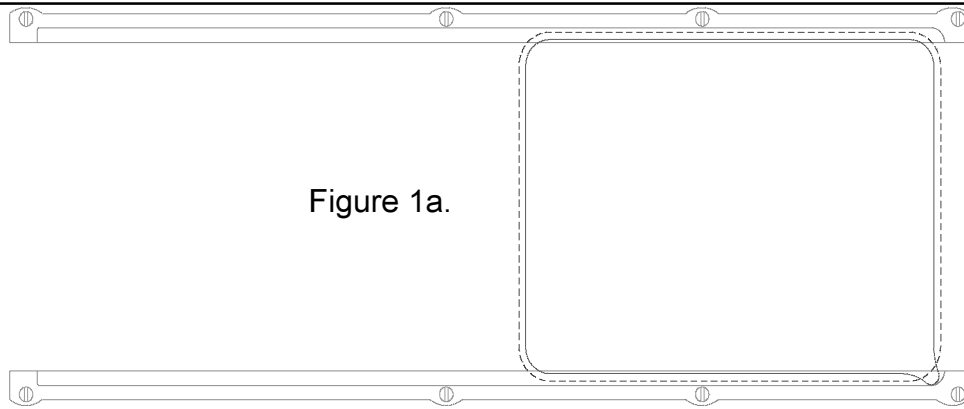


Figure 1a.

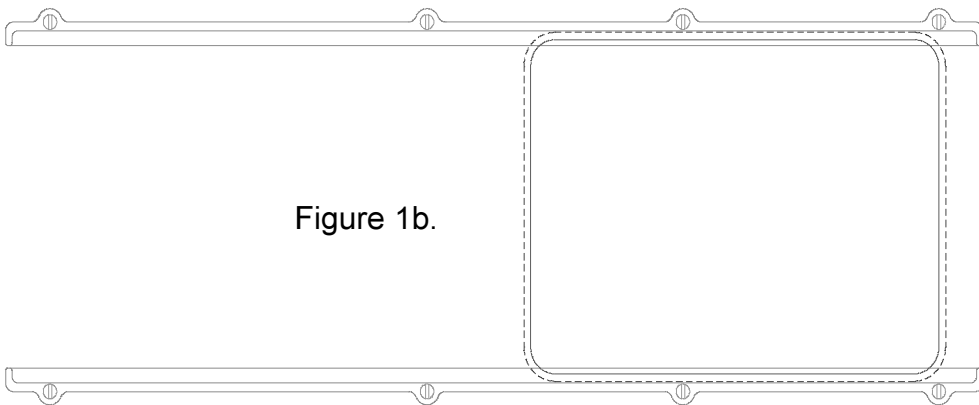


Figure 1b.

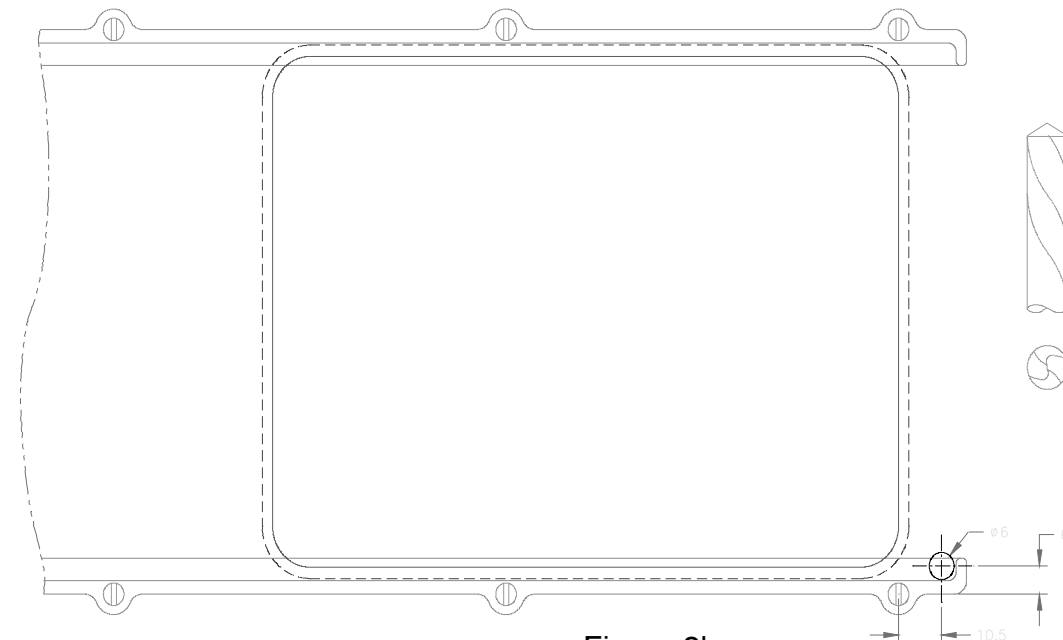


Figure 2a.

Figure 2b.

10.3 If the window style shown in Figure 1a then the modification is as per Figure 3. A template of the router fixture is depicted in Figure 9, page 6 which locates on the two forward trough screws. Fashion a routing template based on the attached drawing. Locate the the template on the two forward screws and using a 1/16" or 1/8" tapered router bit route the canopy as shown in Figure 3 using the template as a guide. Carefully remove any sharp edges with a small round file.

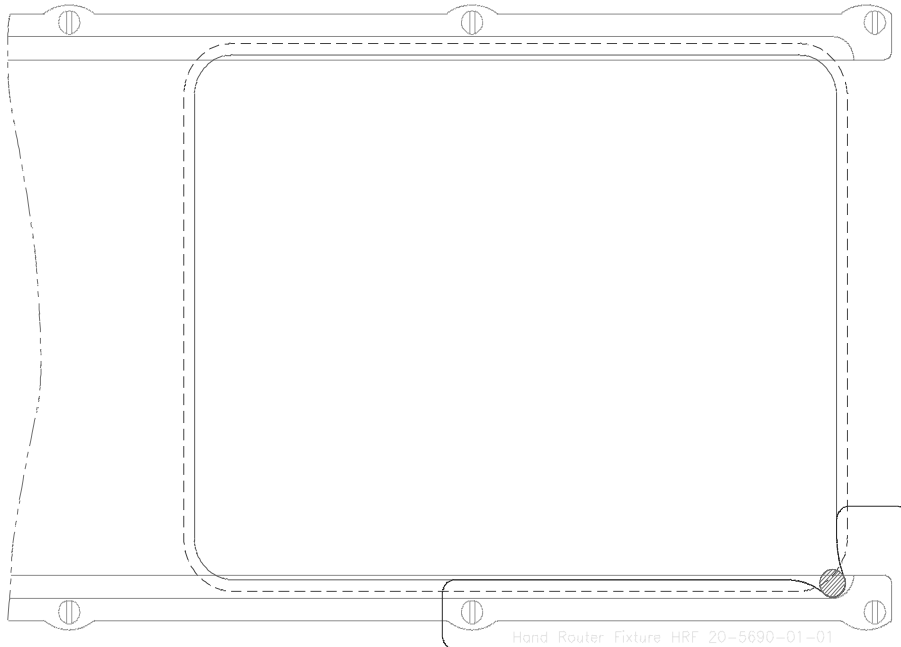


Figure 3.

10.4 Remove the lower trough (and window) and apply a 2" wide piece of masking tape on the inside of the canopy as shown in Figure 4. Replace the trough and using a **dull** scribe, or similar instrument, scribe the outline of the trough faying surface on the tape. Use utmost care not to scratch the canopy.



Figure 4.



- 10.5 Remove the trough and peel the likeness of the trough out of the tape as shown in Figure 5 below.



Figure 5.

- 10.6 Apply a bead of RTV 108 to the exposed likeness of the trough (Figure 6) on the canopy. Fill the locking mechanism hole in the knob of the sliding window. Use only as much as required to keep the next steps from being messy.

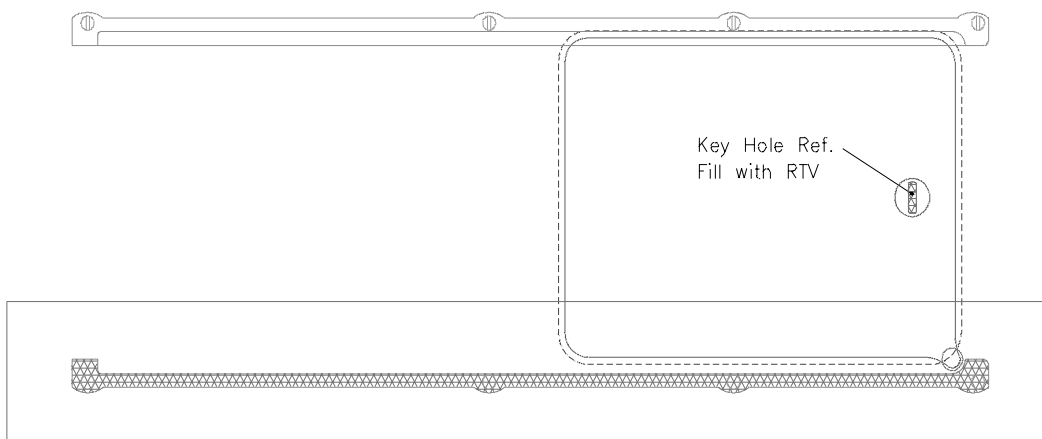


Figure 6.

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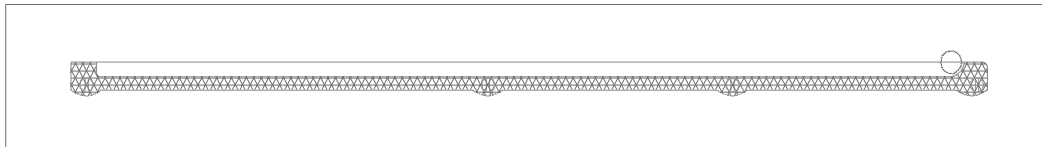
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- 10.7 Carefully replace the trough and fasten the screws slowly to until the air bubbles are pressed out and no longer visible. The canopy and trough should again appear to be transparent. Wipe away the excess that has squeezed out being carefull not to soil the trough or the rest of the canopy. (Figure 7)



Figure 7.



- 10.8 After the RTV is no longer tacky, remove the rest of the tape as shown in Figure 8. Remove the upper trough and reinstall the sliding window. Allow the RTV to cure before exposing to moisture.

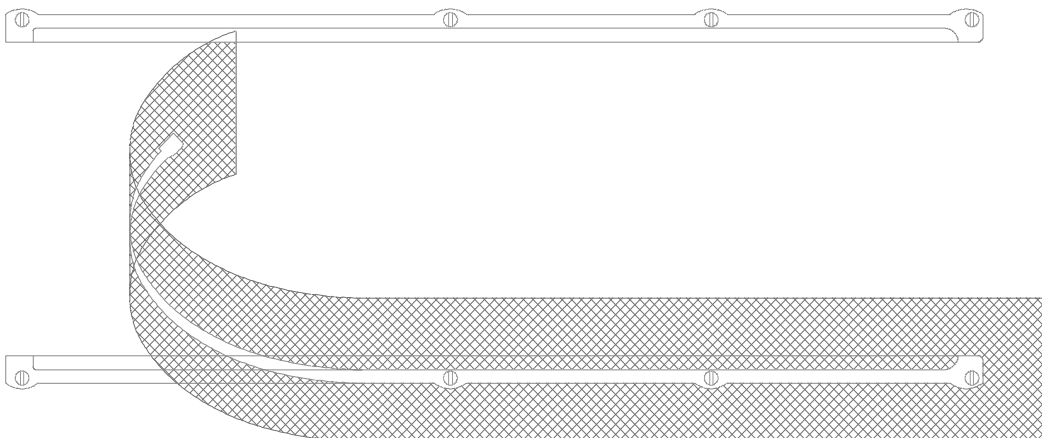


Figure 8.

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11. A 1:1 scale depiction of Hand Router Fixture HRF20-5690-01-01

### Hand Router Fixture Template

Figure 9.

12. **Weight and Balance:** N/A

13. **Electrical Load Data:** N/A

14. **Credit:** A labour allowance of 1.5 hours will be issued upon receipt of a completed warranty application form.

To obtain satisfactory results, procedures specified in this service information letter must be accomplished in accordance with accepted methods and current government regulations. Diamond Aircraft Industries Inc. cannot be responsible for the quality of work performed in accomplishing the requirements of this service information letter.

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