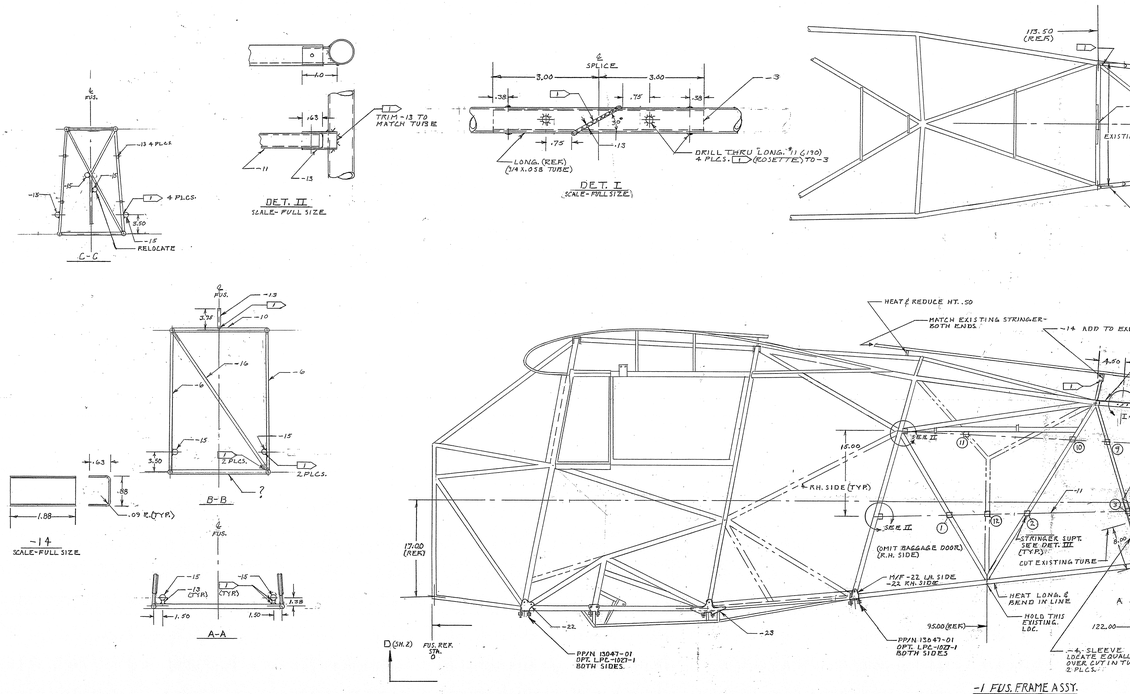

REVISIONS			
SYM.	DESCRIPTION	DATE	APP'D

1. WELD PER FAR PART 43 43.13-1B, SECT. 2.
2. REMOVE EXISTING TUBE & WELD READ, ADD NEW TUBE & WELD PER 1.
3. FTG. & TO BE PARALLEL TO OPPOSITE FTG. - LOCATE FTG. OVER JOINT CENTER.
4. TRIM TUBE TO FIT REQUIRED JOINT.
5. JOINT LOCATION TO PROVIDE A STRAIGHT LONGERON BETWEEN EXISTING FUSELAGE SECTIONS.
6. FINISH - PRIME ASSY WITH 2 COATS MIL-P-23377 - COVER PRIMED SURFACE WITH 2 COATS OF EPOXY OR URETHANE ENAMEL.

NOTES 1. THIS DWG. IS A REDRAW OF SIMPSON AVIATION CO. DWG. 66-2
2. CLEAN FRAME ASSY WITH LIGHT SAND BLASTING, INSPECT FOR CRACKS & MEMBER DAMAGE.
3. WELDING & REPAIRS ARE TO BE PERFORMED PER FAR PART AC 43.13-1A, SECTION 2.
4. LIGHT PLANE COMPONENTS (PARTS SOURCE) 309 BUCKLEY RD. AURORA, COLO. 80011
5. DRILL ALL NEW TUBING AT HIGH POINT WITH #30 (.128) HOLE. FILL TUBE WITH HOT LINSEED OIL - DRAIN & PLUG HOLES WITH SELF TAPPING SCREWS.

NO.	X-L.H.	X-R.H.
1	1.25	——
2	2.25	2.00
3	2.60	2.00
4	1.73	1.75
5	1.13	1.38
6	.75	.88
7	2.00	2.13
8	2.25	2.25
9	2.75	2.88
10	2.88	3.00
11	——	1.63
12	——	1.75

TOL. ±.125 TO PROVIDE A WELL FAIRED STRINGER.

P/N	ITEM	STOCK SIZE	MATERIAL	QTY	LOC
13934-00	STRINGER-TOP	——	PIPER PART	1	1
LPC-1027-1	OPT TO 13047-01	——	LIGHT PLANE COMPONENTS	4	1
13047-01	FLOAT FTG.	——	PIPER PART	4	1
LPC-1027-2	OPT TO 20411-00	——	LIGHT PLANE COMPONENTS	1	1
20411-00	TAIL WHEEL FTG.	——	PIPER PART	1	1
-23	FTG. GUSSET	.090 X 2.75 X 6.10	AISI C 4130 NORM. SHT.	2	2
-22	GUSSET (OPT.)	.090 X 2.13 X 2.90	AISI 4130 NORM. SHT	4	2
-21	TUBE-LWR. DIAG.	1/2 X .035 X 30.50	AISI 4130 NORM. 4	1	1
-20	TUBE-LWR. CROSS	3/4 X .058 X 17.50		1	2
-19	TUBE-LWR. DIAG.	1/2 X .035 X 31.00		1	2
-18	TUBE-LWR. CROSS	5/8 X .058 X 22.50		1	2
-17	TUBE-PULLEY	5/8 X .035 X 1.38		1	1
-16	TUBE-FRAME DIAG.	1/2 X .035 X 30.00		1	1
-15	TUBE-RING	7/8 X .035 X .50	AISI 4130 NORM. 6	8	1
-14	CHAN.	.080 X .590 X 2.15	AISI 1020 OR EQUIV.	1	1
-13	STRG. SUPT TUBE	1/2 X 1/2 X .035 SQUARE	AISI 1020 OR EQUIV.	AR	F
-12	FAIRING STRG. UPR.	LEN.= 94.00	M/F PPVN 21621-00	2	1
-11	FAIRING STRG. LWR.	LEN.= 98.00	M/F PPVN 21621-00	2	1
-10	TUBE-UPR. CROSS	3/4 X .058 X 17.00	AISI 4130 NORM. 4	1	1
-9	TUBE-UPR. DIAG.	1/2 X .035 X 30.50		1	1
-8	TUBE-UPR. DIAG.	1/2 X .035 X 38.50		1	1
-7	TUBE-SIDE DIAG.	1/2 X .035 X 35.00		2	1
-6	"	1/2 X .035 X 25.00		2	1
-5	TUBE-SIDE DIAG.	1/2 X .035 X 31.00		2	1
-4	SPLICE TUBE-DIAG.	5/8 X .058 X 8.00		3	2
-3	SPLICE TUBE-LONG	7/8 X .035 X 6.25		4	1
-2	TUBE EXT.-LONG.	3/4 X .058 X 23.00	AISI 4130 NORM. 4	4	1
-1	FUS. FRAME ASSY	——	——	1	1

DRAWN BY: [illegible]
CHECK BY:
SCALE: 1:6 OR NOTED
TOL: ±.03
FINISH: 5
USED ON: SAC-1000

BUSHMASTER DESIGN LLC.
KENT, WASHINGTON - Division of Bushmaster Mfg. Ltd.
5019 Verdict Road, Cobble Hill, B.C. Canada, V0R-1Y0

FUSELAGE FRAME ASSY.
SAC-3000 -1 2