



**Step 1:** Position the WD-1023 Gas Strut Attach Bracket on the C-1001 Cabin Cover as shown on Page 45-15, Figure 2, and as shown in Figures 1 and 2. The gas strut attach bracket inboard/outboard position is determined by the point of "best-fit" to the cabin cover. The gas strut attach bracket is centered fwd/aft on the door hinge.

With the gas strut attach bracket held in place, match-drill #12 through the cabin cover using the holes in the gas strut attach bracket as drill guides. Install a temporary screw/washer/nut in each hole as it is drilled to hold the gas strut attach bracket in position while the remaining holes are match-drilled.

Remove the gas strut attach bracket and deburr the holes that were just match-drilled.

Machine countersink the holes in the cabin cover to fit the head of an AN509-10 screw as shown in Figure 1.

Final install the gas strut attach bracket using the hardware called-out in Figure 1.

**Step 2:** Fabricate a Bracket Locating Bar out of 1/8 to 1/2 inch thick metal/plastic/wood as shown in Figure 3. Material is not provided in the kit. The bar simulates the compressed C-1016 Gas Strut and is used instead of the gas strut to locate the C-1013 Gas Strut Attach Brackets on the inner surface of the C-1002-L/R Door.

**Step 3:** Fabricate four C-1016B Bushings from AT6-058 x 5/16 as shown in Figure 4.

**Step 4:** Break apart the C-1013 Gas Strut Attach Bracket into it's two halves and smooth the edges.

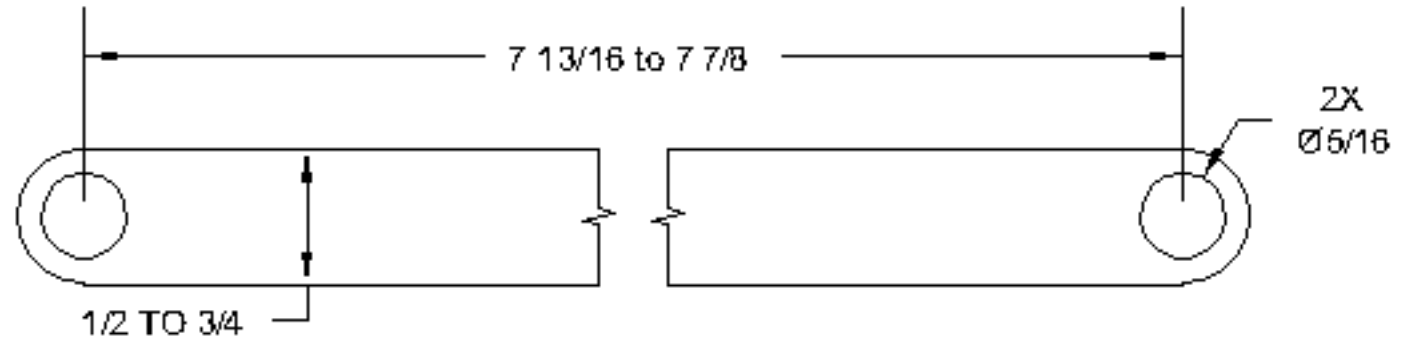
Insert a C-1016B Bushing in each end of the Bracket Locating Bar and attach the gas strut attach brackets to the bar using the AN3 bolt/washer/nut called-out in Figure 2.

Attach the bracket locating bar to the WD-1023 Gas Strut Attach Bracket using the AN3 bolt/washer/nut called-out in Figure 2.

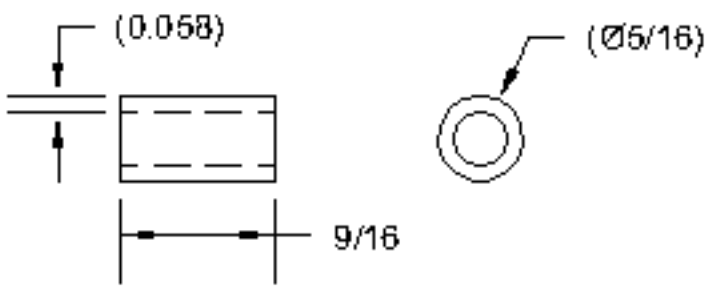
Close the C-1002-L/R Door and latch it closed. Rotate the bracket locating bar up until the gas strut attach brackets rest against the inner surface of the door. With the gas strut attach brackets held in place as shown in Figures 1 and 2, match-drill #30 and cleco to the door using the holes in the gas strut attach brackets as drill guides.

Remove the bracket locating bar and remove the gas strut attach brackets and bushings

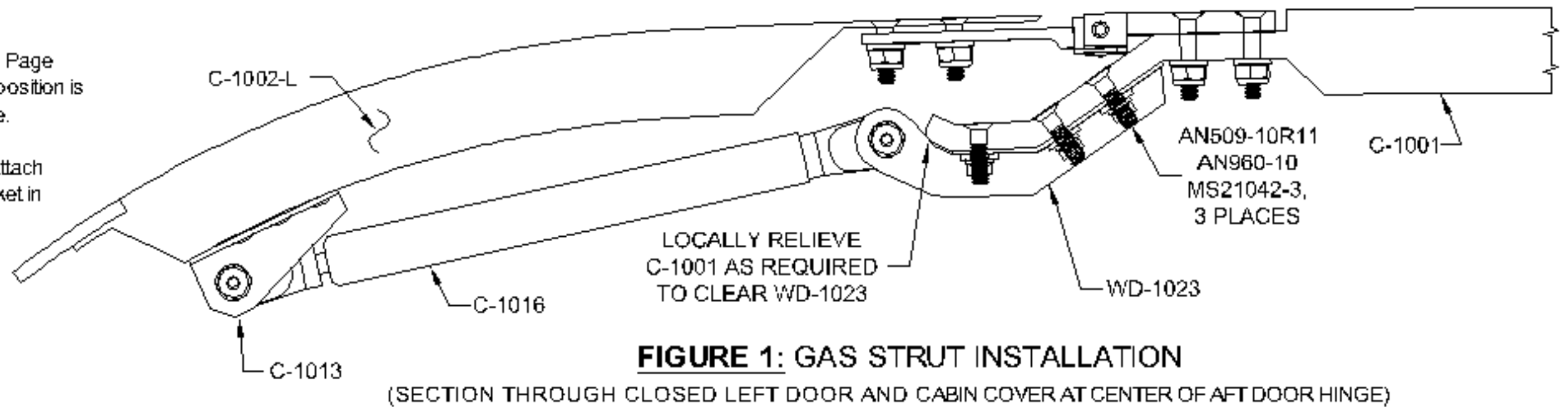
Deburr the holes of the C-1013 Gas Strut Attach Brackets. Prime if/as desired.



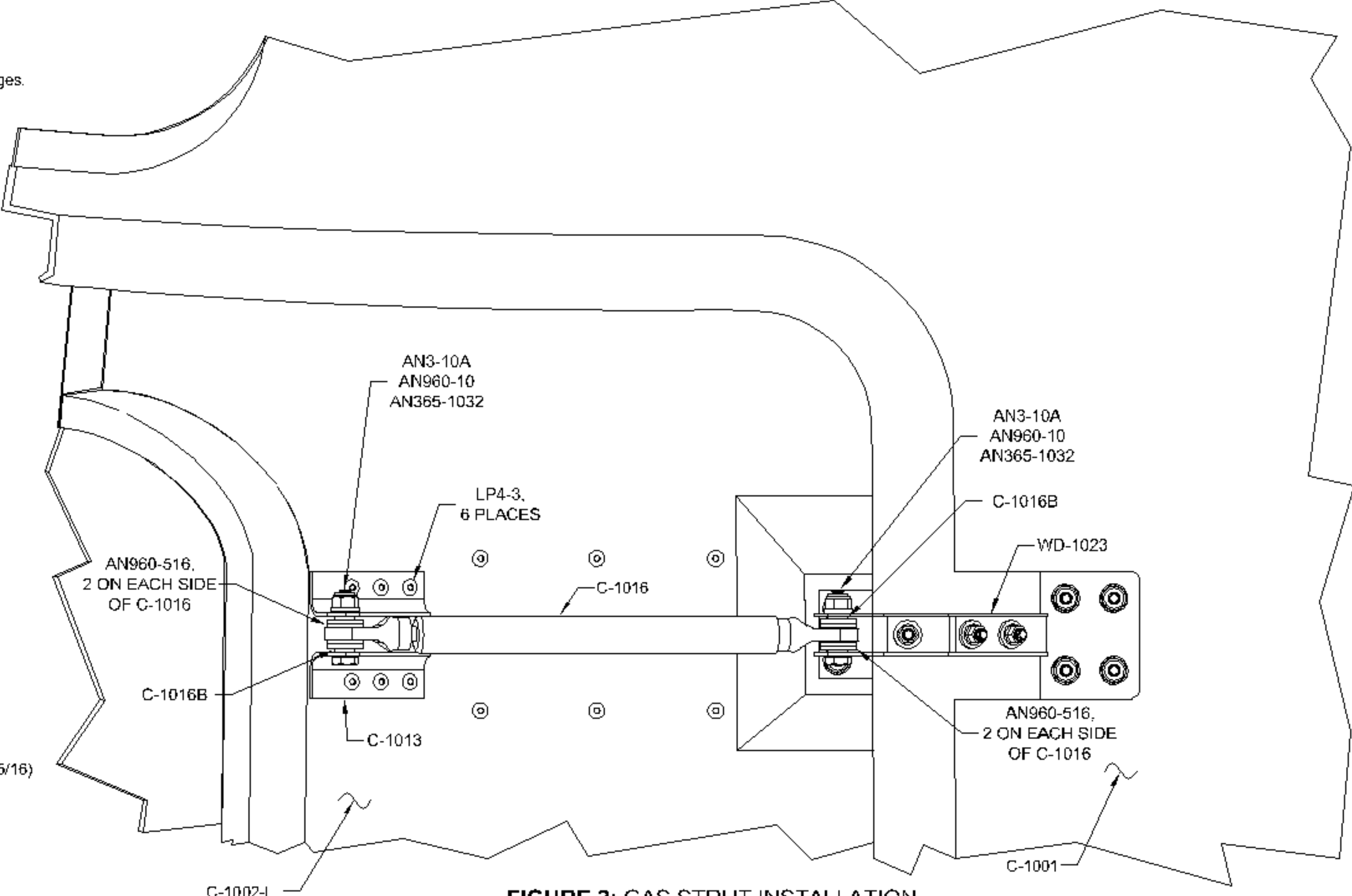
**FIGURE 3:**  
BRACKET LOCATING BAR



**FIGURE 4:** BUSHING



**FIGURE 1: GAS STRUT INSTALLATION**  
(SECTION THROUGH CLOSED LEFT DOOR AND CABIN COVER AT CENTER OF AFT DOOR HINGE)



**FIGURE 2: GAS STRUT INSTALLATION**  
(VIEW LOOKING UP AT INNER SURFACE OF CLOSED LEFT DOOR AND CABIN COVER)