

WHEEL PANT INSTRUCTIONS **Wheel Pants** **Sub Section "F"**

PREPARE CAP AND AXLE

STEP 1: TRIM WHEEL OPENING

Trim the wheel opening in the #37002 Right and #37001 Left Pant to allow for the wheel to fit just enough to clear the tire. This will allow plenty of room for the tire, once the Wheel Pant is lowered.

STEP 2: DRILL HUB CAP

Drill a 11/16" hole in the center of each hub cap.

STEP 3: COUNTERBORE AXLE

Counterbore each axle 9/16", 1 inch deep at the threaded end. Refer to Fig LG-F-1

STEP 4: DRILL SPINDLE

Remove the cotter pin from the AN320-12 Nut and insert the #35005 Spindle. Mark the Spindle through the same hole for cotter pin placement. Drill a 1/8 inch hole through the Spindle for an AN380-4-5 Cotter Pin. Refer to Fig. LG-F-1.

STEP 5: INSTALL Z BRACE

Drill two 13/64" rivet holes in the #32001 Z Brace for a 3/16" Nut Plate, and two 1/4" holes to match the existing bolts in the brake caliper plates per Fig. Fig LG-F-1.

STEP 6: ATTACH NUT PLATE

Using AN426-3-4 Rivets attach the nut plate to the Z Brace.

NOTE: Some of the first wheel pants were not marked for centering the pant on the wheel (positioning for the AN4-5A Bolt into the Spindle or attachment to the Z Brace). This will have to be done with several measurements, triangulating the position of the bolt or screw holes then transferring those measurements to the pant. Use "shot" bags and block to help you level and position the pant.

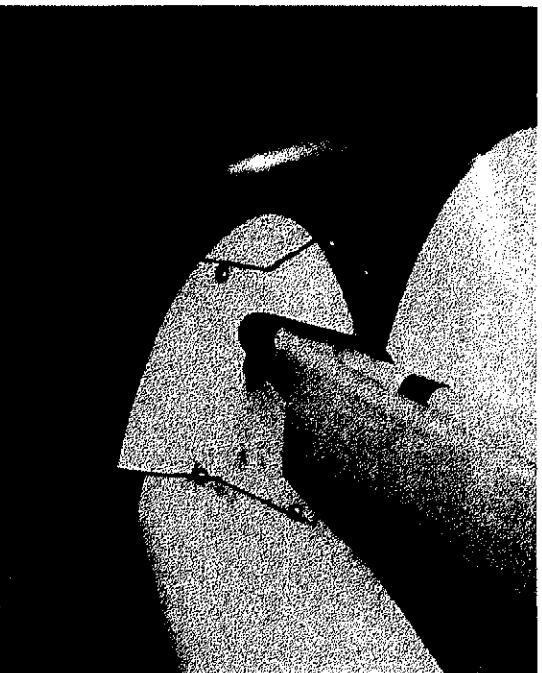


Spindle fits inside axle



Inside Bracket

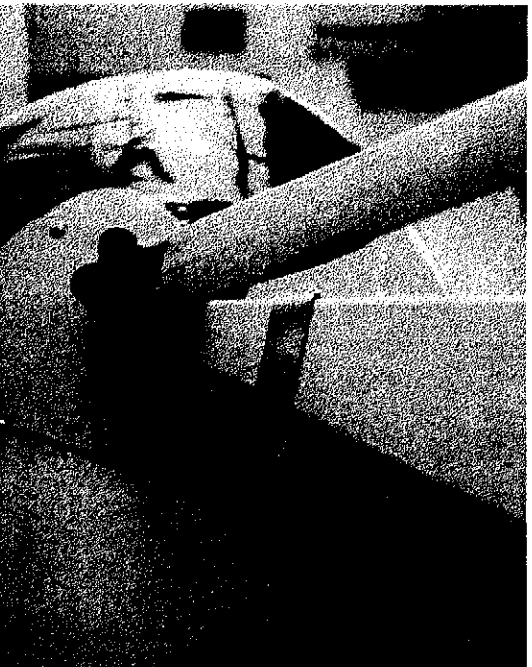
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STEP 7: POSITION WHEEL AND PANT
Drill the AN970-3 Washer to 1/4" I.D. Then drill a 1/4" hole through the Pant on the outside half, for the AN4-5A Spindle Attach Bolt. Use either the pre-marked dimple location or your triangulation measurements for the correct position.

STEP 8: POSITION PANT FOR Z BRACE
When positioning the Pant for attachment to the Z Brace, drill only one of the 3/16" holes at this time. This allows you to rotate and level the Pant. When you are satisfied with the position, drill the second 3/16" mounting hole for the Z Brace. A strip duplicator is handy for this application.

Wheel Pant With Bracket Cover



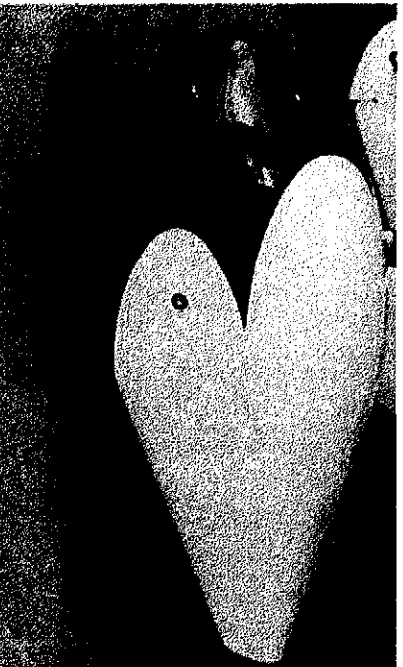
STEP 9: TRIM COVER PLATES
Trim the #32901 Left and #32902 Right Cover Plates for the gear leg and brake line per Fig LG-F-1. Using a strap duplicator to mark the holes, drill three more 3/16" holes in the Cover Plates per Fig. LG-F-1 for AN526-1032R8 Screws. Position the Cover Plate on the Pant, and attached it to the Z Brace, then back drill the 3/16" holes into Pant.

STEP 10: ATTACH NUT PLATES
Remove the Cover Plates and Pants. Using the nut plates as a guide, back drill through the nut plate and Pant for AN426-3-4 Rivets. Attach the nut plates. Use a #32002 Backing Plate on the bottom aft hole for the AN3-15A Bolt.

STEP 11: DRILL REINFORCING STRAP
After checking the fit, drill two 3/16" holes in the P/N 32701 Reinforcing Strap for the AN3-15A Bolt.

STEP 12: DRILL SPACERS
Cut to fit and drill a 3/16" holes in each #34001 Spacer. Align the Reinforcing Strap and Spacers on the landing gear. (These will level out the gaps between the landing gear and Wheel Pant.) Drill through the Strap and Spacer into and through the speed fairing.

P/N 32701 Strap In Place



Final Installation

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Wheel Pant Installation
Fig. LG-F-1

