

# ZENAIR CH 640

# I.P.L. INSPECTION PARTS LIST

STANDARD 49% KIT	
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## AILERON L/R

REVISION DATE: AUG. 01		REVISION: 1		MAN. TO MWO: AILERON L/R		QTY	CODE	BUILDER
PART NO	REV.	DRAWING	ASSEMBLY	DESCRIPTION				
				Ref. Std. Procedure A115 - 20-A-1-1				
				PRE-DRILLED SKIN HOLES TO MARKER LINE ON RIBS. BE CAREFULL NOT TO DAMAGE AILERON SKIN. RIBS MUST BE TIGHT TOWARDS THE FRONT. DRILL INTO RIBS AND CLECO.				
				DRAWING 640-A-3 TOP LEFT - SHOWS THAT THE TOP SURFACE OF THE AILERON IS FLAT. THEREFORE, PUT THE TOP OF THE AILERON DOWN ON A FLAT TABLE. THERE SHOULD BE NO TWIST LOCATIONS AS PER 640-A-1. PLACE A STOPPER (PLYWEED, ETC.) BETWEEN SKIN + RIBS AND PRE-DRILL TO #40 HOLES. CHECK THAT HOLES LINE UP WITH RIB CENTER MARKER LINES AND DRILL CLECO'S IN THE DRILLED HOLES SO THAT THE RIBS CANNOT MOVE. LOCATE THE HINGE AS PER 640-A-3 AND DRILL.				
				OPEN SKIN, INSPECT, CLEAN CLOSE, CLECO AND RIVET EVERYTHING.				
PRE-CLOSING INSPEC				DATE:                      SIG:				
				INSTALL TIP AILERON RIB 640-A-3-2. THE IMPORTANT THING HERE IS THAT IT LOOKS NICE. EXACT				
20-A-1-2								
20-A-2-1				RIB				
20-A-2-2				RIB				
20-A-2-3				RIB				
20-A-2-4				RIB				
640-A-3-1				AILERON SKIN				
		20-A-3	20-V-14	HINGE L=1830mm				
				AILERON TIP			1	
				A4 RIVETS			46	
				A5 RIVETS			85	
INSPECTION:				DATE:                      SIG:				