

75-TA-1
Horizontal Stabilizer Skeleton



This manual has been prepared for assembly of the Horizontal Stabilizer supplied with match drilled parts. This photo assembly manual is intended as a supplement to the drawings. If there is any discrepancy between this manual and the drawings, the drawings supersede this manual. For information on building standards and tolerances see "Construction Standards for Zenair Light Aircraft" available from Zenith Aircraft Co.



P/N: 75T1-5
Horizontal Stabilizer
Rear Spar

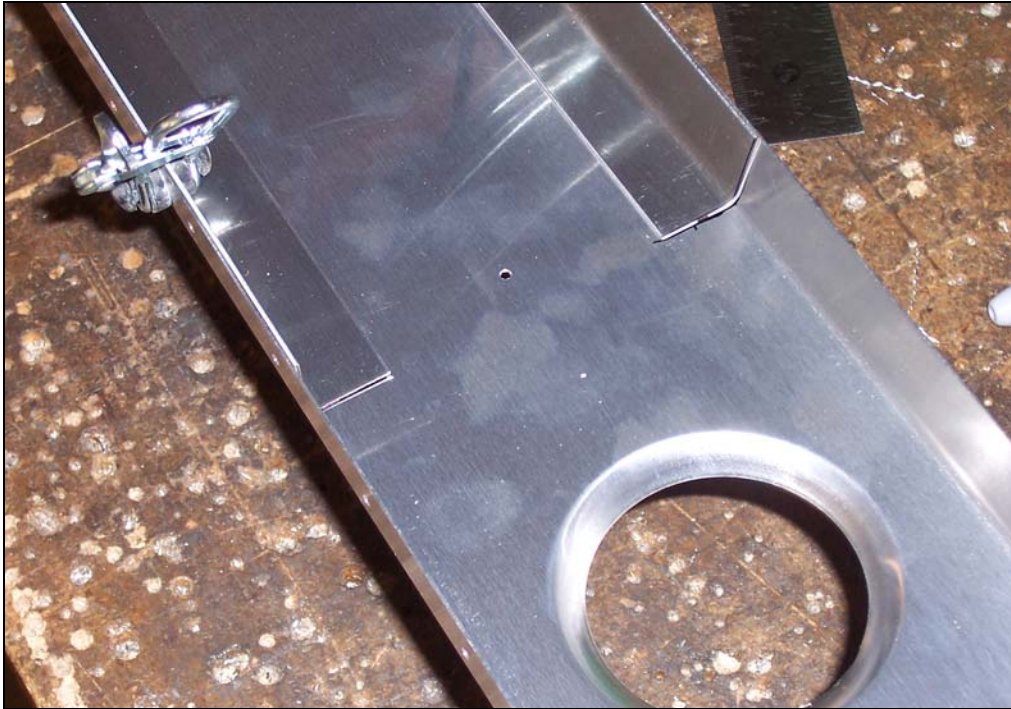
P/N: 75T2-1
Horizontal Stabilizer
Front & Rear Spar
Upper Doubler

P/N: 75T2-3
Horizontal Stabilizer
Rear Spar Lower
Doubler

Mark a line 10mm outboard of the predrilled holes that are 710mm from the center of the Rear Spar. Line up the end of the Doublers with the mark and clamp them to the Rear Spar.



Drill to A4 and Cleco the Doublers to the Rear Spar.



P/N: 75T1-4
Horizontal Stabilizer
Front Spar

P/N: 75T2-1
Horizontal Stabilizer
Front & Rear Spar Upper
Doubler

P/N: 75T2-2
Horizontal Stabilizer
Front Spar Lower
Doubler

Mark a line 10mm outboard of the holes that are 710mm from the center of the Front Spar. Line up the end of the Doublers with the mark and clamp them to the Front Spar. Drill to A4 and Cleco the Doublers to the Front Spar.



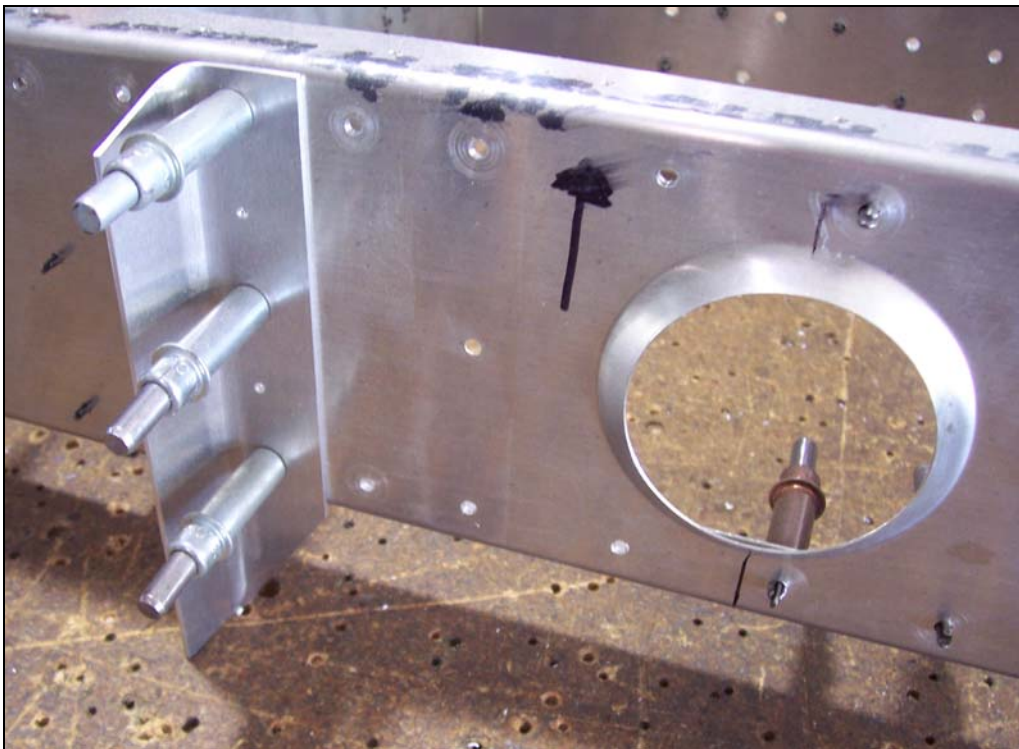
P/N: Standard "L"
Length = 100mm

Ref: Construction
Standards for Zenair
Light Aircraft

Cut an L angle to 100mm. Mark the center line on one flange and align the center line through the predrilled holes in the Front Spar on the ends. With a #40 drill bit, back drill through the Front Spar into the L angle and Cleco. Expand the holes with a #30 drill bit and Cleco.

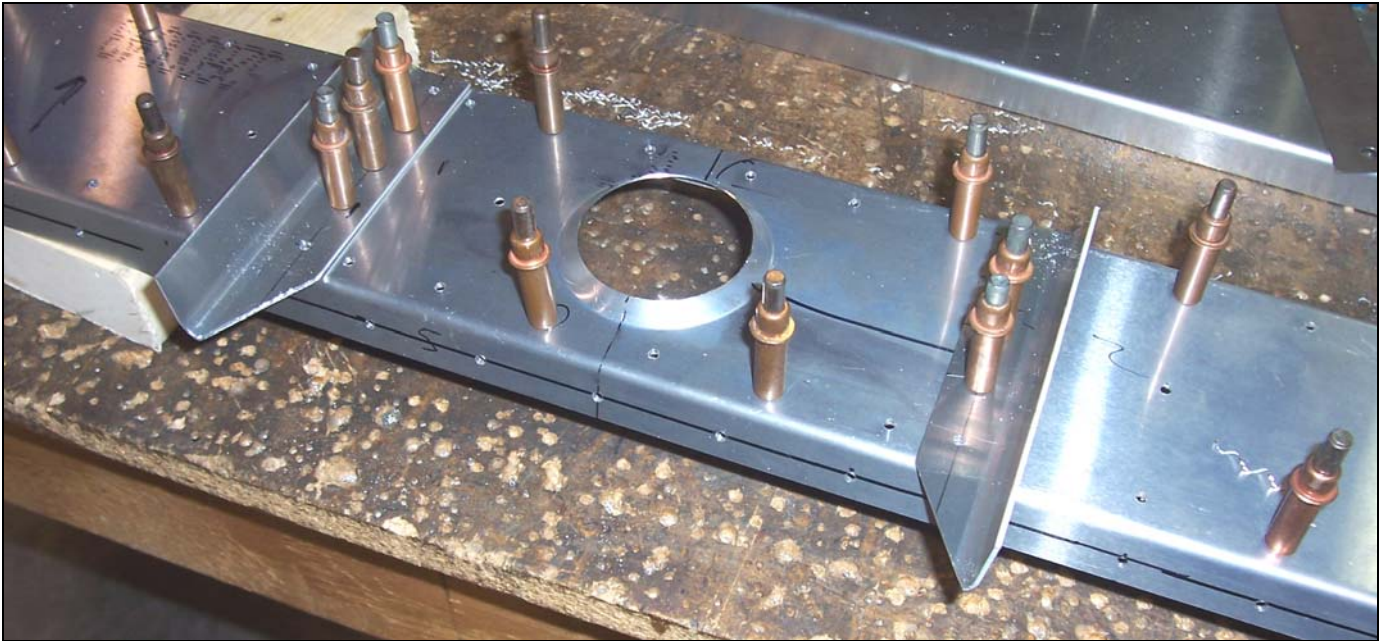


P/N: 75T2-4
Horizontal Stabilizer Front
Brackets



Cleco the Front Brackets to the Front Spar.

Orientation: The flanges of the Front Brackets that are Clecoed to the Front Spar point inboard.



Expand the holes with a #20 drill bit and Cleco. Once the Front Brackets are drilled remove them until final assembly of the Skin.



P/N: 75T1-3
Horizontal Stabilizer
Rear Ribs

Cleco the Rear Ribs to the Front Spar. The inboard set of Rear Ribs cleco to the holes 160mm from the center of the Front Spar. The outboard set of Rear Ribs cleco to the holes 710mm from the center of the Front Spar.

Note: The height of the front of the Rear Rib is shorter than the rear.



Cleco the Rear Spar to the Rear Ribs.



P/N: 75T1-2
Horizontal Stabilizer Nose
Ribs

Cleco the Nose Ribs to the Front Spar. The outboard nose ribs have common holes with the outboard Rear Ribs. The center Nose Rib is Clecoed on to the holes 60mm to the right of the Front Spar center line. Drill the Nose Ribs and Rear Ribs to A4.