

REVISION LIST

CHAPTER 15: SEATS AND SEAT BELTS

The following list of revisions will allow you to update the Legacy construction manual chapter listed above.

Under the “Action” column, “R&R” directs you to remove and replace the pages affected by the revision. “Add” directs you to insert the pages shown and “R” to remove the pages.

PAGE(S) AFFECTED	REVISION # & DATE	ACTION	DESCRIPTION
15-1 through 15-6	0/02-15-02	None	Current revision is correct
15-1	3/12-15-04	R&R	Updated table of contents with page numbers.
15-3	3/12-15-04	R&R	Updated instructions.

Chapter 15: Seats & Seat Belts

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1. INTRODUCTION

The standard Legacy seat belt system is a 3-point harness. It consist of a lap belt and a shoulder harness. The lap belt bolts to a reinforced section of the inboard rib. The shoulder harness secures to a hardpoint in the ceiling of the baggage compartment.

2. PARTS LIST

#	PART NO. (P/N)	QTY	DESCRIPTION	OPTIONAL ITEM <i>(not included with kit)</i>
FITTING SEAT PAN				
1)	4024-01	1	Seat Support, Left Center	
2)	4024-02	1	Seat Support, Right Center	
3)	4027-01	1	Outboard Seat Support, Left	
4)	4027-02	1	Outboard Seat Support, Right	
5)	4033-01	1	Seat Pan, Left	
6)	4033-02	1	Seat Pan, Right	
INSTALLING SEAT BELTS				
1)	AN6-10A	4	Bolt, Undrilled	
2)	1106-01	2	Lap Belt	
3)	AN365-624A	6	Nut, Nylock	
4)	MS24694-S199	2	Screw, Machine	
5)	1106-02	2	Shoulder Harness	
6)	AN960-616	16	Washer, Flat	

Note:

Optional Parts available through :

(*) Lancair Avionics

() Kit Components, Inc.**



15-1

Chapter 15 | REV. 3/12-15-04

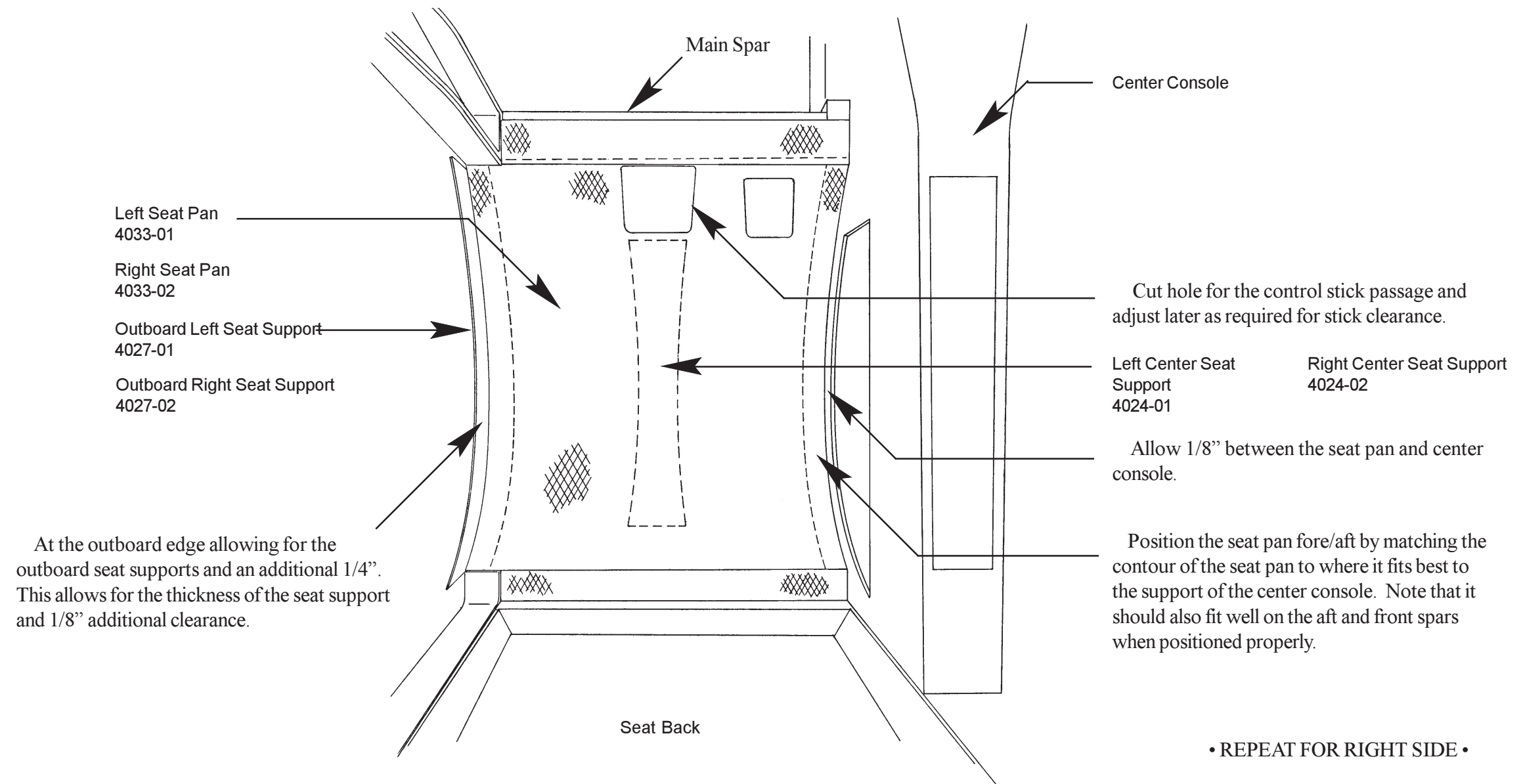
SEATS & SEAT BELTS

3. CONSTRUCTION PROCEDURES

Fitting Seat Pans
Fig. 15:A:1

A. Fitting the Seat Pans

- A 1. The seat pans have scribe lines to aid in the fitting process. Start by trimming 1/8" outside the scribe lines and custom fit following the instructions.



B. Outboard Seat Supports

Installing Outboard Seat Supports
Fig. 15:B:1

B 1. Cleco the seat support to the outboard edge of the seat support. Align the support to the seat pan by matching the contours as best as possible. Two clecos are sufficient.

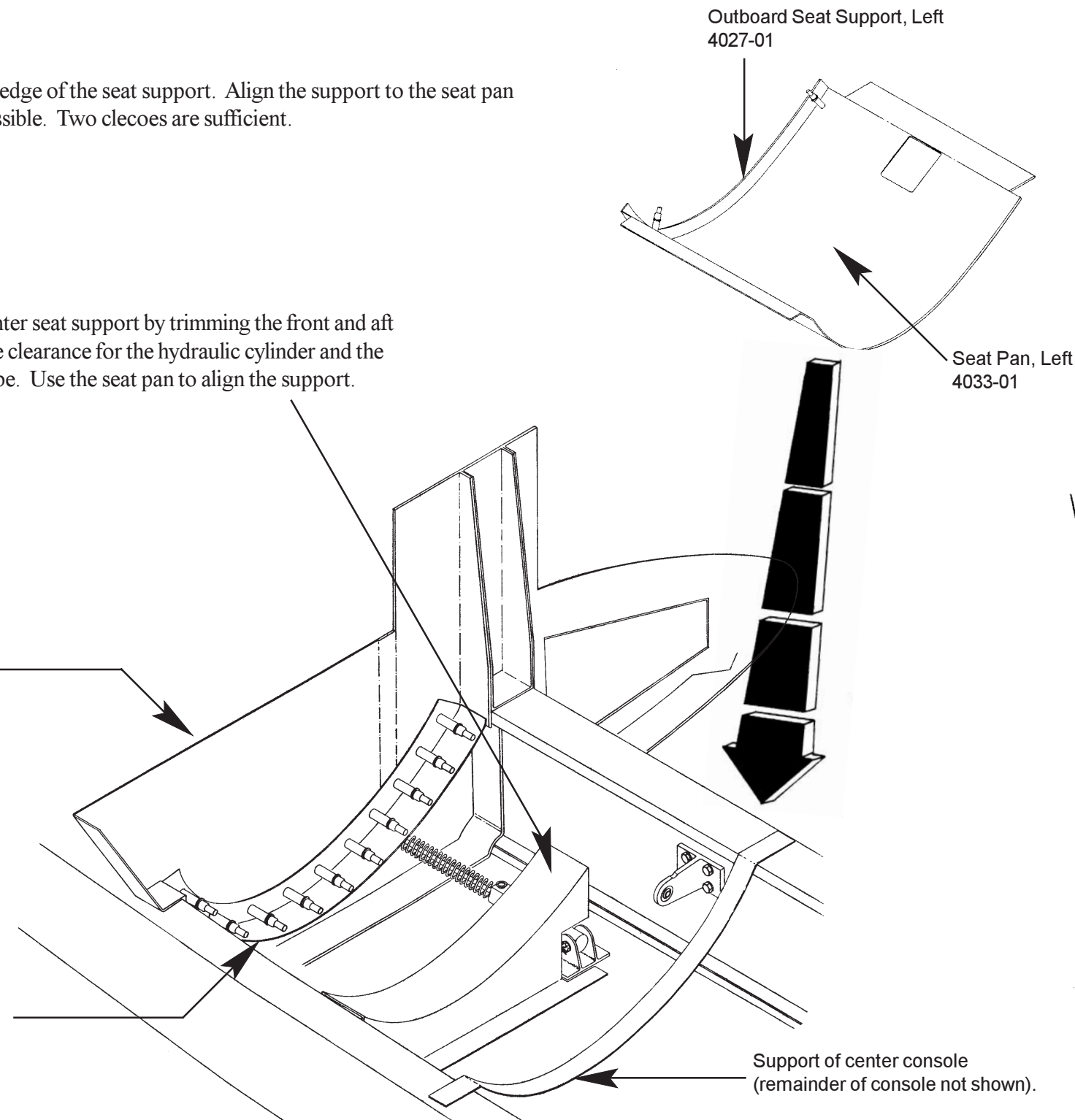
B 2. Fit the center seat support by trimming the front and aft to provide clearance for the hydraulic cylinder and the torque tube. Use the seat pan to align the support.

B 4. Bond the seat support using approved bonding procedures using epoxy/flox.

WARNING:
DO NOT DRILL CLECO HOLES
THROUGH THE SPARS!

B 3. Fit and trim the outboard support. Start by aligning the seat pan to the three supports. Once aligned, cleco the seat support to the aft closeout rib.

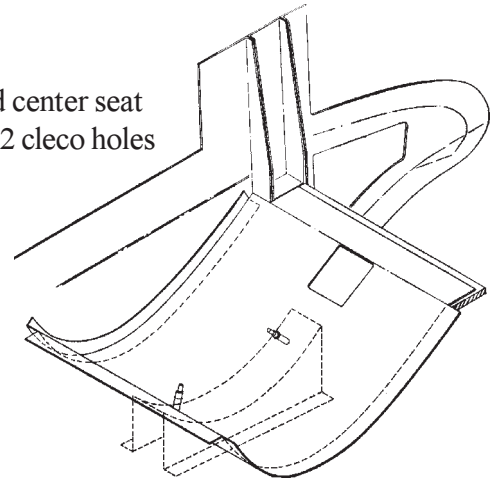
Aft closeout rib



C. Center Seat Supports

Center Supports
Fig. 15:C:1

- C 1. With the seat pan and center seat support aligned, drill 2 cleco holes through the seat pan.

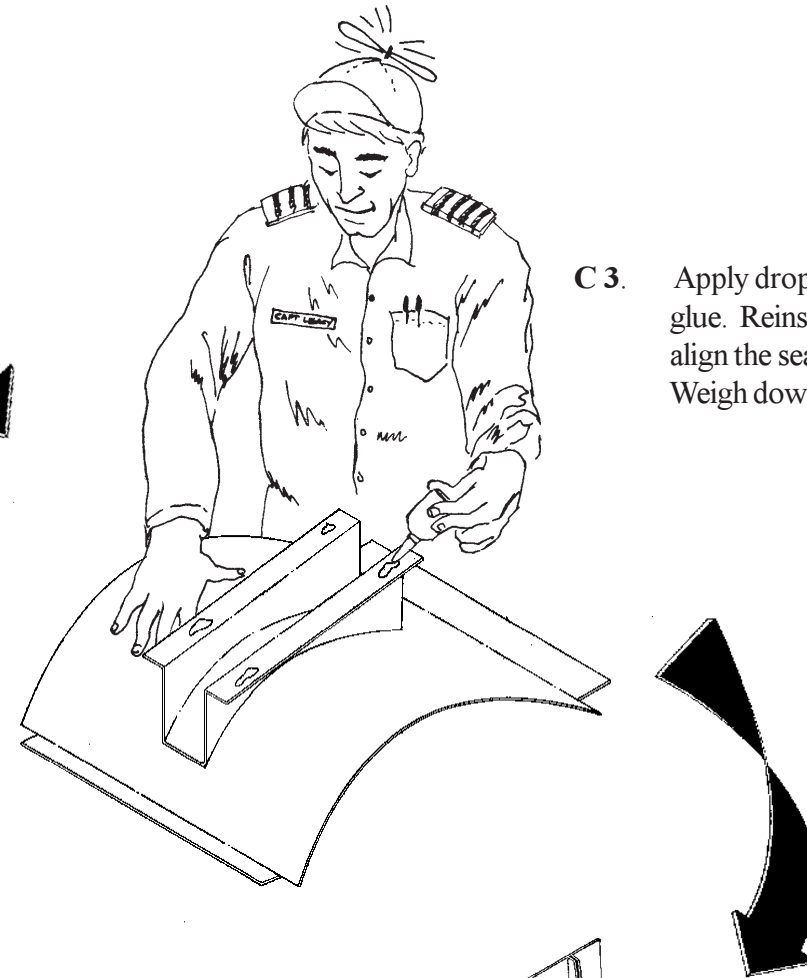


- C 2. Remove seat pan and



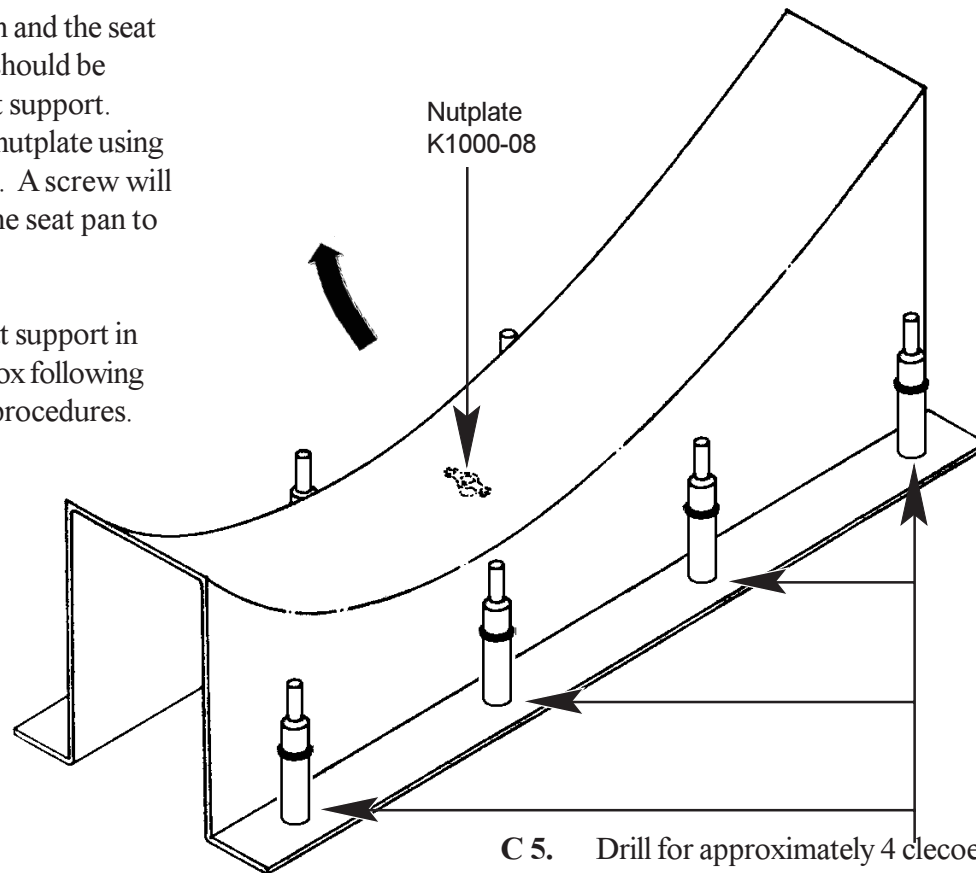
turn upside down (don't remove clecoes yet).

- C 3. Apply drops of instant glue. Reinstall and align the seat pan. Weigh down.



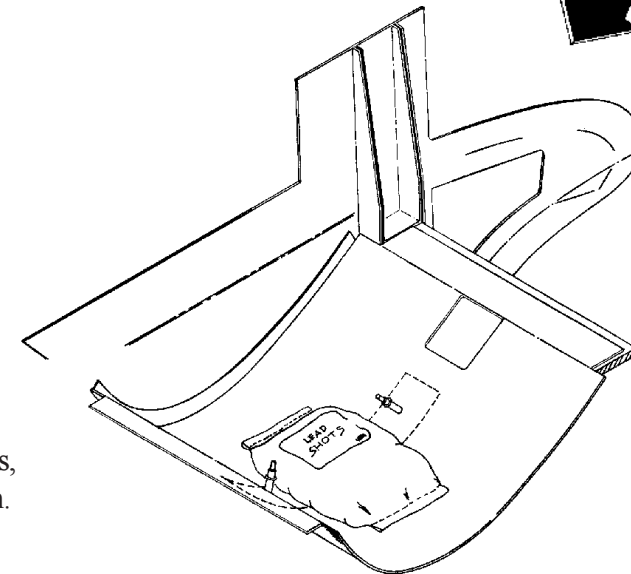
- C 6. Reinstall the seat pan. Drill a hole through the seat pan and the seat support. The hole should be centered on the seat support. Install a K1000-08 nutplate using MSC-32 pop rivets. A screw will be used to secure the seat pan to the seat support.

- C 7. Bond the center seat support in place using epoxy/flox following approved bonding procedures.



- C 5. Drill for approximately 4 clecoes per side.

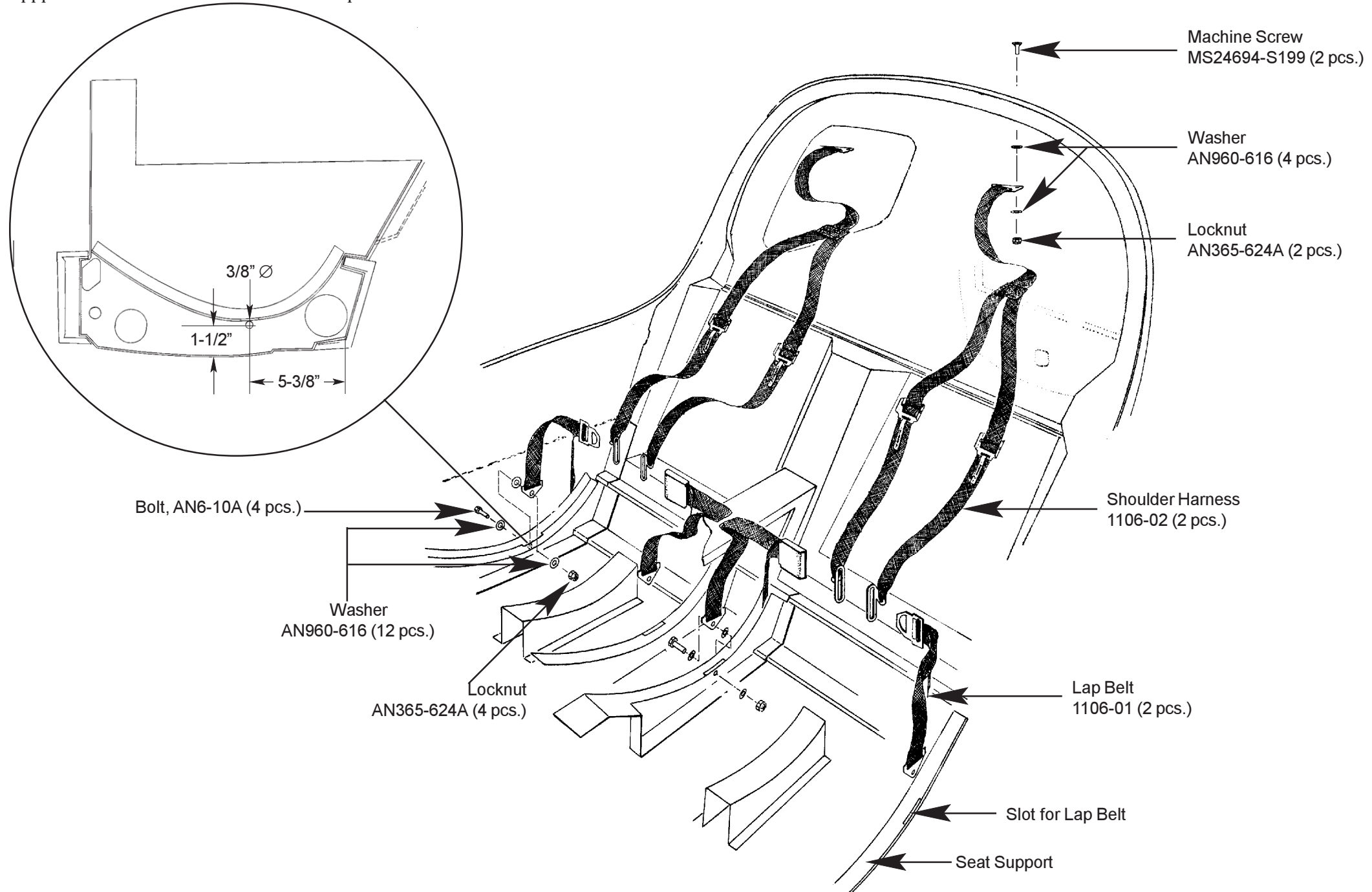
- C 4. Remove the two clecoes, weight bag and seat pan.



D. Installing the Seat Belts

Installing Seat Belts
Fig. 15:D:1

Install the seat belts using the hardware shown. Note the slots for the lap belts in the seat supports. Make a similar notch in the seat pans.

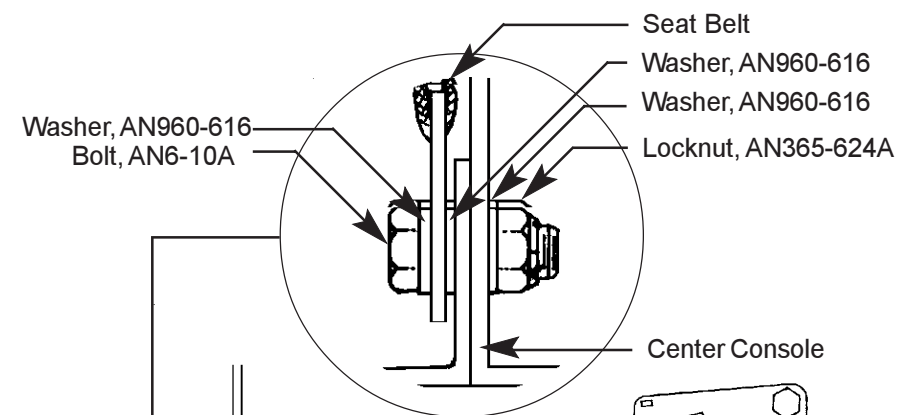
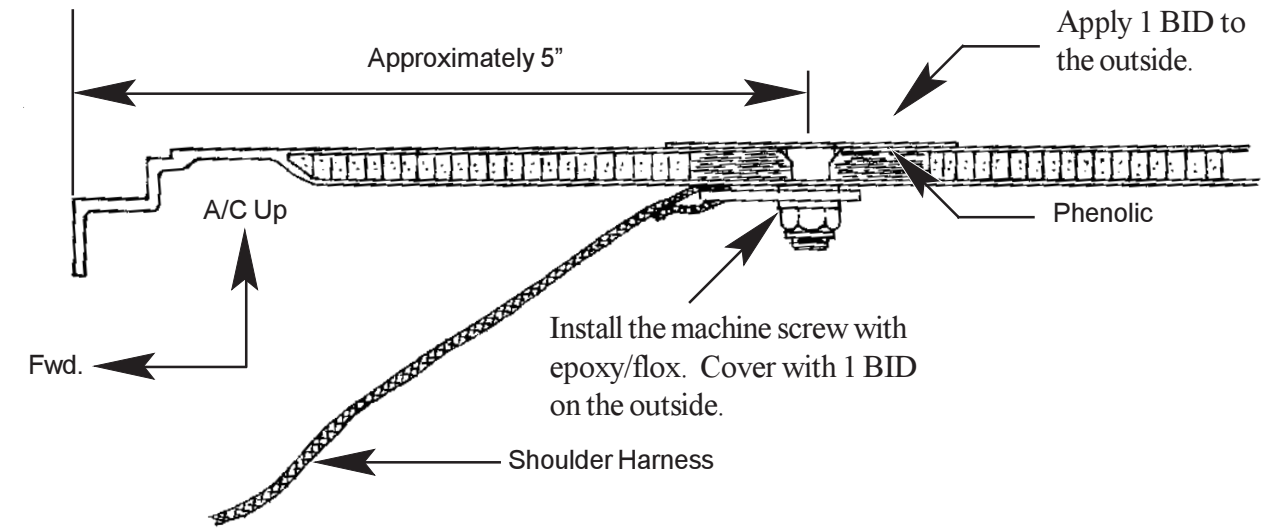
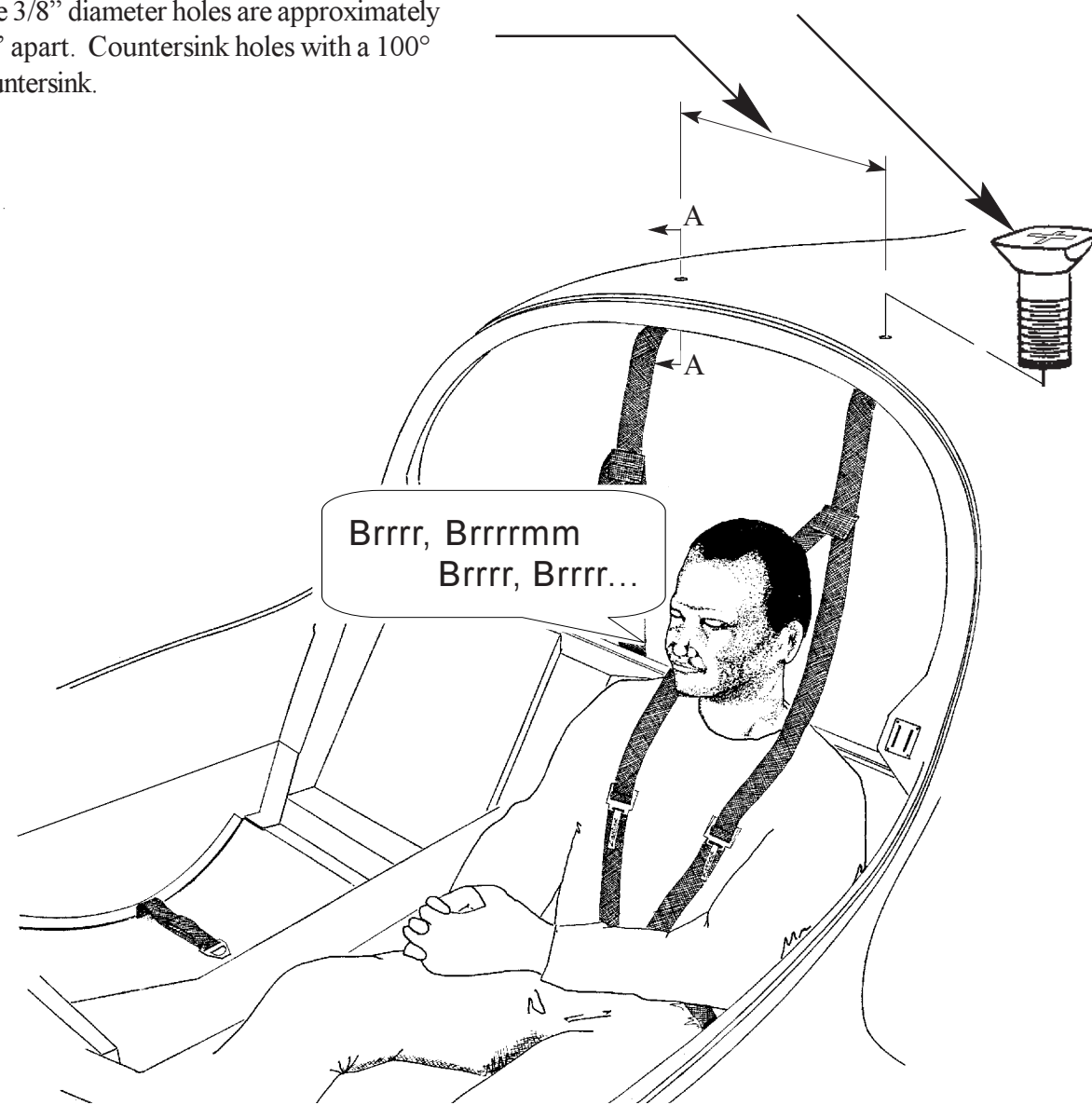


Installing Seat Belts
Fig. 15:D:2

You must locate the phenolic and verify that you are drilling through the center of the phenolic.

The 3/8" diameter holes are approximately 15" apart. Countersink holes with a 100° countersink.

Grind the sides of screw flat.



The latch side of the belt typically installs on the inboard as it is easier to tighten. (The outboard hand is typically on the control stick handle whether left or right seat.)

