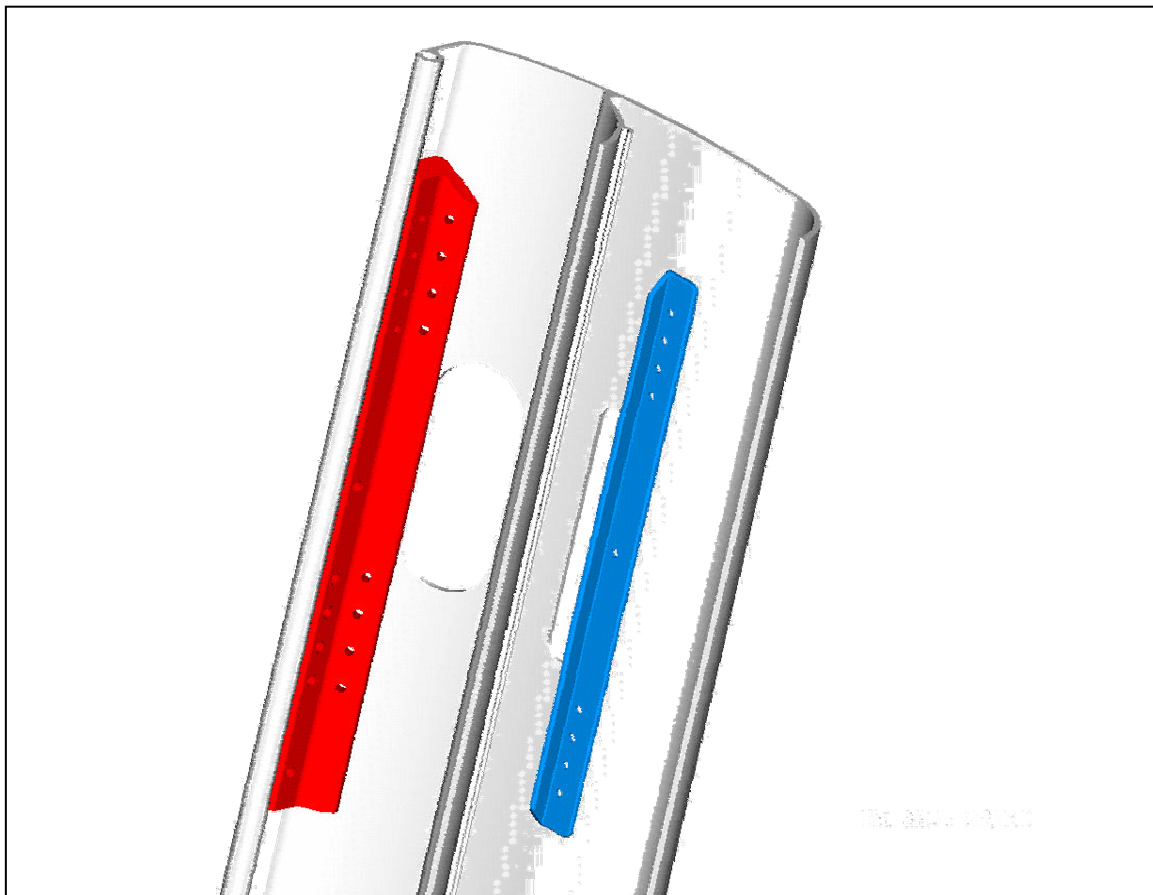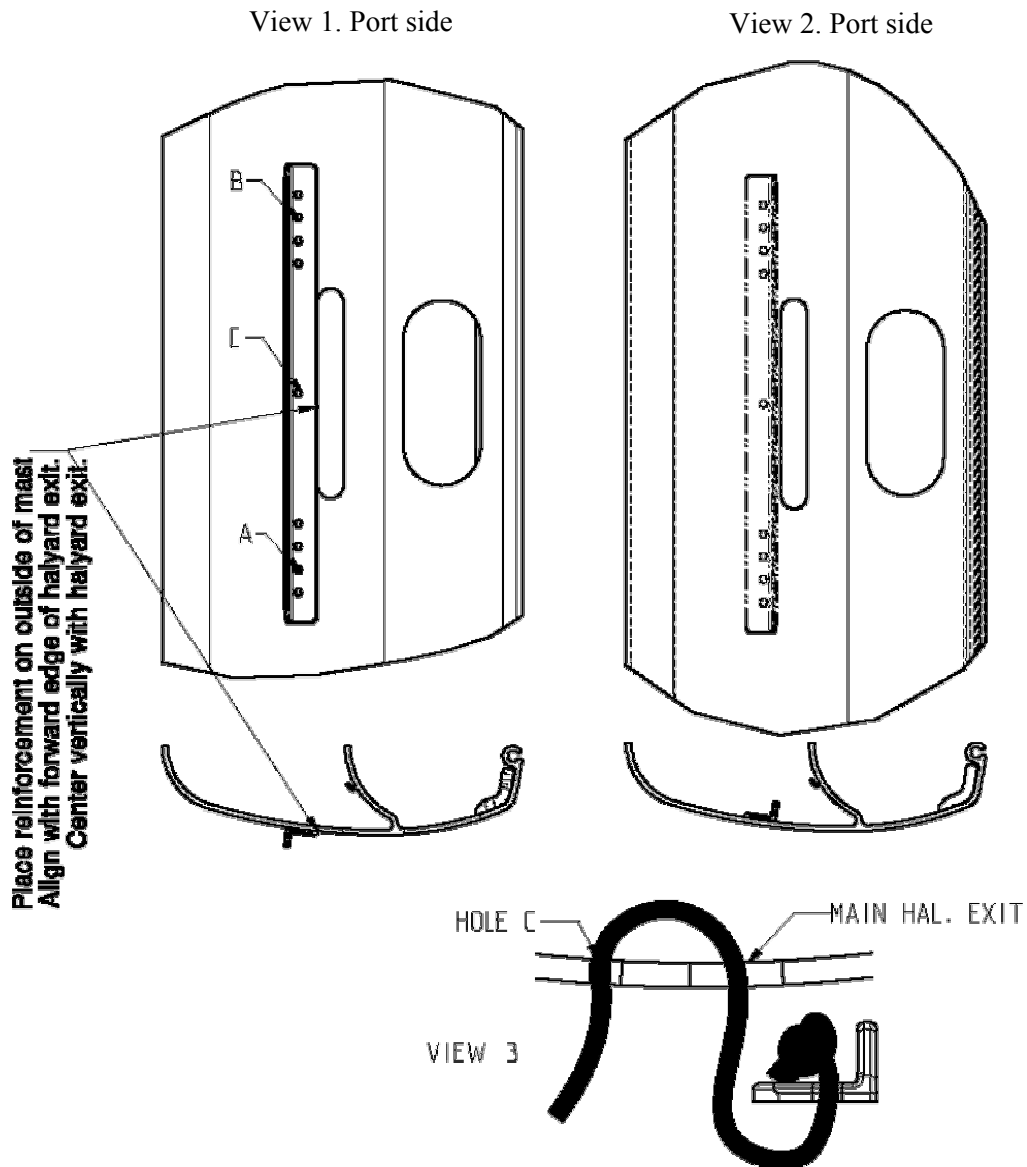# Instruction for retrofitting reinforcement on Bavaria 40 AC in-mast furling

Mounting Halyard Exit Reinforcement
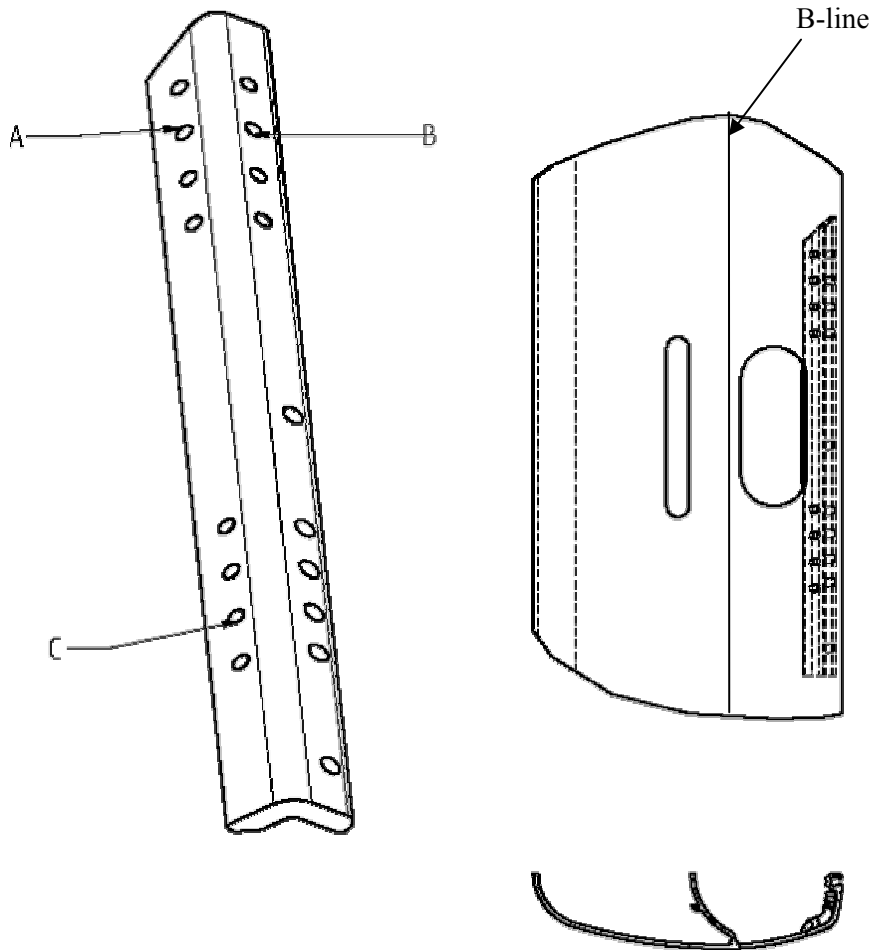**Article no. 507-308**

View 1. Port side   View 2. Port side

Place reinforcement on outside of mast.
Align with forward edge of halyard exit.
Center vertically with halyard exit.

HOLE C ———   ———MAIN HAL. EXIT

VIEW 3

1. Remove any rope clutch that prevents your work.
2. Position 507-308 on outside of mast using adhesive tape, acc. to view 1.
3. Drill ø 4.9 mm holes at A & B.
4. Insert pop rivets in hole A & B, and fix the rivets with adhesive tape. **Do not rivet!**
5. Drill the remaining holes ø 4.9 mm.
6. Remove 507-308.
7. Check that inner mast surface and 507-308 are free from burrs.
8. Thread a messenger line through mast wall and 507-308 at hole C acc. to view 3.
9. Fit bracket on inside of mast wall acc. to view 2, and rivet all holes.
10. Punch all center-pins out of the rivets.

Mounting aft reinforcement
Article no.: 507-304

B-line

1. Insert a cloth through the access hole to protect the furling gear from chips.
2. Remove boom bracket rivets on port side using a ø6.5mm drill.
3. Mark hole positions on mast according to PS-409 using drill template 595-174.
4. Cut a hole through the drill template and position 507-304 acc. to PS-409 Secure with clamp, protect mast from scratches.
5. Drill holes A, B & C ø 4.9mm.
6. Tap holes A, B & C through mast wall and 507-304 to M6 thread.
7. Remove 507-304 and drill hole A, B & C ø 6.2mm in mast wall only.
8. Refit 507-304 and secure with M6 screws at A, B & C.
9. Drill all holes ø4.9mm, including boom bracket holes.
10. Drill Boom bracket holes ø6.5mm.
11. Tap all ø 4.9mm holes in 507-304 to M6 thread.
12. Remove 507-304 and drill remaining holes in mast ø 6.2mm.
13. Check that mast inner surface and 507-304 are free from burrs.
14. Refit 507-304 and fit all screws with locking adhesive.
15. Fix boom bracket with pop-rivets ø 6.4mm.
16. Remove the cloth.

Required equipment (not supplied)
Hand drilling machine
Torx spanner T30
Tap handle
Pop rivet plier
Screw clamp
Hammer

Equipment included:
Adhesive tape
Drillbit ø4,9mm
Drillbit ø6,2mm
Drillbit ø6,5mm
Tap M6
Messenger line
Locking adhesive