



1				2				3				4				5				6			
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.								
1	011-00978-00	Garmin Sub-Assy, GTP59	1	36	GB1-3910-00-60	Canopy Alignment Bushing	1	70	MS21044-N08	Nut Nyloc #8-32 UNF CPS	1												
2	05-01036	Quick disconnect, W/O shoutoff	1	37	GB1-5000-31-00	Baggage Compartment Door	1	71	MS21044-N3	Nut Nyloc #10-32 UNF CPS	2												
3	10-00496	Sirs Compass	1	38	GB1-5000-40-01	Hinge Arm, Baggage Door	2	72	MS21919-WDG7	Clamp, Cushion, 0.438" ID Alu	2												
4	11-02040	Servo Pushrod kit	1	39	GB1-5000-50-00	Baggage inspection panel	1	73	MS24665-151	Split Pin 1/16" x 0.5" Lg SS	6												
5	22080.0108	Spring Plunger 6.5mm stroke	2	40	GB1-5010-10-00	W/Assy, Baggage Door Lock	1	74	MS24693-S52	Screw, 8-32 UNC x 3/4", Csk Hd	6												
6	32MK28	Blind Rivet,0.387"L, 3/16"Dia	8	41	GB1-5010-21-01	Baggage Lock Lever	1	75	MS27039-1-24	Bolt, Pan Hd, #10-32UNF x 1.531	2												
7	452-201-011	CO GUARDIAN (13-06918)	1	42	GB1-5010-22-01	Baggage Lock Lever Bracket	1	76	MS35206-247	Pan Hd, #8-32UNC x 3/4"	4												
8	47043	PCV, 90° fitting	1	43	GB1-5210-10-02	Access Cover	2	77	MS35214-31	Screw Pan Hd #6-32UNCx1.0 Brass	4												
9	840_006_10	Hose, Behka-Lit OD 8mm, ID 6mm	1400mm	44	GB1-5211-00-00	Bonded Assy, Windshield	1	78	MS35338-44	Washer, Spring, 1/4" UNC/UNF CPS	2												
10	AN3-5A	Bolt AN3 x 21/32" Lg CPS	2	45	GB1-5220-10-00	Bonded Assy, Canopy	1	79	NAS1149C0332R	Washer Plain #10 x .032 Thk CRS	4												
11	AN310-4	Nut Castle 1/4-28 UNF CPS	2	46	GB1-5220-70-01	Canopy Lock clip	1	80	NAS1149C0332R	Washer Plain 1/2" x .032" Steel	4												
12	AN4-10	Bolt AN4 x 1 1/32" Lg CPS	2	47	GB1-5220-71-00	Assy, Rod, Canopy Lock	1	81	NAS1149G0332P	Washer Plain #10 x .032 THK CPS	4												
13	AN4-4A	Bolt AN4 x 17/32" Lg CPS	4	48	GB1-5220-73-73	Plate, Canopy Lock	2	82	NAS1149G0363P	Washer Plain #10 x .063 THK CPS	32												
14	AN525-832-R10	Screw Wshr Hd #8-32x5/8"	16	49	GB1-5220-73-00	W/Assy, Handle, Canopy Release	2	83	NAS1149G0432P	Washer Plain 1/4 ID x .032" CPS	2												
15	AN525-832-R12	Screw Wshr Hd #8-32 x 3/4"	3	50	GB1-5220-75-00	W/Assy Spindle, Canopy Lock Rear	1	84	NAS1149G0463P	Washer Plain 1/4 ID x .063" CPS	8												
16	AN525-832-R14	Screw Wshr Hd #10-32UNF x 7/8"	4	51	GB1-5220-77-61	Spindle, Canopy Lock, Front	1	85	NAS1352-08-12P	3/4", 8-32 socket head	1												
17	AN525-832-R9	Screw Wshr Hd #8-32 x 9/16"	40	52	GB1-5220-79-00	Assy, Canopy Hinge	2	86	PC535	Odyssey PC535 battery	1												
18	AVEOAIR0504464	AVEOAIR eyeball vent 05-04464	4	53	GB1-5220-90-00	Strap, Canopy	1	87	RN832130FLR	Ribbed Rivet Nut 8-32UNC	5												
19	CB6009_CR_08-1	Nutplate Two Lug Adhsive Bonded	2	54	GB1-5300-40-00	Front Seat	1	88	W31-X2M1G-5	Toggle Switch CB 5A	1												
20	CCR274CS-3-3	Rivet Blind 3/32in Dia Norm Hd	8	55	GB1-5300-41-00	Rear Seat	1	89	Wsh_M5x11_Ppr	10038970 Fiber wshr 11.2x4.7x1	11												
21	CG21-8x19-0	Carbon Fibre Composite Tube OD21.8 ID19	1	56	GB1-5700-01-00	Assy Sight Gauge	2																
22	DA320SAB	Foam rubber strip 40x3x10000	1.54m	57	GB1-5711-72-00	Cover, Inspection Hole, Wing, LH	2	OPTIONAL B.O.M. (LITHIUM ION BATTERY OPTION INCLUDED)?															
23	DP55 8 x 24	Dowel, ISO 2338A, dia 8, length 24	2	58	GB1-7130-20-00	Assy Belly Pan, Firewall	1	ITEM NO.	PART NUMBER	DESCRIPTION	QTY.												
24	GA35_WAAS_ant	Garmin(013-00235-00)Antenna	1	59	GB1-7710-10-00	Annunciator Lights Board	1	90	EST-900-TSO	EarthX EST-900-TSO Li-ion battery	1												
25	GB1-2400-03-00	Trim Panel Assembly	1	60	GB1-7710-00-01	Annunciator lights panel	1	91	GB1-2410-20-01	Li-ion Battery Clamp Top Plate	1												
26	GB1-2410-10-01	Battery Clamp Top Plate	1	61	GB1-0000-10-00	Assy Bolt, Main Spar	2	92	GB1-2410-20-02	Li-ion Battery Clamp Side Plate	2												
27	GB1-2410-10-02	Battery Clamp Side Plate	2	62	GB1-0000-20-00	Assy Bolt, Auxiliary Spar	2	93	5052-TO-0.25	5052-0 Alum Tube 1/4x0.035	1												
28	GB1-2500-10-00	Seatbelt, 6 point	1	63	GB1-0000-00-63	Tip, Hinge Pin	1	94	2GUF6	Brass T-fitting 1/4" OD	1												
29	GB1-2500-90-00	W/Assy Harness Attach Tube	4	64	GB1-ST0040	Engine Installation	1	95	5239K13	1/4" Battery Vent Tubing	1												
30	GB1-2500-92-01	Tube, Shoulder Harness Attachment	1	65	GDU 465	Garmin (010-01057-10) 10.6" screen	1	If included, then remove ITEM NO 26,27,&86															
31	GB1-2810-30-00	Acro Tank	1	66	MS16562-18	5/64"Ø, 3/4" long spilt pin.	1	<div>For each step listed below follow applicable procedures of SP-GB1-5100-00-01. Always refer to latest revision.</div> <table><tr><td>Serial Number (refer to work order)</td><td></td></tr><tr><td>Date of Manufacturing</td><td></td></tr></table>								Serial Number (refer to work order)		Date of Manufacturing					
Serial Number (refer to work order)																							
Date of Manufacturing																							
32	GB1-2810-40-00	Acro Tank Strap	2	67	MS20392-2C11	Pin, Clevis, 3/16" OD x 11/32"	2																
33	GB1-3211-60-00	Leg Fairing, L.H.	1	68	MS20392-2C21	Pin, Clevis, 3/16" OD x 21/32"	2																
34	GB1-3212-60-00	Leg Fairing, R.H.	1	69	MS21042-L06	Nut Kaynar 6-32 UNC	2																
35	GB1-3910-11-00	Head Rest Antenna Cover	1																				

A02	Spars bolts in BOM	BD			01 Nov 2018	EXCLUSIVE PROPERTY OF GAME COMPOSITES, LLC		SCALE VALID FOR MASTER DRAWING ONLY DO NOT SCALE DRAWING				
A02	Spars bolts in BOM	BD		HOA	15 Oct 2019	UNDER NO CIRCUMSTANCES MUST THE DESIGN OR ANY OTHER INFORMATION IN THIS DRAWING BE COPIED OR FURNISHED TO OTHERS WITHOUT AUTHORITY.		UNLESS OTHERWISE SPECIFIED: DRAWING STANDARD: ISO 128				
A05	Access covers for front wind screen added.	SL		HOA	09 Jan 2020							
A06	Editorial	SL	PS	HOA	10 Apr 2020	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS		<div>Game Composites, LLC 3201 SW I St, Bentonville, AR 72712 US</div> <div>E:psteinbach@gamecomposites.com</div>		TITLE:  Airframe Completion		
A07	Work instruction updates	NW	PS	CE	29 Oct 2020	MATERIAL						
A08	Redline corrections made, Assembly corrections.	PM	PS	CE	04 Jan 2021	WEIGHT						
A09	Added optional li-ion battery, Redline corrections	AN	PS	CE	07 Jul 2021	SURFACE FINISH AND TREATMENT						
A10	Redline revisions	DG	PS	CE	27 Aug 2021	TOLERANCES	LINEAR					
REVISION	COMMENT	DRAWN BY	CHECKED BY	RELEASED BY	RELEASE DATE	TOLERANCES	ANGULAR		Approved Design Data		SCALE:1:50 at sheet size 11"x17"	SHEET 1 OF 8

1

2

3

4

5

6

A

Terminals			
Part Number	Type	Size	Rated for Wire
52267-1	ring	M6	2 AWG
52044-4	ring	M8	2 AWG
35149	ring	#6	12-10 AWG
35108	ring	#8	12-10 AWG
35110	ring	1/4	12-10 AWG
35112	ring	3/8	12-10 AWG
32442	ring	#6	16-14 AWG
31902	ring	#8	16-14 AWG
31906	ring	1/4	16-14 AWG
31885	ring	#6	22-16 AWG
31890	ring	#8	22-16 AWG
36154	ring	#10	22-16 AWG
31894	ring	1/4	22-16 AWG
11-09313	ring	5/16	22-16 AWG
640903-1	Receptacle	6.35×0.81	22-18 AWG
140971-2	Blade	6.35×0.81	16-14 AWG
336-00021-00	Pin	22D	22-24 AWG
336-00022-02	Socket	20	20-22 AWG
336-00024-00	Pin	20	20-22 AWG
11-04447	Coax	-	RG400
11-01802	Coax	-	RG400
11-03992	Coax	-	RG58
66103-3	Pin	20	20-24 AWG
66105-3	Pin	20	20-24 AWG

B

C

D

Phraseology	
Abbreviation	Meaning
-	Not Applicable
A	Amps
ANT	Antenna
AWG	American Wire Gauge
B-	Negative Battery Terminal
B+	Battery Positive Terminal
BAT	Battery
Can Term Plug	Garmin Can Terminal Bus Plug
Chassis	Chassis Ground
CHT	Cylinder Head Temperature Sensor
CNTRL	Control
CO	Carbon Monoxide
Coax	Coaxial Cable
COM	Communications
EGT	Exhaust Gas Temperature Sensor
ELT	Emergency Location Transmitter
Eng Bolt	Engine Bolt
Field	Field Lug on Alternator
GND	Ground
GPS	Global Positioning System
LH	Left Hand
MAN	Manifold
MIC	Microphone
NC	No Connection
OAT	Outside Air Teperature Sensor
P	Part
P-Lead	Magneto Primary Lead
PWR	Power
PWR	Power
QTY	Quantity
REG	Regulator
RH	Right Hand
Shld	Shielded Wire
22 shld x2	2-Core, 22 gauge Shielded Wire
22 shld x3	3-Core, 22 gauge Shielded Wire
22 shld x4	4-Core, 22 gauge Shielded Wire
STR	Structural
SYS	System

Connectors				
Referenced As	Part Number	Description	P/N to plug	Backshell P/N
02R	02R-JWPF-VSLE-S	2 way JST, male	-	-
02T	02T-JWPF-VSLE-S	2 way JST, female	-	-
03R	03R-JWPF-VSLE-S	3 way JST, male	-	-
03T	03T-JWPF-VSLE-S	3 way JST, female	-	-
06R	06R-JWPF-VSLE-D	6 way JST, male	-	-
06T	06T-JWPF-VSLE-D	6 way JST, female	-	-
OCT	206061-1	Plug Panel Mnt, female	-	-
OCR	206060-1	Plug, male	-	-
OCTA	206429-1	Plug, Female	-	-
OCRA	206430-1	Plug Panel Mnt, male	-	-
P4602	P4602	Garmin Connector	MS24308/2-5 Z	011-01855-04
P111	P111	Garmin Connector	MS24308/2-1 Z	011-01855-00
P241	P241	Garmin Connector	MS24308/2-1 Z	011-01855-00
P251	P251	Garmin Connector	MS24308/2-1 Z	011-01855-00
P4502	P4502	Garmin Connector	MS24308/2-5 Z	011-01855-04
P252	P252	Garmin Connector	MS24308/2-2 Z	011-01855-01
P2001	P2001	Garmin Connector	M24308/4-13F	011-00950-02
P3251	P3251	Garmin Connector	330-00185-62	125-00084-00
P243	P243	Garmin Connector	MS24308/2-4 Z	011-01855-03
P242	P242	Garmin Connector	MS24308/4-3 Z	011-01855-02
P01	P01	CO Guardian Plug	20504-1	-
P02	P02	ELT Plug	-	-
P03	P03	ELT Remote Plug	-	-
P244	P244	Garmin Connector	MS24308/2-5 Z	011-01855-04
J Case	HLJC2002G	Fuse Holder	-	-
Note: All Garmin connector pin numbers labeled on the connector.				


A02	Spars bolts in BOM	BD			01 Nov 2018	EXCLUSIVE PROPERTY OF GAME COMPOSITES, LLC  UNDER NO CIRCUMSTANCES MUST THE DESIGN OR ANY OTHER INFORMATION IN THIS DRAWING BE COPIED OR FURNISHED TO OTHERS WITHOUT AUTHORITY.			SCALE VALID FOR MASTER DRAWING ONLY DO NOT SCALE DRAWING		
A02	Spars bolts in BOM	BD		HOA	15 Oct 2019				UNLESS OTHERWISE SPECIFIED: DRAWING STANDARD: ISO 128		
A05	Access covers for front wind screen added.	SL		HOA	09 Jan 2020						
A06	Editorial	SL	PS	HOA	10 Apr 2020	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			<b>Game Composites, LLC</b> <b>3201 SW I St,</b> <b>Bentonville, AR 72712</b> <b>US</b>  <b>E:psteinbach@gamecomposites.com</b>		
A07	Work instruction updates	NW	PS	CE	29 Oct 2020	MATERIAL				DWG NO.  <b>GB1-ST0050</b>	
A08	Redline corrections made, Assembly corrections.	PM	PS	CE	04 Jan 2021	WEIGHT					
A09	Added optional li-ion battery, Redline corrections	AN	PS	CE	07 Jul 2021	SURFACE FINISH AND TREATMENT					
A10	Redline revisions	DG	PS	CE	27 Aug 2021	TOLERANCES	LINEAR			<b>Approved Design Data</b>	SCALE:1:50 at sheet size 11"x17"
REVISION	COMMENT	DRAWN BY	CHECKED BY	RELEASED BY	RELEASE DATE	TOLERANCES	ANGULAR				

	1		2	
	Devices			
A	Device	Part Number	Location	
	10 Amp Circuit Breaker	W23X1A1G10	01.1	
	10A Fuse			
	2 Amp Circuit Breaker	W23X1A1G2	01.1	
	3 Amp Circuit Breaker	W23X1A1G3	01.1	
	35 Amp Toggle Switch	W31X2M1G35	01.3	
	4 Way Switch	ROS-4	03.1	
	40A Fuse	895040		
	5 Amp Circuit Breaker	W23X1A1G5	01.1	
	5 Amp Toggle Switch	W31X2M1G5	01.3	
B	7.5 Amp Toggle Switch	W31X2M1G7.5	01.3	
	Aileron Servo	T2-10A	-	
	Alternator	SD-20	14.5	
	Ammeter Shunt	909-D0000-00	14.4	
	Battery	Oddesdy Extreme 535	12.6, 12.7	
	CHT Sensor	86253	-	
	CO Guardian	CO_Guardian	4.4	
	Communications Antenna	013-00235-00	-	
	EGT Sensor	86255	-	
	Elevator Servo	T2-10A	-	
C	ELT	ELT_1000	07.7	
	ELT Antenna	110-324	-	
	ELT Switch	RC200	04.6	
	Fuel Flow Transducer	FT-60	13.4	
	Fuel Pump	PX375-TC	10.1	
	Garmin AirData Indication System	GSU25	09.4	
	Garmin Configuration Module	012-00605-20	-	
	Garmin Engine Monitor	GEA24	09.1	
	Garmin Magnetometer	GMU11	02.3	
	Garmin Outside Air Temperature Sensor	GTP 59	13.5	
D	Garmin Personal Flight Display 1	GDU 465	04.2	
	Garmin Personal Flight Display 2	GDU 450	09.2	
	Garmin Transponder	GTX345	04.1	
	Garmin VHF COM Radio	GTR225A	04.5	
	Headphone Jack	JJ-033	02.2, 08.1	
	Ignition Switch	A-510-2 FAA-PMA	01.2	
	Landing Light	01-0771685-01	-	
	LED Position Indicator	RP4	03.1	
	Master Relay	70 111226 5B1	12.1	
	Magneto	6393 Rev E	14.1, 14.6	
		Microphone Jack	SWC-12B	02.2, 08.1
		Oil Pressure Sensor	PT-100GA	14.7
		Oil Temperature Sensor	555-41362	13.2, 14.3
		RPM Sensor	T1A9-X	14.2
		Servo Relay	REL-2	-

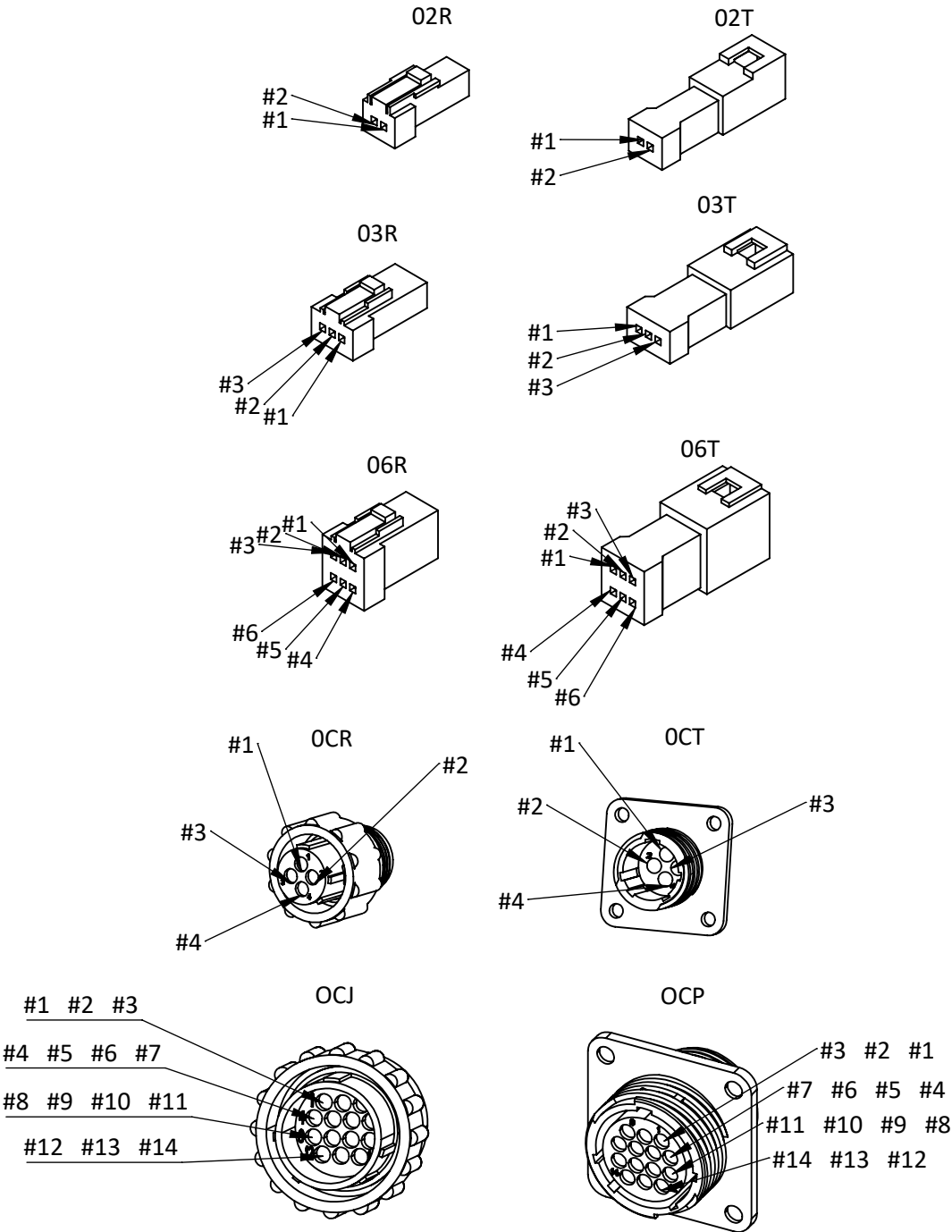
Devices Cont.		
Device	Part Number	Location
Slick Start	SS1001	13.1
Smoke Pump	UP2-16420212	10.2
Smoke Relay	RM805012	10.3
Split Red Switch	S-1994-1-1	01.3
Starter	149-12LS	11.1
Starter Relay	22735	12.3
Structural Temperature Sensor	PT1000	07.5, 07.6
Terminal Block	SPTGB6	BUS (Essential), Avionic Bus (Non-Essential), GND
Smoke Throttle Switch	SRB22A2FBBNN	03.2
Transponder Antenna	AV74-1	-
USB	Blue_Sea_1016	04.3, 08.2
Voltage Regulator	07-06742	12.2
Wing Fuel Float Sensors	GB1-2852-70-92	10.4, 12.8
Wing Tip Light	Andromeda DayLite	07.1, 07.2

Tools	
Device	Referenced As
Astro Crimp Tool p/n 615715	CT1
TE 59824-1 TETRA-CRIMP TOOL	CT2
JST WC-JWPF CRIMPING PLIERS	CT3
RS 683-1627 COAX CRIMP TOOL	CT4
DMC GMT232 CRIMP TOOL	CT5
TE CRIMP TOOL 91505-1	CT6

BUTT SPLICES		
Part Number	AWG	Color
11-04425	26-20	red
11-04427	20-16	blue
11-04429	16-12	yellow

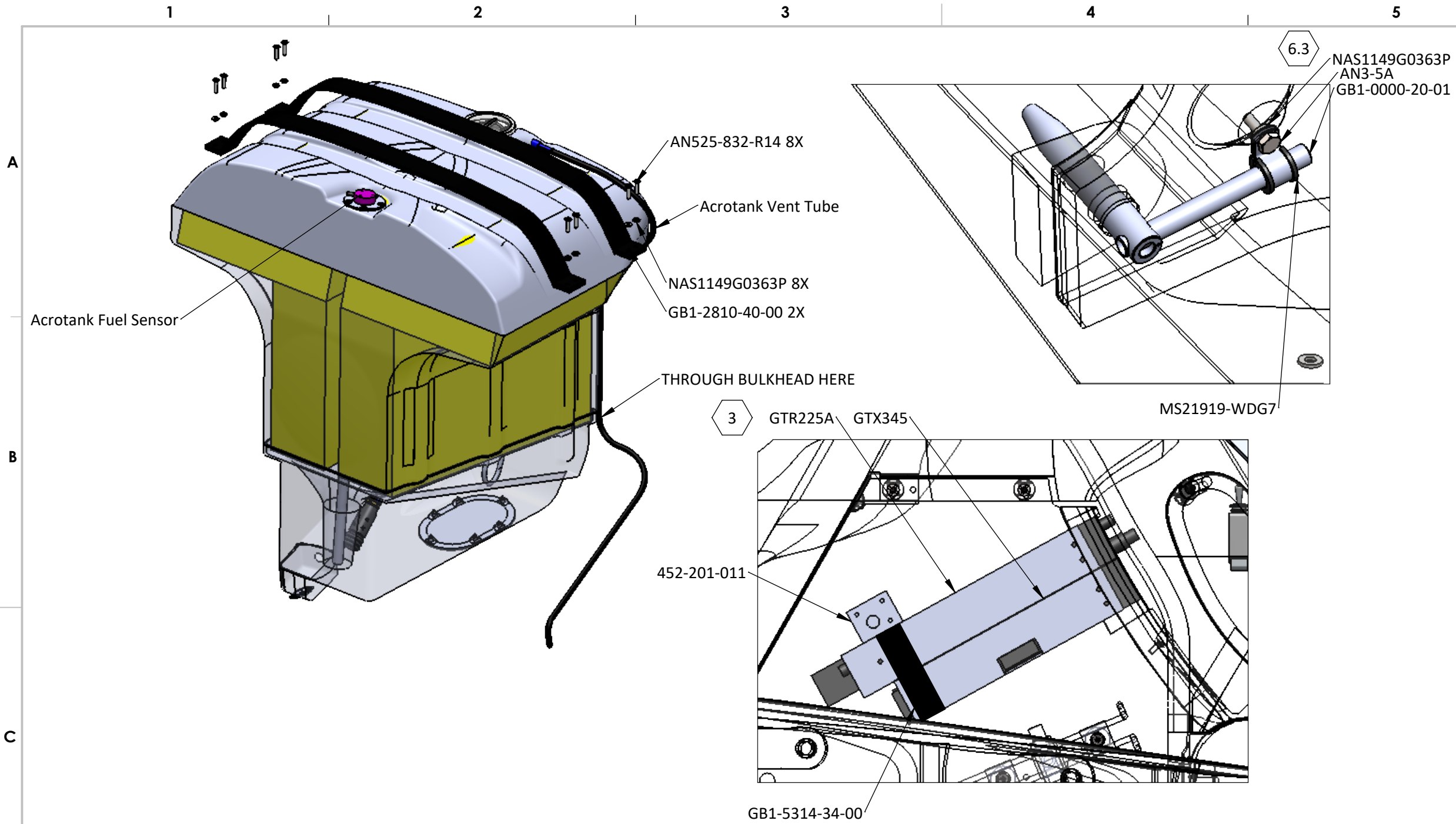
A02	Spars bolts in BOM	BD			01 Nov 2018	EXCLUSIVE PROPERTY OF GAME COMPOSITES, LLC			SCALE VALID FOR MASTER DRAWING ONLY DO NOT SCALE DRAWING		
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A05	Access covers for front wind screen added.	SL		HOA	09 Jan 2020						
A06	Editorial	SL	PS	HOA	10 Apr 2020	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			<b>Game Composites, LLC</b> <b>3201 SW I St,</b> <b>Bentonville, AR 72712</b> <b>US</b>  <b>E:psteinbach@gamecomposites.com</b>	TITLE:  <b>Airframe Completion Glossary</b>	
A07	Work instruction updates	NW	PS	CE	29 Oct 2020	MATERIAL					
A08	Redline corrections made, Assembly corrections.	PM	PS	CE	04 Jan 2021	WEIGHT					
A09	Added optional li-ion battery, Redline corrections	AN	PS	CE	07 Jul 2021	SURFACE FINISH AND TREATMENT					
A10	Redline revisions	DG	PS	CE	27 Aug 2021	TOLERANCES	LINEAR			DWG NO.	<b>GB1-ST0050</b>
REVISION	COMMENT	DRAWN BY	CHECKED BY	RELEASED BY	RELEASE DATE	TOLERANCES	ANGULAR		<b>Approved Design Data</b>	SCALE:5:1 at sheet size 11"x17"	SHEET 3 OF 8

02R:1 Represents Connector 02R, No. 1 in the document. Pin numbers are defined as below.



Note: Garmin Connector Pin Numbers are Scribed on Each Connector.



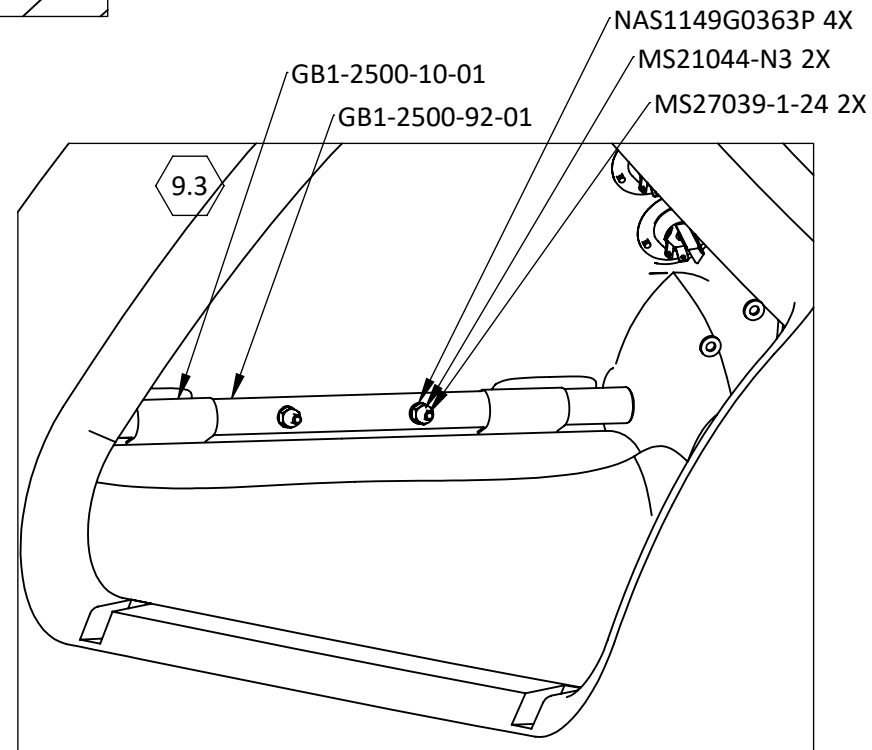
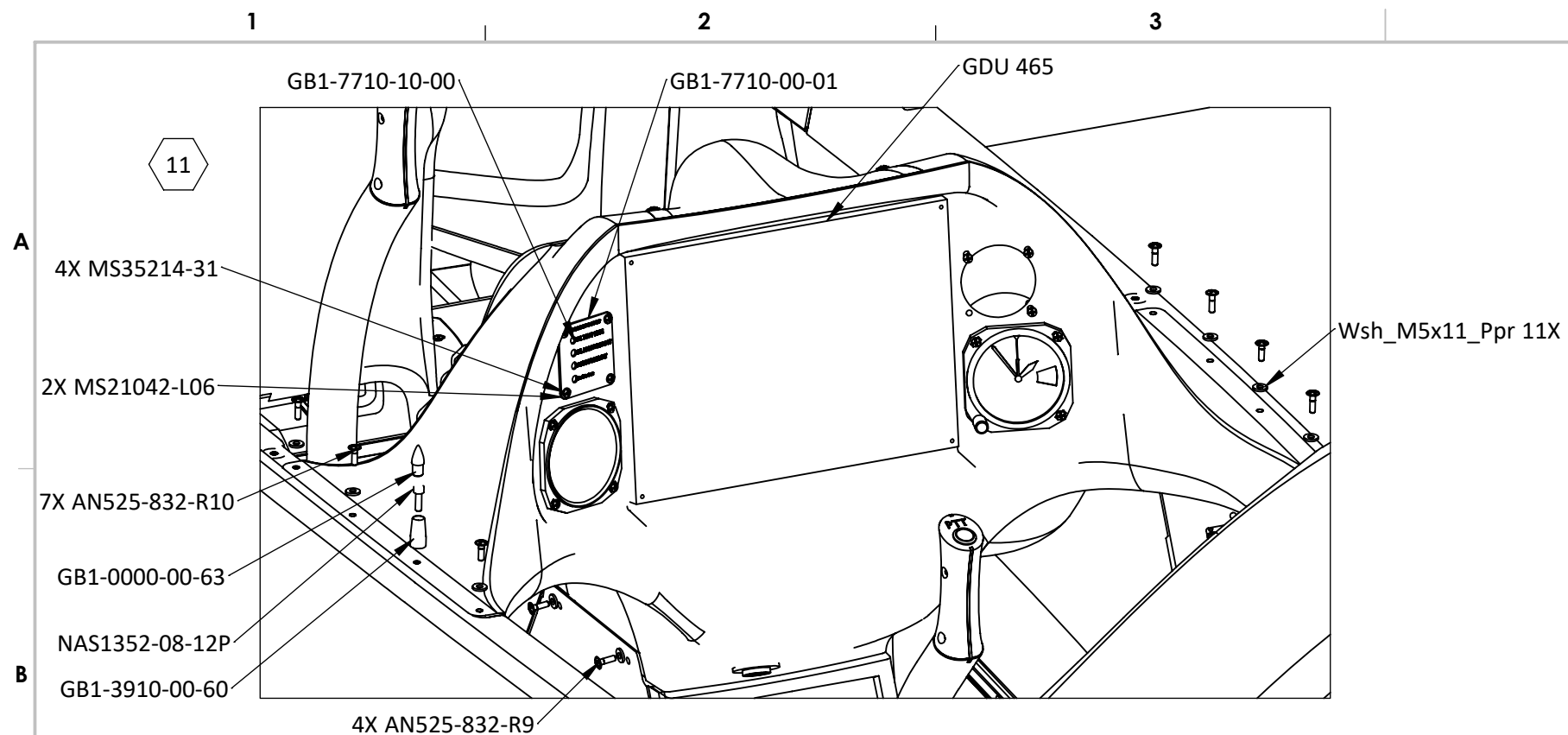


Step	Part	Label Wire	Color	Terminate with Terminal P/N	Connector	Connector Pin
1.2.1	Acro Tank Sensor	W812	Red	384-9790	03R:3	1
1.2.2	Acro Tank Sensor	W813	Orange	384-9790	03R:3	3
1.2.3	Acro Tank Sensor	W814	Black	384-9790	03R:3	2

7	Place windshield on piano hinge and insert piano hinge rods. Secure by lock wiring in place through a firewall rivet either side as shown. Trim Windshield as needed for proper fitment and packaging of other parts.		
8	Inspection		

D	A02	Spars bolts in BOM	BD			01 Nov 2018	EXCLUSIVE PROPERTY OF GAME COMPOSITES, LLC  UNDER NO CIRCUMSTANCES MUST THE DESIGN OR ANY OTHER INFORMATION IN THIS DRAWING BE COPIED OR FURNISHED TO OTHERS WITHOUT AUTHORITY.	SCALE VALID FOR MASTER DRAWING ONLY DO NOT SCALE DRAWING  UNLESS OTHERWISE SPECIFIED: DRAWING STANDARD: ISO 128	
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	A05	Access covers for front wind screen added.	SL		HOA	09 Jan 2020			
	A06	Editorial	SL	PS	HOA	10 Apr 2020			
	A07	Work instruction updates	NW	PS	CE	29 Oct 2020	MATERIAL	Game Composites, LLC 3201 SW I St, Bentonville, AR 72712 US  E:psteinbach@gamecomposites.com	TITLE:  Airframe Completion
	A08	Redline corrections made, Assembly corrections.	PM	PS	CE	04 Jan 2021	WEIGHT		
	A09	Added optional li-ion battery, Redline corrections	AN	PS	CE	07 Jul 2021	SURFACE FINISH AND TREATMENT		
	A10	Redline revisions	DG	PS	CE	27 Aug 2021	TOLERANCES		
	REVISION	COMMENT	DRAWN BY	CHECKED BY	RELEASED BY	RELEASE DATE	TOLERANCES	Approved Design Data	DWG NO.  GB1-ST0050
							ANGULAR		
								SCALE:1:1 at sheet size 11"x17"	SHEET 4 OF 8

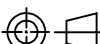

For each step listed below follow applicable procedures of SP-GB1-5100-00-01. Always refer to latest revision.				Worker Initials	Insp. Initials
Work Steps					
1.1	Cut acrotank vent tube out of 840_006_10 as necessary and route to the forward 6AFH3 fitting on the acrotank drain as shown. Seal with Sikaflex				
1.2	Lower acrotank into fuselage. Cut and connect the Fuel Sensor using steps 1.2.1-1.2.3 leaving 3" diameter service loop.				
1.3	Attach hose GB1-2830-04-00 to forward facing AN fitting on acro tank. And GB1-2830-25-00 to the aft AN fitting.				
1.4	Install both GB1-2810-40-00 straps with 750mm of foam rubber strip DA320SAB installed on underside of each of the straps. Secure with 8x AN525-832-R14 screws and 8x NAS1149G0363P washers.				
Brake Bleeding, Both Sides.					
2.1	Unscrew top reservoir cover and remove membrane.				
2.2	Connect hose from brake fluid source to bleeder valve.				
2.3	Open bleeder valve a 1/2 turn.				
2.4	Pump fluid until reservoir is filled app 3mm / 1/16" below upper rim. Close bleeder valve				
2.5	Check brake pedal for 'hard feel' when operated. If 'hard feel' is not felt bleed air out of system untill a 'hard feel' is felt.				
2.6	Remove the hose, install membrane, and close reservoir.				
3.1	Postion shop tool to match drill holes for the GTR and GTX then install the racks using 8x 32MK28 rivets. Install 2x GB1-5314-34-00 brackets using sikaflex as shown.				
3.2	Install GTR225A and the GTX345 in their respective racks, secure using Allen Key.				
4.1	Use mounting bracket that comes with the CO_Guardian kit to mark and drill holes.				
4.2	Mount CO_Guardian using hardware suplied in CO_guardian kit.				
5.1	Drill 5/8" hole in fuselage in line with trim tab harness tube.				
6.1	Slide left wing into place, leave app. 4 inch gap. Connect all smoke, fuel, pitot, tip lights, landing lights and fuel sensor lines. Close the gap, start GB1-0000-20-00 aft LH spar pin.				
6.2	Slide right wing into place, leave app. 4 inch gap. Connect all smoke, fuel, tiplight and fuel sensor lines, aileron trim connector, and GMU11. Close the gap, start GB1-0000-20-00 aft RH spar pin.				
6.3	Secure wings by inserting the GB1-0000-10-00 pin into the main spars, and GB1-0000-20-00 seat the auxiliary spars pins, securing auxiliary spar pins as shown.				
6.4	Connect aileron control rods to torque tube using two AN4-10 bolts, NAS1149G0432P washers, AN310-4 nuts, and MS24665-151 cotter pins.				
6.5	Adjust rod length to ensure deflection of $\pm 22.5^{\circ} \pm 2^{\circ}$ for both alierons.				
6.6	Install GB1-5711-72-00 wing access covers using 3x AN525-832-R9 screws.				

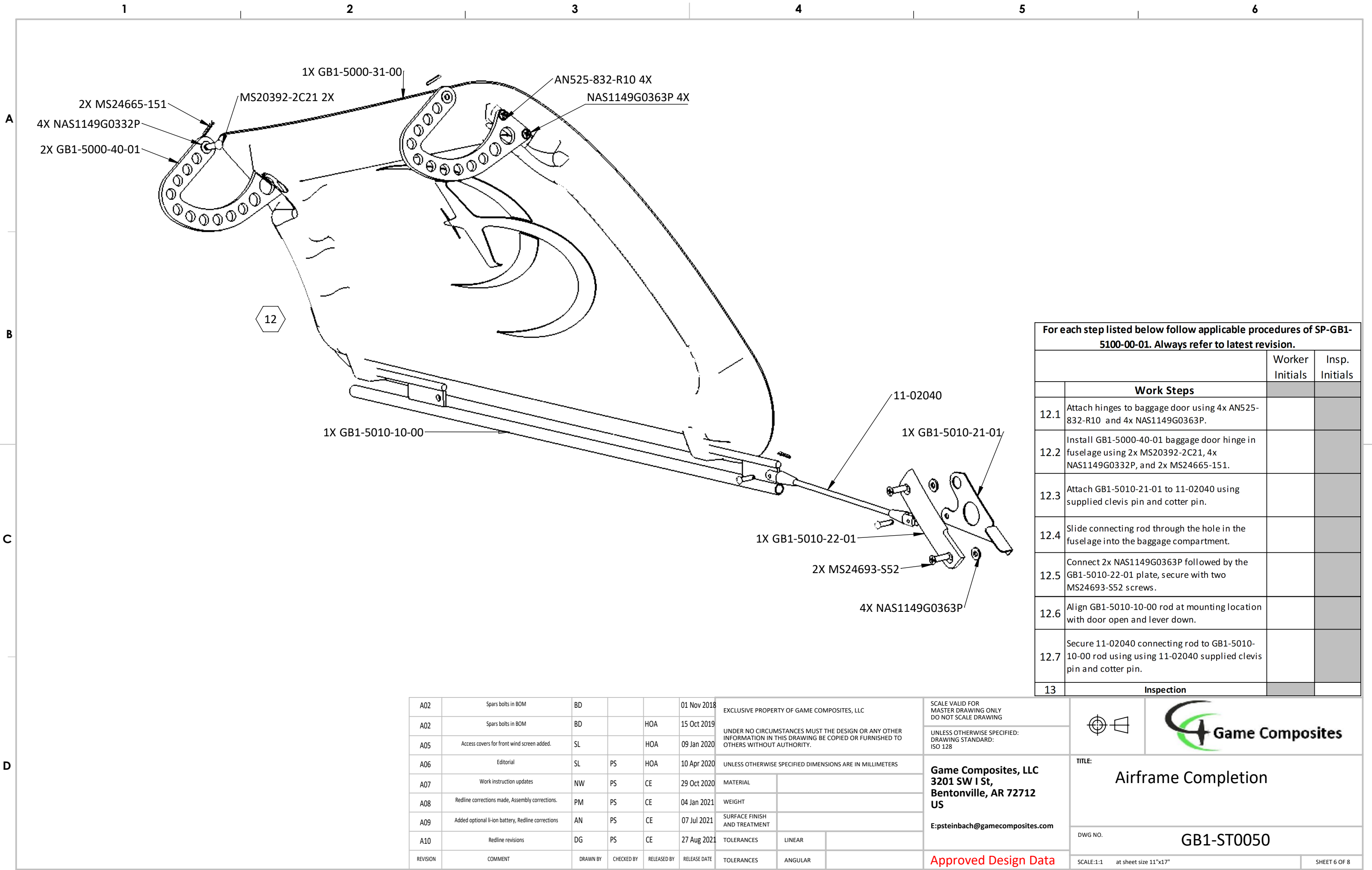


Step	Part	Label Wire	Terminate with Terminal	Connector	Connector Pin Number	Worker Initials
10.1.1	Annunciator Panel	W874	384-9790	06T	1	
10.1.2	Annunciator Panel	W875	384-9790	06T	2	
10.1.3	Annunciator Panel	W876	384-9790	06T	3	
10.1.4	Annunciator Panel	W877	384-9790	06T	4	
10.1.5	Annunciator Panel	W879	384-9790	06T	5	
10.1.6	G Meter	Wire pin 7 splice to W879 with 1A fuse holder.				
10.1.7	G Meter	Wire pin 8 splice to W874.				

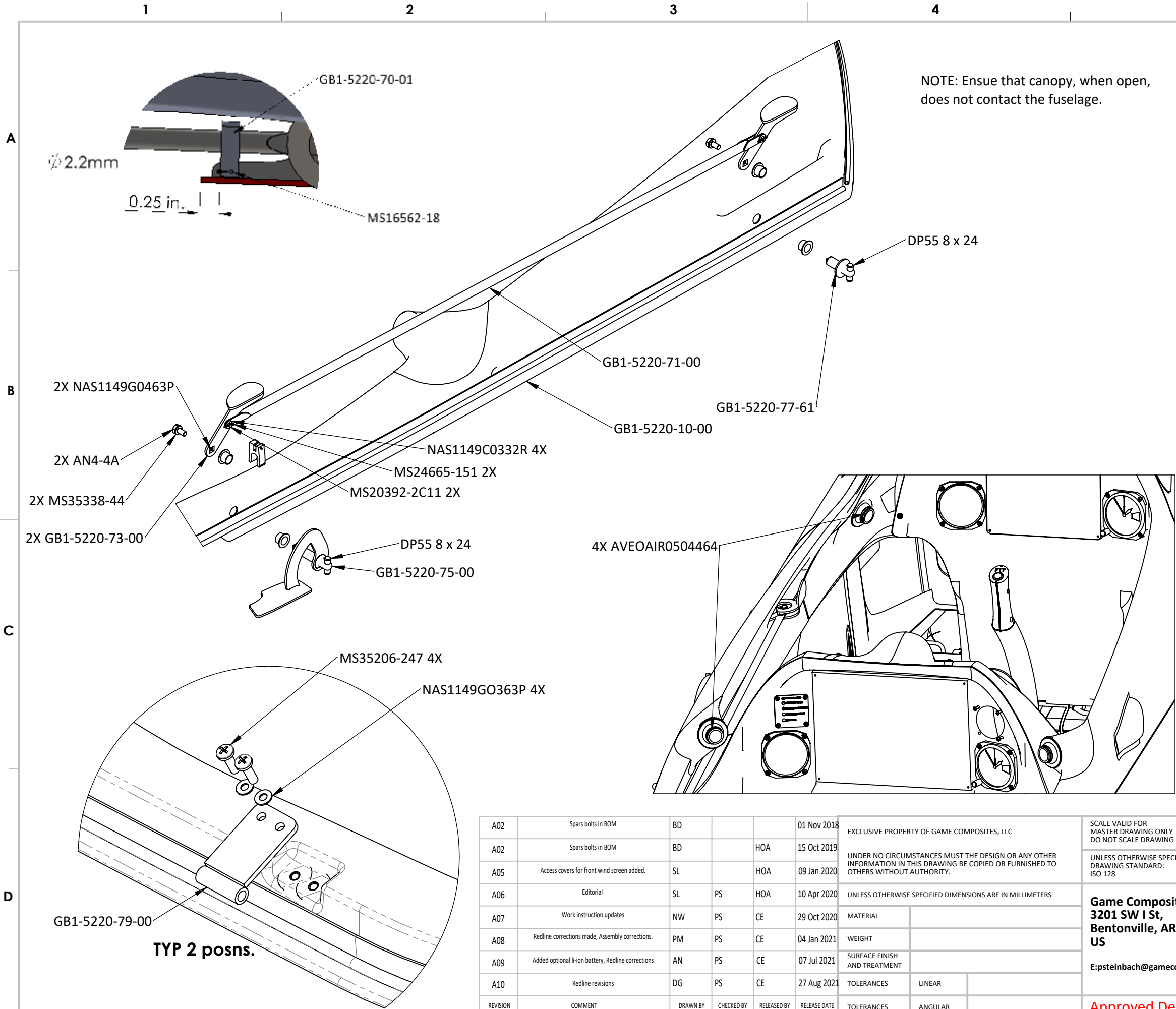
For each step listed below follow applicable procedures of SP-GB1-5100-00-01. Always refer to latest revision.			
		Worker Initials	Insp. Initials
	Work Steps		
9.1	Hold loops of the lap belts into each of the recesses and push 4x GB1-2500-90-00 harness tubes in place. NOTE: Ratchet on RH side, upper if double ratchet.		
9.2	Secure lap harness tubes with 4x AN525-832-R10 bolts and and 4x NAS1149G0363P washers.		
9.3	Secure aft shoulder harness using GB1-2500-92-01, 2x MS27039-1-24 bolts, 2x MS21044-N3 nuts, and 4x NAS1149G0363P washers.		
10.1	Install eyeball vents, AVEOAIR504464, into the canopy and windshield securing with Sikaflex.		
10.2	Install 2x GB1-5210-10-02 covers using 8x CCR274CS-3-3 rivets, Use covers as guide to through drill mounting holes.		
10.3*	Install the front panel using 8x AN525-832-R9 screws, install electrical connector, push in quick disconnects.		
11.1	Install annunciator lights panel and annunciator lights board, connecting the lights board to the wiring loom.		
11.2	Install the rear panel using 7x AN525-832-R10 screws, 4x AN525-832-R9 screws, 11x Wsh_M5x11_Ppr, 1x GB1-3910-00-60 with 1x NAS1352-08-12P, and 1x GB1-0000-00-63.		
11.3	Install GDU 465 using mounting plate and hardware provided with install kit. Connect wires		
11.4	Trim instrument panel as needed and Install GA35_WAAS_ant antenna into the GB1-3910-11-00 antenna cover using Sikaflex, Trim the rear instrument panel as needed for proper fitment.		
11.5	Connect GPS antenna coax to transponder.		

**\*NOTE:** If GB1-3920-12-00 front instrument panel option is selected, there will be no quick disconnects in step 10.3.

A02	Spars bolts in BOM	BD			01 Nov 2018	EXCLUSIVE PROPERTY OF GAME COMPOSITES, LLC		SCALE VALID FOR MASTER DRAWING ONLY DO NOT SCALE DRAWING			
A02	Spars bolts in BOM	BD		HOA	15 Oct 2019	UNDER NO CIRCUMSTANCES MUST THE DESIGN OR ANY OTHER INFORMATION IN THIS DRAWING BE COPIED OR FURNISHED TO OTHERS WITHOUT AUTHORITY.		UNLESS OTHERWISE SPECIFIED: DRAWING STANDARD: ISO 128			
A05	Access covers for front wind screen added.	SL		HOA	09 Jan 2020						
A06	Editorial	SL	PS	HOA	10 Apr 2020	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS		<b>Game Composites, LLC</b> <b>3201 SW I St,</b> <b>Bentonville, AR 72712</b> <b>US</b>  <b>E:psteinbach@gamecomposites.com</b>		<b>TITLE:</b>  <b>Airframe Completion</b>	
A07	Work instruction updates	NW	PS	CE	29 Oct 2020	MATERIAL					
A08	Redline corrections made, Assembly corrections.	PM	PS	CE	04 Jan 2021	WEIGHT					
A09	Added optional li-ion battery, Redline corrections	AN	PS	CE	07 Jul 2021	SURFACE FINISH AND TREATMENT					
A10	Redline revisions	DG	PS	CE	27 Aug 2021	TOLERANCES	LINEAR			DWG NO.	<b>GB1-ST0050</b>
REVISION	COMMENT	DRAWN BY	CHECKED BY	RELEASED BY	RELEASE DATE	TOLERANCES	ANGULAR		<b>Approved Design Data</b>	SCALE:1:1 at sheet size 11"x17"	SHEET 5 OF 8







For each step listed below follow applicable procedures of SP-GB1-5100-00-01. Always refer to latest revision.

		Worker Initials	Insp. Initials
	Work Steps		
14.1	Using 80 grit sandpaper, clean/roughen bonding areas of GB15220-77-61, GB1-5220-75-00 and 2X DP55 8 x 24. Clean with acetone.		
14.2	Apply a thin film of Loctite 660 glue to inside of each spindle, slide pins in place and remove excessive Loctite 660.		
14.3	Let cure for 30 mins.		
14.4	Position the fwd face of part GB1-5220-70-01 .25in from the front face of the rear handle and ensure the inboard face is flush and seated against the red part of the handle as shown then use GB1-5220-70-01 as a guide to drill a 1.95mm hole in the rear handle.		
14.5	Remove the Clip and drill a 2.2mm hole through the handle.		
14.6	Insert an MS16562-18 roll pin through the handle and handle clip to secure the clip in place.		
14.7	Install canopy latch components as shown.		
14.8	Install canopy hinges and fasten as shown.		
14.9	Install 2x canopy lock plates (GB1-5220-73-73) with 4x MS24693-S52 screws.		
14.10	Install the canopy by placing hinges in the recesses and sliding the canopy back on the pre-installed hinge pin, attach the canopy strap with 1x AN525-832-R9 screw, vulcan fibre washer, and MS21044-N08 nut in the fuselage and 1x AN525-832-R9 in the canopy itself into the pre-installed click-bond. Install GB1-5220-90-00 Canopy strap using an AN525-832-R12 and MS21044-N08 nut to the fuselage, and use an AN525-832-R9 to attach the strap to the canopy.		
14.11	Install compass, 10-00496, at the apex of the canopy.		
14.12	Inspection		

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A02	Spars bolts in BOM	BD		HOA	15 Oct 2019			
A05	Access covers for front wind screen added.	SL		HOA	09 Jan 2020			
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REVISION	COMMENT	DRAWN BY	CHECKED BY	RELEASED BY	RELEASE DATE	TOLERANCES	ANGULAR	

TITLE:  
**Airframe Completion**

DWG NO. GB1-ST0050

SCALE:1:1 at sheet size 11"x17"

SHEET 7 OF 8

