

# ZENAIR CH 640

# I.P.L. INSPECTION PARTS LIST

STANDARD 49% KIT	
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## FLAP L/R

REVISION DATE: AUG. 01		REVISION: 1		MAN. TO MWO: FLAP L/R			
PART NO	REV.	DRAWING	ASSEMBLY	DESCRIPTION	QTY	CODE	BUILDER
				Ref. Std. Procedure A115 - 20-A-4			
20-A-6-1				SKIN LEFT RIGHT	1		
				MARK CENTER LINE ON RIB FLANGES. INSTALL RIBS INTO SKIN AND LOCATE RIB CENTER LINE THROUGH PRE-DRILLED HOLES IN SKIN. DRILL INTO RIBS AND CLECO ALL RIBS INTO POSITION. DO NOT DRILL HOLES WHERE HINGE WILL GO AT THIS TIME. SEE 640-A-6			
				REMOVE RIBS, INSPECT AND CLEAN HOLES. RE-INSTALL AND RIVET BOTTOM ONLY. TRIM ABOUT 32mm ON I/B TOP OF SKIN TO RIB #1 FOR CONTROL LEVER 640-A-4-2. PLACE FLAP ON A FLAT TABLE AND LIFT O/B AS SHOWN ON 640-A-6. HOLD IN PLACE WITH A WOOD STOP. POSITION HINGE AND DRILL HOLES.			
20-A-5-1				INBOARD RIB	1		
20-A-5-2				RIBS	1ea		
20-A-5-3				RIBS	1ea		
20-A-5-4				RIBS	1ea		
20-A-5-5				RIBS	1ea		
20-A-5-6				RIBS	1ea		
20-A-5-7				OUTBOARD RIB	1		
20-A-6-2				PIANO HINGE L=2284mm	1		
20-A-4-2		20-A-4	20-A-4	FLAP CONTROL LEVER. POSITION AND RIVET TO RIB #1	1		
L				STANDARD L x 145mm - POSITION AND DRILL TO FLAP AND CONTROL LEVER. DO NOT RIVET	1		
A4				A4 RIVETS			
A5				A5 RIVETS			
PRE-CLOSING INSPEC				DATE: SIG:			
				FINISH RIVETING AFTER PRE-CLOSING INSPECTION			
INSPECTION:				DATE: SIG:			