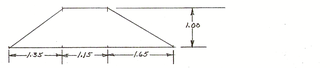

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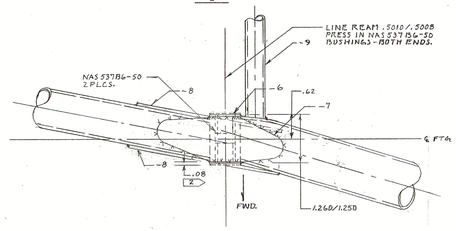
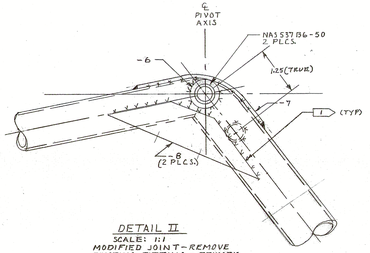
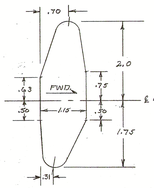




DETAIL II
SCALE: 1:1
MODIFIED JOINT - REMOVE EXISTING FITTING - REWORK AS SHOWN.



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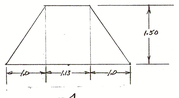

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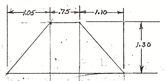

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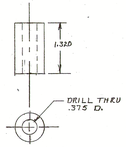
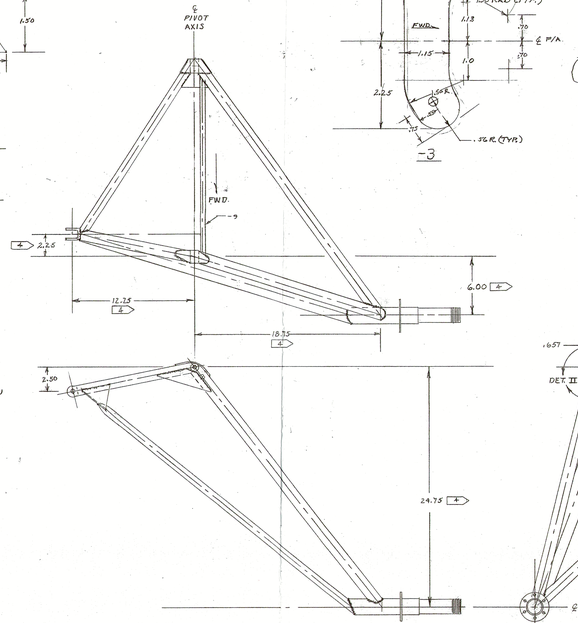
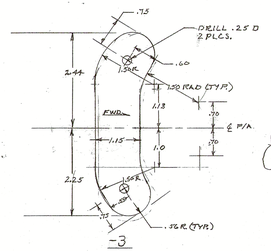


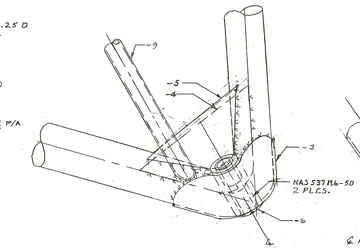
-6



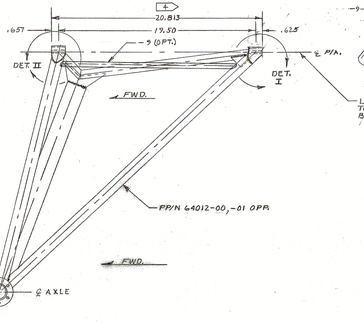
-1 ASSY, -2 OPP.
(SCALE: 1:4)

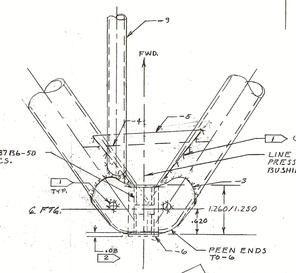


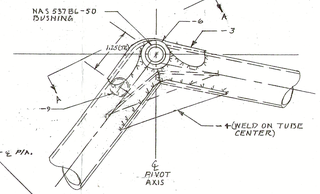
-3



A-A







DETAIL I
(SCALE 1:1)
MODIFIED JOINT - REMOVE EXISTING FTG. - REWORK AS SHOWN.

LINE REAM TO .5154/.5146 BOTH FTG.

1 > WELD PER FAR AC 43.13-1A, SECT. 2.

2 > SPOT FACE TO DIM. TO PROVIDE TRUE BRG. SURFACE - .08 DIM. TO LOCATE -6 PLUG & -3 STRAP.

3 > 2 COATS MIL-P-23377 PRIMER, MASK OFF AXLE.

4 > HOLD THESE DIMENSIONS BY A JIG TOOL.

NOTE 1. REMOVE EXISTING FTG. TO BE MODIFIED. LIGHTLY SAND BLAST ASSY - MASK OFF AXLE.
2. MAGNETIC PARTICLE INSPECT ALL WELD JOINTS, REF FAR AC 43.13-1A, SECT. 3.

REVISIONS			
SYM.	DESCRIPTION	DATE	APP'L

P/N	ITEM	STOCK SIZE	MATERIAL	QTY	LOC
	BUSHING - BRONZE	NAS 537 BG-50		4	
64012-01	OPP. -00 (R.H.)		PIPER PART	1	
64012-00	MAIN GR. VEE ASSY (L.H.)		PIPER PART	1	10
-9	TUBE OPT. (TAKING)	1/2 X .035 LEN. 16.00	AISI 4130 NORM. TUBE	2	
-8	GUSSET	.090 X 1.00 X 4.18	AISI 4130 NORM. SHT.	4	
-7	REINF. STRAP	.090 X 1.18 X 3.88	AISI 4130 NORM. SHT.	2	
-6	PLUG	.75 DIA. LEN. 1.54	AISI 4130 NORM. BAR.	2	
-5	GUSSET -	.090 X 1.31 X 3.0	AISI 4130 NORM. SHT.	2	
-4	GUSSET - LWR.	.090 X 1.53 X 3.18		2	
-3	REINF. STRAP	.090 X 1.53 X 4.75	AISI 4130 NORM. SHT.	2	
-2	OPP. -1			1	
-1	MAIN GR. VEE ASSY LH.			1	

DWN. BY: BSHelm 3/4/81
CHK. BY:
SCALE: 1:1 OR NOTED
TOL.: .000 ±.01
.00 ±.02
FINISH: 63
USED ON: SAC-4000

SIMPSON AVIATION CO.
P.O. BOX 126
GILLIAM, LA. 71029

MAIN LANDING GEAR VEE ASSY.

SAC-4100

SAC-4100