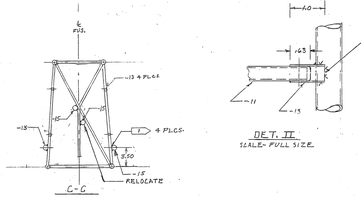
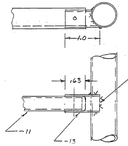
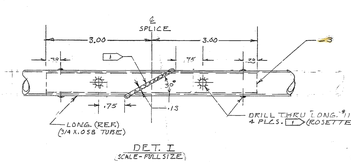
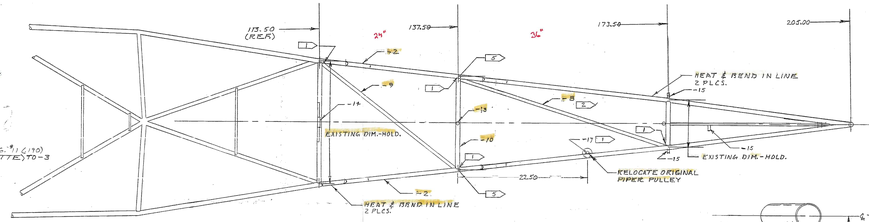
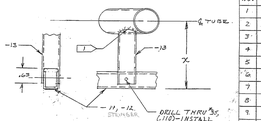
REVISIONS			
SYM.	DESCRIPTION	DATE	APP'D





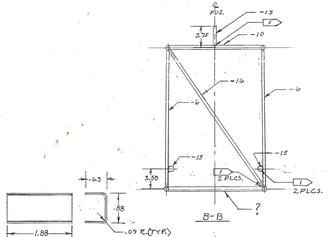


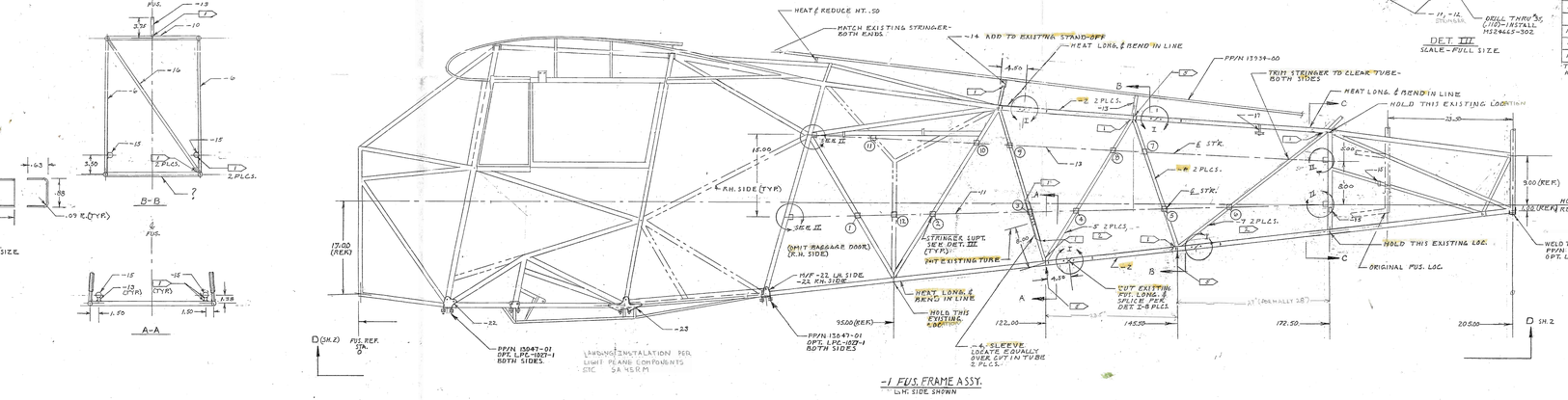




NO.	X- L.H.	X- R.H.
1	1.25	——
2	2.25	2.00
3	2.00	2.00
4	1.75	1.75
5	1.13	1.38
6	.75	.88
7	2.00	2.13
8	2.25	2.25
9	2.75	2.88
10	2.88	3.00
11	——	1.63
12	——	1.75

TOL. ±.125 TO PROVIDE A WELL FAIRED STRING





-1 FUS. FRAME ASSY.
L.H. SIDE SHOWN

WELD PER FAR PART 43.13-1A, SECT. 2.
REMOVE EXISTING TUBE & WELD READY, ADD NEW TUBE & WELD PER
FTG. & TO BE PARALLEL TO OPPOSITE FTG. - LOCATE FTG OVER JOINT CENTER.
TRIM TUBE TO FIT REQUIRED JOINT.
JOINT LOCATION TO PROVIDE A STRAIGHT LONGERON BETWEEN EXISTING FUSELAGE SECTIONS.
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 & MINIMAL DAMAGE.
3. WELDING & REPAIRS ARE TO BE PERFORMED PER FAR PART AC. 43.13-1A, SECTION 2.
4. LIGHT PLANE COMPONENTS (PARTS SOURCE).
309 DUCKLEY RD.
AURORA, COLO. 80011
5. DRILL ALL NEW TUBING AT HIGH POINT WITH #30 (.128) HOLE, FILL TUBE WITH HOT UNSALTED OIL - DRAIN & PLUG HOLES WITH SELF TAPPING SCREW.

P/N	ITEM	STOCK SIZE	MATERIAL	QTY. LOC
13934-00	STRINGER-TOP	——	PIPER PART	1 1
LPC-1027-1	OPT. TO 13047-01	"AN" STEEL HARDWARE PREVIOUSLY	LIGHT PLANE COMPONENTS	4 1
13047-01	FLOAT FTG.	——	PIPER PART	4 1
LPC-1027-2	OPT TO 20611-00	" AN" STEEL	LIGHT PLANE COMPONENTS	1 1
20611-00	TAIL WHEEL FTG.	——	PIPER PART	1 1
-23	FTG. GUSSET	.090 X 2.75 X 6.10	AISI. 4130 NORM. SHT.	2 2
-22	GUSSET (OPT.)	.090 X 2.13 X 2.50	AISI 4130 NORM. SHT	4 2
-21	TUBE- LWR. DIAG.	1/2 X .035 X 30.50	AISI 4130 NORM.	1 2
-20	TUBE- LWR. CROSS	3/4 X .058 X 17.50		1 2 30
-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 .032 X 1.38		1 1
-16	TUBE - FRAME DIAG.	1/2 X .035 X 30.00		1 1
-15	TUBE - RING	3/8 X .035 X .50	AISI 4130 NORM.	8 1
-14	CHAN.	.040 X 1.50 X 2.15	AISI 1020 OR EQUIV.	1 1
-13	STGR. SUPT TUBE	1/2 X 1/2 X .035 SQUARE	AISI 1020 OR EQUIV.	AR 1
-12	FAIRING STGR. UPR.	LEN.= 74.00	M/F PP/N 21621-00	2 1
-11	FAIRING STGR. - LWR.	LEN.= 78.00	M/F PP/N 21621-00	2 1
-10	TUBE - UPR. CROSS	3/4 X .058 X 17.00	AISI 4130 NORM.	1 1 10
-9	TUBE - UPR. DIAG.	1/2 X .035 X 30.50		1 1
-8	TUBE - UPR. DIAG.	1/2 X .035 X 30.50		1 1
-7	TUBE - SIDE DIAG.	1/2 X .035 X 35.00		2 1
-6	TUBE - SIDE DIAG.	1/2 X .035 X 22.00		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.	5/8 X .035 X 6.25		4 2
-2	TUBE EXT.- LONG.	3/4 X .058 X 25.00	AISI 4130 NORM.	4 2
-1	FUS. FRAME ASSY	——	——	1 1

DRAWN BY: [illegible] 4/5/99
CHECK BY:
SCALE: 1:6 OR NOTED
TOL.: ±.02
FINISH:
USED ON: SAC-1000

BUSHMASTER DESIGN LLC.
KENT, WASHINGTON - Division of Bushmaster Mfg. Ltd.
8919 Weddell Road, Coldstream, BC, Canada, V1B-1Y4

FUSELAGE FRAME ASSY.

SAC-3000 1-2