

# KUBICEK

issues

## SERVICE INSTRUCTION no. 2023/04 Basket stainless steel cables replacement

**Cause:** Damaged basket stainless steel cables  
**With reference to:** Kubicek K-series baskets, all serial numbers  
**Required material:**

Part	Part number	Quantity
Ferrules 6 (Nicopress)	581.00	2
Cable thimble 6 mm, stainless steel	582.00	2
Stainless steel cable dia. 6mm	375.00	Depends on basket model
Insulation PVC tape - 19 mm – red / black	3302.01/3302.10	1+1
Heat-shrink tube 19/6 – black / red	597.00 / 597.01	2
Transparent tube	1473.00	Depends on basket model

### **WARNING**

**Change of stainless-steel cables is maintenance category C, so only approved service organization with written approval from Kubíček Factory may carry on this repair.**

#### 1. Procedure of basket stainless steel wire replacement:

1.1. Measure length of replaced wire on basket, by measuring L1 and L2 (from end of support rod socket to middle of cable thimble). Be sure to measure one piece of wire, based on basket type may route transverse or diagonally under floor.

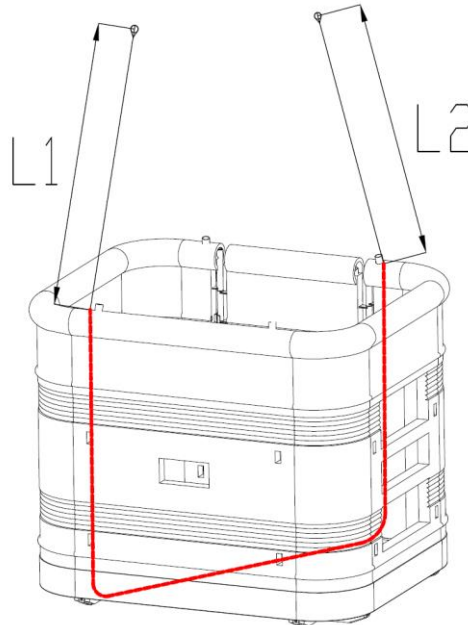


Fig. 1

1.2. Disassemble floor runners and bottom leather cover from damaged basket wire.

1.3. Cut off thimbles on damaged basket wire.

1.4. By welding, connect new basket wire on old, damaged basket wire.



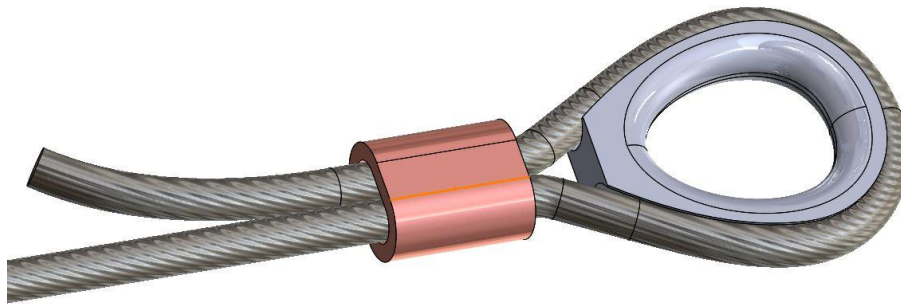
Fig. 2

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- 1.5. Route new basket wire through basket walls, leave at least 0,5 m on each end on top of L1 and L2.
- 1.6. On basket wire put transparent tube.

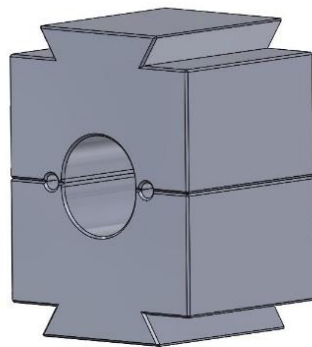
## 2. Procedure of swaging:

- 2.1. Whole procedure of swaging must be made according to **EN 13411-3**.
- 2.2. Before swaging, place heat-shrink tube on basket wire. Leave the heat-shrink tube loose on the rope for now.
- 2.3. Thread the steel wire through the copper ferrule.
- 2.4. Prepare the cable thimble (eyelet), hold, and wrap the wire rope around the thimble.
- 2.5. Thread the end of the rope back into the copper cable ferrule, see Figure 3.



*Fig. 3*

- 2.6. Tighten free end of wire, to keep space between thimble and ferrule as small as possible. Thimble must stay on place by itself. Make sure, that measured lengths L1 and L2 are set on ends of wire.
- 2.7. Make sure, that upper swaging bore is in line with bottom one. If not, adjust swaging bores (see Figure 4).



*Fig. 4*

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2.8. Prepared assembly is now ready to swage. Insert ferrule into swaging bores Fig. 5.

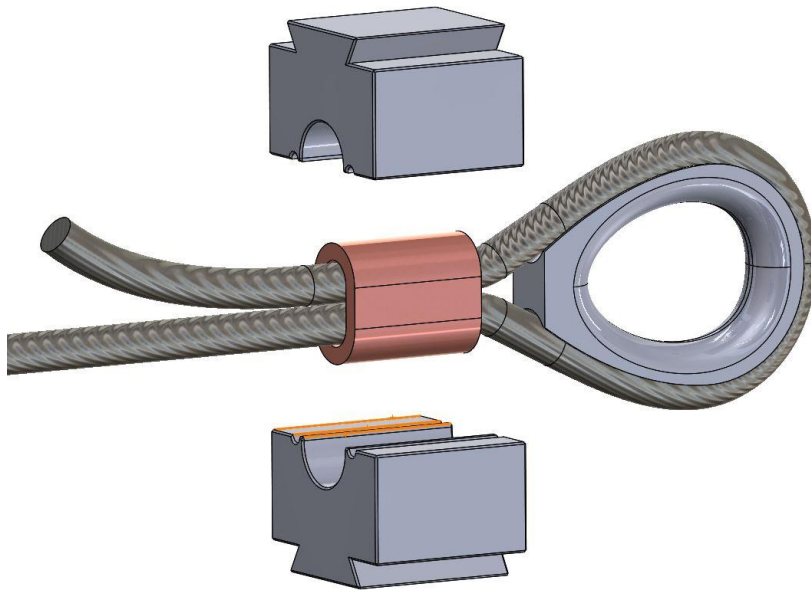
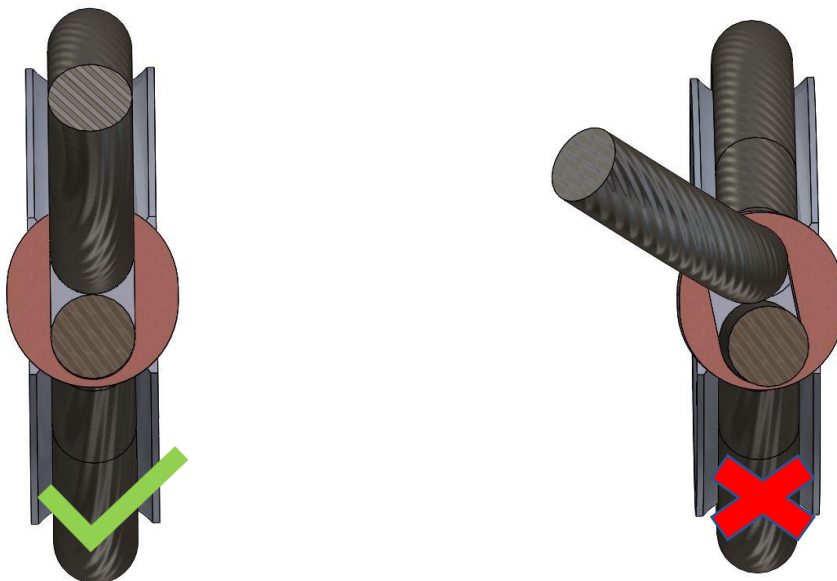


Fig. 5

2.9. After alignment and tightening of stainless-steel cables activate press and press until pressure reaches value specified by press manufacturer for pressing specific size of ferrules. During pressing, is necessary to keep eye on parallelism of cables, according to Fig.6.



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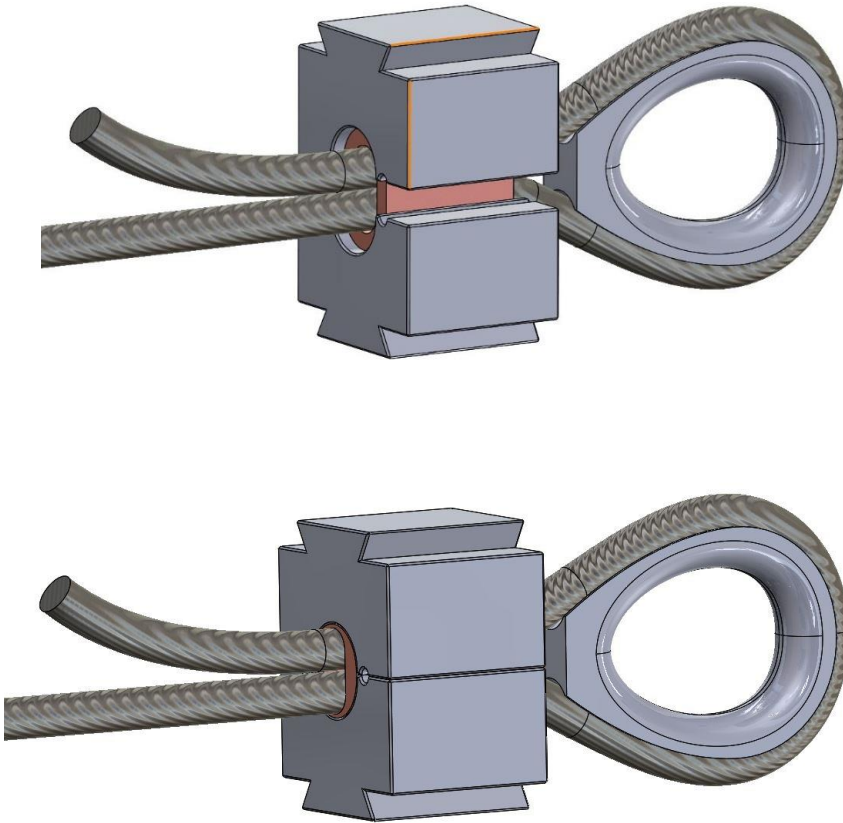


Fig. 6

2.10. Swaging will make overflows on ferrule according to Fig. 7

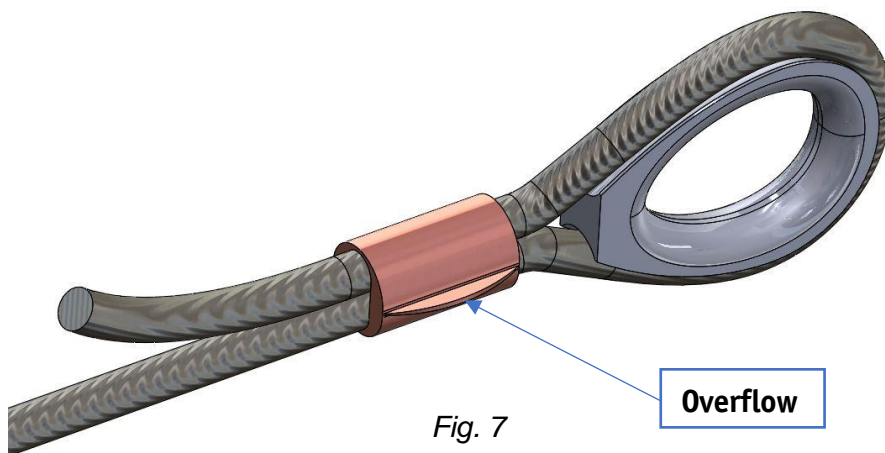


Fig. 7

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2.11. Overflow, made by swaging is possible only to grind away. Any other way of overflow reduction (e.g. chip off) is not possible. It is necessary to use angle grinder or file (see Fig. 8). No other material than on overflow may be grinded or removed.

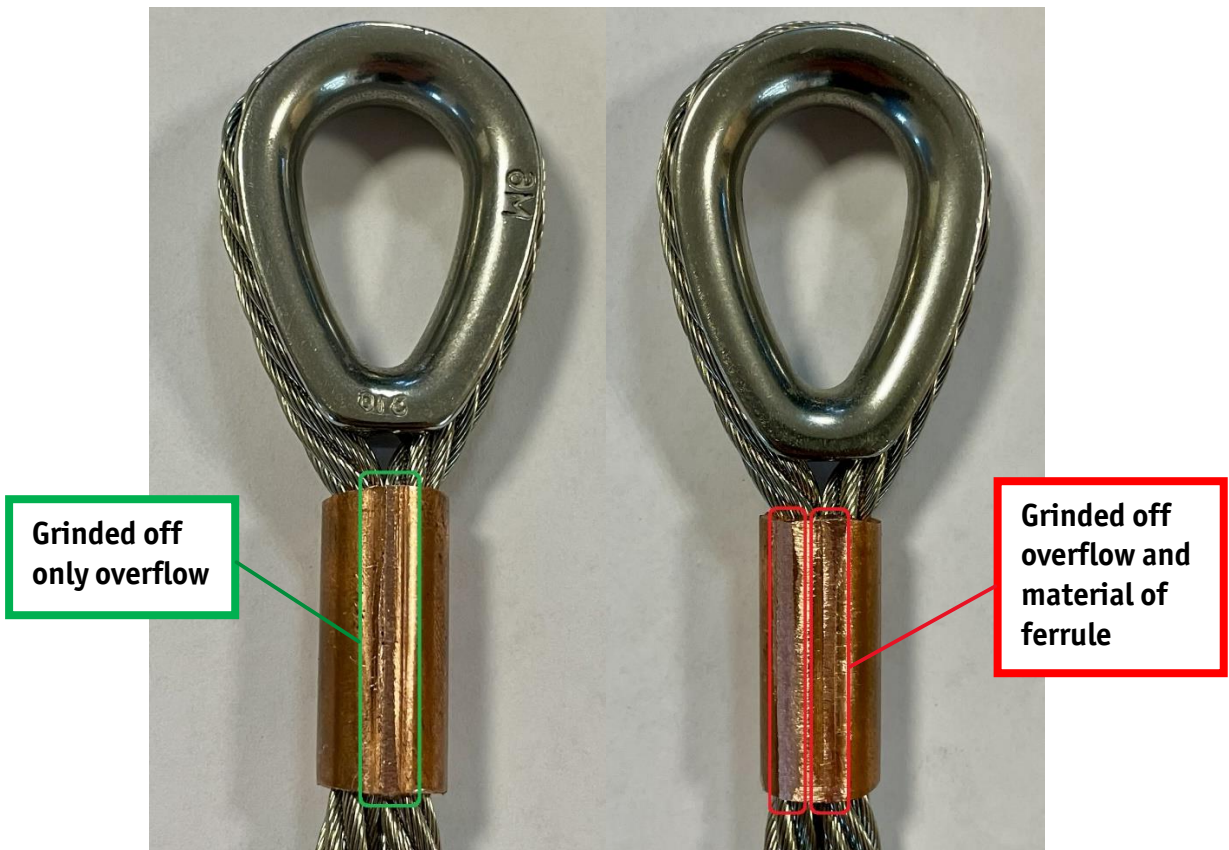
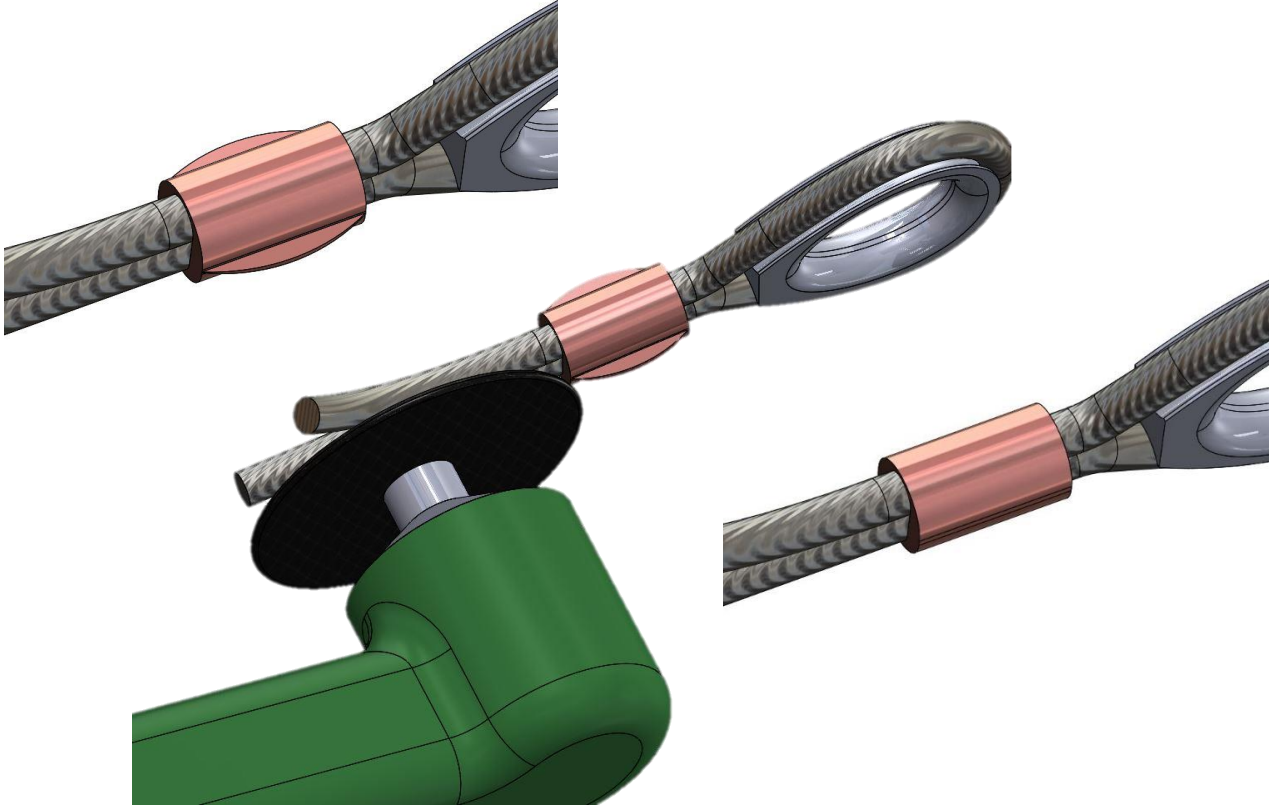
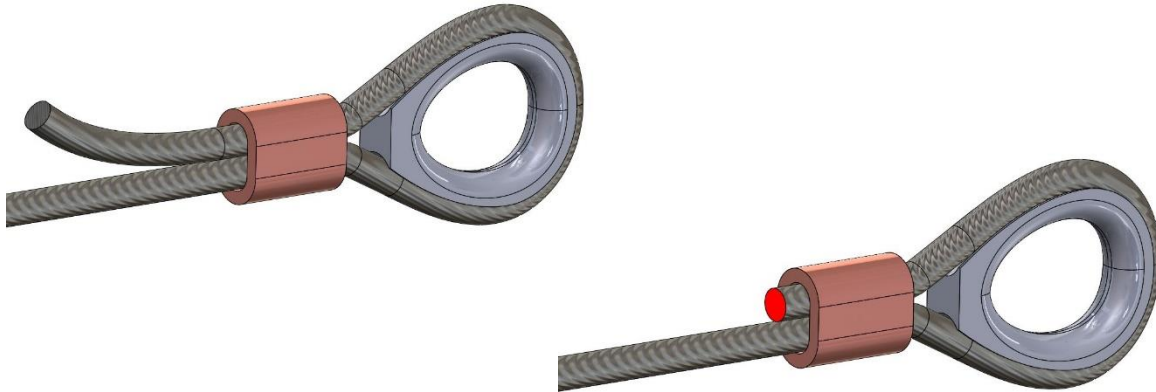


Fig. 8

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- 2.12. After grinding check pressed ferrules dimensions with caliber according to EN 13411-3. Once it passes the inspection, it is necessary to trim the excess end of the cable close to the ferrule.



*Fig. 9*

- 2.13. Finally, the only thing left to do is to wrap the whole assembly with insulating tape, and finally seal it in heat shrinkable tape.



*Fig. 10*

Technical content of this document is approved under the authority of DOA No. EASA.21J.277.

On behalf of Kubíček Factory s.r.o.

Ing. Petr Kubíček, technical director

Datum: **06.03.2024**