

## FUSELAGE HULL - STAGE TWO

### SECTION 1

REVISION DATE: 01/02 REVISION: 1

PART NO	REV.	DRAWING	ASSEMBLY	DESCRIPTION	QTY	CODE	BUILDER
			640-F-21	TURN THE ASSEMBLY UPSIDE DOWN ON TWO SAW HORSES.			
				WITH A/C TURNED UPSIDE DOWN, INSPECT THE UNDERSIDE OF THE A/C.			
				LOOK FOR ANY TOUCH-UP WORK REQUIRED			
				COMPLETE THE FOLLOWING FINISHING WORK			
				(1) TRIM & PEEN THE BOTTOM EDGE OF THE FRONT SIDE SKIN. PEEL THE SIDE SKINS TIGHTLY AROUND THE FIREWALL WITH STRAPS. TWO RIVET LINES GO INTO THE BOTTOM SKINS.			
				(2) FILE ANY EXCESS MATERIAL OFF THE CORNERS OF THE FUSELAGE WHERE FLOOR & SIDE SKIN MEET (PAY EXTRA ATTENTION IN THE AREA OF THE MAIN GEAR SUPPORTS)			
				(3) CHECK FOR ANY INTERFERENCE BETWEEN SPAR & SIDE SKINS, TRIM IF NECESSARY			
				(4) INSTALL ANY MISSING RIVETS IN THE SIDE SKINS			
640-F-24-5		640-F-24	20-F-21	LOWER LONGERON DOUBLERS. THE EXACT LOCATION IS NOT CRITICAL.	L&R		
640-F-24-4		640-F-24	20-F-21	FRONT LOWER LONGERON (From Floor Assy). FINISH ALL HOLES AND RIVETS.	L&R		
20-C-6-3		20-C-6		OUTBOARD PEDAL BEARING (From Floor Assy). FINISH ALL HOLES AND BOLTS.	L&R		
AD5-8				BOLT OR RIVET THE PARTS IN PLACE	AS R		
AN3-5A				BOLT	4		
AN960-10				WASHER	4		
AN365-10-32				SL NUT	4		
20-C-7-2				BRAKE CYLINDER SUPPORT (From Floor Assy)			
AN3-5A				BOLT-(Lower Engine Mount)	6		
20-F-18-2		20-F-18		WASHER WELDED TO BOLT, LOWER ENGINE MOUNT	2		
AN960-10				WASHER	6		
AN365-10-32				SL NUT	6		
AD5-8				RIVET	60		
				INSTALL MAIN GEAR SUPPORTS			
				WATCH EDGE DISTANCES ON ALL RIVET LINES			
				MAKE SURE MAIN GEAR SUPPORT IS CLAMPED TIGHTLY IN ALL DIRECTIONS WHEN DRILLING TO A/C			
20-F-19-1		20-F-19	20-F-19/F-	MAIN GEAR SUPPORT (LEFT)	1		

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20-F-19-3		20-F-19	20-F-19/F-	MAIN GEAR SUPPORT (RIGHT)	1		
20-F-25-4		20-F-25	20-F-20	MAIN GEAR SUPPORT SHIM	2		
				INDIVIDUALLY INSPECT ALL SOLID RIVETS INSTALLED ON MAIN GEAR SUPPORT			
				INSTALL SKID BAR			
AD5-7			20-F-5	INSTALL (2) AD5 RIVETS THRU LOWER RUDDER BRACKET, IGNORE CENTER TOOLING HOLE.	2		
20-F-39-1		20-F-39	20-F-39	SKID BAR	1		
20-F-39-2		20-F-39	20-F-39	ANCHOR PAD	2		
20-F-39-3		20-F-39	20-F-39	CLAMP PAD	1		
20-F-39-4		20-F-39	20-F-39	CLAMP BAR	1		
20-F-39-5		20-F-39	20-F-39	BUSHING	2		
AN5-12A		20-F-39		BOLT	2		
AN960-516		20-F-39		WASHER	2		
AN365-524		20-F-39		S/L NUT	2		
AN6-13A		20-F-39		BOLT	1		
AN970-6		20-F-39		WASHER	1		
AN365-624		20-F-39		S/L NUT	1		
AN960-616				WASHER	1		
		640-F-34		DRILL ALL DRAIN HOLES. FLANGE DRAIN HOLES UNDER SEAT PANEL. SEE 20-L-3 & 20-F-34			
		640-F-1		DRILL HOLES FOR BRAKE LINES.			
RB215		20-E-12		GROMMET FOR BRAKE LINES	2		
				INSPECT FOR ANY MISSING RIVETS. DRILL & RIVET AS REQUIRED			
				MAIN GEAR AND WHEEL INSTALLATION. INSTALL THE FOLLOWING MAIN GEAR PARTS TO THE			
				FUSELAGE.			
A115-20-L-2				MAIN GEAR AND WHEEL ASSEMBLY	1		
20-L-3-4		20-E-12	20-L-3	RUBBER HOSE - 3/16" x 1" CUT IN HALF L=300	4		
20-L-3-3		20-L-3	20-L-3	MAIN GEAR SUPPORT ASSEMBLY	2		
PMT 150		20-E-12		TIE WRAP	4		
024-0030		20-E-12		BRAKE LINE CLIPS	4		
AN6-H-11A		20-L-3		BOLTS (SAFETY WIRE AND TIGHTEN IN STAGE 7 SECTION 1 AFTER WING INSTALLATION)	4		
20-F-19-2		20-F-19		LANDING GEAR NUTS	4		
				NOTE: DRILL HOLES IN BOTTOM CORNERS OF MAIN GEAR SUPPORTS FOR WATER DRAIN.			

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PART NO	REV.	DRAWING	ASSEMBLY	DESCRIPTION	QTY	CODE	BUILDER
				WASH OFF ALL MARKER AND EXTRA ZINC CHROMATE WITH LACQUER THINNER			
INSPECTION:				DATE:                      SIG:			
				TURN AIRCRAFT RIGHT SIDE UP			
				FITTING OF THE LOWER NOSE GEAR BEARING : SEE DRAWING 640-L-6 AND 640-C-11 FOR ASSMEBLY			
20-F-17-3				LOWER NOSE GEAR BEARING. DRILL AND TAP (FOR AN3 BOLTS) THE FOUR MOUNTING HOLES. LOCATE THE BEARING TO THE BOTTOM OF THE FIREWALL. SEE 640-C-11 FOR DRILLING AND TAPING. REMOVE FOR NOSE GEAR STRUT INSTALLATION.	1		
20-F-16-9		20-F-16		DOUBLER. LOCATE THE BOTTOM EDGE FLUSH WITH THE TOP OF THE LOWER NOSE GEAR BEARING. FLUSH RIVET TO SIDES. TRIM BOTTOM SIDES AS REQUIRED, AND DRILL 3/4" DIA. HOLE NEAR TOP FOR THE BUNGEE PIN.	1		
				INSTALLATION OF THE NOSE GEAR:			
				2 -- LUBRICATE THE TOP END OF THE NOSE GEAR AND INSTALL IT TO THE FIREWALL. PLACE THE BUNGEE IN POSITION. SEE 640-L-6			
				3 -- LUBRICATE THE LOWER BEARING AND SLIDE IT IN PLACE			
				4 -- INSTALLTHE BEARING THROUGH BOLTS & LIGHTLY TIGHTEN			
				5 -- INSTALL LOWER BEARING BOLTS & TIGHTEN			
				6 --- TIGHTEN ALL BOLTS			
AN3-42A		20-L-6		INSTALL THE LOWER NOSE GEAR BEARING. BOLT. SEE 640-C-11. DRILL THE HOLES THROUGH THE SIDES OF THE BEARING. ONE FRONT AND ONE AT THE REAR, THROUGH THE FIREWALL ANGLES. DO NOT TIGHTEN BOLT. NOSE GEAR NEEDS TO MOVE FREELY.	2		
20-F-16-5		20-F-16	20-L-6	BUNGEE PIN	1		
AN380-4-6				COTTER PIN 1/8 x 1 1/2	2		
20-L-6-1/1		20-L-6	20-L-6	BUNGEE.	1		
20-L-4-1		20-L-4	20-L-6	NOSE GEAR LEG. POSITION INTO PLACE, THROUGH THE TOP BEARING AND BUNGEE. HOOK BUNGEE TO THE REAR OF THE NOSE GEAR. 640-F-16-2. SEE 640-L-6	1		
20-F-17-3				LOWER NOSE GEAR BEARING. RE-INSTALL WITH NOSE GEAR LEG IN CENTER.	1		
AN3-10		20-L-6		BOLT & SAFETY WIRE	4		
AN365-1032				S/L NUT	2		

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20-L-4-3		20-L-4	20-L-6	NOSE GEAR TOP PLATE			1		
AN310-3				CASTLE NUT			1		
AN960-10				WASHER			5		
MS24665				COTTER PIN			1		
NOSE WHEEL INSTALLATION. SEE 640-L-6. INSTALL THE FOLLOWING NOSE WHEEL PARTS TO THE FUSELAGE. MAKE SURE THAT THE NOSE WHEEL FORK IS CENTERED WITH THE FUSELAGE. (STRAIGHT LINE).									
20-SAF-2-12				NOSE WHEEL TIRE + RIM			1		
20-L-4-2		20-L-4	20-L-6	NOSE GEAR FORK			1		
AN960-516				WASHER			2		
AN365-524				SL NUT			2		
AN4-11A				BOLTS			4		
AN960-416				WASHERS			4		
AN365-428A				S/L NUTS			4		
20-L-5-1		20-L-5		NOSE WHEEL AXLE			1		
20-L-5-3		20-L-5		SPACER			2		
20-L-5-4		20-L-5		SHIMS			A/R		
20-L-5-2		20-L-5		AXLE BOLT			1		
AN960-616		20-L-5		WASHER			2		
AN365-524		20-L-5		S/L NUT			1		
THE NOSE GEAR IS COMPLETELY INSTALLED AT THIS TIME.									
BLEED BRAKES									
Std. Ref: Procedure A116-40									
INSPECTION: _____ DATE: _____ SIG: _____									