

ZENAIR CH 640

I.P.L. INSPECTION PARTS LIST

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| STANDARD 49% KIT | |
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CABIN FLOOR SUB-ASSY

| REVISION DATE: 19/02 | | REVISION: 0 | | MAN. TO MWO: CABIN FLOOR SUB-ASSY | | | |
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| PART NO | REV. | DRAWING | ASSEMBLY | DESCRIPTION | QTY | CODE | BUILDER |
| 640-F-9-5 | | 640-F-9 | 640-F-12 | CABIN FLOOR. CUT AS PER DRAWING. | 1 | | |
| 20-F-17-1 | | 20-F-17 | 20-F-21 | BOTTOM FLOOR STIFFENER. LINE UP THE CENTER LINE OF THE STIFFENER THE THE CENTER LINE FO THE SKIN. THE STIFFENER IS FLUSH WITH THE FRONT OF THE SKIN. DRILL ALL THE HOLES EXCEPT FOR BOLTS AND CROSSING CHANNELS. | 1 | | |
| 640-F-24-4 | | 640-F-24 | 20-F-21 | FRONT LOWER LONGERONS. THE FRONT PART OF THE LONGERONS WILL BE BOLTED TO THE ENGINE MOUNT FITTINGS. THEREFORE, FIREWALL DRAWING 640-f-23 GIVES 565mm. THIS IS TO THE CENTER OF THE LONGERONS. AT THE REAR, THE LONGERONS ARE 1035mm FROM EACH OTHER, OR 48mm FROM THE SIDES. DRILL ALL THE HOLES EXCEPT FOR BOLTS OR AD-5 HOLES, AND CROSSING CHANNELS. THERE IS NO RIVET AT THE VERY FRONT. | 2 | | |
| 20-F-17-4 | | 20-F-17 | 20-C-8 | FORWARD FLOOR CHANNEL.. LOCATE AS PER DRAWING 640-C-8. THE REAR OF THE CHANNEL IS 160mm FROM THE FRONT OF THE FIREWALL. CUT ENDS SO THAT THEY ARE FLUSH TO THE SIDES OF THE BOTTOM FLOOR. DRILL HOLES . | 1 | | |
| 20-F-17-5 | | 20-F-17 | 20-C-8 | CENTER BEARING CHANNEL.. LOCATE AS PER DRAWING 640-C-8. THIS CANEL IS LINED UP WITH THE CENTR LINE OF THE FLOOR AND AGAINST 640-F-17-4. DRILL THE 6 A5 HOLES. | 1 | | |
| 20-C-6-2 | | 20-C-6 | 20-C-8/C-1 | PEDAL CENTER BEARING. POSITION INTO 640-F-17-5 AND CENTER WITH THE FLOOR. DRILL THE THREE BOLT HOLES. WHEN DRILLING THE BEARING, MAKE SURE THAT THE TWO HOLES FOR THE RUDDER PEDALS ARE NICE AND ROUND AND WITH THE PROPER HOLE SIZE. BOLT THE BEARING TO THE FLOOR. | 1 SE | | |
| 20-C-6-3 | | 20-C-6 | 20-C-8 | OUTBOARD PEDAL BEARING. LOCATE AND DRILL INTO PLACE. NOTE THAT THE HOLES MUST BE CENTERED TO THE BOTTOM LONGERONS AND THE BEARING MUST BE IN PARALLEL TO EACH OTHER SO THAT THE PEDALS WILL FIT THE BEARINGS. | 2 | | |
| 20-C-7-2R | | 20-C-7 | 20-C-8 | BRAKE CYLINDER SUPPORT. POSITION AND DRILL AS PER DRAWING. | 1 SE | | |
| AN3-16A | | | | BOLTS WASHERS & SL NUTS | 6 | | |
| AN3-4A | | | | BOLTS WASHERS & SL NUTS | 4 | | |
| | | | | DO NOT RIVET THE BOTTOM EXTRUSIONS AT THIS TIME | | | |
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| INSPECTION: | | | | DATE: SIG: | | | |