

FRONT Z & TORQUE TUBE TUNNEL S/A

REVISION DATE: 19/02		REVISION: 0		MAN. TO MWO: FRONT Z & TORQUE TUBE TUNNEL S/A			
PART NO	REV.	DRAWING	ASSEMBLY	DESCRIPTION	QTY	CODE	BUILDER
				THE CRITICAL PART OF THE ASSEMBLY IS THE LOCATION OF THE TORQUE TUBE BEARING HOLE.			
				DRILL & RIVET TOGETHER PARTS AS FOLLOWS:			
				SEE DRAWING 640-F-15, BOTTOM LEFT FOR ASSEMBLY.			
20-F-10-1				FORWARD Z.. WITH A 90 ANGLE, DRAW A LINE IN THE CENTER OF THE Z. MEASURE 60mm LEFT AND RIGHT AND DRAW TWO LINE. THIS WILL BE THE LOCATION OF THE TWO SIDE WALLS 640-F-15-2 AND 3.	1		
20-F-15-2L		20-F-15	20-F-15	TORQUE TUBE SUPPORT SIDE WALL LEFT. POSITION TO 640-F-10-1, FRONT Z AND DRILL 8 A5 HOLES. TOP AND BOTTOM OF THE SIDE WALLS MUST BE FLUSH WITH THE TOP AND BOTTOM OF THE Z.	1		
20-F-15-2R		20-F-15	20-F-15	TORQUE TUBE SUPPORT SIDE WALL RIGHT. SAME AS LEFT SIDE.	1		
20-F-15-1		20-F-15	20-F-15	TORQUE TUBE FRONT SUPPORT PANEL . POSITION TO THE FRONT OF THE SIDE WALLS AND FLUSH TO THE BOTTOM OF THE SIDE WALLS. DRILL ONE HOLE 35mm FROM THE TOP INTO THE WALLS AND ANOTHER HOLE 95mm FROM THE TOP. CLECO.	1		
20-F-15-5		20-F-15	20-F-15/C-	TORQUE TUBE BEARING PLATE. INSTALL SO THAT THE BEARING HOLE IS LINED UP WITH THE FRONT PANEL HOLE 640-F-15-1.	1		
20-F-15-3		20-F-15	20-F-15	TORQUE TUBE SUPPORT HORIZONTAL DIAPHRAM.	2		
20-F-15-4		20-F-15	20-F-15	ANGLE. DRILL AND RIVET TO 640-F-15-3. QUANTITY TWO.	2		
				FROM THE BEARING, DRILL THROUGH THE FRONT PANEL 3/16" DIA. 4 HOLES.			
				POSITION ASSEMBLY 640-F-15-3 AND 4 TO THE MAIN ASSEMBLY SO THAT THE 3/16" DIA HOLES ARE LINED UP IN THE CENTER OF 640-F-15-4 ANGLES..			
20-F-15-6				FLOOR Z. INSTALL TO THE FRONT OF THE ASSEMBLY, FLUSH TO THE BOTTOM OF THE SIDE WALLS. FINISH DRILLING THE HOLES INTO THE FRONT PANEL. TOTAL OF SIX HOLES PER SIDE.	1		
				REMOVE PARTS, CLEAN AND RIVET. PLACE 4 A6 RIVETS OR 4 AN3 BOLTS INTO THE BEARING.			
20-F-10-2		20-F-10	20-F-10	FRONT WING ATTACH BRACKETS. DRILL HOLES AS PER DRAWING 640-F-10. DO NOT DRILL THE SPAR BOLT HOLES TO 5/16 AT THIS TIME. POSITION THE BRACKETS TO THE FRONT Z, FLUSH TO THE BOTTOM AND 1210mm FROM TIP TO TIP. DRILL INTO THE FRONT Z EXCEPT FOR HOLES AT THE EDGE OF THE Z. CLECO	2		
20-F-10-3		20-F-10	20-F-12	FRONT UPRIGHT. IT IS IMPORTANT THAT THIS UPRIGHT IS 90 DDEG. TO THE TOP OF THE FRONT Z. AND FLUSH TO THE ENDS OF THE Z. DRILL AND CLECO. DRILL THROUGH 640-F-10-2 INTO THE FRONT UPRIGHT.	2		
20-F-10-4		20-F-10	20-F-12	REAR UPRIGHT. POSITION FLUSH TO THE EDGE OF THE FRONT Z.. FROM THE FRONT UPRIGHT, DRILL INTO THE REAR UPRIGHT. CLECO.	2		
20-C-10-2				FAIRLEAD. INSTALL TO THE FRONT PART OF THE FRONT Z, PARALLEL AND CENTERED. DOWN 70mm FROM THE TOP OF THE FRONT Z.	1		
L				STD L L= 250mm. CUT TWO L ANGLES 250mm LONG AND POSITION TO THE FRONT Z, 310mm FROM THE CENTER LINE. DRILL AND CLECO.	4		
20-F-15-8		20-F-15	20-F-21	FLOOR SUPPORT. INSTALL TO THE FRONT PART OF THE FRONT Z, UP 73mm FROM THE BOTTOM. DRILL FOR A5 P50.	2		

ZENAIR CH 640

I.P.L. INSPECTION PARTS LIST

STANDARD 49% KIT	
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PART NO	REV.	DRAWING	ASSEMBLY	DESCRIPTION	QTY	CODE	BUILDER
				TAKE APART, CLEAN AND RIVET TOGETHER			
				BOLTS MAY BE USED INSTEAD OF THE AD RIVETS.			
INSPECTION:				DATE:			SIG: