

REAR SEAT

REVISION DATE: 19/02		REVISION: 0		MAN. TO MWO: REAR SEAT					
PART NO	REV.	DRAWING	ASSEMBLY	DESCRIPTION			QTY	CODE	BUILDER
				REAR SEAT INSTALLATION					
				START THIS SECTION ONLY AFTER YOU HAVE COMPLETED STAGE 1 SECTION 3, WHICH INCLUDES THE REAR FUSEALGE BULKHEADS, AND LONGERON DOUBLERS ETC..					
				THE EXACT POSITION OF THE REAR SEAT, L ANGLES AND OTHER CHANNELS IS NOT CRITICAL. MAKE SURE THAT THE CONTROL CABLES ARE NOT TOUCHING THE SEAT SUPPORTS ETC..					
640-F-40-2		640-F-40	604-F-41	REAR SEAT REAR SUPPORT. TRIM AROUND CONTROL CABLES AS PER DRAWING 640-F-40 AND INSTALL. AS PER 640-F-41. THE TOP IS 280mm FROM THE FLOOR AND OVERLAPS THE REAR SPAR BY 20mm. DRILL A5 P30 TO THE REAR SPAR AND SPAR UPRIGHT.			1		
640-F-40-12		640-F-41	640-F-41	CUT AND INSTALL SHORT L ~200 mm ON THE RIGHT & LEFT SIDE OF THE REAR SEAT SUPPORT, WITH 490 mm BETWEEN THE ANGLES. SEE 640-F-41, DETAIL SEAT SUPPORT INST. AND SEAT PANEL RIVETING. DO THE SAME FOR THE FRONT SEAT SUPPORT 640-F-41-1.			3		
640-F-40-3		640-F-41	640-F-41	INSTALL THE TWO REAR SEAT SUPPORTS 640-F-40-3 SO THAT THE TOP ARE FLUSH WITH THE TOP OF THE SEATS			2		
640-F-40-4		640-F-40	640-F-41	TRIM TO FIT THE SEAT PANEL AND DRILL.			1		
640-F-40-7		640-F-41		POSITION THE LOWER SEAT BACK ANGLE AS SHOWN ON 640-F-41, DRILL AND RIVET A5 p. 30 TO 640-F-40-2			1		
640-F-40-12		640-F-41	640-E-5	TUNNEL INSTALLATION BEHIND MAIN SPAR. ON THE REAR SIDE OF THE CENTER MAIN SPAR, CUT 640-F-40-12 L ANGLES AND POSITION ON BOTH SIDES OF THE CENTER LIGHTNING HOLE. SEE DRAWING 640-F-41, RIGHT SIDE FOR TUNNEL INSTALLATION.			1		
640-F-40-12		640-F-41	640-E-5	REPEAT THE SAME FOR THE FRONT SEAT SUPPORT 640-F-40-1. NOTE THAT THE DISTENCE BETWEEN THE L ANGLES MUST BE 130mm SO THAT THE TUNNEL TOP 640-F-40-10 WILL FIT FLOOR. THE FLOOR IN FRONT OF THE REAR SEAT IS UP ABOUT 140-150mm FROM THE BOTTOM FUSELAGE SKIN. SEE 640-F-41 SECTIONAL VIEW. THEREFORE, INSTALL 640-F-40-12 L ANGLES ON THE WALLS SO THAT A WOOD PIECE OF WOOD CAN BE PLACED OVER THEM. SEE 640-F-41 TUNNEL INSTALLATION			4		
640-F-11-4			640-E-5	FLOOR STIFFENER. IN THE CENTER OF THE TWO FLOOR AREA'S, FLUSH RIVET FROM L ANGLES TO 640-F-11-4, FRONT TO BACK WITH 2 A5 FLUSH RIVETS AT EACH END			2		
640-F-40-9		640-F-41		TUNNEL SIDES (A5)(p.~40), LENGTH TO BE CUT TO FIT BOTTOM AS WELL AS REAR			2		
640-F-40-10		640-F-41		TUNNEL TOP IS TRIMED TO FIT BETWEEN THE MAIN SPAR AND SEAT FRONT. SINCE THE CONTROL CABLES PASS INSIDE THE TUNNEL, YOU MAY WANT TO RIVNUT TO TOP TO THE SIDES. MAKE SURE THAT THERE IS ONE L ANGLES AT THE FRONT AND REAR OF THE TOP TUNNEL.			1		
640-F-40-8		640-F-40	640-F-41	THE SEAT BACK IS TRIMED IN WIDTH AND HEIGHT. SEE 640-F-41 SETIONAL VIEW FOR DETAILS. THE SEAT BACK IS IN FRONT OF THE REAR SPAR UPRIGHT.			1		
				INSTALL SHORT "L" ANGLES ON THE FUSELAGE SIDE SKINS, NEAR THE TOP, PAST THE REAR SPAR UPRIGHT.					

ZENAIR CH 640

I.P.L. INSPECTION PARTS LIST

STANDARD 49% KIT	
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640-F-11-4				CUT AND INSTALL 640-F-11-4 CHANNEL DOWN CENTER OF SEAT BACK , A5(p.40). TOP AND BOTTOM MUST BE RIVETED TO THE 640-F-40-7 AND 640-F-40-6. TWO RIVETS AT THE TOP AND ON RIVET IN THE BOTTOM CENTER. SEAT BELT ATTACH. 640-F-40-11 ARE BOLTED TO THE BOTTOM, THROUGH 640-F-40-7.	1		
640-F-40-11		640-F-40		CENTER SEAT BELT ATTACH. BRACKETS ARE INSTALLED WITH A PIECE OF ALUMINUM 1/8" x30mm WIDE AND L=50mm AT THE REAR OF 640-F-13-4,	2		
640-F-40-11		640-F-40		LEFT AND RIGHT SEAT BELT ATTACH. DRILL HOLE THROUGH SEAT BACK AND 640-F-40-7 AND CENTER OF REAR SPAR UPRIGHT. BRACKETS ARE INSTALLED WITH A PIECE OF ALUMINUM 1/8" x30mm WIDE AND L=50mm AT THE REAR OF THE REAR SPAR UPRIGHT.	2		
				REMOVE EVERYTHING, CLEAN AND RIVET TOGETHER.			
1/4" PLYWOOD		640-E-5		SEE 640-E-5 CUT AND INSTALL 1/4" PLYWOOD FOR THE SEAT BACK AND SEAT BOTTOM, AND FOR EACH FOOT REST AREA. PLYWOOD IS NOT SUPPLIED IN THE KIT.	3		
				SIGN: _____ DATE: _____			