

FUSELAGE HULL - STAGE ONE

SECTION 2

REVISION DATE: 2/7/01 REVISION: 0

PART NO	REV.	DRAWING	ASSEMBLY	DESCRIPTION	QTY	CODE	BUILDER
640-F-11-2L			640-F-12	Mark, Drill and Cleco seat channels 640-F-11-2L and 640-F-11-2R.	1		
640-F-11-2R			640-F-12		1		
640-F-11-4			640-F-12	Install the fuel selector / center channel assembly to the front and rear spars. Use 4 A5 flush rivets. Line up to the center line of the spars			
640-F-11-1L			640-F-12	Drill and Cleco the 640-F-11-1L and 640-F-11-1R seat side channels. Line them up to the edge of the edge of the fuselage.			
640-F-11-1R			640-F-12				
640-F-8				CENTER SEAT PANEL. PLACE ON TOP OF THE CENTER CHANNEL 640-F-11-4 AND DRILL. DO NOT DRILL AT THE MAIN SPAR.			
640-F-11-7			640-F-12	SEAT PANEL. TRIM ENDS AND FIT OVER MAIN SPAR. BENT EDGE IS AT THE BACK, FACING DOWN.			
640-F-11-9				SEAT RAILS. POSITION TO THE TOP OF THE FRONT SEAT AS PER DRASING 640-F-12. RIVET WITH A5, P50 TO SEAT SIDE CHANNEL 640-F-11-1, AND TO TRONT AND REAR SPARS.			
				RUDDER & BRAKE PEDAL INSTALLATION			
			20-C-8/C-1	BRAKE PEDAL & CYLINDER SUB-ASSY. INSTALL THE RUDDER / BRAKE PEDAL ASSEMBLY TO THE FUSELAGE FLOOR.	1		
AN3-16A			20-C-11	CENTER BEARING BOLT, WASHER & NUTS FROM FLOOR ASSEMBLY	3		
TS17R-10			20-E-12	ADEL CLAMP	1		
640-C-7-4			640-C-8	INSTALL BUSHINGS ON CYLINDERS AS PER 640-C-8	2		
640-C-7-3							
		640-E-12		INSTALL BRAKE LINE FITTINGS TO THE CYLINDERS. USE TEFLON TAPE ON THREADS. SEE 640-E-12 FOR THE PROPER ANGLE OF THE FITTINGS ETC.			
469-4A				ELBOW FITTING	2		
468-4A				STRAIGHT FITTING	4		
				INSTALL THE BRAKE CYLINDERS TO THE FUSELAGE			
10-35			640-C-8	MASTER CYLINDERS	2		
10-54			640-C-8	SLAVE CYLINDERS	2		
AN3-10			640-C-8	BOLT, 5 WASHERS, CASTLE NUT AND COTTER PIN FOR BOTTOM OF CYLINDERS TO CYLINDER BRACKETS 640-C-7-2	4		
AN3-7			640-C-8	BOLT, 5 WASHERS, CASTLE NUT AND COTTER PIN FOR TOP OF CYLINDER TO BRAKE PEDAL. CLEVIS PIN MAY HAVE TO BE ADJUSTED.	4		
487-4		20-E-12		1/4" POLY TUBING 22 FT.	1		
FLT-64		20-E-12		URETHANE TUBING (TO PREVENT CHAFFING) L=120	2		
				NOSE BEARING SUPPORT ASSEMBLY			
20-F-17-2		20-F-17	20-F-21	LOWER NOSE BEARING SUPPORT. DRILL HOLES AS PER DRAWING INTO THE BEARING. INSTALL SO THAT THE FIREWALL NOSE GEAR TOP BEARING IS PARALLEL TO THE BOTTOM BEARING. NOSE STRUT 640-L-4-1 MUST BE PARALLEL TO THE FIREWALL. SEE 640-L-6	1		
AN3-6A			20-F-21	BEARING BOLT	7		
AN960-10				WASHER	7		

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PART NO	REV.	DRAWING	ASSEMBLY	DESCRIPTION	QTY	CODE	BUILDER
AN365-1032			20-F-21	LOCK NUT	7		
20-F-18-1		20-F-18	20-F-20	LOWER ENGINE MOUNT FITTINGS. SEE 640-F-20 DETAIL D	2		
20-F-18-5		20-F-18	20-F-20	LOWER ENGING MOUNT SHIM T=.040 60X40	2		
				MAKE SURE ENGINE MOUNT FITTING IS CLAMPED TIGHTLY TO FIREWALL AND SHIMMED AS REQUIRED BEFORE DRILLING			
			20-F-20	IT IS VERY IMPORTANT THAT THE THREE HOLES IN THE MOUNT FITTING ARE DRILLED INTO THE CENTER OF THE EXTRUSIONS.			
				COMPLETE ALL CABLE CONNECTIONS AND SAFETY, FEED ALL CABLES TO REAR OF FUSELAGE AND SECURE WITH MASKING TAPE.			
20-C-13-3		20-C-13	20-C-13	RUDDER CABLE ASSEMBLY	1		
20-C-13-4		20-C-13	20-C-13	RUDDER CABLE ASSEMBLY	1		
20-M-50-2		20-M-50	20-M-50	UPPER HORIZONTAL CONTROL CABLE	1		
20-M-50-3		20-M-50	20-M-50	LOWER HORIZONTAL CONTROL CABLE	1		
AN3-6				BOLT	4		
AN310-3				CASTLE NUT	4		
MS24665-132				COTTER PIN	4		
AN960-10				WASHER	8		
20-C-10-3		20-C-10-	20-C-13	RIVET OR BOLT 20-C-10-3 FAIRLEAD, AFTER POSITIONING THE CABLES. THIS FAIRLEAD IS POSITIONED ON TOP OF 640-F-15-2	2		
A6				RIVET OR BOLT 20-V-4-1 TORQUE TUBE BEARING (FRWD SPAR). TORQUE TUBE MUST MOVE FREELY, WITH NO PLAY. TORQUE TUBE MUST MOVE FREELY, WITH NO PLAY.	4		
A4				RIVET 20-C-10-6 TO THE L ANGLES, AFTER PASSING THE CABLE THROUGH.	3		
				SAFETY WIRE 20-C-10-5 & 20-F-15-5	A/R		
INSPECTION:				DATE: SIG:			