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DWG NO. CC2840330015 SH 1 REV. B

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REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
-	INITIAL RELEASE	-	SEE BELOW
A	ALL SHTS: UPDATED NOTES AND PROCEDURES.	1/2/2020	DRAWN: A FACKRELL CHECKED: S PHILIBEN APPROVED: S PHILIBEN
B	ALL SHTS: UPDATED BOM TO CURRENT HARDWARE.	1/20/2021	S PHILIBEN A FACKRELL CHECKED: <i>R Crogan</i> APPROVED: <i>S Philiben</i>

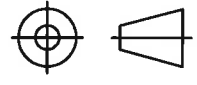
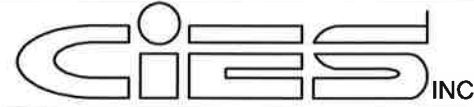
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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE: DECIMALS ANGLES .X±.10 ±.5' .XX±.03 .XXX±.010 DO NOT SCALE DRAWING THIRD ANGLE PROJECTION 	CONTRACT NO.		 1375 SE WILSON AVE. SUITE 150 BEND, OR 97702		
	APPROVALS	DATE			
	DRAWN A FACKRELL	8/28/2019	TITLE INSTALLATION ASSEMBLY - CIRRUS SR22 G1/G2		
	CHECKED R CROGAN	12/5/2019			
ENGINEER S PHILIBEN	12/5/2019				
APPROVED S PHILIBEN	12/5/2019	SIZE B	CAGE CODE 66YY1	DWG NO. CC2840330015	REV. B
		SCALE NONE	APPROVED JAN 20 2021		SHEET 1 OF 8

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NOTES: REFER TO CIRRUS AIRPLANE MAINTENANCE MANUAL, CHAPTER 51-20 FOR SPECIFICATION ON SURFACE PREPARATION AND BONDING PROCESS. INSTRUCTIONS HERE ARE SUPPLEMENTAL.

- 1) DRAIN FUEL FROM THE TANK(S).
- 2) REMOVE THE MOST INBD AND THE OUTBD FUEL TANK ACCESS PANELS.
- 3) LOCATE SENDER HOLE AND NUTRING FASTENER HOLES FOR THE INBD FUEL SENDER.
- 4) COVER THE INSIDE OF THE FUEL TANK WITH PROTECTIVE PANELS OR CARDBOARD. (SEE SH. 8 IMAGE 1&2).
- 5) REMOVE SEALANT FROM THE WING RIB ON THE TANK SIDE AROUND THE NUTRING LOCATION.
- 6) ABRABE RIB SURFACE WITH 80 TO 120 GRIT SANDPAPER TO REMOVE THE SURFACE SHEEN AND EVEN THE SURFACE.
NOTE: DO NOT CUT THROUGH REINFORCEMENT FIBERS, ONLY THE SURFACE RESIN.
- 7) ABRABE SURFACE OF NUTRING WITH 80 TO 120 GRIT SANDPAPER TO REMOVE THE SURFACE SHEEN.
- 8) DRILL ADAPTER PLATE HOLES PER THE TEMPLATE AND CLEAN HOLE EDGES. MOUNT THE ADAPTER PLATE. (SEE SH 8 IMAGE 3).
- 9) APPLY RELEASE AGENT TO ALL BOLTS TO PREVENT THEIR ACCIDENTAL BONDING. ARRANGE BOLTS AND SPRINGS CONTROLLING BOND GAP COMPRESSION TO MAKE AVAILABLE FOR BONDED ASSEMBLY.
- 10) WEAR PROTECTIVE GLOVES.
- 11) WIPE THE RIB SURFACE ABRABED FOR BONDING IN STEP 6 WITH ISOPROPYL ALCOHOL AND A LINT-FREE CLOTH TO REMOVE COMPLETELY SANDING DEBRIS OR RESIN POWDER. (SEE SH. 8 IMAGE 4)
- 12) WIPE NUTRING SURFACE ABRABED FOR BONDING IN STEP 7 WITH ISOPROPYL ALCOHOL TILL CLEAN AND VERIFY SURFACE PREPARATION WITH WATER BREAK TEST. SET ASIDE PROTECTED FROM DUST.
- 13) APPLY CLICKBOND OR EQ ADHESIVE TO WING RIB SURFACE AND NUTRING SURFACE.
- 14) ALIGN NUTRING AND ATTACH WITH BOLTS AND SPRINGS (SUPPLIED). ENSURE BOLTS ARE PROTECTED WITH RELEASE AGENT. (SEE SH. 5)
- 15) ALLOW ASSEMBLY TO CURE FOR 8 HOURS IN ROOM TEMPERATURE.
- 16) LIGHTY ABRABE THE OUTER SURFACE OF THE GASKET TO INSURE TIGHT FIT.
- 17) CLEAN THE GASKET SURFACE WITH ISOPROPYL ALCOHOL.
- 18) PLACE THE GASKET UNDER THE SENDER AND BOLT THE FUEL SENDER TO THE NUTRING WITH SUPPLIED FASTENERS. APPLY MIL-S-46163 TYPE II TYPE N MEDIUM THREADLOCKER. OPERATE THE ARM TO ENSURE IT HAS UNRESTRICTED MOVEMENT INSIDE THE TANK. TORQUE BOLTS 20 TO 25 IN-LBS. (SEE SH. 6)
- 19) RE-SEAL AND INSTALL THE INBD FUEL TANK ACCESS PANELS. IN ACCORDANCE WITH CIRRUS MAINTENANCE MANUAL.
- 20) REMOVE THE OUTBD FUEL SENDER AND REMOVE THE SENDER SUPPORT BRACKET FROM THE WING. (SEE SH. 8 IMAGE 6).
- 21) PLACE THE GASKET UNDER THE SENDER AND BOLT THE OUTBD FUEL SENDER WITH SUPPLIED FASTENERS. APPLY MIL-S-46163 TYPE II TYPE N MEDIUM THREADLOCKER. OPERATE THE ARM TO ENSURE IT HAS UNRESTRICTED MOVEMENT INSIDE THE TANK. TORQUE TO 20 TO 25 IN-LBS.
- 22) CONNECT THE SENDER ELECTRICAL CONNECTORS AND VERIFY THAT BOTH SENDERS CONTRIBUTE TO A FREQUENCY OUTPUT (INBD BLUE WIRE) MEASURED WITH A DIGITAL MULTIMETER.
- 23) RESEAL AND INSTALL THE OUTBD FUEL TANK ACCESS PANELS IN ACCORDANCE WITH CIRRUS MAINTENANCE MANUAL.

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		1375 SE WILSON AVE SUITE 150 BEND, OR 97702	
TITLE INSTALLATION ASSEMBLY - CIRRUS SR22 G1/G2			
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B	66YY1	CC2840330015	B
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NONE			

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-	N/A	WING FUEL RIB TANK				35
1	TORQUE SEAL	09-05509				34
-	EA9396 (OPTIONAL ALTERNATIVE)	EPOXY STRUCTUAL ADHESIVE	HYSOL			33
-	EA9395 (OPTIONAL ALTERNATIVE)	EPOXY ADHESIVE	HYSOL			32
1	CB420 (PREFERED)	ACRYLIC ADHESIVE	CLICKBOND			31
20	AN3-5	BOLT	(10-32 X 21/32 L)			13
30	MS51496-P73	WASHER	(#10)			12
10	9434K510	COMPRESSION SPRINGS	MCMASTER CARR			11
10	92200A244	SOCKET CAP SCREW	(10-24 X 5/8 L)			10
2	CC2840450011-001	NUTRING				6
2	CC2840450005-001	ADAPTER PLATE				5
2	CC2840450003-001	COVER PLATE				4
6	CC2840440006-001	GASKET				3
2	CC2840220016-101	FUEL SENDER ASSEMBLY OUTBD				2
2	CC2840220015-101	FUEL SENDER ASSEMBLY INBD				1
QTY	PART NUMBER	DESCRIPTION	MATERIAL/SPECIFICATON	WEIGHT	ZONE	ITEM

PARTS LIST

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CIES INC 1375 SE WILSON AVE
SUITE 150
BEND, OR 97702

TITLE
**INSTALLATION ASSEMBLY -
CIRRUS SR22 G1/G2**

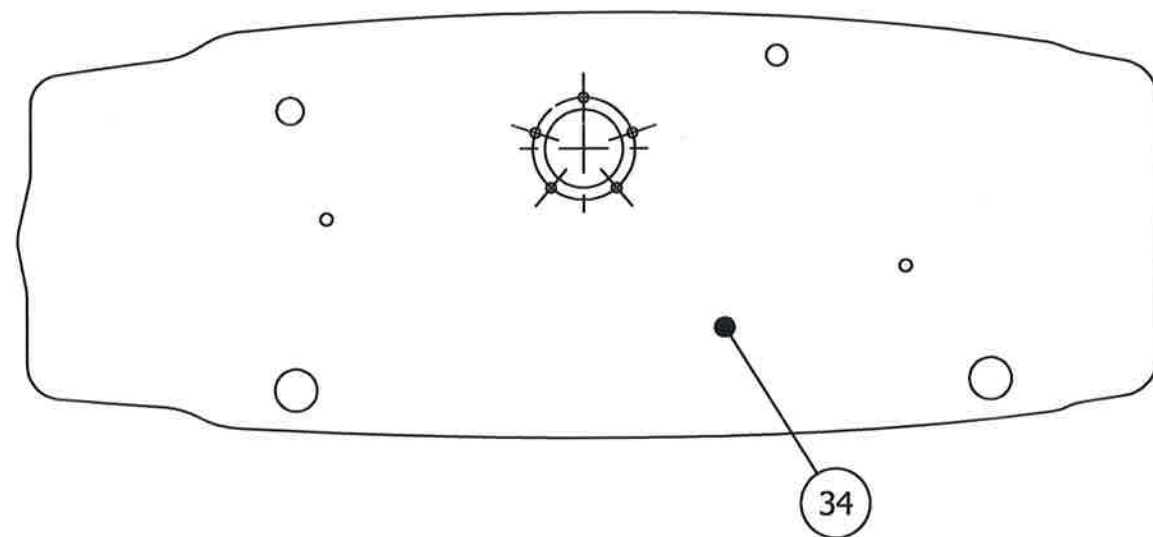
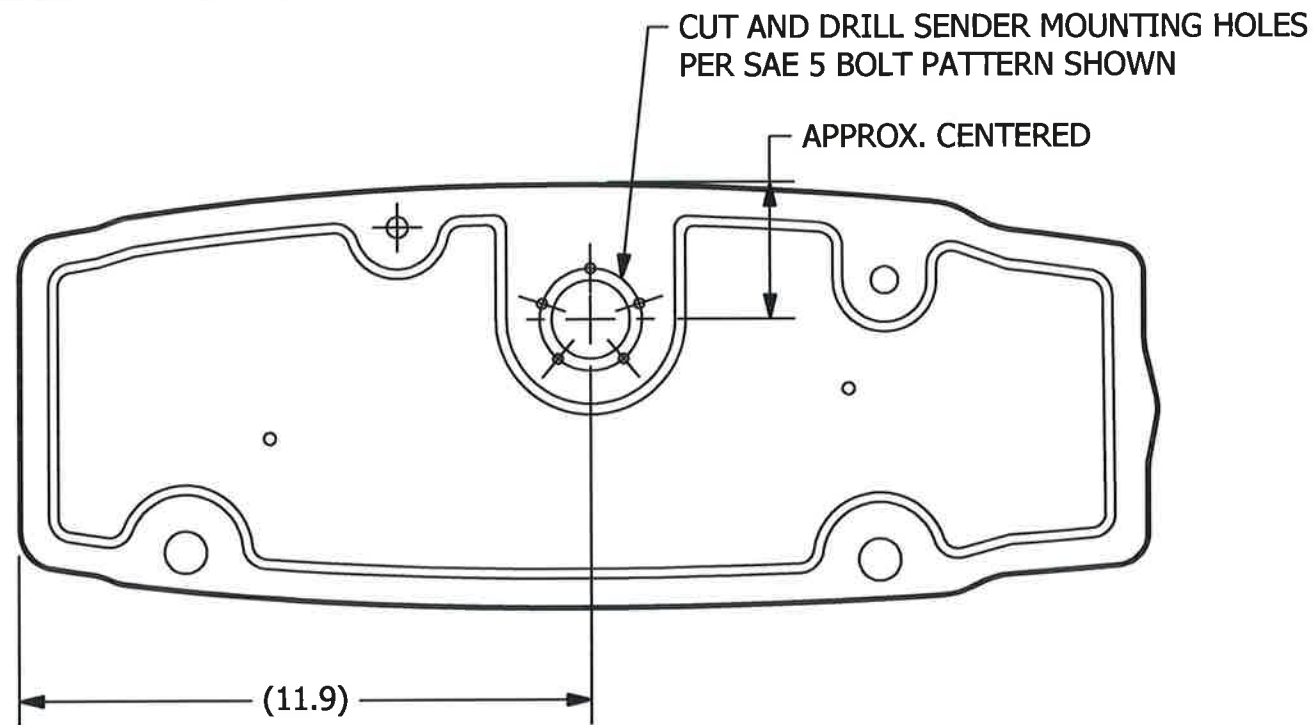
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B	66YY1	CC2840330015	B
SCALE	APPROVED JAN 20 2021		SHEET 3 OF 8
NONE			

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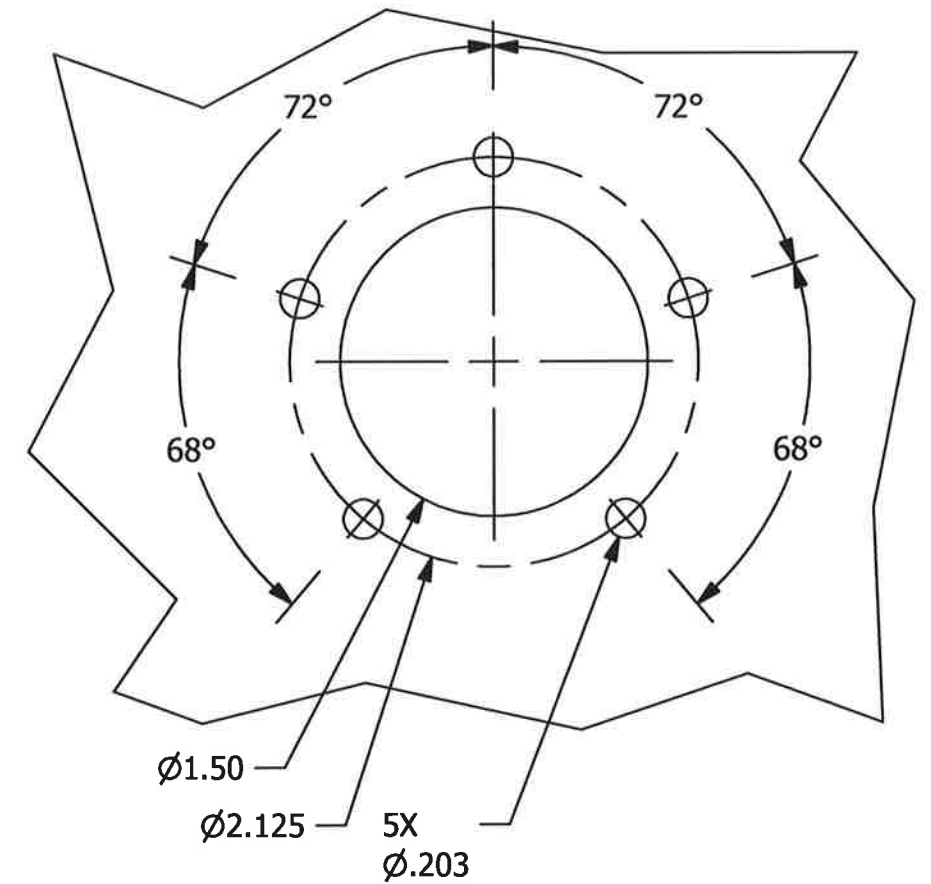
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WING FUEL RIB TANK, INBD DETAIL



STANDARD SAE 5 BOLT PATTERN

SCALE 1 : 1

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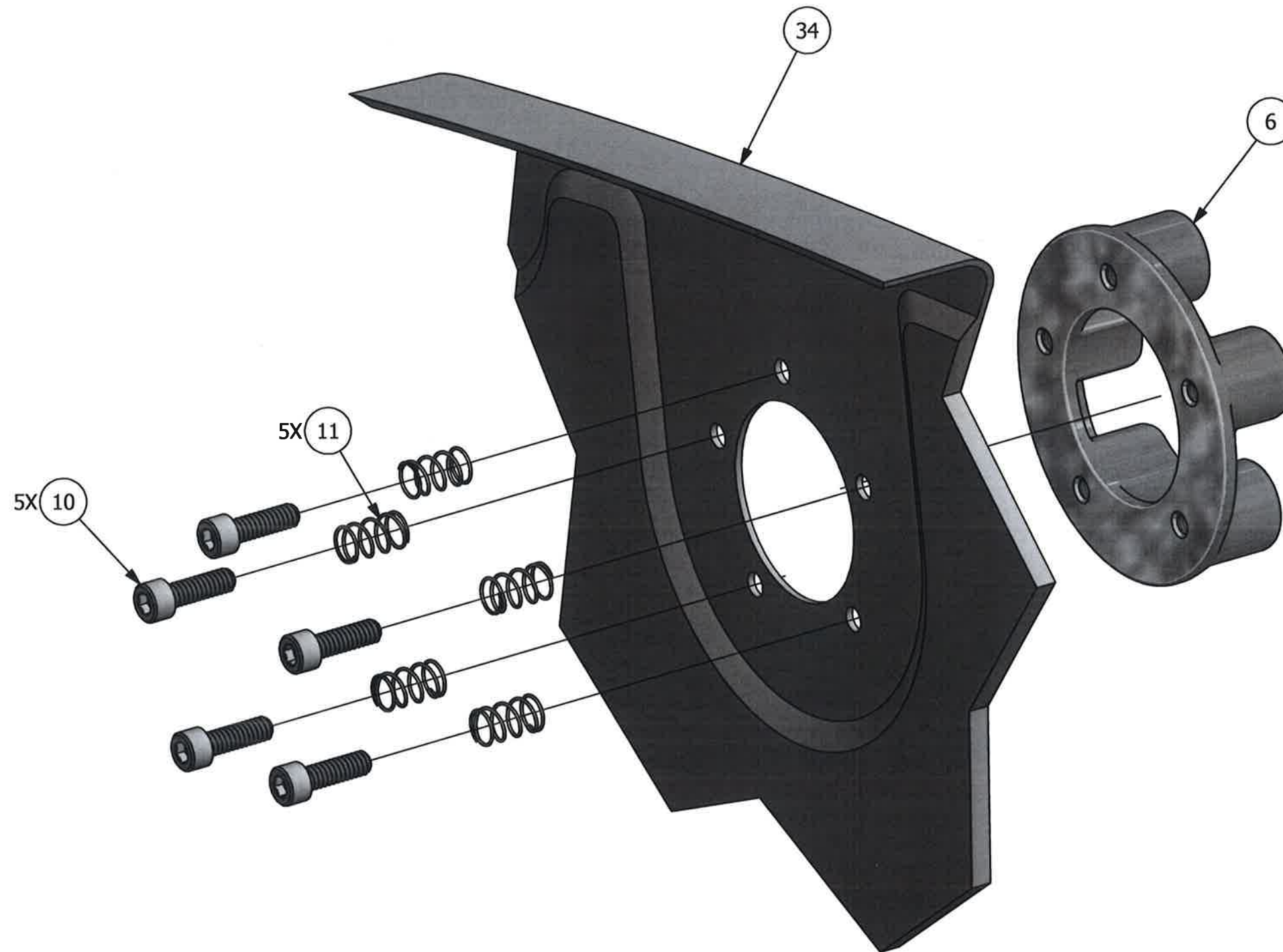
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TITLE INSTALLATION ASSEMBLY - CIRRUS SR22 G1/G2			
SIZE B	CAGE CODE 66YY1	DWG NO. CC2840330015	REV. B
SCALE 1 / 2	APPROVED JAN 20 2021		SHEET 4 OF 8

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TITLE INSTALLATION ASSEMBLY - CIRRUS SR22 G1/G2			
SIZE B	CAGE CODE 66YY1	DWG NO. CC2840330015	REV. B
SCALE 1 : 1	APPROVED JAN 20 2021		SHEET 5 OF 8

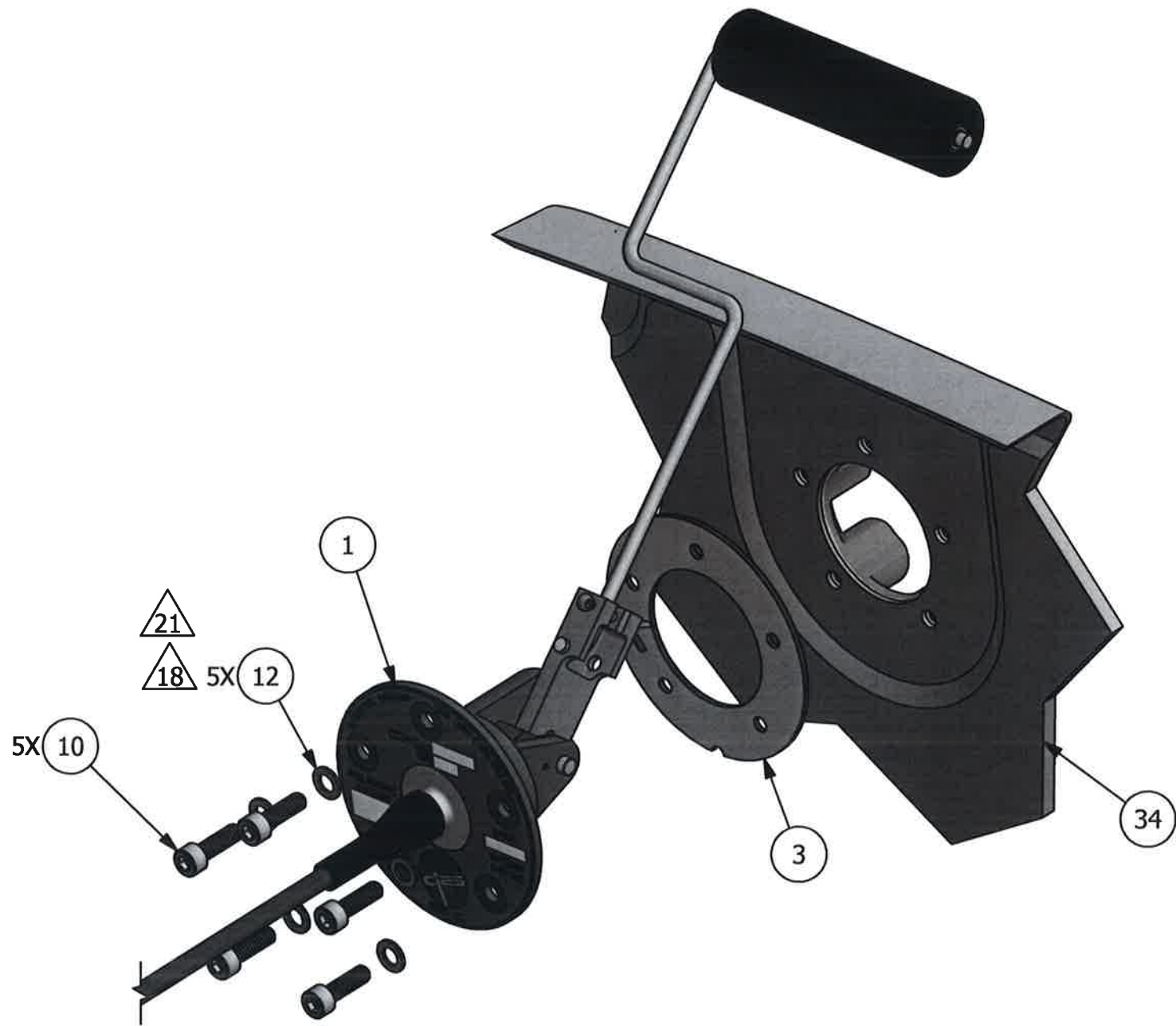
14 NUTRING EPOXY DETAIL
(INBD RIB ONLY)

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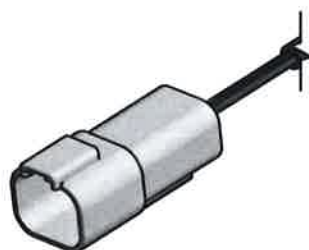
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FUEL SENDER INSTALLATION
 (TYPICAL, INBD AND OUTBD RIB)

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SIZE B	CAGE CODE 66YY1	DWG NO. CC2840330015	REV. B
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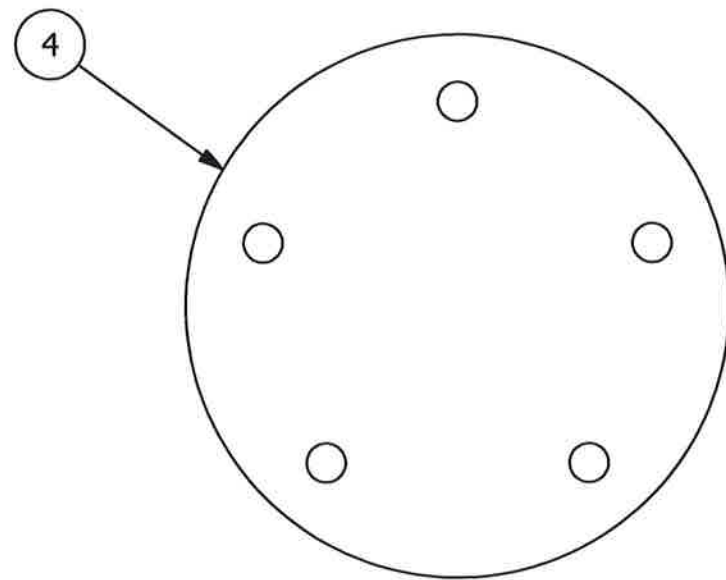
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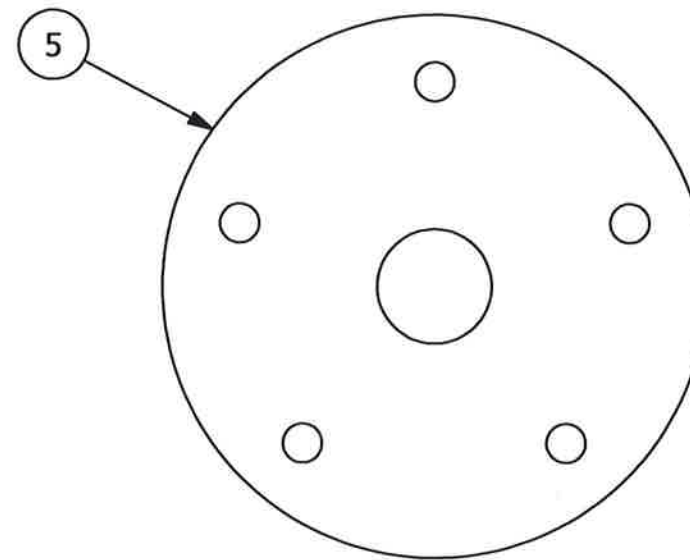
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NOTES:

- OPTIONAL TO REMOVE COLLECTOR TANK FUEL SENDERS AND REPLACE WITH COVER PLATE (ITEM NO.3) AND GASKET (ITEM NO. 2).
NOTE: USE EXISTING HARDWARE AND TORQUE 18-22 INCH LBS.



CC2840450003-001 COVER PLATE
(OPTIONAL)



CC2840450005-001 ADAPTER PLATE

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1 : 1			



IMAGE NO. 1 \triangle_4



IMAGE NO. 2 \triangle_8

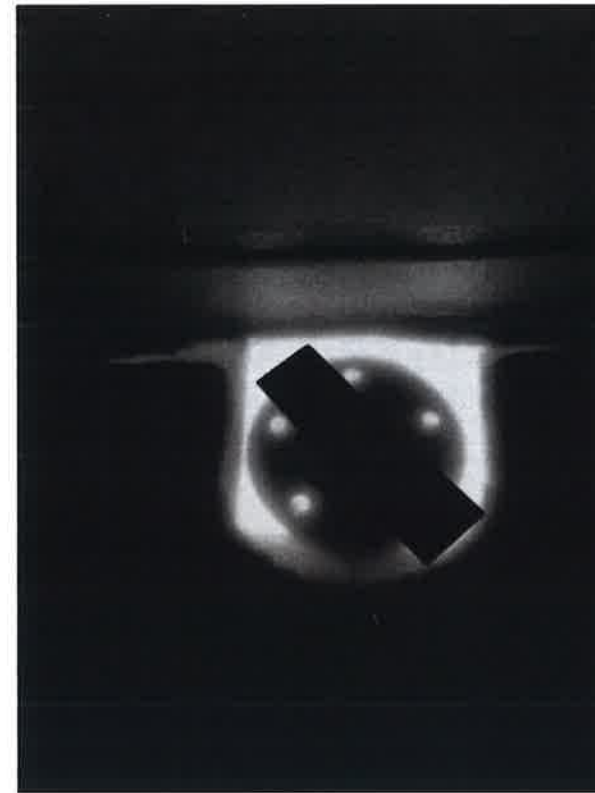


IMAGE NO. 3 \triangle_8

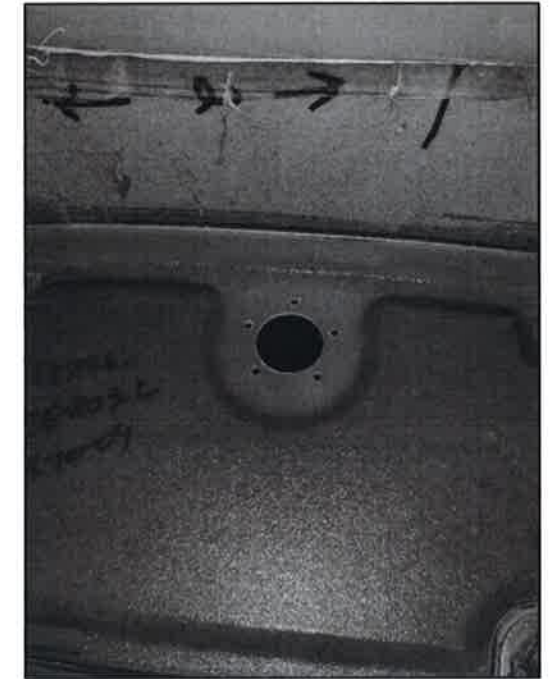


IMAGE NO. 4 \triangle_{11}

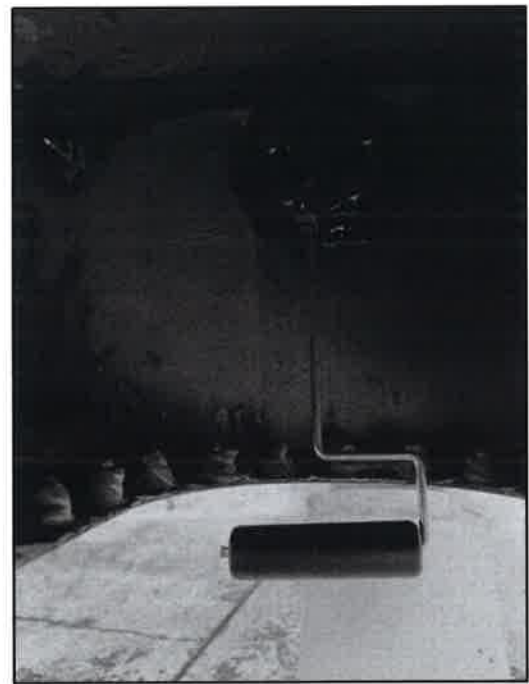


IMAGE NO. 5 \triangle_{18}



CUT SUPPORT BRACKET \triangle_{20}

IMAGE NO. 6 \triangle_{20}

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