**TITLE**

COPILOT SECONDARY SEAT STOP INSTALLATION

**EFFECTIVITY**

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<td>F177RG0161 thru F177RG0177</td>
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<td>F182P</td>
<td>1976</td>
<td>F18200001 thru F18200025</td>
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<td>F182Q</td>
<td>1977</td>
<td>F18200026 thru F18200064</td>
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<td>F182Q</td>
<td>1978</td>
<td>F18200065 thru F18200094</td>
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<td>1979</td>
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<td>FR18200021 thru FR18200045</td>
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<td>FR182</td>
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<td>FR18200046 thru FR18200070</td>
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**DESCRIPTION**

To install a new-design secondary seat stop.

**APPROVAL**

FAA approval has been obtained on technical data in this publication that affects airplane type design.

**REFERENCE**

- SEB07-5R2
Service Kit
SK210-175A

Change in Weight and Balance

Model

Weight Increase

ARM

Refer to the following as applicable to calculate the Arm and the Moment: The Airplane Weight and Balance Report and Equipment List, Pilot’s Operating Handbook, or the FAA Approved Airplane Flight Manual.

Resultant Moment

MOMENT/1000

Material Information

The parts below cover installation of the copilot secondary seat stop for one airplane.

<table>
<thead>
<tr>
<th>New P/N</th>
<th>Quantity</th>
<th>Description</th>
<th>Old P/N</th>
<th>Disposition</th>
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<tbody>
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<td>SK210-175A</td>
<td>1</td>
<td>Kit, consisting of the following parts:</td>
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<tr>
<td>H880015</td>
<td>1</td>
<td>Grommet</td>
<td></td>
<td></td>
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<tr>
<td>H990000</td>
<td>1 foot</td>
<td>Spiral Wrap</td>
<td></td>
<td></td>
</tr>
<tr>
<td>S2300-26</td>
<td>1</td>
<td>Bracket</td>
<td></td>
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</tr>
<tr>
<td>SK210-175HDWR</td>
<td>1</td>
<td>Hardware Kit</td>
<td></td>
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<tr>
<td>1299377-14</td>
<td>1</td>
<td>Doubler Assembly</td>
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<tr>
<td>1299377-24</td>
<td>12 inches</td>
<td>Extrusion</td>
<td></td>
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<td>505590-403</td>
<td>1</td>
<td>Reel Assembly</td>
<td></td>
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</tr>
<tr>
<td></td>
<td>1</td>
<td>Instructions</td>
<td></td>
<td></td>
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</tbody>
</table>

*The 505590-403 Reel Assembly is made up of these three components:

- 505530-405 Cable Assembly
- 502457-1 Cable End Nut
- 505589-403 Reel.

You will receive all three components of the 505590-403 Reel Assembly when you order this part.
The parts below make up the SK210-175HDWR Kit:

**NOTE:** Not all of the parts included in this kit will be used for some installations.

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<th>OLD P/N</th>
<th>DISPOSITION</th>
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<td>AN310-4</td>
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<tr>
<td>AN316-5R</td>
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<td>Nut</td>
<td></td>
<td></td>
</tr>
<tr>
<td>AN4-16</td>
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<tr>
<td>AN4-6</td>
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<tr>
<td>AN525-10R10</td>
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<tr>
<td>AN525-10R8</td>
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<td>MS20392-1C27</td>
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<td>MS20470AD5-17A</td>
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<td>MS21042-3</td>
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<td>MS21919WDG12</td>
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<td>MS21919WDG16</td>
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<tr>
<td>MS24665-132</td>
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<td>Cotter Pin</td>
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<tr>
<td>MS24665-134</td>
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<td>Cotter Pin</td>
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<tr>
<td>MS3367-5-0</td>
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<td>Strap</td>
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<td>MS35333-41</td>
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<td>Lock Washer</td>
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<td>NAS1149FN432P</td>
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<td>Washer</td>
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<td>NAS1149F0332P</td>
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<td>NAS43DD1-24FC</td>
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<td>NAS43DD4-32FC</td>
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<tr>
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<td>Rivet - Nominal</td>
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In addition to the SK210-175A Kit, the parts below will be necessary for secondary seat stop installation "L":

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<th>NEW P/N</th>
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<th>OLD P/N</th>
<th>DISPOSITION</th>
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<tr>
<td>AN525-10R8</td>
<td>1</td>
<td>Screw</td>
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<td>MS21919WDG10</td>
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<td>Clamp</td>
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<td>MS21919WDG8</td>
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<td>Clamp</td>
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The material that follows, or equivalent, may be necessary:

<table>
<thead>
<tr>
<th>NAME</th>
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<th>MANUFACTURER</th>
<th>USE</th>
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<tr>
<td>EC1300LP</td>
<td>U000787S (1 Pint)</td>
<td>Cessna Aircraft Company Cessna Parts Distribution 5800 East Pawnee PO Box 1521 Wichita, KS 67218</td>
<td>To attach H880015 Grommet to seat frame</td>
</tr>
<tr>
<td>Loctite 242</td>
<td>Loctite242</td>
<td>Cessna Aircraft Company Cessna Parts Distribution 5800 East Pawnee PO Box 1521 Wichita, KS 67218</td>
<td>To further secure the belt reel manual lock</td>
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</tbody>
</table>

Identification of Applicable Secondary Seat Stop Installation

1. (Refer to Figure 1) Identify the seat installation for your airplane, and go to the applicable section of this service kit.
NOTE: All dimensions are shown in inches.

Figure 1. Identification of Applicable Secondary Seat Stop Installation (Sheet 1)
Go to Installation "E"

Go to Installation "F"

Go to Installation "G"

Figure 1. Identification of Applicable Secondary Seat Stop Installation (Sheet 2)
Figure 1. Identification of Applicable Secondary Seat Stop Installation (Sheet 3)
Figure 1. Identification of Applicable Secondary Seat Stop Installation (Sheet 4)
Accomplishment Instructions for Secondary Seat Stop Installation "A"

1. Prepare the airplane for maintenance.
   A. Make sure that all switches are in the OFF/NORM position.
   B. Disconnect electrical power from the airplane.
      (1) Disconnect the airplane battery.
      (2) Disconnect external electrical power.
   C. Attach maintenance warning tags to the battery and external power receptacle that have "DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS" written on them.

2. Remove the airplane interior and the access panels as necessary to get access to the seats and floorboard areas where you must install the seat stop. (Refer to the applicable sections of the Service Manual.)

3. Do an inspection of the seat rails, rollers, roller housings, and stop pins. Refer to Cessna Service Information Letter SE83-6 and FAA Airworthiness Directive (AD) 87-20-03 Revision 2 or subsequent revision.

4. Repair or replace components as necessary.

5. Install the secondary seat stop.
   A. Remove the copilot seat.
   B. (Refer to Figure 2, Detail C.) Make the 1299377-13 Reel Assembly Bracket.
      (1) Cut the 1299377-13 Reel Assembly Bracket to the correct dimensions from the 1299377-24 Extrusion.
      (2) Drill two 0.203-inch diameter holes in the 1299377-13 Reel Assembly Bracket.
         NOTE: These holes are for the bolts that attach the clamps to the 1299377-13 Reel Assembly Bracket. The clamps will attach the 1299377-13 Reel Assembly Bracket to the aft outboard leg of the seat.
      (3) Drill one 0.266-inch diameter hole in the 1299377-13 Reel Assembly Bracket.
         NOTE: This hole is used to attach the 505590-403 Reel Assembly to the 1299377-13 Reel Assembly Bracket.
      (4) Deburr the holes and apply Alodine to the bare metal.
   C. (Figure 2, Views D-D and E-E.) With the two MS21919WDG12 Clamps, AN525-10R8 Screws, NAS1149F0332P Washers, and MS21042-3 Nuts, install the 1299377-13 Reel Assembly Bracket on the aft outboard seat leg.
   D. (Figure 2, Views B-B and D-D.) With one AN4-6 Bolt, four NAS1149F0463P Washers, one NAS43DD4-8FC Spacer, one AN310-4 Nut, and one MS24665-134 Cotter Pin, install the 505590-403 Reel Assembly to the 1299377-13 Reel Assembly Bracket.
   E. (Refer to Figure 2, Detail A, View A-A, and View G-G.) Make the 1299377-16 Cable End Mounting Bracket.
      (1) Keep an edge distance of no less than two fastener diameters between the edge of the 1299377-16 Cable End Mounting Bracket and the center of the fasteners that you will install in the bracket.
      (2) Cut the 1299377-16 Cable End Mounting Bracket to the correct dimensions from the 1299377-24 Extrusion.
      (3) If necessary, remove material from the 1299377-16 Cable End Mounting Bracket or turn the MS21919WDG8 Clamps to make clearance for the seat frame and the seat stop pin. Make sure that you keep an edge distance of no less than two fastener diameters between the edge...
of the 1299377-16 Cable End Mounting Bracket and the center of the fasteners that you will install in the bracket.

(4) Remove the sharp edges of the 1299377-16 Cable End Mounting Bracket.

F. (Refer to Figure 2, Detail A and Views A-A and G-G.) Install the 1299377-16 Cable End Mounting Bracket.

(1) Temporarily install the S2300-26 Bracket on the center of the threaded end of the 505530-405 Cable Assembly.

**NOTE:** You can make the hole in the S2300-26 Bracket larger to a 0.312-inch diameter as necessary.

(2) Remove and discard the existing MS20392 Pin.

(3) (Refer to Figure 2, Detail B.) Temporarily install the 505530-405 Cable Assembly to the release handle or the release handle link with a new MS20392-1C21 Pin (or longer if necessary) and from one to three NAS1149FN432P Washers as necessary.

(4) Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

(5) Attach the 505530-405 Cable Assembly to the 505590-403 Reel Assembly.

(6) Put the seat stop in the fully engaged position.

(7) Drill two 0.203-inch diameter holes in the 1299377-16 Cable End Mounting Bracket for the bolts.

(8) Deburr the holes and apply Alodine to the bare metal.

(9) (Refer to Figure 2, View G-G.) Attach the 1299377-16 Cable End Mounting Bracket to the seat frame with the two MS21919WDG8 Clamps, AN525-10R8 Screws, NAS1149F0332P Washers, and MS21042-3 Nuts.

G. (Refer to Figure 2, Detail D.) Install the seat in the airplane with each of the seat stop pins fully inserted into a seat rail hole.

H. (Refer to Figure 2, Detail A and View A-A.) Move the 505530-405 Cable Assembly and the S2300-26 Bracket to the area shown and find the correct position for the S2300-26 Bracket.

I. (Refer to Figure 2, Detail B.) Make sure that the cable end axis stays no more than 30 degrees from the seat stop pin or the link centerline.

J. Put marks on the 1299377-16 Cable End Mounting Bracket at the rivet hole locations of the S2300-26 Bracket.

K. Remove the copilot seat.

L. (Refer to Figure 2, View A-A.) Remove the 505530-405 Cable Assembly from the MS20392-1C21 Pin.

M. Remove the S2300-26 Bracket from the 505530-405 Cable Assembly.

N. At the marks that you made, drill two Number 30 (0.128-inch diameter) holes in the 1299377-16 Cable End Mounting Bracket for the rivets for the S2300-26 Bracket.

O. Deburr the holes and apply Alodine to the bare metal.

P. (Refer to Figure 2, Detail A,) Install the S2300-26 Bracket to the 1299377-16 Cable End Mounting Bracket with the two MS20470AD4-6A Rivets.

Q. (Refer to Figure 2, View A-A,) Install the 505530-405 Cable Assembly in the S2300-26 Bracket with the two AN316-5R Nuts and the two MS35333-41 Lock Washers. Do not tighten the AN316-5R Nuts.

R. Attach the 505530-405 Cable Assembly to the MS20392-1C21 Pin again with from one to three NAS1149FN432P Washers as necessary. Install the MS20392 Pin, Spring, and NAS1149FN432P Washers in the sequence that gives the best alignment between the cable assembly and the release handle.
S. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

T. Install the copilot seat.

U. (Refer to Figure 2, Views C-C and F-F.) Install the 1299377-14 Doubler Assembly.
   (1) Find the best position under the floorboard to install the 1299377-14 Doubler Assembly.
      • It must be within the shaded area in View C-C of Figure 2.
      • It must be between the seat rails.
      • It must be aligned with the attach point of the 505590-403 Reel Assembly to the seat base frame.
      • There must be no interference between the 1299377-14 Doubler Assembly and the structure of the airplane.
      • With the seat in the forward locked position, the 1299377-14 Doubler must be forward of the 505590-403 Reel Assembly when it is installed on the seat frame.
      • There must be no interference between the left and the right sides of the seat frame and the belt path of the 505590-403 Reel Assembly.

   (2) Use the 1299377-14 Doubler Assembly as a pattern.

   (3) Drill one 0.266-inch diameter hole in the floorboard to match the center hole in the 1299377-14 Doubler Assembly.

   (4) Drill four Number 30 (0.128-inch diameter) holes through the floorboard for the rivets.

   (5) Deburr the holes and apply Alodine to the bare metal.

   (6) Install the 1299377-14 Doubler Assembly to the floorboard with the four MS20470AD4-4A Rivets.

V. (Refer to Figure 2, View F-F.) Attach the belt end fitting to the floorboard and the 1299377-14 Doubler Assembly with the AN4-5A Bolt and the NAS1149F0432P Washer.

   NOTE: You can use a longer AN4 Bolt as necessary to make sure that the bolt threads engage correctly.

W. (Refer to Figure 2, Detail D.) Put the seat stop pin on the top of the seat rail and put the seat in position.

6. (Refer to Figure 2, Details B and D and View A-A.) Adjust the manual lock as follows:
   A. Put the stop pins 0.10 inch above the seat rail.
   B. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to release the belt reel manual lock.
   C. Put the stop pin 0.05-inch above the seat rail.
   D. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to lock the belt reel manual lock.
   E. If necessary, do Step 6 again until you see that the manual lock operates correctly.

   WARNING: Do not torque the AN316-5R Nuts to more than 30 inch-pounds. If you tighten the nuts too much, you can cause damage to the ferrule, and the secondary seat stop may not operate correctly.

   F. Apply Loctite 242 to the threads and tighten the AN316-5R Nuts to lock the cable end in position with the MS35333-41 Lock Washers.

7. Install the H990000 Spiral Wrap on the seat frame where the belt of the 505590-403 Reel Assembly touches the seat frame.

8. Attach the 505530-405 Cable Assembly to the seat base as necessary with MS3367-5-0 Tie Straps.
9. Make sure that the 505530-405 Cable Assembly moves smoothly and freely during operation. If it does not move smoothly and freely, you must move the 505530-405 Cable Assembly as necessary and attach it to the seat base again with the MS3367-5-0 Tie Straps.

10. Install the airplane interior and the access panels that you removed.

11. Remove the maintenance warning tags and connect the airplane battery.

12. Make an entry in the airplane logbook stating this Service Kit has been installed.
Figure 2. Secondary Seat Stop Installation "A" (Sheet 1)
VIEW D–D
S21919WDG8 Clamp
AN525–10R8 Screw
NAS1149F0332P Washer
MS21042–3 Nut
(1 Each Required)

S21919WDG8 Clamp
AN525–10R8 Screw
NAS1149F0332P Washer
MS21042–3 Nut
(1 Each Required)

AN4–6 Bolt
NAS43DD4–8FC Spacer
AN310–4 Nut
MS24665–134 Cotter Pin
(1 Each Required)
NAS1149F0463P Washer
(4 Required)

505590–403 Inertia Reel Assembly
(1 Required)

OUTBD

VIEW F–F

AN4–5A Bolt
NAS1149F0432P Washer
(1 Each Required)

Floorboard
(Reference)

Figure 2. Secondary Seat Stop Installation "A" (Sheet 2)
Figure 2. Secondary Seat Stop Installation "A" (Sheet 3)
Secondary Seat Stop Installation "B"

1. Prepare the airplane for maintenance.
   A. Make sure that all switches are in the OFF/NORM position.
   B. Disconnect electrical power from the airplane.
      (1) Disconnect the airplane battery.
      (2) Disconnect external electrical power.
   C. Attach maintenance warning tags to the battery and external power receptacle that have "DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS" written on them.

2. Remove the airplane interior and the access panels as necessary to get access to the seats and floorboard areas where you must install the seat stop. (Refer to the applicable sections of the Service Manual.)

3. Do an inspection of the seat rails, rollers, roller housings, and stop pins. Refer to Cessna Service Information Letter SE83-6 and FAA Airworthiness Directive (AD) 87-20-03 Revision 2 or subsequent revision.

4. Repair or replace components as necessary.

5. Install the secondary seat stop.
   A. Remove the copilot seat.
   B. (Refer to Figure 3, Views B-B, C-C, D-D, and Step 5.S.) Align the MS21919WDG16 Clamp with the estimated position of the 1299377-14 Doubler Assembly on the floorboard and install it on the aft height-adjust tube with the AN525-10R8 Screw, NAS1149F0332P Washer, and MS21042-3 Nut.
   C. (Refer to Figure 3, Views B-B and D-D.) With the two MS21919WDG18 Clamps, AN525-10R10 Screws, NAS1149F0332P Washers, and MS21042-3 Nuts, install the 505590-403 Reel Assembly on the aft height-adjust tube.
   D. (Refer to Figure 3, Detail A.) Make the 1299377-17 Cable End Mounting Bracket.
      (1) Keep an edge distance of no less than two fastener diameters between the edge of the 1299377-17 Cable End Mounting Bracket and the center of the fasteners that you will install in the bracket.
      (2) Cut the 1299377-17 Cable End Mounting Bracket to the correct dimensions from the 1299377-24 Extrusion.
      (3) If necessary, remove material from the 1299377-17 Cable End Mounting Bracket to make clearance for the seat frame and the seat stop pin. Make sure that you keep an edge distance of no less than two fastener diameters between the edge of the 1299377-17 Cable End Mounting Bracket and the center of the fasteners that you will install in the bracket.
      (4) Remove the sharp edges of the 1299377-17 Cable End Mounting Bracket.
   E. (Refer to Figure 3, Detail A and Views A-A and F-F.) Install the 1299377-17 Cable End Mounting Bracket.
      (1) Temporarily install the S2300-26 Bracket on the center of the threaded end of the 505530-405 Cable Assembly.
         NOTE: You can make the hole in the S2300-26 Bracket larger to a 0.312-inch diameter as necessary.
      (2) Remove and discard the existing MS20392 Pin.
      (3) (Refer to Figure 3, Detail B.) Temporarily install the 505530-405 Cable Assembly to the release handle or the release handle link with a new MS20392-1C21 Pin (or longer if necessary) and from one to three NAS1149FN432P Washers as necessary.
      (4) Attach the spring or install the MS24665-132 Cotter Pin, as necessary.
(5) Attach the 505530-405 Cable Assembly to the 505590-403 Reel Assembly.

(6) Turn the 505530-405 Cable Assembly and the S2300-26 Bracket to the correct position.

(7) Drill two 0.203-inch diameter holes in the 1299377-17 Cable End Mounting Bracket for the bolts.

(8) Deburr the holes and apply Alodine to the bare metal.

(9) Attach the 1299377-17 Cable End Mounting Bracket to the seat base with the two MS21919WDG8 Clamps, NAS1149F0332P Washers, AN525-10R8 Screws, and MS21042-3 Nuts.

F. (Refer to Figure 3, Detail C.) Install the seat in the airplane with each of the seat stop pins fully inserted into a seat rail hole.

G. (Refer to Figure 3, View A-A.) Move the 505530-405 Cable Assembly and the S2300-26 Bracket to the position shown to find the correct position for the S2300-26 Bracket.

H. (Refer to Figure 3, Detail B.) Make sure that the cable end axis stays no more than 30 degrees from the seat stop pin or the link centerline.

I. Put marks on the 1299377-17 Cable End Mounting Bracket at the rivet hole locations of the S2300-26 Bracket.

J. Remove the copilot seat.

K. (Refer to Figure 3, View A-A.) Remove the 505530-405 Cable Assembly from the MS20392-1C21 Pin.

L. Remove the S2300-26 Bracket from the 505530-405 Cable Assembly.

M. At the marks that you made, drill two Number 30 (0.128-inch diameter) holes in the 1299377-17 Cable End Mounting Bracket for the rivets.

N. Deburr the holes and apply Alodine to the bare metal.

O. (Refer to Figure 3, Detail A.) Install the S2300-26 Bracket to the 1299377-17 Cable End Mounting Bracket with the two MS20470AD4-6A Rivets.

P. (Refer to Figure 3, View A-A.) Install the 505530-405 Cable Assembly in the S2300-26 Bracket with the two AN316-5R Nuts and the two MS35333-41 Lock Washers. Do not tighten the AN316-5R Nuts.

Q. Attach the 505530-405 Cable Assembly to the MS20392-1C21 Pin again with the three NAS1149FN432P Washers. Use one, two, or all of the washers as necessary.

R. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

S. (Refer to Figure 3, View C-C.) Install the 1299377-14 Doubler Assembly.

1. Find the best position under the floorboard to install the 1299377-14 Doubler Assembly.
   • It must be within the shaded area in View C-C of Figure 3.
   • It must be between the seat rails.
   • It must be aligned with the attach point of the 505590-403 Reel Assembly to the seat base frame.
   • There must be no interference between the 1299377-14 Doubler Assembly and the structure of the airplane.
   • With the seat in the forward locked position, the 1299377-14 Doubler must be forward of the 505590-403 Reel Assembly when it is installed on the seat frame.
   • There must be no interference between the left and the right sides of the seat frame and the belt path of the 505590-403 Reel Assembly.

2. Use the 1299377-14 Doubler Assembly as a pattern.

3. Drill four Number 30 (0.128-inch diameter) holes through the floorboard.
(4) Drill one 0.266-inch diameter hole in the floorboard to match the center hole in the 1299377-14 Doubler Assembly.

(5) Deburr the holes and apply Alodine to the bare metal.

(6) Install the 1299377-14 Doubler Assembly to the floorboard with the four MS20470AD4-4A Rivets.

T. Install the copilot seat.

U. (Refer to Figure 3, View E-E.) Attach the belt end fitting to the floorboard and the 1299377-14 Doubler Assembly with the AN4-5A Bolt and the NAS1149F0432P Washer.

**NOTE:** You can use a longer AN4 Bolt as necessary to make sure that the bolt threads engage correctly.

V. (Refer to Figure 3, Detail C.) Put the seat stop pin on the top of the seat rail and put the seat in position.

6. (Refer to Figure 3, Details B and C and View A-A.) Adjust the manual lock as follows:

   A. Put the stop pins 0.10 inch above the seat rail.

   B. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to release the belt reel manual lock.

   C. Put the stop pin 0.05-inch above the seat rail.

   D. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to lock the belt reel manual lock.

   E. If necessary, do Step 6 again until you see that the manual lock operates correctly.

**WARNING:** Do not torque the AN316-5R Nuts to more than 30 inch-pounds. If you tighten the nuts too much, you can cause damage to the ferrule, and the secondary seat stop may not operate correctly.

   F. Apply Loctite 242 to the threads and tighten the AN316-5R Nuts to lock the cable end in position with the MS35333-41 Lock Washers.

7. Install the H990000 Spiral Wrap on the seat frame where the belt of the 505590-403 Reel Assembly touches the seat frame.

8. Attach the 505530-405 Cable Assembly to the seat base as necessary with MS3367-5-0 Tie Straps.

9. Make sure that the 505530-405 Cable Assembly moves smoothly and freely during operation. If it does not move smoothly and freely, you must move the 505530-405 Cable Assembly as necessary and attach it to the seat base again with the MS3367-5-0 Tie Straps.

10. Install the airplane interior and the access panels that you removed.

11. Remove the maintenance warning tags and connect the airplane battery.

12. Make an entry in the airplane logbook stating this Service Kit has been installed.
NOTE 1: All dimensions are shown in inches.
NOTE 2: Install H990000 Spiral Wrap as required where the reel assembly touches the seat frame.

Figure 3. Secondary Seat Stop Installation "B" (Sheet 1)
Figure 3. Secondary Seat Stop Installation "B" (Sheet 2)
Figure 3. Secondary Seat Stop Installation "B" (Sheet 3)
Secondary Seat Stop Installation "C"

1. Prepare the airplane for maintenance.
   A. Make sure that all switches are in the OFF/NORM position.
   B. Disconnect electrical power from the airplane.
      1. Disconnect the airplane battery.
      2. Disconnect external electrical power.
   C. Attach maintenance warning tags to the battery and external power receptacle that have "DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS" written on them.

2. Remove the airplane interior and the access panels as necessary to get access to the seats and floorboard areas where you must install the seat stop. (Refer to the applicable sections of the Service Manual.)

3. Do an inspection of the seat rails, rollers, roller housings, and stop pins. Refer to Cessna Service Information Letter SE83-6 and FAA Airworthiness Directive (AD) 87-20-03 Revision 2 or subsequent revision.

4. Repair or replace components as necessary.

5. Install the secondary seat stop.
   A. Remove the copilot seat.
   B. (Refer to Figure 4, Views B-B and D-D.) Remove and discard the AN24-13A Bolt, washer, and nut that attach the right aft leg of the seat to the seat frame. Keep the spacer.
   C. Install the 505590-403 Reel Assembly to the seat frame and the aft leg of the seat with the AN4-16 Bolt, four NAS1149F0463P Washers, NAS43DD4-8FC Spacer, AN310-4 Nut, and MS24665-134 Cotter Pin as follows:
      1. Install three of the NAS1149F0463P Washers between the seat frame and the 505590-403 Reel Assembly and one of the NAS1149F0463P Washers under the AN310-4 Nut.
      2. If your airplane has the 1414112-1 Spacer/Nut installed also, discard it and install one NAS43DD4-32FC Spacer.
   D. (Refer to Figure 4, View A-A.) Temporarily install the S2300-26 Bracket on the center of the threaded end of the 505530-405 Cable Assembly.

   NOTE: You can make the hole in the S2300-26 Bracket larger to a 0.312-inch diameter as necessary.

   E. Remove and discard the existing MS20392 Pin.
   F. Temporarily install the 505530-405 Cable Assembly to the release handle or the release handle link with a new MS20392-1C21 Pin (or longer if necessary) and from one to three NAS1149FN432P Washers as necessary.
   G. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.
   H. Attach the 505530-405 Cable Assembly to the 505590-403 Reel Assembly.
   I. (Refer to Figure 4, Detail C.) Install the seat in the airplane with each of the seat stop pins fully inserted into a seat rail hole.
   J. (Refer to Figure 4, Detail A, View A-A.) Move the 505530-405 Cable Assembly and the S2300-26 Bracket to the position shown to find the correct position for the S2300-26 Bracket.
   K. (Refer to Figure 4, Detail B.) Make sure that the cable end axis stays no more than 30 degrees from the seat stop pin or the link centerline.
   L. Put marks on the seat leg at the rivet hole locations of the S2300-26 Bracket.
   M. Remove the copilot seat.
N. Drill two Number 30 (0.128-inch diameter) holes (as marked) in the seat leg for the rivets.

O. (Refer to Figure 4, View A-A.) Remove the 505530-405 Cable Assembly from the MS20392-1C21 Pin.

P. Remove the S2300-26 Bracket from the 505530-405 Cable Assembly.

Q. (Refer to Figure 4, Detail A.) Attach the S2300-26 Bracket to the left forward leg of the seat with the two S2906-4-3 Rivets.

R. (Refer to Figure 4, View A-A.) Install the 505530-405 Cable Assembly in the S2300-26 Bracket with the two AN316-5R Nuts and the two MS35333-41 Lock Washers. Do not tighten the AN316-5R Nuts.

S. Attach the 505530-405 Cable Assembly to the MS20392-1C21 Pin again with the three NAS1149FN432P Washers. Use one, two, or all of the washers as necessary.

T. Attach the stop pin spring or install the MS24665-132 Cotter Pin, as necessary.

U. (Refer to Figure 4, Views C-C and E-E.) Install the 1299377-14 Doubler Assembly.

1. Find the best position under the floorboard to install the 1299377-14 Doubler Assembly.
   • It must be within the shaded area in View C-C of Figure 4.
   • It must be between the seat rails.
   • It must be aligned with the attach point of the 505590-403 Reel Assembly to the seat base frame.
   • There must be no interference between the 1299377-14 Doubler Assembly and the structure of the airplane.
   • With the seat in the forward locked position, the 1299377-14 Doubler must be forward of the 505590-403 Reel Assembly when it is installed on the seat frame.
   • There must be no interference between the left and the right sides of the seat frame and the belt path of the 505590-403 Reel Assembly.

2. Use the 1299377-14 Doubler Assembly as a pattern.

3. Drill one 0.266-inch diameter hole in the floorboard to match the center hole in the 1299377-14 Doubler Assembly.

4. Drill four Number 30 (0.128-inch diameter) holes through the floorboard.

5. Deburr the holes and apply Alodine to the bare metal.

6. Install the 1299377-14 Doubler Assembly to the floorboard with the four MS20470AD4-4A Rivets.

V. Attach the belt end fitting to the floorboard and the 1299377-14 Doubler Assembly with the AN4-5A Bolt and the NAS1149F0432P Washer.

NOTE: You can use a longer AN4 Bolt as necessary to make sure that the bolt threads engage correctly.

W. (Refer to Figure 4, Detail C.) Put the seat stop pin on the top of the seat rail and put the seat in position.

6. (Refer to Figure 4, Details B and C and View A-A.) Adjust the manual lock as follows:

A. Put the stop pins 0.10 inch above the seat rail.

B. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to release the belt reel manual lock.

C. Put the stop pin 0.05-inch above the seat rail.

D. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to lock the belt reel manual lock.

E. If necessary, do Step 6 again until you see that the manual lock operates correctly.
WARNING: Do not torque the AN316-5R Nuts to more than 30 inch-pounds. If you tighten the nuts too much, you can cause damage to the ferrule, and the secondary seat stop may not operate correctly.

F. Apply Loctite 242 to the threads and tighten the AN316-5R Nuts to lock the cable end in position with the MS35333-41 Lock Washers.

7. Attach the 505530-405 Cable Assembly to the seat base as necessary with MS3367-5-0 Tie Straps.

8. Make sure that the 505530-405 Cable Assembly moves smoothly and freely during operation. If it does not move smoothly and freely, you must move the 505530-405 Cable Assembly as necessary and attach it to the seat base again with the MS3367-5-0 Tie Straps.

9. Install the airplane interior and the access panels that you removed.

10. Remove the maintenance warning tags and connect the airplane battery.

11. Make an entry in the airplane logbook stating this Service Kit has been installed.
Figure 4. Secondary Seat Stop Installation "C" (Sheet 1)
Figure 4. Secondary Seat Stop Installation "C" (Sheet 2)

NOTE 1: All dimensions are shown in inches.

NOTE 2: Install three NAS1149F0463F Washers between the seat frame and the 505590-403 Inertia Reel Assembly and one NAS1149F0463P Washer under the AN310-4 Nut.
Secondary Seat Stop Installation "D"

1. Prepare the airplane for maintenance.
   A. Make sure that all switches are in the OFF/NORM position.
   B. Disconnect electrical power from the airplane.
      (1) Disconnect the airplane battery.
      (2) Disconnect external electrical power.
   C. Attach maintenance warning tags to the battery and external power receptacle that have "DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS" written on them.

2. Remove the airplane interior and the access panels as necessary to get access to the seats and floorboard areas where you must install the seat stop. (Refer to the applicable sections of the Service Manual.)

3. Do an inspection of the seat rails, rollers, roller housings, and stop pins. Refer to Cessna Service Information Letter SE83-6 and FAA Airworthiness Directive (AD) 87-20-03 Revision 2 or subsequent revision.

4. Repair or replace components as necessary.

5. Install the secondary seat stop.
   A. Remove the copilot seat.
   B. (Refer to Figure 5, Views B-B and D-D.) Remove and discard the AN24-13A Bolt, washer, and nut that attach the left aft leg of the seat to the seat frame. Keep the spacer.
   C. Install the 505590-403 Reel Assembly to the seat frame and the left aft leg of the seat with the AN4-16 Bolt, four NAS1149F0463P Washers, NAS43DD4-8FC Spacer, AN310-4 Nut, and MS24665-134 Cotter Pin as follows:
      (1) Put one NAS1149F0463P Washer under the bolt head, put one NAS1149F0463P Washer between the seat frame and the reel, and put two NAS1149F0463P Washers under the nut.
      (2) If your airplane has the 1414112-1 Spacer/Nut installed also, discard it and install one NAS43DD4-32FC Spacer.
   D. (Refer to Figure 5, Detail A, View F-F.) Make the 1299377-19 Cable End Mounting Bracket.
      (1) Keep an edge distance of no less than two fastener diameters between the edge of the 1299377-19 Cable End Mounting Bracket and the center of the fasteners that you will install in the bracket.
      (2) Cut the 1299377-19 Cable End Mounting Bracket to the correct dimensions from the 1299377-24 Extrusion.
      (3) Remove the sharp edges of the 1299377-19 Cable End Mounting Bracket.
   E. Install the 1299377-19 Cable End Mounting Bracket.
      (1) (Refer to Figure 5, View A-A.) Temporarily install the S2300-26 Bracket on the center of the threaded end of the 505530-405 Cable Assembly.
         NOTE: You can make the hole in the S2300-26 Bracket larger to a 0.312-inch diameter as necessary.
      (2) Remove and discard the existing MS20392 Pin.
      (3) Temporarily install the 505530-405 Cable Assembly to the release handle or the release handle link with a new MS20392-1C21 Pin (or longer if necessary) and from one to three NAS1149FN432P Washers as necessary.
      (4) Attach the spring or install the MS24665-132 Cotter Pin, as necessary.
      (5) Attach the 505530-405 Cable Assembly to the 505590-403 Reel Assembly.
(6) Temporarily install the copilot seat.

(7) (Refer to Figure 5, Detail C.) Put the seat stop in the fully engaged position.

(8) (Refer to Figure 5, View A-A.) Move the 505530-405 Cable Assembly and the S2300-26 Bracket to the correct position.

(9) Put marks on the seat frame at the location of the 1299377-19 Cable End Mounting Bracket.

(10) Remove the copilot seat.

(11) Drill two Number 30 (0.128-inch diameter) holes in the 1299377-19 Cable End Mounting Bracket for the rivets that attach the 1299377-19 Bracket to the seat frame.

(12) Deburr the holes and apply Alodine to the bare metal.

(13) Match drill two Number 30 (0.128-inch diameter) holes through the 1299377-19 Bracket into the seat frame to install the 1299377-19 Cable End Mounting Bracket. Drill through only one side of the seat base frame tube.

(14) Deburr the holes and apply Alodine to the bare metal.

(15) (Refer to Figure 5, Detail A.) Attach the 1299377-19 Cable End Mounting Bracket to the seat frame with the two S2906-4-3 Rivets.

6. (Refer to Figure 5, Detail C.) Install the seat in the airplane with each of the seat stop pins fully inserted into a seat rail hole.

7. (Refer to Figure 5, Detail A-A.) Move the 505530-405 Cable Assembly and the S2300-26 Bracket to the position shown to find the correct position for the S2300-26 Bracket.

8. (Refer to Figure 5, Detail B.) Make sure that the cable end axis stays no more than 30 degrees from the seat stop pin or the link centerline.

9. Put marks on the 1299377-19 Cable End Mounting Bracket at the rivet hole locations of the S2300-26 Bracket.

10. Remove the copilot seat.

11. (Refer to Figure 5, View A-A.) Remove the 505530-405 Cable Assembly from the MS20392 Pin.

12. Remove the S2300-26 Bracket from the 505530-405 Cable Assembly.

13. Drill two Number 30 (0.128-inch diameter) holes in the 1299377-19 Cable End Mounting Bracket for the rivets that attach the S2300-26 Bracket to the 1299377-19 Bracket.

14. Deburr the holes and apply Alodine to the bare metal.

15. (Refer to Figure 5, Detail A and View A-A.) Install the S2300-26 Bracket to the 1299377-19 Cable End Mounting Bracket with the two MS20470AD4-6A Rivets.

16. Install the 505530-405 Cable Assembly in the S2300-26 Bracket with the two AN316-5R Nuts and the two MS35333-41 Lock Washers. Do not tighten the AN316-5R Nuts.

17. Attach the 505530-405 Cable Assembly to the MS20392 Pin again with the three NAS1149FN432P Washers. Use one, two, or all of the washers as necessary.

18. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

19. (Refer to Figure 5, Views C-C and E-E.) Install the 1299377-14 Doubler Assembly.

A. Find the best position under the floorboard to install the 1299377-14 Doubler Assembly.
   • It must be within the shaded area in View C-C of Figure 5.
   • It must be between the seat rails.
   • It must be aligned with the attach point of the 505590-403 Reel Assembly to the seat base frame.
   • There must be no interference between the 1299377-14 Doubler Assembly and the structure of the airplane.
• With the seat in the forward locked position, the 1299377-14 Doubler must be forward of the
505590-403 Reel Assembly when it is installed on the seat frame.
• There must be no interference between the left and the right sides of the seat frame and the
belt path of the 505590-403 Reel Assembly.

B. Use the 1299377-14 Doubler Assembly as a pattern.
C. Drill one 0.266-inch diameter hole in the floorboard to match the center hole in the 1299377-14
Doubler Assembly.
D. Drill four Number 30 (0.128-inch diameter) holes through the floorboard for the rivets.
E. Install the copilot seat.
F. Install the 1299377-14 Doubler Assembly to the floorboard with the four MS20470AD4-4A Rivets.

20. (Refer to Figure 5, View E-E.) Attach the belt end fitting to the floorboard and the 1299377-14 Doubler
Assembly with the AN4-5A Bolt and the NAS1149F0432P Washer.

NOTE: You can use a longer AN4 Bolt as necessary to make sure that the bolt threads engage correctly.

21. (Refer to Figure 5, Detail C.) Put the seat stop pin on the top of the seat rail and put the seat in position.

22. (Refer to Figure 5, Details B and C and View A-A.) Adjust the manual lock follows:
A. Put the stop pins 0.10 inch above the seat rail.
B. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to release
the belt reel manual lock.
C. Put the stop pin 0.05-inch above the seat rail.
D. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to lock the
belt reel manual lock.
E. If necessary, do Step 22 again until you see that the manual lock operates correctly.

WARNING: Do not torque the AN316-5R Nuts to more than 30 inch-pounds. If you tighten
the nuts too much, you can cause damage to the ferrule, and the secondary
seat stop may not operate correctly.
F. Apply Loctite 242 to the threads and tighten the AN316-5R Nuts to lock the cable end in position
with the MS35333-41 Lock Washers.

23. Attach the 505530-405 Cable Assembly to the seat base as necessary with MS3367-5-0 Tie Straps.

24. Make sure that the 505530-405 Cable Assembly moves smoothly and freely during operation. If it does
not move smoothly and freely, you must move the 505530-405 Cable Assembly as necessary and attach
it to the seat base again with the MS3367-5-0 Tie Straps.

25. Install the airplane interior and the access panels that you removed.

26. Remove the maintenance warning tags and connect the airplane battery.

27. Make an entry in the airplane logbook stating this Service Kit has been installed.
**NOTE 1:** All dimensions are shown in inches.

**NOTE 2:** Install the 1299377–19 Cable End Mounting Bracket on the inner or the outer side of the seat base frame as necessary to make the cable align straight with the handle.

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Figure 5. Secondary Seat Stop Installation "D" (Sheet 1)
Figure 5. Secondary Seat Stop Installation "D" (Sheet 2)
Figure 5. Secondary Seat Stop Installation "D" (Sheet 3)
Secondary Seat Stop Installation "E"

1. Prepare the airplane for maintenance.
   A. Make sure that all switches are in the OFF/NORM position.
   B. Disconnect electrical power from the airplane.
      (1) Disconnect the airplane battery.
      (2) Disconnect external electrical power.
   C. Attach maintenance warning tags to the battery and external power receptacle that have "DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS" written on them.

2. Remove the airplane interior and the access panels as necessary to get access to the seats and floorboard areas where you must install the seat stop. (Refer to the applicable sections of the Service Manual.)

3. Do an inspection of the seat rails, rollers, roller housings, and stop pins. Refer to Cessna Service Information Letter SE83-6 and FAA Airworthiness Directive (AD) 87-20-03 Revision 2 or subsequent revision.

4. Repair or replace components as necessary.

5. Install the secondary seat stop.
   A. Remove the copilot seat.
   B. (Refer to Figure 6, Views B-B and D-D.) Install the 505590-403 Reel Assembly on the footrest.
      (1) (Refer to Figure 6, View C-C.) Align the attachment point of the 505590-403 Reel Assembly with the estimated attachment point of the 1299377-14 Doubler Assembly.
      (2) (Refer to Figure 6, View B-B and Step 5.R.) Find the best position for the 505590-403 Reel Assembly on the footrest.
      (3) Drill four 0.203-inch diameter holes in the footrest for the screws.
      (4) With the four AN525-10R10 Screws, NAS1149F0332P Washers, and MS21042-3 Nuts, install the 505590-403 Reel Assembly to the footrest.
   C. (Refer to Figure 6, View A-A.) Temporarily install the S2300-26 Bracket on the center of the threaded end of the 505530-405 Cable Assembly.
      NOTE: You can make the hole in the S2300-26 Bracket larger to a 0.312-inch diameter as necessary.
   D. Remove and discard the existing MS20392 Pin.
   E. (Figure 6, View A-A and Detail B.) Temporarily install the 505530-405 Cable Assembly to the seat adjustment lever link with a new MS20392-1C21 Pin (use a shorter or a longer MS20392 Pin if necessary) and from one to three NAS1149FN432P Washers as necessary.
   F. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.
   G. Attach the 505530-405 Cable Assembly to the 505590-403 Reel Assembly.
   H. (Refer to Figure 6, Detail C.) Install the seat in the airplane with each of the seat stop pins fully inserted into a seat rail hole.
   I. (Refer to Figure 6, View A-A and Detail B.) Move the 505530-405 Cable Assembly and the S2300-26 Bracket to the position shown to find the correct position for the S2300-26 Bracket and make marks at the rivet hole locations.
   J. (Refer to Figure 6, Detail B.) Make sure that the cable end axis stays no more than 30 degrees from the seat stop pin or the link centerline.
   K. (Refer to Figure 6, View A-A.) Remove the 505530-405 Cable Assembly from the MS20392-1C21 Pin.
L. Remove the S2300-26 Bracket from the 505530-405 Cable Assembly.

M. In the position that you found in Step 5I, drill two Number 30 (0.128-inch diameter) holes.

N. Install the S2300-26 Bracket to the 1299377-19 Cable End Mounting Bracket with the two MS20470AD4-6A Rivets.

O. Install the 505530-405 Cable Assembly in the S2300-26 Bracket with the two AN316-5R Nuts and the two MS35333-41 Lock Washers. Do not tighten the AN316-5R Nuts.

P. Attach the 505530-405 Cable Assembly to the MS20392-1C21 Pin again with the three NAS1149FN432P Washers. Use one, two, or all of the washers as necessary.

Q. Attach the stop pin spring or install the MS24665-132 Cotter Pin, as necessary.

R. (Refer to Figure 6, Views C-C and E-E.) Install the 1299377-14 Doubler Assembly.
   (1) Find the best position under the floorboard to install the 1299377-14 Doubler Assembly.
      • It must be within the shaded area in View C-C of Figure 6.
      • It must be between the seat rails.
      • It must be aligned with the attach point of the 505590-403 Reel Assembly to the seat base frame.
      • There must be no interference between the 1299377-14 Doubler Assembly and the structure of the airplane.
      • With the seat in the forward locked position, the 1299377-14 Doubler must be forward of the 505590-403 Reel Assembly when it is installed on the seat frame.
      • There must be no interference between the left and the right sides of the seat frame and the belt path of the 505590-403 Reel Assembly.
   (2) Use the 1299377-14 Doubler Assembly as a pattern.
   (3) Drill one 0.266-inch diameter hole through the floorboard for the AN4-5A Bolt.
   (4) Drill four Number 30 (0.128-inch diameter) holes through the floorboard.
   (5) Install the 1299377-14 Doubler Assembly to the floorboard with the four MS20470AD4-4A Rivets.

S. Attach the belt end fitting to the floorboard and the 1299377-14 Doubler Assembly with the AN4-5A Bolt and the NAS1149F0432P Washer.

NOTE: You can use a longer AN4 Bolt as necessary to make sure that the bolt threads engage correctly.

6. (Refer to Figure 6, Detail C.) Put the seat stop pin on the top of the seat rail and put the seat in position.

7. (Refer to Figure 6, Details B and C.) Adjust the manual lock as follows:
   A. Put the stop pins 0.10 inch above the seat rail.
   B. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to release the belt reel manual lock.
   C. Put the stop pin 0.05-inch above the seat rail.
   D. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to lock the belt reel manual lock.
   E. If necessary, do Step 7 again until you see that the manual lock operates correctly.

WARNING: Do not torque the AN316-5R Nuts to more than 30 inch-pounds. If you tighten the nuts too much, you can cause damage to the ferrule, and the secondary seat stop may not operate correctly.

F. Apply Loctite 242 to the threads and tighten the AN316-5R Nuts to lock the cable end in position with the MS35333-41 Lock Washers.
8. Attach the 505530-405 Cable Assembly to the seat base as necessary with MS3367-5-0 Tie Straps.

9. Make sure that the 505530-405 Cable Assembly moves smoothly and freely during operation. If it does not move smoothly and freely, you must move the 505530-405 Cable Assembly as necessary and attach it to the seat base again with the MS3367-5-0 Tie Straps.

10. Install the airplane interior and the access panels that you removed.

11. Remove the maintenance warning tags and connect the airplane battery.

12. Make an entry in the airplane logbook stating this Service Kit has been installed.
Figure 6. Secondary Seat Stop Installation "E" (Sheet 1)

- **View A-A**
  - 505530-405 Cable Assembly (Reference)
  - AN316-5R Nut
  - MS35333-41 Lock Washer (2 Each Required)
  - MS20392-1C21 Pin
  - MS24665-132 Cotter Pin (1 Each Required)
  - NAS1149FN432P Washer (As Required, 3 Maximum)

- **View B-B**
  - 505590-403 Inertia Reel Assembly (Reference)
  - Seat Rail (Reference)

- **View C-C**
  - Belt End Fitting (Reference)
  - 0.266-Inch Diameter Hole (1 Required)
  - 0.128-Inch Diameter Hole (MS20470AD4-4A Rivet (4 Each Required))

- **View D**
  - Footrest (Reference)
  - 0.203-Inch Diameter Hole (4 Required)
  - AN525-10R10 Screw (Reference)
Figure 6. Secondary Seat Stop Installation "E" (Sheet 2)
NOTE: All dimensions are shown in inches.

Figure 6. Secondary Seat Stop Installation "E" (Sheet 3)
Secondary Seat Stop Installation "F"

1. Prepare the airplane for maintenance.
   A. Make sure that all switches are in the OFF/NORM position.
   B. Disconnect electrical power from the airplane.
      (1) Disconnect the airplane battery.
      (2) Disconnect external electrical power.
   C. Attach maintenance warning tags to the battery and external power receptacle that have "DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS" written on them.

2. Remove the airplane interior and the access panels as necessary to get access to the seats and floorboard areas where you must install the seat stop. (Refer to the applicable sections of the Service Manual.)

3. Do an inspection of the seat rails, rollers, roller housings, and stop pins. Refer to Cessna Service Information Letter SE83-6 and FAA Airworthiness Directive (AD) 87-20-03 Revision 2 or subsequent revision.

4. Repair or replace components as necessary.

5. Install the secondary seat stop.
   A. Remove the copilot seat.
   B. (Refer to Figure 7, Views C-C and E-E.) Install the 1299377-14 Doubler Assembly.
      (1) Find the best position under the floorboard to install the 1299377-14 Doubler Assembly.
         • It must be within the shaded area in View C-C of Figure 7.
         • It must be between the seat rails.
         • It must be aligned with the attach point of the 505590-403 Reel Assembly to the seat base frame.
         • There must be no interference between the 1299377-14 Doubler Assembly and the structure of the airplane.
         • With the seat in the forward locked position, the 1299377-14 Doubler must be forward of the 505590-403 Reel Assembly when it is installed on the seat frame.
         • There must be no interference between the left and the right sides of the seat frame and the belt path of the 505590-403 Reel Assembly.
      (2) Use the 1299377-14 Doubler Assembly as a pattern.
      (3) Drill one 0.266-inch diameter hole through the floorboard for the AN4-5A Bolt.
      (4) Drill four Number 30 (0.128-inch diameter) holes through the floorboard for the rivets.
      (5) Install the 1299377-14 Doubler Assembly to the floorboard with the four MS20470AD4-4A Rivets.
   C. (Refer to Figure 7, Views B-B and D-D.) Align the MS21919WDG16 Clamp with the 1299377-14 Doubler Assembly. Center the MS21919WDG16 Clamp between the two MS21919WDG18 Clamps to correctly align the reel with the belt attachment.
   D. Install the MS21919WDG16 Clamp with the AN525-10R8 Screw, NAS1149F0332P Washer, and MS21042-3 Nut.
   E. With the two MS21919WDG18 Clamps, AN525-10R10 Screws, NAS1149F0332P Washer, and MS21042-3 Nuts, install the 505590-403 Reel Assembly on the aft height-adjust tube.
   F. (Refer to Figure 7, View A-A.) Temporarily install the S2300-26 Bracket on the center of the threaded end of the 505530-405 Cable Assembly.
      NOTE: You can make the hole in the S2300-26 Bracket larger to a 0.312-inch diameter as necessary.
   G. Remove and discard the existing MS20392 Pin.
H. (Refer to Figure 7, View A-A and Detail B.) Temporarily install the 505530-405 Cable Assembly to the seat adjustment lever link or the seat adjustment lever bell crank with a new MS20392-1C21 Pin (or longer if necessary) and from one to three NAS1149FN432P Washers as necessary.

I. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

J. Attach the 505530-405 Cable Assembly to the 505590-403 Reel Assembly.

K. (Refer to Figure 7, Detail C.) Install the seat in the airplane with each of the seat stop pins fully inserted into a seat rail hole.

L. (Refer to Figure 7 View A-A and Detail B.) Move the 505530-405 Cable Assembly and the S2300-26 Bracket to the position shown to find the correct position for the S2300-26 Bracket and make marks at the rivet hole locations.

M. (Refer to Figure 7, Detail B.) Make sure that the cable end axis stays no more than 30 degrees from the seat stop pin or the link centerline.

N. (Refer to Figure 7, View A-A.) Remove the 505530-405 Cable Assembly from the MS20392-1C21 Pin.

O. Remove the S2300-26 Bracket from the 505530-405 Cable Assembly.

P. (Refer to Figure 7, Detail A.) In the position that you found in Step 5L, drill two Number 30 (0.128-inch diameter) holes.

Q. Install the S2300-26 Bracket to the 1299377-19 Cable End Mounting Bracket with the two MS20470AD4-6A Rivets.

R. (Refer to Figure 7, View A-A.) Install the 505530-405 Cable Assembly in the S2300-26 Bracket with the two AN316-5R Nuts and the two MS35333-41 Lock Washers. Do not tighten the AN316-5R Nuts.

S. Attach the 505530-405 Cable Assembly to the MS20392-1C21 Pin again with the three NAS1149FN432P Washers. Use one, two, or all of the washers as necessary.

T. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

U. (Refer to Figure 7, View E-E.) Attach the belt end fitting to the floorboard and the 1299377-14 Doubler Assembly with the AN4-5A Bolt and the NAS1149F0432P Washer.

NOTE: You can use a longer AN4 Bolt as necessary to make sure that the bolt threads engage correctly.

6. (Refer to Figure 7, Detail C.) Put the seat stop pin on the top of the seat rail and put the seat in position.

7. (Refer to Figure 7, Details B and C.) Adjust the manual lock as follows:

A. Put the stop pins 0.10 inch above the seat rail.

B. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to release the belt reel manual lock.

C. Put the stop pin 0.05-inch above the seat rail.

D. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to lock the belt reel manual lock.

E. If necessary, do Step 7 again until you see that the manual lock operates correctly.

WARNING: Do not torque the AN316-5R Nuts to more than 30 inch-pounds. If you tighten the nuts too much, you can cause damage to the ferrule, and the secondary seat stop may not operate correctly.

F. Apply Loctite 242 to the threads and tighten the AN316-5R Nuts to lock the cable end in position with the MS35333-41 Lock Washers.

8. Attach the 505530-405 Cable Assembly to the seat base as necessary with MS3367-5-0 Tie Straps.
9. Make sure that the 505530-405 Cable Assembly moves smoothly and freely during operation. If it does not move smoothly and freely, you must move the 505530-405 Cable Assembly as necessary and attach it to the seat base again with the MS3367-5-0 Tie Straps.

10. Install the airplane interior and the access panels that you removed.

11. Remove the maintenance warning tags and connect the airplane battery.

12. Make an entry in the airplane logbook stating this Service Kit has been installed.
Figure 7. Secondary Seat Stop Installation "F" (Sheet 1)
Figure 7. Secondary Seat Stop Installation "F" (Sheet 2)
Figure 7. Secondary Seat Stop Installation "F" (Sheet 3)

NOTE: All dimensions are shown in inches.
Secondary Seat Stop Installation "G"

1. Prepare the airplane for maintenance.
   A. Make sure that all switches are in the OFF/NORM position.
   B. Disconnect electrical power from the airplane.
      (1) Disconnect the airplane battery.
      (2) Disconnect external electrical power.
   C. Attach maintenance warning tags to the battery and external power receptacle that have "DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS" written on them.

2. Remove the airplane interior and the access panels as necessary to get access to the seats and floorboard areas where you must install the seat stop. (Refer to the applicable sections of the Service Manual.)

3. Do an inspection of the seat rails, rollers, roller housings, and stop pins. Refer to Cessna Service Information Letter SE83-6 and FAA Airworthiness Directive (AD) 87-20-03 Revision 2 or subsequent revision.

4. Repair or replace components as necessary.

5. Install the secondary seat stop.
   A. Remove the copilot seat.
   B. (Refer to Figure 8, Views C-C and E-E.) Install the 1299377-14 Doubler Assembly.
      (1) Find the best position under the floorboard to install the 1299377-14 Doubler Assembly.
         • It must be within the shaded area in View C-C of Figure 8.
         • It must be between the seat rails.
         • It must be aligned with the attach point of the 505590-403 Reel Assembly to the seat base frame.
         • There must be no interference between the 1299377-14 Doubler Assembly and the structure of the airplane.
         • With the seat in the forward locked position, the 1299377-14 Doubler must be forward of the 505590-403 Reel Assembly when it is installed on the seat frame.
         • There must be no interference between the left and the right sides of the seat frame and the belt path of the 505590-403 Reel Assembly.
      (2) Use the 1299377-14 Doubler Assembly as a pattern.
      (3) Drill one 0.266-inch diameter hole through the floorboard for the AN4-5A Bolt.
      (4) Drill four Number 30 (0.128-inch diameter) holes through the floorboard for the rivets.
      (5) Deburr the holes and apply Alodine to the bare metal.
      (6) Install the 1299377-14 Doubler Assembly to the floorboard with the four MS20470AD4-4A Rivets.
   C. (Refer to Figure 8, View D-D.) Align the MS21919WDG16 Clamp with the 1299377-14 Doubler Assembly. Center the MS21919WDG16 Clamp between the two MS21919WDG18 Clamps to correctly align the reel with the belt attachment.
   D. Install the MS21919WDG16 Clamp with the AN525-10R8 Screw, NAS1149F0332P Washer, and MS21042-3 Nut.
   E. With the two MS21919WDG18 Clamps, AN525-10R10 Screws, NAS1149F0332P Washers, and MS21042-3 Nuts, install the 505590-403 Reel Assembly on the aft height-adjust tube.
   F. (Refer to Figure 8, Detail A and View F-F.) Make the 1299377-20 Cable End Mounting Bracket.
      (1) Keep an edge distance of no less than two fastener diameters between the edge of the 1299377-20 Cable End Mounting Bracket and the center of the fasteners that you will install in the bracket.
(2) Cut the 1299377-20 Cable End Mounting Bracket to the correct dimensions from the 1299377-24 Extrusion.

(3) Remove the sharp edges of the 1299377-20 Cable End Mounting Bracket.

G. Drill out the existing rivets from the Number 21 (0.159-inch diameter) holes in the leg.

H. (Refer to Figure 8, View A-A.) Temporarily install the S2300-26 Bracket on the center of the threaded end of the 505530-405 Cable Assembly.

NOTE: You can make the hole in the S2300-26 Bracket larger to a 0.312-inch diameter as necessary.

I. Remove and discard the existing MS20392 Pin.

J. (Refer to Figure 8, View A-A and Detail B.) Temporarily install the 505530-405 Cable Assembly to the seat adjustment lever link or the seat adjustment lever bell crank with a new MS20392-1C21 Pin (or longer if necessary) and from one to three NAS1149FN432P Washers as necessary.

K. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

L. Attach the 505530-405 Cable Assembly to the 505590-403 Reel Assembly.

M. (Refer to Figure 8, Detail C.) Install the seat in the airplane with each of the seat stop pins fully inserted into a seat rail hole.

N. (Refer to Figure 8, View A-A and Detail B.) Move the 505530-405 Cable Assembly and the S2300-26 Bracket to the position shown for the S2300-26 Bracket and make marks at the rivet hole locations on the 1299377-20 Cable End Mounting Bracket.

O. Drill two Number 21 (0.159-inch diameter) holes in the 1299377-20 Cable End Mounting Bracket for the rivets that attach the 1299377-20 Cable End Mounting Bracket to the seat frame.

P. Deburr the holes and apply Alodine to the bare metal.

Q. (Refer to Figure 8, Detail A.) Attach the 1299377-20 Cable End Mounting Bracket to the seat base with the two MS20470AD5-17A Rivets.

R. (Refer to Figure 8, Detail C.) Install the seat in the airplane with each of the seat stop pins fully inserted into a seat rail hole.

S. Move the S2300-26 Bracket to the position shown to find the correct position for the S2300-26 Bracket and make marks for the rivet locations of the S2300-26 Bracket.

T. Refer to Figure 8, Detail B.) Make sure that the cable end axis stays no more than 30 degrees from the seat stop pin or the link centerline.

U. (Refer to Figure 8, View A-A.) Remove the 505530-405 Cable Assembly from the MS20392-1C21 Pin.

V. Remove the S2300-26 Bracket from the 505530-405 Cable Assembly.

W. Drill two Number 30 (0.128-inch diameter) holes in the 1299377-20 Cable End Mounting Bracket for the rivets that attach the S2300-26 Bracket to the 1299377-20 Cable End Mounting Bracket.

X. (Refer to Figure 8, View F-F.) Install the S2300-26 Bracket to the 1299377-20 Cable End Mounting Bracket with the two MS20470AD4-6A Rivets.

Y. (Refer to Figure 8, View A-A.) Install the 505530-405 Cable Assembly in the S2300-26 Bracket with the two AN316-5R Nuts and the two MS35333-41 Lock Washers. Do not tighten the AN316-5R Nuts.

Z. Attach the 505530-405 Cable Assembly to the MS20392-1C21 Pin again with the three NAS1149FN432P Washers. Use one, two, or all of the washers as necessary.

AA. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.
AB. (Refer to Figure 8, View E-E.) Attach the belt end fitting to the floorboard and the 1299377-14 Doubler Assembly with the AN4-5A Bolt and the NAS1149F0432P Washer.

NOTE: You can use a longer AN4 Bolt as necessary to make sure that the bolt threads engage correctly.

6. (Refer to Figure 8, Detail C.) Put the seat stop pin on the top of the seat rail and put the seat in position.

7. (Refer to Figure 8, Details B and C.) Adjust the manual lock as follows:
   A. Put the stop pins 0.10 inch above the seat rail.
   B. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to release the belt reel manual lock.
   C. Put the stop pin 0.05-inch above the seat rail.
   D. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to lock the belt reel manual lock.
   E. If necessary, do Step 7 again until you see that the manual lock operates correctly.

   WARNING: Do not torque the AN316-5R Nuts to more than 30 inch-pounds. If you tighten the nuts too much, you can cause damage to the ferrule, and the secondary seat stop may not operate correctly.

   F. Apply Loctite 242 to the threads and tighten the AN316-5R Nuts to lock the cable end in position with the MS35333-41 Lock Washers.

8. Attach the 505530-405 Cable Assembly to the seat base as necessary with MS3367-5-0 Tie Straps.

9. Make sure that the 505530-405 Cable Assembly moves smoothly and freely during operation. If it does not move smoothly and freely, you must move the 505530-405 Cable Assembly as necessary and attach it to the seat base again with the MS3367-5-0 Tie Straps.

10. (Refer to Figure 8.) With EC1300LP Adhesive or equivalent, install H880015 Grommet as necessary where the 505590-403 Reel Assembly touches the seat frame.

11. Install the airplane interior and the access panels that you removed.

12. Remove the maintenance warning tags and connect the airplane battery.

13. Make an entry in the airplane logbook stating this Service Kit has been installed.
Figure 8. Secondary Seat Stop Installation "G" (Sheet 1)

NOTE 1: All dimensions are shown in inches.

NOTE 2: Install H880015 Grommet as required where the 505590–403 Inertia Reel Assembly touches the seat frame.
Figure 8. Secondary Seat Stop Installation "G" (Sheet 2)
Figure 8. Secondary Seat Stop Installation "G" (Sheet 3)
Secondary Seat Stop Installation "H"

1. Prepare the airplane for maintenance.
   A. Make sure that all switches are in the OFF/NORM position.
   B. Disconnect electrical power from the airplane.
      (1) Disconnect the airplane battery.
      (2) Disconnect external electrical power.
   C. Attach maintenance warning tags to the battery and external power receptacle that have "DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS" written on them.

2. Remove the airplane interior and the access panels as necessary to get access to the seats and floorboard areas where you must install the seat stop. (Refer to the applicable sections of the Service Manual.)

3. Do an inspection of the seat rails, rollers, roller housings, and stop pins. Refer to Cessna Service Information Letter SE83-6 and FAA Airworthiness Directive (AD) 87-20-03 Revision 2 or subsequent revision.

4. Repair or replace components as necessary.

5. Install the secondary seat stop.
   A. Remove the copilot seat.
   B. (Refer to Figure 9, Views C-C and E-E.) Install the 1299377-14 Doubler Assembly.
      (1) Find the best position under the floorboard to install the 1299377-14 Doubler Assembly.
      • It must be within the shaded area in View C-C of Figure 9.
      • It must be between the seat rails.
      • It must be aligned with the attach point of the 505590-403 Reel Assembly to the seat base frame.
      • There must be no interference between the 1299377-14 Doubler Assembly and the structure of the airplane.
      • With the seat in the forward locked position, the 1299377-14 Doubler must be forward of the 505590-403 Reel Assembly when it is installed on the seat frame.
      • There must be no interference between the left and the right sides of the seat frame and the belt path of the 505590-403 Reel Assembly.
      (2) Use the 1299377-14 Doubler Assembly as a pattern.
      (3) Drill one 0.266-inch diameter hole through the floorboard for the AN4-5A Bolt.
      (4) Drill four Number 30 (0.128-inch diameter) holes through the floorboard.
      (5) Deburr the holes and apply Alodine to bare metal.
      (6) Install the 1299377-14 Doubler Assembly to the floorboard with the four MS20470AD4-4A Rivets.
   C. (Refer to Figure 9, View B-B.) Align the MS21919WDG16 Clamp with the 1299377-14 Doubler Assembly. Center the MS21919WDG16 Clamp between the two MS21919WDG18 Clamps to correctly align the reel with the belt attachment.
   D. (Refer to Figure 9, View D-D.) Install the MS21919WDG16 Clamp with the AN525-10R8 Screw, NAS1149F0332P Washer, and MS21042-3 Nut.
   E. With the two MS21919WDG18 Clamps, AN525-10R10 Screws, NAS1149F0332P Washers, and MS21042-3 Nuts, install the 505590-403 Reel Assembly on the aft height-adjust tube.
   F. (Refer to Figure 9, Detail A and View F-F.) Make the 1299377-21 Cable End Mounting Bracket.
      (1) Keep an edge distance of no less than two fastener diameters between the edge of the 1299377-21 Cable End Mounting Bracket and the center of the fasteners that you will install in the bracket.
(2) Cut the 1299377-21 Cable End Mounting Bracket to the correct dimensions from the 1299377-24 Extrusion.

(3) Remove the sharp edges of the 1299377-21 Cable End Mounting Bracket.

G. Drill out the existing rivets from the Number 21 (0.159-inch diameter) holes in the leg.

H. (Refer to Figure 9, View A-A.) Temporarily install the S2300-26 Bracket on the center of the threaded end of the 505530-405 Cable Assembly.

NOTE: You can make the hole in the S2300-26 Bracket larger to a 0.312-inch diameter as necessary.

I. Remove and discard the existing MS20392 Pin.

J. Temporarily install the 505530-405 Cable Assembly with the MS20392-1C21 Pin (or longer if necessary) and from one to three NAS1149FN432P Washers as necessary.

K. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

L. Attach the 505530-405 Cable Assembly to the 505590-403 Reel Assembly.

M. (Refer to Figure 9, Detail C.) Put the seat stop in the fully engaged position.

N. (Refer to Figure 9, Detail A and View A-A.) Move the 505530-405 Cable Assembly and the S2300-26 Bracket to the position shown for the S2300-26 Bracket and make marks at the rivet hole locations on the 1299377-20 Cable End Mounting Bracket.

O. Drill two Number 21 (0.159-inch diameter) holes in the 1299377-21 Cable End Mounting Bracket for the rivets that attach the 1299377-21 Cable End Mounting Bracket to the seat frame.

1. Deburr the holes and apply Alodine to the bare metal.

P. (Refer to Figure 9, Detail A.) Attach the 1299377-21 Cable End Mounting Bracket to the seat frame with the two MS20470AD5-17A Rivets.

6. (Refer to Figure 9, Detail C.) Install the seat in the airplane with each of the seat stop pins fully inserted into a seat rail hole.

7. (Refer to Figure 9, Detail A and View A-A.) Move the S2300-26 Bracket to the position shown to find the correct position for the S2300-26 Bracket and make marks for the rivet locations of the S2300-26 Bracket.

8. (Refer to Figure 9, Detail B.) Make sure that the cable end axis stays no more than 30 degrees from the seat stop pin or the link centerline.

9. Remove the 505530-451 Cable Assembly from the MS20392-1C21 Pin.

10. Remove the S2300-26 Bracket from the 505530-405 Cable Assembly.

11. Drill two Number 30 (0.128-inch diameter) holes in the 1299377-21 Cable End Mounting Bracket for the rivets that attach the S2300-26 Bracket to the 1299377-21 Cable End Mounting Bracket.

A. Deburr the holes and apply Alodine to the bare metal.

12. (Refer to Figure 9, View F-F.) Install the S2300-26 Bracket to the 1299377-21 Cable End Mounting Bracket with the two MS20470AD4-6A Rivets.

13. (Refer to Figure 9, View A-A.) Install the 505530-405 Cable Assembly in the S2300-26 Bracket with the two AN316-5R Nuts and the two MS35333-41 Lock Washers. Do not tighten the AN316-5R Nuts.

14. Attach the 505530-405 Cable Assembly to the MS20392-1C21 Pin again with the three NAS1149FN432P Washers. Use one, two, or all of the washers as necessary.

15. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

16. (Refer to Figure 9, View E-E.) Attach the belt end fitting to the floorboard and the 1299377-14 Doubler Assembly with the AN4-5A Bolt and the NAS1149FO432P Washer.

NOTE: You can use a longer bolt as necessary to make sure that the bolt threads engage correctly.
17. (Refer to Figure 9, Details B and C.) Adjust the manual lock works correctly as follows:
   A. Put the stop pins 0.10-inch above the seat rail.
   B. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to release the belt reel manual lock.
   C. Put the stop pin 0.05-inch above the seat rail.
   D. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to lock the belt reel manual lock.
   E. If necessary, do Step 17 again until you see that the manual lock operates correctly.

   **WARNING:** Do not torque the AN316-5R Nuts to more than 30 inch-pounds. If you tighten the nuts too much, you can cause damage to the ferrule, and the secondary seat stop may not operate correctly.

   F. Apply Loctite 242 to the threads and tighten the AN316-5R Nuts to lock the cable end in position with the MS35333-41 Lock Washers.

18. Attach the 505530-405 Cable Assembly to the seat base as necessary with MS3367-5-0 Tie Straps.

19. Make sure that the 505530-405 Cable Assembly moves smoothly and freely during operation. If it does not move smoothly and freely, you must move the 505530-405 Cable Assembly as necessary and attach it to the seat base again with the MS3367-5-0 Tie Straps.

20. (Refer to Figure 9.) With EC1300LP Adhesive or equivalent, install H880015 Grommet as necessary where the 505590-403 Reel Assembly touches the seat frame.

21. Install the airplane interior and the access panels that you removed.

22. Remove the maintenance warning tags and connect the airplane battery.

23. Make an entry in the airplane logbook stating this Service Kit has been installed.
NOTE 1: All dimensions are shown in inches.

NOTE 2: Install H880015 Grommet as necessary where the 505590–403 Inertia Reel Assembly touches the seat frame.

Figure 9. Secondary Seat Stop Installation "H" (Sheet 1)
Figure 9. Secondary Seat Stop Installation "H" (Sheet 2)
Figure 9. Secondary Seat Stop Installation "H" (Sheet 3)
Secondary Seat Stop Installation "J"

1. Prepare the airplane for maintenance.
   A. Make sure that all switches are in the OFF/NORM position.
   B. Disconnect electrical power from the airplane.
      (1) Disconnect the airplane battery.
      (2) Disconnect external electrical power.
   C. Attach maintenance warning tags to the battery and external power receptacle that have "DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS" written on them.

2. Remove the airplane interior and the access panels as necessary to get access to the seats and floorboard areas where you must install the seat stop. (Refer to the applicable sections of the Service Manual.)

3. Do an inspection of the seat rails, rollers, roller housings, and stop pins. Refer to Cessna Service Information Letter SE83-6 and FAA Airworthiness Directive (AD) 87-20-03 Revision 2 or subsequent revision.

4. Repair or replace components as necessary.

5. Install the secondary seat stop.
   A. Remove the copilot seat.
   B. (Refer to Figure 10, Views C-C and E-E.) Install the 1299377-14 Doubler Assembly.
      (1) Find the best position under the floorboard to install the 1299377-14 Doubler Assembly.
         • It must be within the shaded area in View C-C of Figure 10.
         • It must be between the seat rails.
         • It must be aligned with the attach point of the 505590-403 Reel Assembly to the seat base frame.
         • There must be no interference between the 1299377-14 Doubler Assembly and the structure of the airplane.
         • With the seat in the forward locked position, the 1299377-14 Doubler must be forward of the 505590-403 Reel Assembly when it is installed on the seat frame.
         • There must be no interference between the left and the right sides of the seat frame and the belt path of the 505590-403 Reel Assembly.
      (2) Use the 1299377-14 Doubler Assembly as a pattern.
      (3) Drill one 0.266-inch diameter hole through the floorboard for the AN4-5A Bolt.
      (4) Drill four Number 30 (0.128-inch diameter) holes through the floorboard for the rivets.
      (5) Deburr the holes and apply Alodine to the bare metal.
      (6) Install the 1299377-14 Doubler Assembly to the floorboard with the four MS20470AD4-4A Rivets.
   C. (Refer to Figure 10, Views B-B and D-D.) Align the MS21919WDG16 Clamp with the 1299377-14 Doubler Assembly. Center the MS21919WDG16 Clamp between the two MS21919WDG18 Clamps to correctly align the reel with the belt attachment.
   D. Install the MS21919WDG16 Clamp with the AN525-10R8 Screw, NAS1149F0332P Washer, and MS21042-3 Nut.
   E. With the two MS21919WDG18 Clamps, AN525-10R10 Screws, NAS1149F0332P Washers, and MS21042-3 Nuts, install the 505590-403 Reel Assembly on the aft height-adjust tube.
   F. (Refer to Figure 10, Detail A and View F-F.) Make the 1299377-22 Cable End Mounting Bracket.
      (1) Keep an edge distance of no less than two fastener diameters between the edge of the 1299377-22 Cable End Mounting Bracket and the center of the fasteners that you will install in the bracket.
Cut the 1299377-22 Cable End Mounting Bracket to the correct dimensions from the 1299377-24 Extrusion.

If necessary, remove material from the 1299377-22 Cable End Mounting Bracket to make clearance for the seat frame and the bracket. Make sure that you keep an edge distance of no less than two fastener diameters between the edge of the 1299377-22 Cable End Mounting Bracket and the center of the fasteners that you will install in the bracket.

Remove the sharp edges of the 1299377-22 Cable End Mounting Bracket.

G. (Refer to Figure 10, Detail A and View A-A.) Install the 1299377-22 Cable End Mounting Bracket.

Temporarily install the S2300-26 Bracket on the center of the threaded end of the 505530-405 Cable Assembly.

NOTE: You can make the hole in the S2300-26 Bracket larger to a 0.312-inch diameter as necessary.

Remove and discard the existing MS20392 Pin.

(Refer to Figure 10, View A-A and Detail B.) Temporarily install the 505530-405 Cable Assembly to the seat adjustment lever link or the seat adjustment lever bell crank with a new MS20392-1C21 Pin (or longer if necessary) and from one to three NAS1149FN432P Washers as necessary.

Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

(Refer to Figure 10, View A-A.) Attach the 505530-405 Cable Assembly to the 505590-403 Reel Assembly.

Put the seat stop in the fully engaged position.

Put the 1299377-22 Cable End Mounting Bracket on the seat frame as shown and make marks at the four rivet hole locations.

Match drill four Number 30 (0.128-inch diameter) holes in the seat frame.

Deburr the holes and apply Alodine to the bare metal.

(Refer to Figure 10, Detail A.) Attach the 1299377-22 Cable End Mounting Bracket to the seat base with the four MS20470AD4-6A Rivets.

Install the seat in the airplane with each of the seat stop pins fully inserted into a seat rail hole.

Move the 505530-405 Cable Assembly and the S2300-26 Bracket to the position shown to find the correct position for the S2300-26 Bracket.

Make sure that the cable end axis stays no more than 30 degrees from the seat stop pin or the link centerline.

Make marks at the rivet hole locations of the S2300-26 Bracket on the 1299377-22 Cable End Mounting Bracket.

(Refer to Figure 10, View A-A.) Remove the 505530-405 Cable Assembly from the MS20392-1C21 Pin.

Remove the S2300-26 Bracket from the 505530-405 Cable Assembly.

Drill two Number 30 (0.128-inch diameter) holes in the 1299377-22 Cable End Mounting Bracket for the rivets that install the S2300-26 Bracket to the 1299377-22 Cable End Mounting Bracket.

Deburr the holes and apply Alodine to the bare metal.

(Refer to Figure 10, View F-F.) Install the S2300-26 Bracket on the 1299377-21 Cable End Mounting Bracket with the two MS20470AD4-6A Rivets.

(Refer to Figure 10, View A-A.) Install the 505530-405 Cable Assembly in the S2300-26 Bracket with the two AN316-5R Nuts and the two MS35333-41 Lock Washers. Do not tighten the AN316-5R Nuts.
16. Attach the 505530-405 Cable Assembly to the MS20392-1C21 Pin again with the three NAS1149FN432P Washers. Use one, two, or all of the washers as necessary.

17. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

18. (Refer to Figure 10, View E-E.) Attach the belt end fitting to the floorboard and the 1299377-14 Doubler Assembly with the AN4-5A Bolt and the NAS1149F0432P Washer.

**NOTE:** You can use a longer AN4 Bolt as necessary to make sure that the bolt threads engage correctly.

19. (Refer to Figure 10, Detail C.) Put the seat stop pin on the top of the seat rail and put the seat in position.

20. (Refer to Figure 10, Details B and C.) Adjust the manual lock as follows:
   
   A. Put the stop pins 0.10 inch above the seat rail.
   
   B. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to release the belt reel manual lock.
   
   C. Put the stop pin 0.05-inch above the seat rail.
   
   D. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to lock the belt reel manual lock.
   
   E. If necessary, do Step 20 again until you see that the manual lock operates correctly.

   **WARNING:** Do not torque the AN316-5R Nuts to more than 30 inch-pounds. If you tighten the nuts too much, you can cause damage to the ferrule, and the secondary seat stop may not operate correctly.

   F. Apply Loctite 242 to the threads and tighten the AN316-5R Nuts to lock the cable end in position with the MS35333-41 Lock Washers.

21. Attach the 505530-405 Cable Assembly to the seat base as necessary with MS3367-5-0 Tie Straps.

22. Make sure that the 505530-405 Cable Assembly moves smoothly and freely during operation. If it does not move smoothly and freely, you must move the 505530-405 Cable Assembly as necessary and attach it to the seat base again with the MS3367-5-0 Tie Straps.

23. Install the airplane interior and the access panels that you removed.

24. Remove the maintenance warning tags and connect the airplane battery.

25. Make an entry in the airplane logbook stating this Service Kit has been installed.
Figure 10. Secondary Seat Stop Installation "J" (Sheet 1)
Figure 10. Secondary Seat Stop Installation "J" (Sheet 2)
Figure 10. Secondary Seat Stop Installation "J" (Sheet 3)
Secondary Seat Stop Installation "K"

1. Prepare the airplane for maintenance.
   A. Make sure that all switches are in the OFF/NORM position.
   B. Disconnect electrical power from the airplane.
      (1) Disconnect the airplane battery.
      (2) Disconnect external electrical power.
   C. Attach maintenance warning tags to the battery and external power receptacle that have "DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS" written on them.

2. Remove the airplane interior and the access panels as necessary to get access to the seats and floorboard areas where you must install the seat stop. (Refer to the applicable sections of the Service Manual.)

3. Do an inspection of the seat rails, rollers, roller housings, and stop pins. Refer to Cessna Service Information Letter SE83-6 and FAA Airworthiness Directive (AD) 87-20-03 Revision 2 or subsequent revision.

4. Repair or replace components as necessary.

5. Install the secondary seat stop.
   A. Remove the copilot seat.
   B. (Refer to Figure 11, Views C-C and E-E.) Install the 1299377-14 Doubler Assembly.
      (1) Find the best position under the floorboard to install the 1299377-14 Doubler Assembly.
      • It must be within the shaded area in View C-C of Figure 11.
      • It must be between the seat rails.
      • It must be aligned with the attach point of the 505590-403 Reel Assembly to the seat base frame.
      • There must be no interference between the 1299377-14 Doubler Assembly and the structure of the airplane.
      • With the seat in the forward locked position, the 1299377-14 Doubler must be forward of the 505590-403 Reel Assembly when it is installed on the seat frame.
      • There must be no interference between the left and the right sides of the seat frame and the belt path of the 505590-403 Reel Assembly.
      (2) Use the 1299377-14 Doubler Assembly as a pattern.
      (3) Drill one 0.266-inch diameter hole through the floorboard for the AN4-5A Bolt.
      (4) Drill four Number 30 (0.128-inch diameter) holes through the floorboard.
      (5) Deburr the holes and apply Alodine to the bare metal.
      (6) Install the 1299377-14 Doubler Assembly to the floorboard with the four MS20470AD4-4A Rivets.
   C. Align the MS21919WDG16 Clamp with the 1299377-14 Doubler Assembly. Center the MS21919WDG16 Clamp between the two MS21919WDG18 Clamps to correctly align the reel with the belt attachment.
   D. (Refer to Figure 11, Views B-B and D-D.) Install the MS21919WDG16 Clamp on the aft height-adjust tube with the AN525-10R8 Screw, NAS1149F0332P Washer, and MS21042-3 Nut.
   E. (Refer to Figure 11, Detail B and view B-B.) Make one 1299377-12 Left Bracket and one 1299377-30 Right Bracket.
      (1) Keep an edge distance of no less than two fastener diameters between the edge of the 1299377-12 Left Bracket (1299377-30 Right Bracket) and the center of the fasteners that you will install in the bracket.
(2) Cut the 1299377-12 Left Bracket and the 1299377-30 Right Bracket to the correct dimensions from the 1299377-24 Extrusion.

(3) Drill one 0.203-inch diameter hole in the 1299377-12 Left Bracket and one 0.203-inch diameter hole in the 1299377-30 Right Bracket for the MS21919WDG18 Clamps.

(4) Match drill two 0.203-inch diameter holes in the 1299377-12 Left Bracket and two 0.203-inch diameter holes in the 1299377-30 Right Bracket for the 505590-403 Reel Assembly.

(5) Remove sharp edges, deburr the holes, and apply Alodine to the bare metal.

F. Install the 1299377-12 Left Bracket and the 1299377-30 Right Bracket on the 505590-403 Reel Assembly with four AN525-10R10 Screws, four NAS1149F0332P Washers, and four MS21042-3 Nuts.

G. (Refer to Figure 11, View B-B.) Install the 505590-403 Reel Assembly on the aft height-adjust tube with two MS21919WDG18 Clamps, two AN525-10R10 Screws, two NAS1149F0332P Washers, and two MS21042-3 Nuts.

H. (Refer to Figure 11, Detail A and View F-F.) Make the 1299377-23 Cable End Mounting Bracket.
   
   (1) Keep an edge distance of no less than two fastener diameters between the edge of the 1299377-23 Cable End Mounting Bracket and the fasteners that you will install in the bracket.

   (2) Cut the 1299377-23 Cable End Mounting Bracket from the 1299377-24 Extrusion and make sure that there will be sufficient clearance between the installed 1299377-23 Cable End Mounting Bracket and all areas of the seat structure.

   (3) If necessary, change the 1299377-23 Cable End Mounting Bracket to give clearance between the installed 1299377-23 Cable End Mounting Bracket, seat frame structure, and seat stop pin.

   (4) Remove the sharp edges of the 1299377-23 Cable End Mounting Bracket.

I. (Refer to Figure 11, Detail A.) Install the 1299377-23 Cable End Mounting Bracket as follows:
   
   (1) Temporarily install the S2300-26 Bracket on the center of the threaded end of the 505530-405 Cable Assembly.

   
   **NOTE:** You can make the hole in the S2300-26 Bracket larger to a 0.312-inch diameter as necessary.

   (2) Remove and discard the existing MS20392 Pin.

   (3) (Refer to Figure 11, View A-A, Detail A, and Detail C.) Temporarily install the 505530-405 Cable Assembly to the seat release handle or the seat stop pin with a new MS20392-1C21 Pin (or longer if necessary) and from one to three NAS1149FN432P Washers as necessary.

   (4) Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

   (5) (Refer to Figure 11, Detail D.) Attach the 505530-405 Cable Assembly to the 505590-403 Reel Assembly.

   (6) (Refer to Figure 11, Detail D.) Put the seat stop in the fully engaged position.

   (7) (Refer to Figure 11, Detail A.) Put the 1299377-23 Cable End Mounting Bracket on the seat frame as shown and make four marks for the rivet holes.

   (8) Drill four Number 30 (0.128-inch diameter) holes in the 1299377-23 Cable End Mounting Bracket.

   (9) Match drill four Number 30 (0.128-inch diameter) holes in the seat frame.

   (10) Deburr the holes and apply Alodine to the bare metal

   (11) Attach the 1299377-23 Cable End Mounting Bracket to the seat frame with the four MS20470AD4-6A Rivets.
6. (Refer to Figure 11, Detail D.) Install the seat in the airplane with each of the seat stop pins fully inserted into a seat rail hole.

7. (Refer to Figure 11, View A-A.) Move the 505530-405 Cable Assembly and the S2300-26 Bracket to the position shown to find the correct position for the S2300-26 Bracket.

8. (Refer to Figure 11, Detail C.) Make sure that the cable end axis stays no more than 30 degrees from the seat stop pin or the link centerline.

9. (Refer to Figure 11, View A-A and Detail A.) Make marks for the rivet hole locations of the S2300-26 Bracket on the 1299377-23 Cable End Mounting Bracket.

10. (Refer to Figure 11, View A-A.) Remove the 505530-405 Cable Assembly from the MS20392-1C21 Pin.

11. Remove the S2300-26 Bracket from the 505530-405 Cable Assembly.

12. Drill two Number 30 (0.128-inch diameter) holes in the 1299377-23 Cable End Mounting Bracket for the rivets that install the S2300-26 Bracket to the 1299377-23 Cable End Mounting Bracket.

13. Deburr the holes and apply Alodine to the bare metal.

14. (Refer to Figure 11, View F-F.) In the position that you found in Step 7, install the S2300-26 Bracket to the 1299377-23 Cable End Mounting Bracket with the two MS20470AD4-6A Rivets.

15. (Refer to Figure 11, View A-A.) Install the 505530-405 Cable Assembly in the S2300-26 Bracket with the two AN316-5R Nuts and the two MS35333-41 Lock Washers. Do not tighten the AN316-5R Nuts.

16. Attach the 505530-405 Cable Assembly to the MS20392-1C21 Pin again with the three NAS1149FN432P Washers. Use one, two, or all of the washers as necessary.

17. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

18. (Refer to Figure 11, View E-E.) Attach the belt end fitting to the floorboard and the 1299377-14 Doubler Assembly with the AN4-5A Bolt and the NAS1149F0432P Washer.

   NOTE: You can use a longer AN4 Bolt as necessary to make sure that the bolt threads engage correctly.

19. (Refer to Figure 11, Details C and D.) Adjust the manual lock as follows:

   A. Put the stop pins 0.010 inch above the seat rail.
   B. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to release the belt reel manual lock.
   C. Put the stop pin 0.05-inch above the seat rail.
   D. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to lock the belt reel manual lock.
   E. If necessary, do Step 19 again until you see that the manual lock operates correctly.

   WARNING: Do not torque the AN316-5R Nuts to more than 30 inch-pounds. If you tighten the nuts too much, you can cause damage to the ferrule, and the secondary seat stop may not operate correctly.

   F. Apply Loctite 242 to the threads and tighten the AN316-5R Nuts to lock the cable end in position with the MS35333-41 Lock Washers.

20. Attach the 505530-451 Cable Assembly to the seat base as necessary with MS3367-5-0 Tie Straps.

21. Make sure that the 505530-405 Cable Assembly moves smoothly and freely during operation. If it does not move smoothly and freely, you must move the 505530-405 Cable Assembly as necessary and attach it to the seat base again with the MS3367-5-0 Tie Straps.

22. Install the airplane interior and the access panels that you removed.

23. Remove the maintenance warning tags and connect the airplane battery.

24. Make an entry in the airplane logbook stating this Service Kit has been installed.
Figure 11. Secondary Seat Stop Installation "K" (Sheet 1)

NOTE: All dimensions are shown in inches.
Figure 11. Secondary Seat Stop Installation "K" (Sheet 2)
Figure 11. Secondary Seat Stop Installation "K" (Sheet 3)
Secondary Seat Stop Installation "L"

1. Prepare the airplane for maintenance.
   A. Make sure that all switches are in the OFF/NORM position.
   B. Disconnect electrical power from the airplane.
      (1) Disconnect the airplane battery.
      (2) Disconnect external electrical power.
   C. Attach maintenance warning tags to the battery and external power receptacle that have "DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS" written on them.

2. Remove the airplane interior and the access panels as necessary to get access to the seats and floorboard areas where you must install the seat stop. (Refer to the applicable sections of the Service Manual.)

3. Do an inspection of the seat rails, rollers, roller housings, and stop pins. Refer to Cessna Service Information Letter SE83-6 and FAA Airworthiness Directive (AD) 87-20-03 Revision 2 or subsequent revision.

4. Replace or repair components as necessary.

5. Install the secondary seat stop.
   A. Remove the copilot seat.
   B. (Refer to Figure 12, Detail B.) Make the 1299377-13 Reel Assembly Bracket.
      (1) Cut the 1299377-13 Reel Assembly Bracket to the correct dimensions from the 1299377-24 Extrusion.
      (2) Drill two 0.203-inch diameter holes in the 1299377-13 Reel Assembly Bracket.
         **NOTE:** These holes are for the bolts that attach the clamps to the 1299377-13 Reel Assembly Bracket. The clamps will attach the 1299377-13 Reel Assembly Bracket to the aft inboard leg of the seat.
      (3) Drill one 0.266-inch diameter hole in the 1299377-13 Reel Assembly Bracket.
         **NOTE:** This hole is used to attach the 505590-403 Reel Assembly to the 1299377-13 Reel Assembly Bracket.
      (4) Deburr the holes and apply Alodine to the bare metal.
   C. (Refer to Figure 12, Views F-F and G-G.) With the two MS21919WDG10 Clamps, AN525-10R8 Screws, NAS1149F0332P Washers, and MS21042-3 Nuts, install the 1299377-13 Bracket on the aft inboard seat leg.
   D. Refer to Figure 12, Detail C.) With one MS21919WDG8 Clamp, AN525-10R8 Screw, NAS1149F0332P Washer, and MS21042-3 Nut, attach the 1299377-13 Bracket to the aft inboard seat leg. You must install the reel on the aft seat leg on the same side (inboard or outboard) as the seat latch pin.
   E. (Figure 12, View B-B and View F-F.) With one AN4-6 Bolt, four NAS1149F0463P Washers, one NAS43DD4-8FC Spacer, one AN310-4 Nut, and one MS24665-134 Cotter Pin, install the 505590-403 Reel Assembly to the 1299377-13 Bracket.
   F. (Refer to Figure 12, Views A-A, D-D, and E-E.) Make the 1299377-16 Cable End Mounting Bracket.
      (1) Keep an edge distance of no less than two fastener diameters between the edge of the 1299377-16 Cable End Mounting Bracket and the center of the fasteners that you will install in the bracket.
      (2) Cut the 1299377-16 Cable End Mounting Bracket to the correct dimensions from the 1299377-24 Extrusion.
(3) If necessary, remove material from the 1299377-16 Cable End Mounting Bracket or turn the MS21919WDG8 Clamps to make clearance for the seat frame and the seat stop pin. Make sure that you keep an edge distance of no less than two fastener diameters between the edge of the 1299377-16 Cable End Mounting Bracket and the center of the fasteners that you will install in the bracket.

(4) Remove the sharp edges of the 1299377-16 Cable End Mounting Bracket.

G. (Refer to Figure 12, Views A-A, D-D, and E-E.) Install the 1299377-16 Cable End Mounting Bracket.

1. Temporarily install the S2300-26 Bracket on the center of the threaded end of the 505530-405 Cable Assembly.

   NOTE: You can make the hole in the S2300-26 Bracket larger to a 0.312-inch diameter as necessary.

2. Remove and discard the existing MS20392 Pin.

3. (Refer to Figure 12, View A-A and Detail A.) Temporarily install the 505530-405 Cable Assembly to the release handle or the release handle link with a new MS20392-1C21 Pin (or longer if necessary) and from one to three NAS1149FN432P Washers as necessary.

4. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

5. Attach the 505530-405 Cable Assembly to the 505590-403 Reel Assembly.

6. Put the seat stop in the fully engaged position.

7. (Refer to Figure 12, View D-D.) Drill two 0.203-inch diameter holes in the 1299377-16 Cable End Mounting Bracket for the bolts.

8. Deburr the holes and apply Alodine to the bare metal.

9. (Refer to Figure 12, View E-E.) Attach the 1299377-16 Cable End Mounting Bracket to the seat frame with the two MS21919WDG8 Clamps, AN525-10R8 Screws, NAS1149F0332P Washers, and MS21042-3 Nuts.

H. (Refer to Figure 12, Detail D.) Install the seat in the airplane with each of the seat stop pins fully inserted into a seat rail hole.

I. (Refer to Figure 12, View A-A and View D-D.) Move the 505530-405 Cable Assembly and the S2300-26 Bracket to the area shown and find the correct position for the S2300-26 Bracket.

J. (Refer to Figure 12, Detail A.) Make sure that the cable end axis stays no more than 30 degrees from the seat stop pin or the link centerline.

K. (Refer to Figure 12, View D-D.) Put marks on the 1299377-16 Cable End Mounting Bracket at the rivet hole locations of the S2300-26 Bracket.

L. Remove the copilot seat.

M. (Refer to Figure 12, View A-A.) Remove the 505530-405 Cable Assembly from the MS20392-1C21 Pin.

N. Remove the S2300-26 Bracket from the 505530-405 Cable Assembly.

O. (Refer to Figure 12, View D-D.) At the marks that you made, drill two Number 30 (0.128-inch diameter) holes in the 1299377-16 Cable End Mounting Bracket for the rivets for the S2300-26 Bracket.

P. Deburr the holes and apply Alodine to the bare metal.

Q. Install the S2300-26 Bracket to the 1299377-16 Cable End Mounting Bracket with the two MS20470AD4-6A Rivets.

R. (Refer to Figure 12, View A-A.) Install the 505530-405 Cable Assembly in the S2300-26 Bracket with the two AN316-5R Nuts and the two MS35333-41 Lock Washers. Do not tighten the AN316-5R Nuts.
S. Attach the 505530-405 Cable Assembly to the MS20392-1C21 Pin again with from one to three NAS1149FN432P Washers as necessary. Install the MS20392 Pin, spring, and NAS1149FN432P Washers in the sequence that gives the best alignment between the cable assembly and the release handle.

T. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

U. Install the copilot seat.

V. (Refer to Figure 12, Views C-C and H-H) Install the 1299377-14 Doubler Assembly.
   (1) Find the best position under the floorboard to install the 1299377-14 Doubler Assembly.
   • It must be within the shaded area in View C-C of Figure 12.
   • It must be between the seat rails.
   • It must be aligned with the attach point of the 505590-403 Reel Assembly to the seat base frame.
   • There must be no interference between the 1299377-14 Doubler Assembly and the structure of the airplane.
   • With the seat in the forward locked position, the 1299377-14 Doubler must be forward of the 505590-403 Reel Assembly when it is installed on the seat frame.
   • There must be no interference between the left and the right sides of the seat frame and the belt path of the 505590-403 Reel Assembly.
   (2) Use the 1299377-14 Doubler Assembly as a pattern.
   (3) Drill one 0.266-inch diameter hole in the floorboard to match the center hole in the 1299377-14 Doubler Assembly.
   (4) Drill four Number 30 (0.128-inch diameter) holes through the floorboard for the rivets.
   (5) Deburr the holes and apply Alodine to the bare metal.
   (6) Install the 1299377-14 Doubler Assembly to the floorboard with the four MS20470AD4-4A Rivets.

W. (Refer to Figure 12, View H-H) Attach the belt end fitting to the floorboard and the 1299377-14 Doubler Assembly with the AN4-5A Bolt and the NAS1149F0432P Washer.
   \[NOTE:] You can use a longer AN4 Bolt as necessary to make sure that the bolt threads engage correctly.

X. (Refer to Figure 12, Detail D) Put the seat stop pin on the top of the seat rail and put the seat in position.

6. (Refer to Figure 12, Details A and D and View A-A) Adjust the manual lock as follows:
   A. Put the stop pins 0.10 inch above the seat rail.
   B. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to release the belt reel manual lock.
   C. Put the stop pin 0.05-inch above the seat rail.
   D. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to lock the belt reel manual lock.
   E. If necessary, do Step 6 again until you see that the manual lock operates correctly.

   \[WARNING:] Do not torque the AN316-5R Nuts to more than 30 inch-pounds. If you tighten the nuts too much, you can cause damage to the ferrule, and the secondary seat stop may not operate correctly.

   F. Apply Loctite 242 to the threads and tighten the AN316-5R Nuts to lock the cable end in position with the MS35333-41 Lock Washers.

7. Install the H990000 Spiral Wrap on the seat frame where the belt of the 505590-403 Reel Assembly touches the seat frame.
8. Attach the 505530-405 Cable Assembly to the seat base as necessary with MS3367-5-0 Tie Straps.

9. Make sure that the 505530-405 Cable Assembly moves smoothly and freely during operation. If it does not move smoothly and freely, you must move the 505530-405 Cable Assembly as necessary and attach it to the seat base again with the MS3367-5-0 Tie Straps.

10. Install the airplane interior and the access panels that you removed.

11. Remove the maintenance warning tags and connect the airplane battery.

12. Make an entry in the airplane logbook stating this Service Kit has been installed.
Figure 12. Secondary Seat Stop Installation "L" (Sheet 1)
Figure 12. Secondary Seat Stop Installation "L" (Sheet 2)
Figure 12. Secondary Seat Stop Installation "L" (Sheet 3)
Figure 12. Secondary Seat Stop Installation "L" (Sheet 4)
Figure 12. Secondary Seat Stop Installation "L" (Sheet 5)
Figure 12. Secondary Seat Stop Installation "L" (Sheet 6)
Figure 12. Secondary Seat Stop Installation "L" (Sheet 7)
Secondary Seat Stop Installation "M"

1. Prepare the airplane for maintenance.
   A. Make sure that all switches are in the OFF/NORM position.
   B. Disconnect electrical power from the airplane.
      (1) Disconnect the airplane battery.
      (2) Disconnect external electrical power.
   C. Attach maintenance warning tags to the battery and external power receptacle that have "DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS" written on them.

2. Remove the airplane interior and the access panels as necessary to get access to the seats and floorboard areas where you must install the seat stop. (Refer to the applicable sections of the Service Manual.)

3. Do an inspection of the seat rails, rollers, roller housings, and stop pins. Refer to Cessna Service Information Letter SE83-6 and FAA Airworthiness Directive (AD) 87-20-03 Revision 2 or subsequent revision.

4. Repair or replace components as necessary.

5. Install the secondary seat stop.
   A. Remove the copilot seat.
   B. (Refer to Figure 13, Views C-C and F-F.) Install the 1299377-14 Doubler Assembly.
      (1) Find the best position under the floorboard to install the 1299377-14 Doubler Assembly.
          • It must be within the shaded area in View C-C of Figure 13.
          • It must be between the seat rails.
          • It must be aligned with the attach point of the 505590-403 Reel Assembly to the seat base frame.
          • There must be no interference between the 1299377-14 Doubler Assembly and the structure of the airplane.
          • With the seat in the forward locked position, the 1299377-14 Doubler must be forward of the 505590-403 Reel Assembly when it is installed on the seat frame.
          • There must be no interference between the left and the right sides of the seat frame and the belt path of the 505590-403 Reel Assembly.
      (2) Use the 1299377-14 Doubler Assembly as a pattern.
      (3) Drill one 0.266-inch diameter hole through the floorboard for the AN4-5A Bolt.
      (4) Drill four Number 30 (0.128-inch diameter) holes through the floorboard for the rivets.
      (5) Deburr the holes and apply Alodine to the bare metal.
      (6) Install the 1299377-14 Doubler Assembly to the floorboard with the four MS20470AD4-4A Rivets.
   C. (Refer to Figure 13, View C-C and View E-E.) Align the MS21919WDG16 Clamp with the 1299377-14 Doubler Assembly. Center the MS21919WDG16 Clamp between the two MS21919WDG18 Clamps to correctly align the reel with the belt attachment.
   D. Install the MS21919WDG16 Clamp with the AN525-10R8 Screw, NAS1149F0332P Washer, and MS21042-3 Nut.
   E. With the two MS21919WDG18 Clamps, AN525-10R10 Screws, NAS1149F0332P Washers, and MS21042-3 Nuts, install the 505590-403 Reel Assembly on the aft height adjust tube.
F. (Refer to Figure 13, View C-C, View D-D, and View G-G.) Make the 1299377-33 Cable End
Mounting Bracket.

(1) Keep an edge distance of no less than two fastener diameters between the edge of the
1299377-33 Cable End Mounting Bracket and the center of the fasteners that you will install
in the bracket.

(2) Cut the 1299377-33 Cable End Mounting Bracket to the correct dimensions from the
1299377-24 Extrusion.

(3) Remove the sharp edges of the 1299377-33 Cable End Mounting Bracket.

G. Drill out the existing rivets from the Number 21 (0.159-inch diameter) holes in the leg.

H. (Refer to Figure 13, View D-D.) Temporarily install the S2300-26 Bracket on the center of the
threaded end of the 505530-405 Cable Assembly.

**NOTE:** You can make the hole in the S2300-26 Bracket larger to a 0.312-inch diameter as
necessary.

I. Remove and discard the existing MS20392 Pin.

J. (Refer to Figure 13, View D-D, View E-E, View G-G, and Detail A.) Temporarily install the
505530-405 Cable Assembly to the seat adjustment lever link or the seat adjustment lever bell crank
with a new MS20392-1C21 Pin (or longer if necessary) and from one to six NAS1149FN432P
Washers as necessary.

K. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

L. Attach the 505530-405 Cable Assembly to the 505590-403 Reel Assembly.

M. (Refer to Figure 13, Detail A.) Install the seat in the airplane with each of the seat stop pins fully
inserted into a seat rail hole.

N. (Refer to Figure 13, View B-B, View D-D, and View G-G.) Move the 505530-405 Cable Assembly
and the S2300-26 Bracket to the position shown for the S2300-26 Bracket and make marks at the
rivet hole locations on the 1299377-33 Cable End Mounting Bracket.

O. Remove the seat from the airplane.

P. Drill two Number 21 (0.159-inch diameter) holes in the 1299377-33 Cable End Mounting Bracket for
the rivets that attach the 1299377-33 Cable End Mounting Bracket to the seat frame.

Q. Deburr the holes and apply Alodine to the bare metal.

R. Attach the 1299377-33 Cable End Mounting Bracket to the seat base with the two MS20470AD5-17A
Rivets.

S. (Refer to Figure 13, Detail B.) Install the seat in the airplane with each of the seat stop pins fully
inserted into a seat rail hole.

T. (Refer to Figure 13, View G-G.) Move the S2300-26 Bracket to the position shown to find the correct
position for the S2300-26 Bracket and make marks for the rivet locations of the S2300-26 Bracket.

U. (Refer to Figure 13, View C-C.) Make sure that the cable end axis stays no more than 30 degrees
from the seat stop pin or the link centerline.

V. (Refer to Figure 13, View D-D and View G-G.) Remove the 505530-405 Cable Assembly from the
MS20392-1C21 Pin.

W. Remove the S2300-26 Bracket from the 505530-405 Cable Assembly.

X. Drill two Number 30 (0.128-inch diameter) holes in the 1299377-33 Cable End Mounting Bracket for
the rivets that attach the S2300-26 Bracket to the 1299377-33 Cable End Mounting Bracket.

Y. With temporary fasteners, install the S2300-26 Bracket to the 1299377-33 Cable End Mounting
Bracket.
Z. (Refer to Figure 13, View D-D.) Temporarily install the 505530-405 Cable Assembly in the S2300-26 Bracket with the two AN316-5R Nuts and the two MS35333-41 Lock Washers. Do not tighten the AN316-5R Nuts.

AA. (Refer to Figure 13, View F-F.) In the correct position on the seat frame to make clearance for the MS20392-1C21 Pin, make marks for a half circle with a radius of 0.38.

AB. Remove the 505530-405 Cable Assembly from the S2300-26 Bracket. Keep the attachment hardware.

AC. Remove the S2300-26 Bracket from the 1299377-33 Cable End Mounting Bracket.

AD. Cut the seat frame to make the half circle at the correct position.

AE. Deburr and apply Alodine to bare metal.

AF. Install the S2300-26 Bracket to the 1299377-33 Cable End Mounting Bracket with the two MS20470AD4-6A Rivets.

AG. (Refer to Figure 13, View D-D.) Install the 505530-405 Cable Assembly in the S2300-26 Bracket with the two AN316-5R Nuts and the two MS35333-41 Lock Washers. Do not tighten the AN316-5R Nuts.

AH. (Refer to Figure 13, View G-G.) Attach the 505530-405 Cable Assembly to the MS20392-1C21 Pin again with the three NAS1149FN432P Washers. Use one, two, or all of the washers as necessary.

AI. Attach the spring or install the MS24665-132 Cotter Pin, as necessary.

AJ. (Refer to Figure 13, View F-F.) Attach the belt end fitting to the floorboard and the 1299377-14 Doubler Assembly with the AN4-5A Bolt and the NAS1149F0432P Washer.

NOTE: You can use a longer AN4 Bolt as necessary to make sure that the bolt threads engage correctly.

6. (Refer to Figure 13, Detail A.) Put the seat stop pin on the top of the seat rail and put the seat in position.

7. (Refer to Figure 13, Detail A.) Adjust the manual lock as follows:
   A. Put the stop pins 0.10 inch above the seat rail.
   B. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to release the belt reel manual lock.
   C. Put the stop pin 0.05-inch above the seat rail.
   D. Adjust the 505530-405 Cable Assembly at the S2300-26 Bracket with the AN316-5R Nuts to lock the belt reel manual lock.
   E. If necessary, do Step 7 again until you see that the manual lock operates correctly.

   WARNING: Do not torque the AN316-5R Nuts to more than 30 inch-pounds. If you tighten the nuts too much, you can cause damage to the ferrule, and the secondary seat stop may not operate correctly.

   F. Apply Loctite 242 to the threads and tighten the AN316-5R Nuts to lock the cable end in position with the MS35333-41 Lock Washers.

8. Attach the 505530-405 Cable Assembly to the seat base as necessary with MS3367-5-0 Tie Straps.

9. Make sure that the 505530-405 Cable Assembly moves smoothly and freely during operation. If it does not move smoothly and freely, you must move the 505530-405 Cable Assembly as necessary and attach it to the seat base again with the MS3367-5-0 Tie Straps.

10. With EC1300LP Adhesive or equivalent, install the H880015 Grommet to the lower edge of the seat frame where the 505590-403 Reel Assembly Belt touches the seat frame.

11. Install the airplane interior and the access panels that you removed.

12. Remove the maintenance warning tags and connect the airplane battery.
13. Make an entry in the airplane logbook stating this Service Kit has been installed.
NOTE 1: All dimensions are shown in inches.

NOTE 2: Install H880015 Grommet as necessary where the 505590-403 Inertia Reel Assembly touches the seat frame.

NOTE 3: Replaces existing rivets.

Figure 13. Secondary Seat Stop Installation "M" (Sheet 1)
Figure 13. Secondary Seat Stop Installation "M" (Sheet 2)
AN4-5A Bolt
NAS1149F0432P Washer
(1 Each Required)

1299377-14
Doubler Assembly
(1 Required)

Floorboard
(Reference)

FWD
VIEW E–E

0.38 Radius

MS20392-1C21
Pin
(Reference)

VIEW F–F

S2300-26 Bracket
(1 Required)

Number 30 (0.128-Inch Diameter) Hole
MS20470AD4–6A
Rivets
(2 Each Required)

1299377–33
Bracket
(1 Required)

VIEW G–G
Without Cable Assembly Installed

Figure 13. Secondary Seat Stop Installation "M" (Sheet 3)
NOTE 4: Install one washer here.

NOTE 5: Install not less than one and not more than five washers here.

Figure 13. Secondary Seat Stop Installation "M" (Sheet 4)
Figure 13. Secondary Seat Stop Installation “M” (Sheet 5)