

Procedure 3.090A

FUEL VENT INSTALLATION

In this procedure...

The fuel tank vent tubes will be installed in the outboard fuel tank rib.

For this procedure, the following parts will be required:

<u>Part Number</u>	<u>Description</u>	<u>Qty</u>
111-33-054	Fuel Vent Tube	2
B SP-43	Pop Rivet	6

Step 1. LOCATE THE POSITION OF THE FUEL VENT TUBE.

Locate the position of the fuel vent tube on Rib G, by measuring forward from the main spar shear web 6.50" and up from the lower wing skin 2.75".

Step 2. PREP VENT TUBE.

Drill a 1/4" hole in the Rib G at the location determined in Step 1. Use a 2" Holesaw to remove outboard rib skin a 5lb. foam on Rib "G" (BL 176.00). Temporarily insert the vent tube so that the round plate is located on the inboard skin of Rib G, with the tube vertical. The tube on the inboard side of the rib should come within 1/4" of the top wing skin. (Remember you are building the wing up side down.) With the tube in position drill (3) #30 holes evenly spaced around the plate. Cleco in place, as you drill holes. Remove and prep tube around both plate faces and sand-prep 3.5" circle around holes on both sides of Rib "G". Ensure all foam in 2" cutout is removed so plate sits flat. (Fig. 90.1 and 90.2)



Fig. 90.1 (Installation Example)



Fig. 90.2 (Installation Example)

Step 3. INSTALL VENT TUBE

Cut (2) ea. Side, 3.5" circles of 7781 cloth. Cut small "X" in center of each to pass over vent tube to rib surface.

A. On inboard side, apply (2) plies (Fig. 90.3).



Fig. 90.3

B. Mix up a batch, approx. 50 grs. Resin and mix in mill fiber and Cabosil until the consistency of peanut butter (Doesn't run off stick) with resin from first batch from inboard application. Brush inside hole and base of vent tube. Add Cabo/ Mill fiber mix to hole until flush with surface of rib and cover with (2) plies of 7781 cloth, cut previously prior to inboard application. (Fig. 90.4 and 90.5)

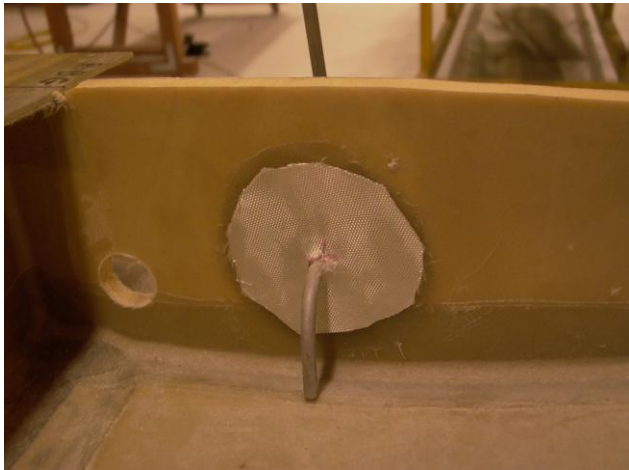


Fig. 90.4



Fig. 90.5

Your Vent Tube Base is now installed.