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PRODUCT MODIFICATION PROCEDURE

DATE: June 23, 1992

PROCEDURE #: 1213

APPLICABLE PRODUCTS: SKYHOOK RESERVE PILOTCHUTE P/N 2233-()
Manufactured between May 16, 1989 and July 29, 1991. Serial numbers include 2405-5551.

DESCRIPTION: Replacement of the pilotchute spring with an upgraded model. **NOTE:** The new spring is readily identifiable by the shiny black powder coat finish. The old springs have a natural metallic finish.

AUTHORIZED REPAIRMEN: FAA Senior or Master Rigger or foreign equivalent.

MATERIALS:

1. Skyhook pilotchute spring P/N 60C002 with pilotchute cap.
2. Supertack nylon tacking thread.
3. "E" thread nylon- white.

MACHINES:

1. Medium duty single needle set up for 301 straight stitch 7-11 stitches per inch (SPI).
2. Zipper foot or narrow presser foot for the above.

EQUIPMENT:

1. Seam ripper.
2. Scissors.
3. Hand tacking needle.

PROCEDURE

DISASSEMBLY:

1. Take the seam ripper and remove the two rows of stitches that hold the pilotchute canopy to the cap. Do not damage the canopy.
2. Fold the canopy down over the base of the spring and expose the Ty-III tapes that hold the pilotchute to the base of the spring.
3. Take the scissors and cut the tapes and remove the spring. Cut the tapes out entirely, trimming them close to the parapack cone at the base of the pilotchute.



RE-ASSEMBLY:

1. After trimming the tapes on the inside of the base of the pilotchute, two reinforcing stitches must be added as in *FIG. 1*.
2. Take the new pilotchute spring and cap assembly and insert the spring into the pilotchute, small end first.
3. Turning the pilotchute upside down, stitch the canopy to the cap of the spring. Fold the canopy fabric under as per the original. Sew two rows of stitching around the cap approximately .19" (4-5mm) from the outside edge. The second row should follow in the holes made by the first row. The points at which the radial tapes meet the cap must also be reinforced. Three additional rows of single needle stitching must overstitch the tapes by a minimum of .50" (12mm) *FIG. 2*.
4. Next hand tack the bottom of the spring to the base cone of the pilotchute. In doing this, you must make sure that the main load tapes of the canopy run directly in a straight line from the cap to the base of the spring. **DO NOT HAVE ANY TWISTS OR SPIRALS** to the tapes. Tack each load tape to the base of the spring with two turns doubled of the supertack nylon thread. *FIG. 3*.

INSPECTION:

INITIAL

INSPECTION:		INITIAL
1	Canopy secure to the cap.	
	a) Stitch tensions.	
	b) Stitches Per Inch.	
	c) Two rows of stitching.	
2	Load tapes straight.	
3	4 ea hand tacks at the base.	
4	4 ea reinforcing patterns at cap.	
5	2 ea reinforcing patterns at base.	

DOCUMENTATION:

1. Fill out the Modification Certification Form and return it to Rigging Innovations.
2. Fill out the stamp on the top of the pilotchute cap in indelible ink.
3. Make a log entry on the packing data card or logbook for the container system the pilotchute is packed into. A typical entry would read "Skyhook modified per RI PMP-1213".