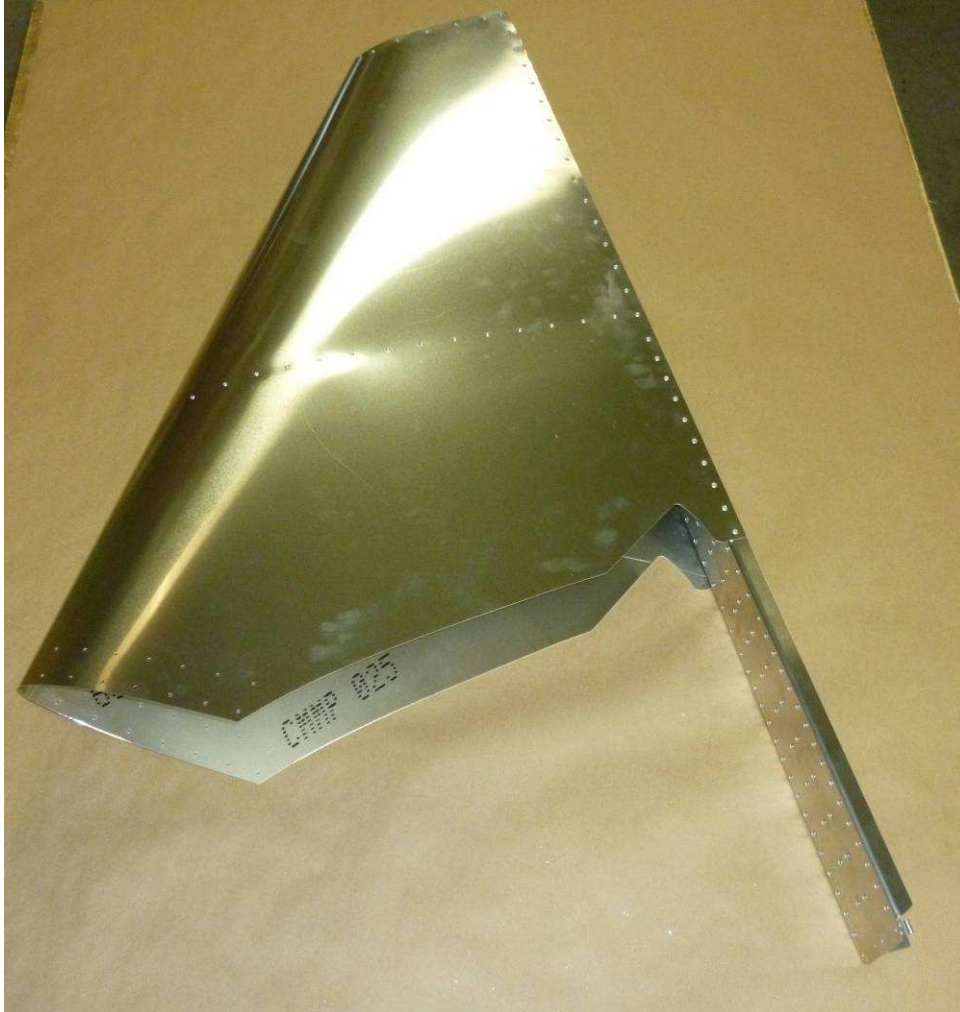
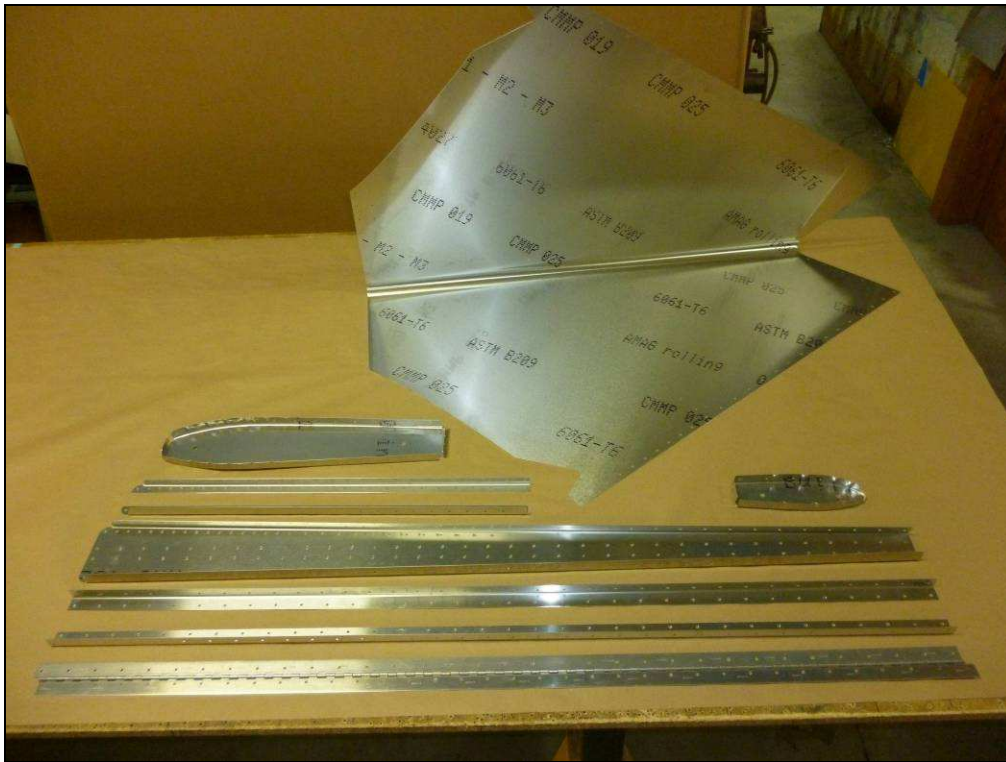


C75-RA-2 Fin



This manual has been prepared for assembly of the vertical fin supplied with finished hole size, 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.



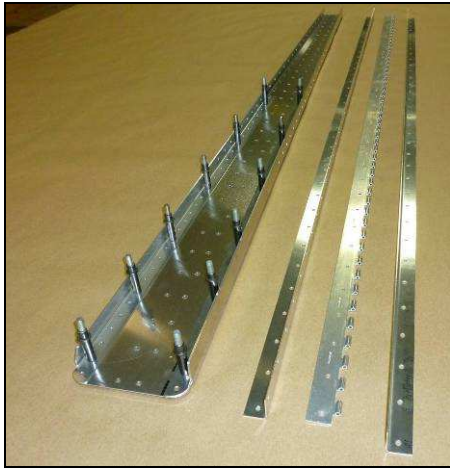
Vertical Fin Parts



P/N: C75R2-5
Fin Spar Doubler

P/N: C75R2-4
Fin Spar

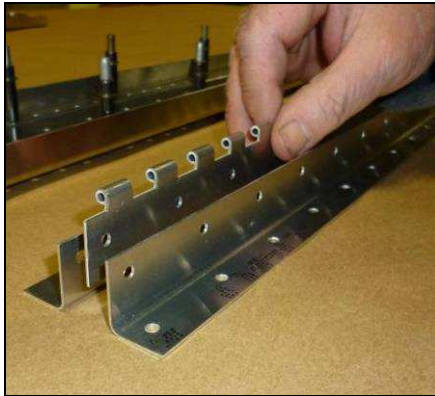
Cleco the doublers inside the spar, using 5/32 Clecos or the black Clecos.



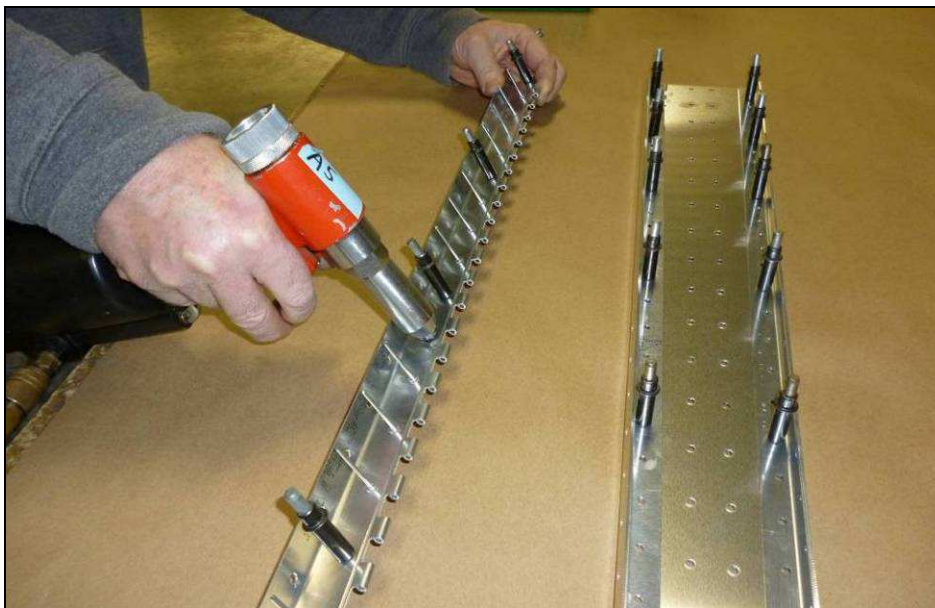
P/N: C75R3-4
Hinge angle

P/N: C75R2-3
Piano hinge

Remove half of the hinge from the rudder and identify the top of the hinge and angles.



Cleco the hinge in between the angles, and double check that the hinge matches the rudder hinge.



A5 rivets

Rivet the angles to the hinge using A5 rivets. Check to make sure you are using the correct rivet head for the A5.



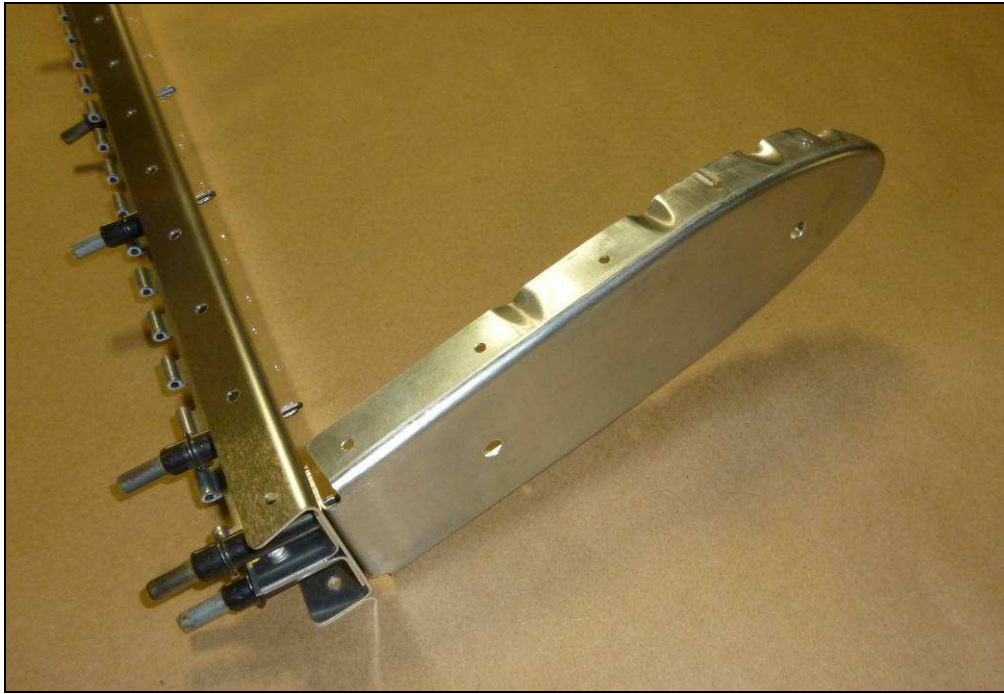
Cleco the hinge angle to the spar.



P/N: C75R2-7
Fin Nose Rib

P/N: C75R2-6
Fin Tip Rib

Open the pilot holes in the flange with #30 drill bit (both sides).



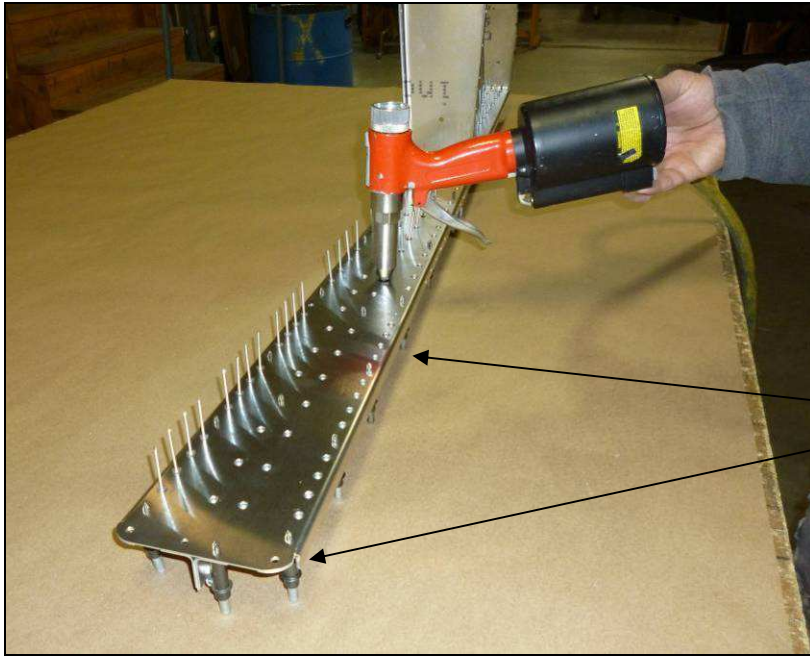
P/N: C75R2-6
Fin Tip Rib

Cleco the tip rib to the spar.



P/N: C75R2-7
Fin Nose Rib

Cleco the nose rib to the spar.

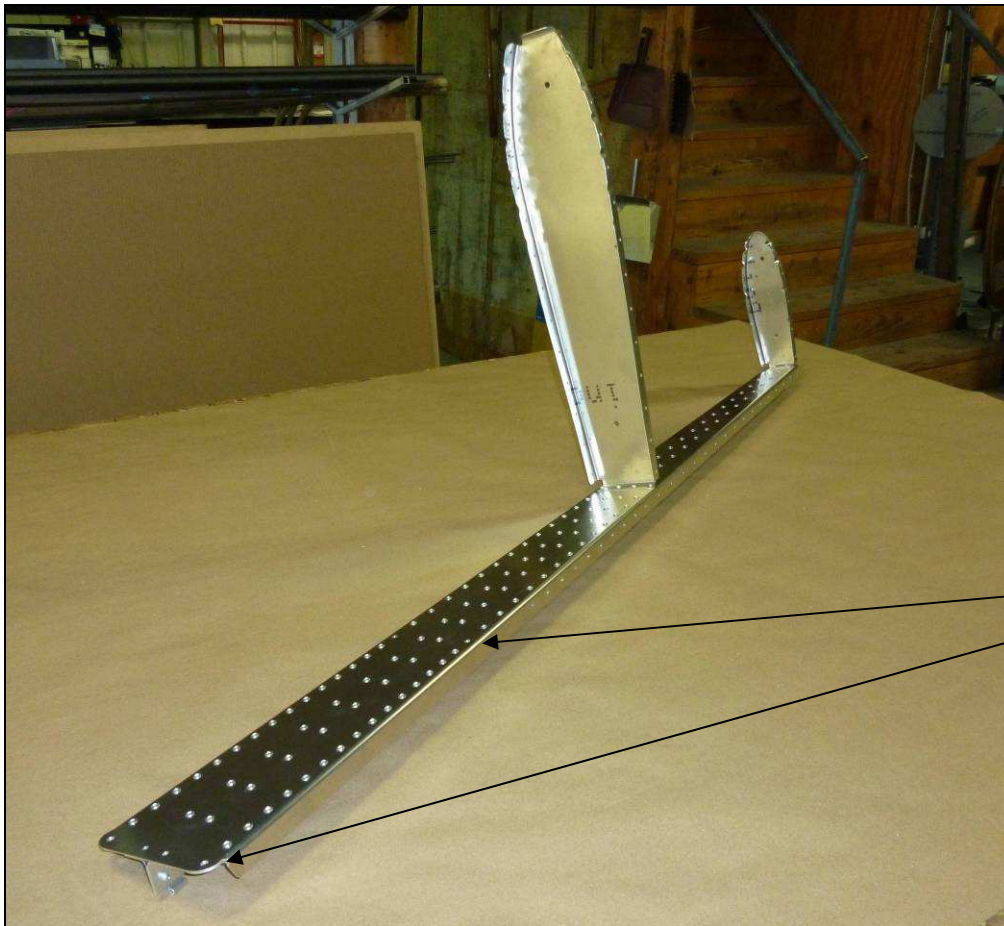


A5 rivets

Do not rivet the 4 holes for the :

- Upper attachment (323mm from bottom)
- Lower attachment (first line of holes up from the bottom)

Let the spar sit on top of the Clecos and rivet the spar to the doublers and hinge angles.



Riveted Fin Skeleton

Holes for the:

- Upper attachment C75R3-5
- Lower attachment C75R3-6

Ref attachment of the fin to the fuselage.

Also rivet the ribs (pull the rivet from the back side of the spar).



P/N: C75R3-7
Fin Upper Skin

Lay the skeleton on top of the skin.



Pull the assembly over the edge of the workbench and cleo the skin to the spar using 5/32 Clecoes (black).



Start in the middle.



Cleco every other hole.



Start at the spar.



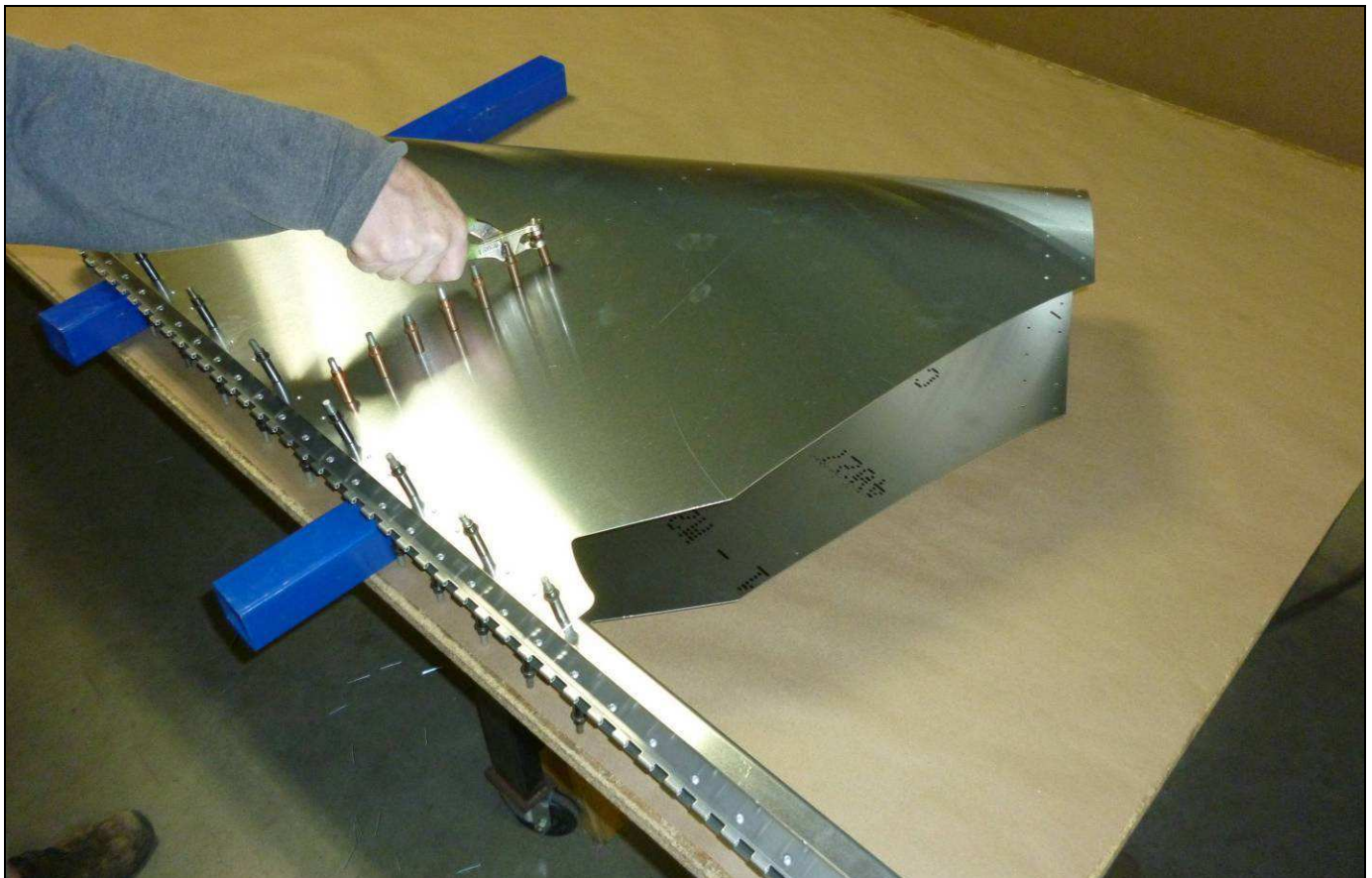
Push down on the skin
and cleco the nose rib.

(Copper Clecos #30 in every hole)



Turn the assembly over – and let it rest on 2 beams.

Do not let the assembly rest on the Clecos – it could damage the skin.



Start at the spar and cleco towards the leading edge.



Copper Clecoes #30

Cleco both ribs.



Remove the in between clecos and rivet with A4 (tip rib).



Rivet in between the clecos (tip nose rib) with A4.



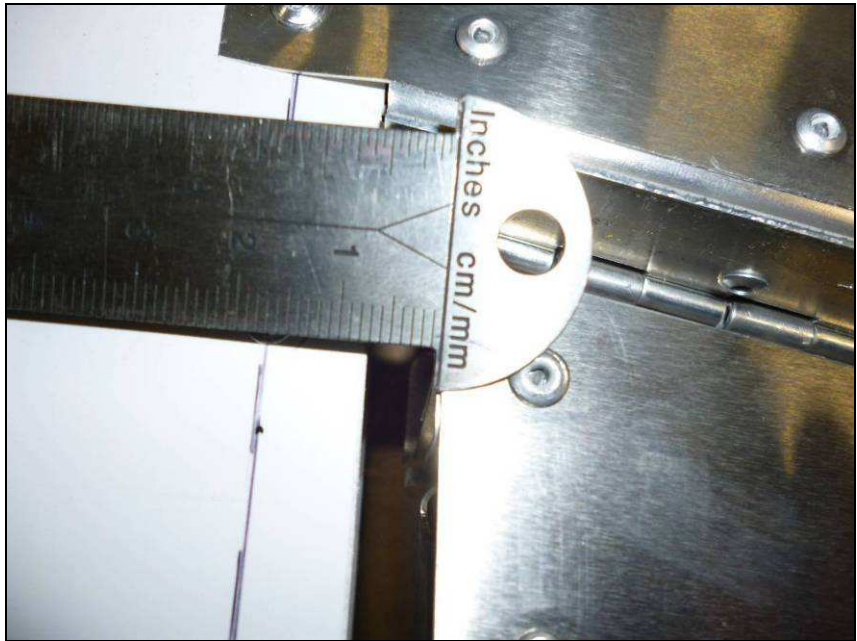
Finish the nose ribs with A4.



Rivet the spar with A5.



Install the piano hinge pin.



5 to 8mm gap between the top of the fin and underside of the rudder tip rib. Ref DWG C75-ZA-2