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**Engineering Department**

**SIGMA-Main Disc Cover Modifications - Magnets**

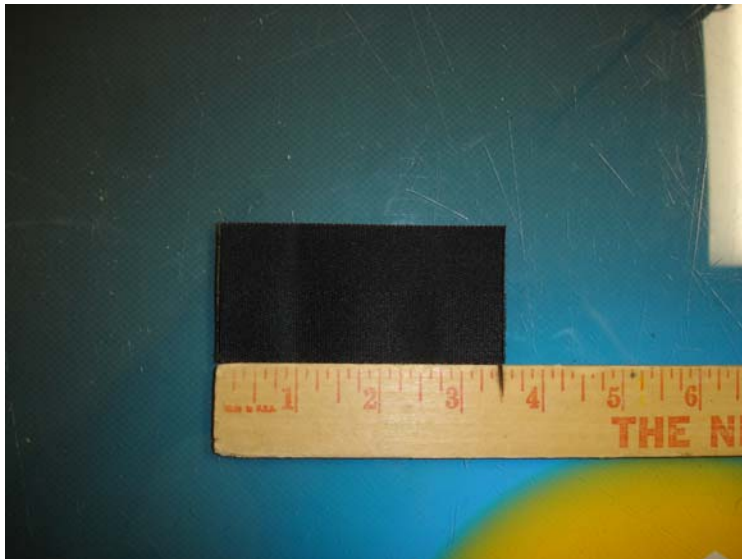


Fig (i)

**Scope:**

- 1.0 To describe a process for systematically retrofitting to a magnetic main disc cover.

**Procedure:**

- 2.0 Cut Type-12 to 3.5" long.  
Fig (i)

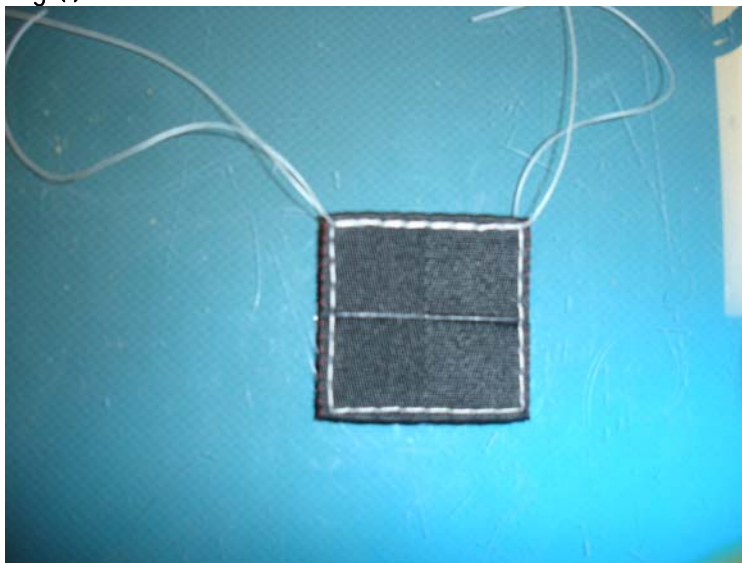


Fig (ii)

- 2.1 Fold in half and prep sew around edge per Fig (ii).

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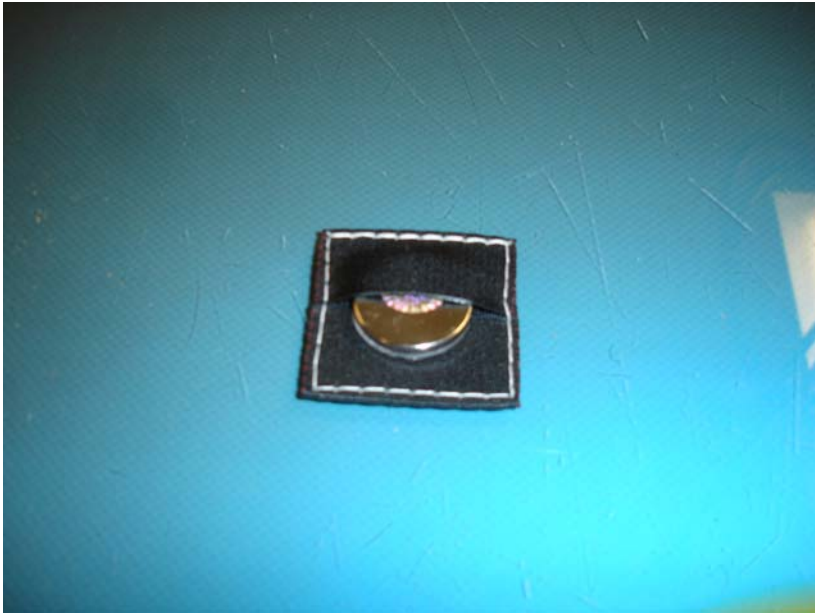


Fig (iii)

**2.2** When complete trim the thread and insert magnet as indicated in Fig (iii) and Fig (iv).

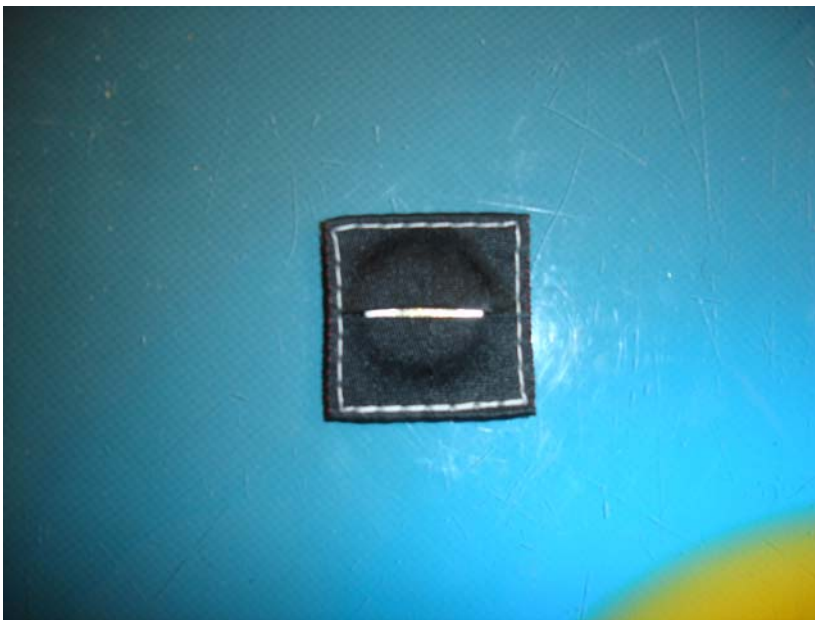


Fig (iv)



Fig (v)

- 2.3** Line up magnet along lower horizontal edge of the Main Disc Cover Flap using a five (5) point stitch pattern, as in Fig ( v)



Fig (vi)

- 2.4** Line up magnet ½” above stiffener and along the center mark on the #2 Main Flap.  
Fig (vi)
- 2.5** Sew down using two passes.