



Installation Manual

for

Single Stack, Minimum Rail Tray Mount Kit RK1027

Document P/N RKD1027-2
Revision A

October 7, 2008

List of Revisions

Revision	Date	Description	Pages
NC	05/26/05	Original Disposition	All
A	2008-10-07	PMA address change, text readability updates	All

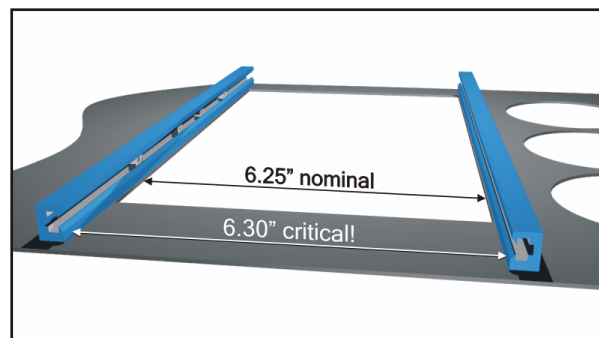
Introduction

The Radorax avionic support rail installation kit provides a straightforward retrofit for almost any aircraft. The following documentation is provided to install the Radorax p/n RK1027 Single Stack, Minimum Rail Kit in your aircraft.

Document #	Description	Used With: RK1027
RKD1027-1	Packing List / Certificate of Conformance	X
RKD1027-2	Installation Manual	X
RKD1027-3	Parts Manual	X
RKD1027-4	Instructions for Continued Airworthiness	X
SA01330LA	STC Front Sheet	X

General Notes

IMPORTANT! The distance between the faces (inside dimension) of installed Radorax support rails **MUST** be **6.30** inches. This spacing provides maximum compatibility with all avionic trays and facilitates the use of other Radorax products, such as Radorax [Tray Cams](#), [Closeout Panels](#), and [Dzus Adapters](#).



Use the RK400 Installation Spacer Tool Kit for simple, precise alignment of the rails

- A. Tag all parts, including attaching hardware (unless otherwise noted), removed to gain access to work areas. Protect all parts from damage during the installation process.
- B. Following any drilling or cutting operation, remove burrs and metal particles. Apply a thin coat of zinc chromate, epoxy, or equivalent primer to bare metal surfaces except when the hole is used as a grounding point.
- C. When reinstalling ground wires, or components requiring grounding, clean the structure surface to provide good electrical contact.

For an original installation not involving the removal of existing avionics tray attachments, please proceed to step 2.1. All item numbers in parentheses (eg. item xx) refer to item listed in RAS Parts Manual p/n RKD1027-3.

Removal of Existing Support Rails (Step 1)

- 1.1 Remove avionics equipment from their trays. Remove screws attaching trays to the existing brackets. Remove all back-straps and attaching hardware supporting the forward end of the trays.
- 1.2 Remove any Pilot and Copilot instrument panel overlays.
- 1.3 Remove the LH and RH tray attaching angles/devices from the instrument panel.

Assembly and Installation of Avionics Support Rails (Step 2)

-The following guidelines are based on a 6.25" wide avionics cutout and 6.30" ID rail spacing. This provides a 0.025" lip to facilitate hiding the avionics trays:

-The new rails are mounted to the instrument panel using the included structural NAS514P632-4P screws.

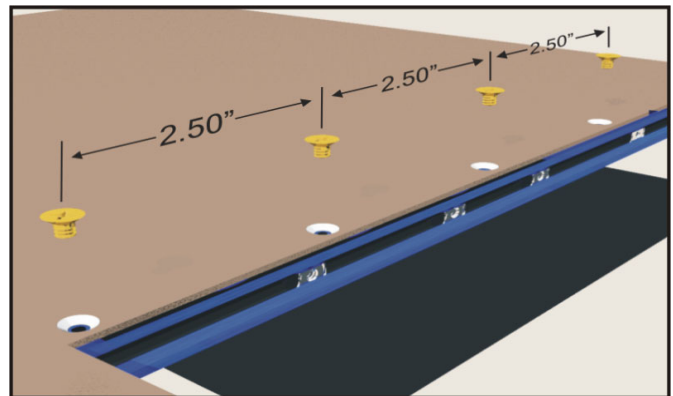
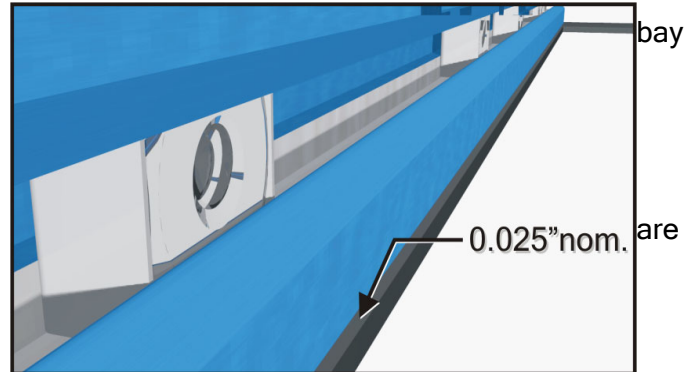
-NAS514P632-5P screws for .125" thick instrument panels available upon request.

- 2.1 **Cut rails to length:** Match to the length of the removed LH and RH angles, if applicable. Trim the rail so as to leave the engraved part number attached and on the forward-facing (visible) side of the rail, when installed.

2.2 **Instrument panel/rail fastener hole pattern layout:**

Reference RKD1027-3 Parts Manual for permissible fastener locations. Temporarily fasten the LH and RH rails in place, 6.30" ID apart, and centered on the avionics bay cutout. Verify an inside dimension of 6.30" between the rail faces.

Use the Radiator RK400 Rail Installation Spacer Kit to properly space and simplify installation.



Verify that the rail p/n's are visible when installed.

SCREW/RIVET PITCH SHOULD NOT EXCEED 2.50"

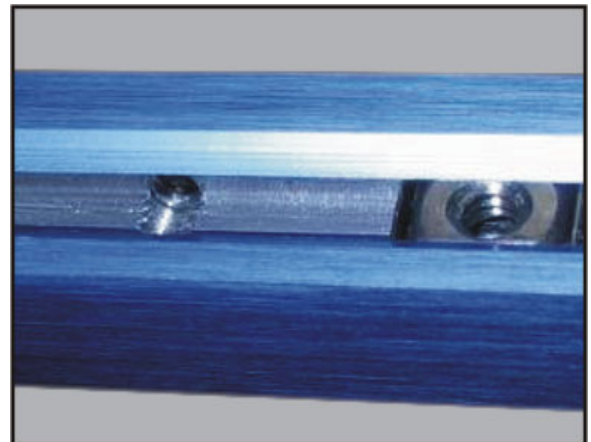
-If using existing holes for mounting, mark their locations on the rail. A scribe works well for this task. Verify that the hole positions do not exceed the dimensions noted in the enclosed Parts Manual (RKD1027-3), and that the screw spacing is ≤ 2.50 ".

2.3 **Drill and tap avionic support rails:**

Holes should be aligned with the flange portion and within the dimensions listed for the support rails (ref. RKD1027-3).

SCREWS: Drill a #36 hole at each fastener location. Thread each hole with a 6-32 tap. While possible to drill a blind hole and use a bottoming tap, it is permissible to drill and tap a through-hole. Some deburring will be necessary for the nut assemblies to move freely, and care should be exercised not to drill and tap deeper than the center of the slot to avoid unnecessary burring on the opposite side.

The rail attaching screw (item 7) will require trimming (in some installations) to avoid intrusion into the slot.



Assembly and Installation of Avionics Support Rails (Step 2), cont.

- 2.4 **Install Nut Assemblies:** Verify the installation of the total number of sliding nut assemblies (Items 2, 3a, 3, 4) used for the installation, plus 4-6 extra assemblies in each rail before final installation of the rail to the structure. Store extra hardware in the slot between used nut assemblies.
- 2.5 **Install the LH and RH rails to the instrument panel:**
Install the LH and RH rails to the instrument panel using the screws (Item 7) supplied with the kit. A small amount of Loctite (or equivalent) may be used to secure the screws.
- 2.6 **Install the avionics trays:** Radiator avionics support rails are designed to take advantage of the increased rigidity offered by the use of countersunk screws and dimpled screw receptacles. Because of the integrity of mounting offered by this system, back-strapping the avionics trays is not necessary, provided the Radiator support rails are affixed in a way which will bear the ultimate load factors of your aircraft.

For trays not supplied with countersunk holes, dimple each mounting hole with a #6 dimple-die, or equivalent means.

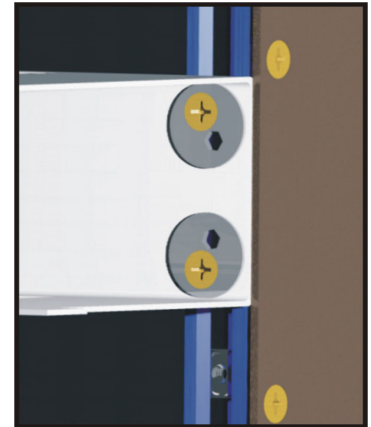
**To achieve perfect face alignment in multiple avionics vendor stacks,
use a Radiator RK5000 Tray Cam Kit.**

After each tray is prepared for installation, stack the tray in its respective position, pushed forward far enough to access the sliding nut assemblies. Slide all the nut assemblies (Items 2, 3a, 3, 4) into place that are being used to mount the top tray.

Move the tray into position and fasten using the supplied screws (Item 5). Do not fully tighten the screws until the tray is verified level in its proper position. Tighten screws to lock in place.

Each additional tray is mounted by positioning the nut assemblies, installing the mounting screws, sliding the tray into position beneath the last permanently affixed tray, and tightening the screws.

Nut assemblies for future use may be stored between the nuts used to mount trays, or grouped toward one end of the rail.

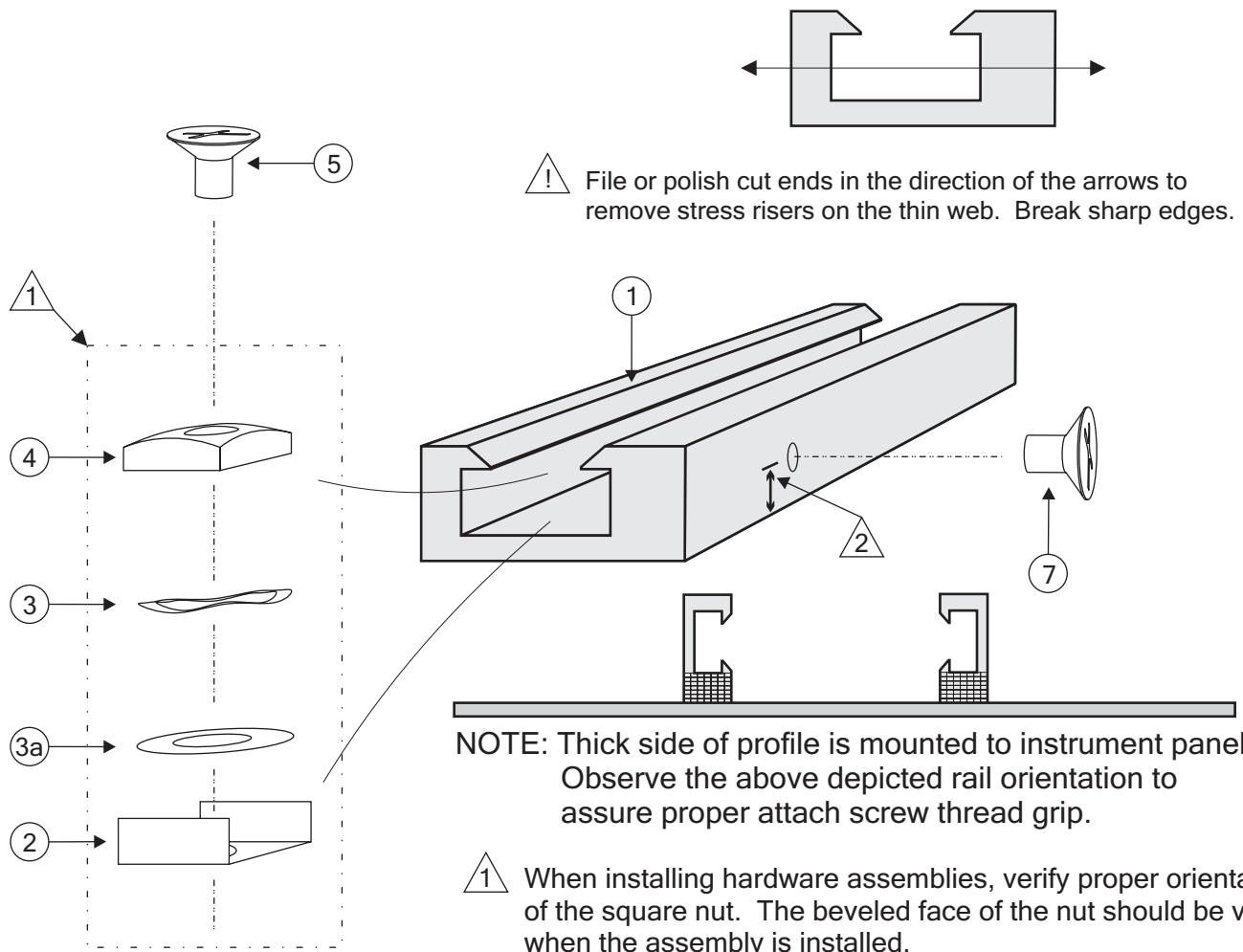


Use a Radiator RK4000 Closeout Panel Kit to close out any remaining space.



Please visit www.radiator.com for more information, including kit documents.

Radorax RP1025-P Tray Mount Rail: Parts and Installation Detail



1 When installing hardware assemblies, verify proper orientation of the square nut. The beveled face of the nut should be visible when the assembly is installed.

2 Maximum dimension .125" - Center mounting holes on part.

Note: It is permissible to pierce the hardware assembly track when drilling the tap holes. Before installing, insure that all burrs are removed from the track.

Tip: Hand turn a 6-32 tap chucked in a drill press to achieve perfect thread alignment.

8	NAS514P632-4P	6-32 STEEL SCREW C/SUNK HEAD	-	100 degree x .250	7	
18	NAS514P632-4P	6-32 STEEL SCREW C/SUNK HEAD	-	100 degree x .250	5	
18	RP3030-P	6-32 STAINLESS SQUARE NUT	-	.310 x .310 x .105	4	
18	RP3020-P	THREE-WAVE WASHER	Stainless	-	3	
18	RP3010-P	SHIM WASHER	Stainless	-	3a	
18	RP3000-P	RETAINER	Stainless	.350 x .310 x .140	2	
1	RP1025-P	AVIONIC SUPPORT RAIL	6061-T6	.250 x .575 x 18.0	1	
QTY.	PART NO.	DESCRIPTION	MATERIAL	SIZE/SPEC	ITEM NO.	
N/A	FAA/PMA	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: DECIMALS .XX ± .02 ANGLES ±0.30° .XXX ±.010	CONTRACT NO.	Radorax Aviation Systems, Inc. www.radorax.com		
			APPROVALS	DATE	TITLE	
			DRAWN M. J. Landes	5/26/05	RADIORAX 1025 SERIES RAIL ASSEMBLY DETAIL	
			CHECKED V. D. L'Esperance	5/26/05	DWG. CODE	
			ENGINEER M. J. Landes	5/26/05	REV. NC	
NEXT ASSY	USED ON	FINISH	APPROVED V. D. L'Esperance	SCALE NONE	FILE:RKD1027-3revNC.cdr	SHEET 1 of 1
APPLICATION		DO NOT SCALE ON DRAWING				