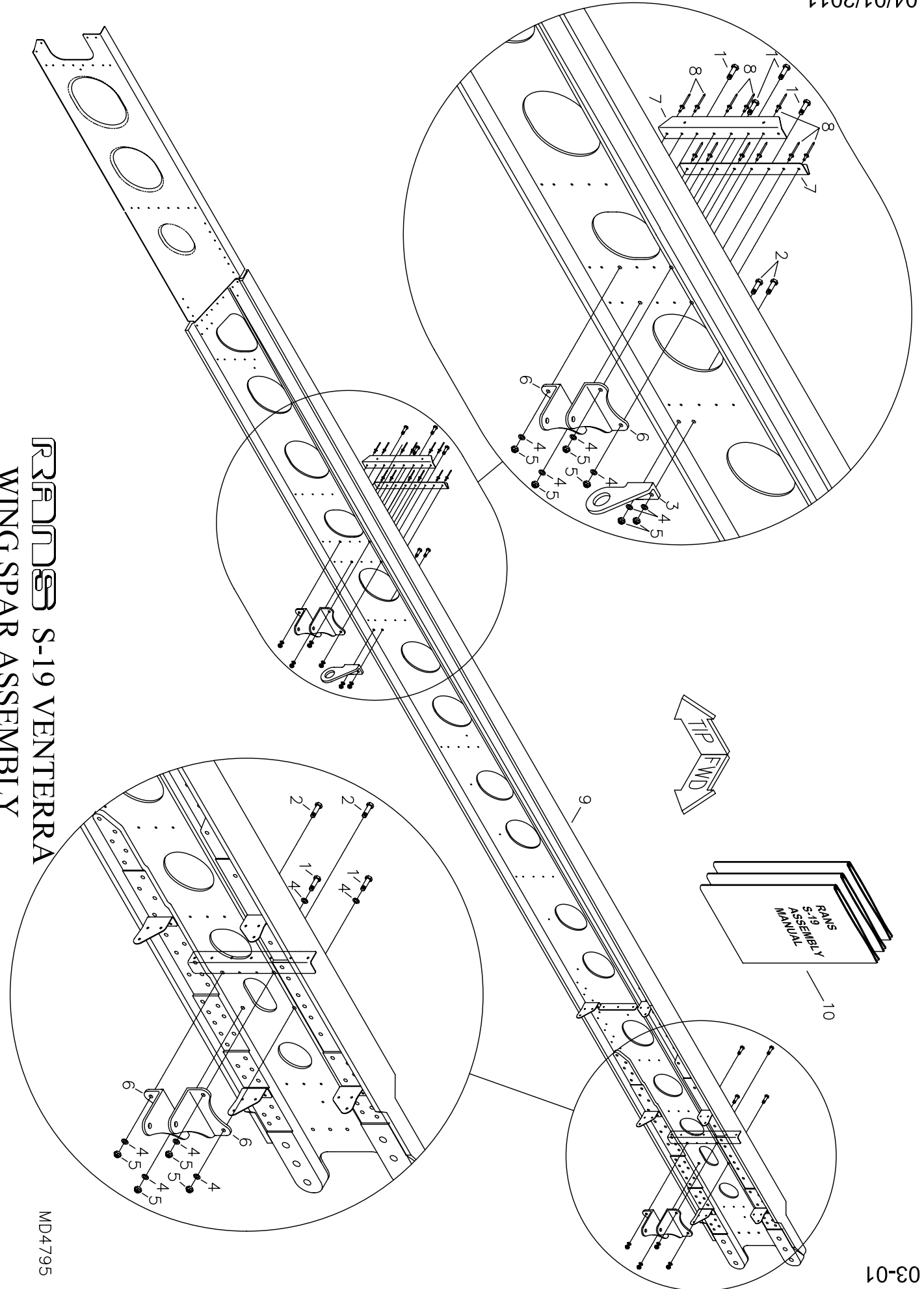


03 – WING ASSEMBLY

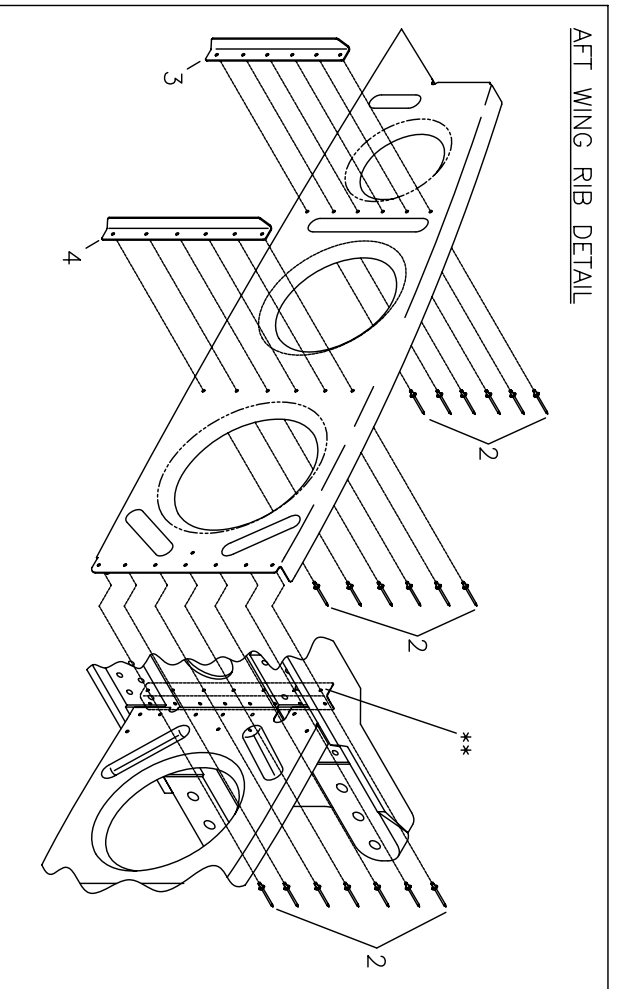
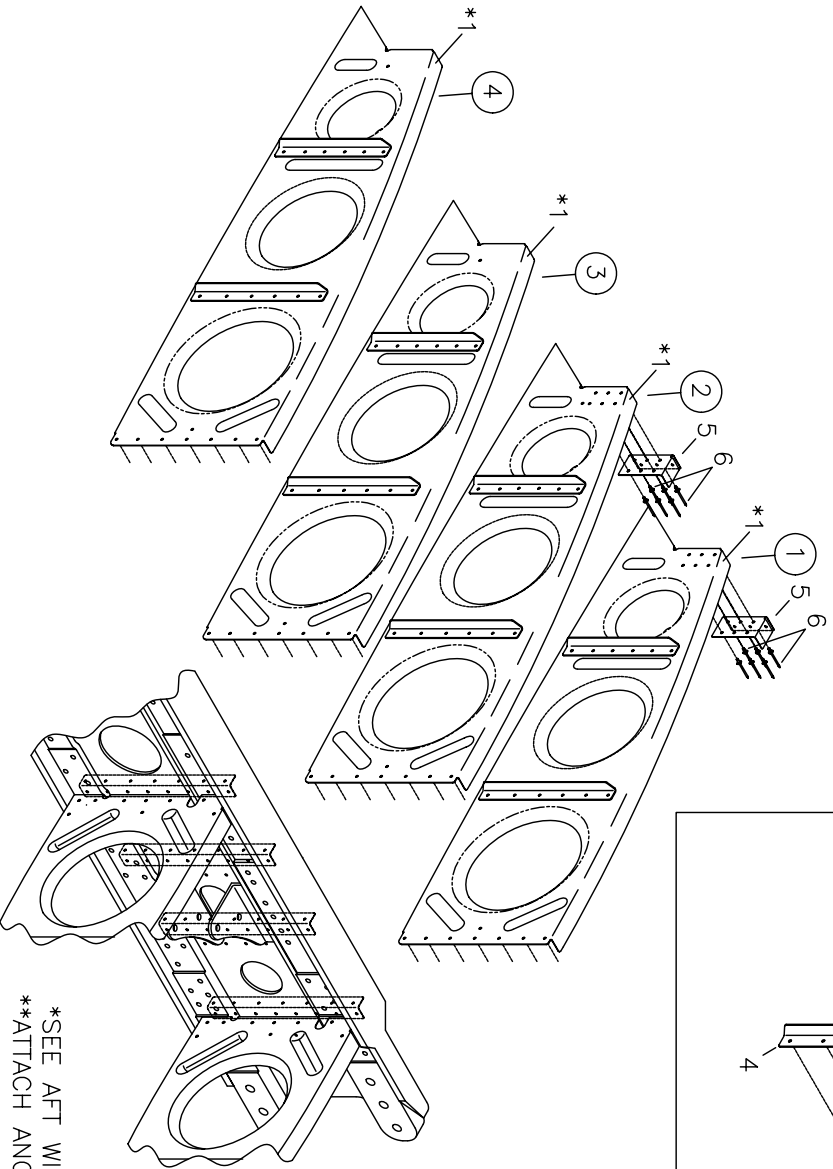
WING SPAR ASSEMBLY	03-01 - 03-02
WING FRAME ASSEMBLY - AFT STEP AREA	03A-01 - 03A-02
WING FRAME ASSEMBLY - FWD STEP AREA.....	03A-03 - 03A-04
WING FRAME ASSEMBLY - OUTBOARD.....	03A-05 - 03A-06
WING FRAME ASSEMBLY - AFT TANK AREA	03B-01 - 03B-02
WING FRAME ASSEMBLY - FWD TANK AREA.....	03B-03 - 03B-04
WING TRAILING EDGE SPAR ASSEMBLY (ROOT AREA #1).....	03C-01 - 03C-02
WING TRAILING EDGE SPAR ASSEMBLY (ROOT AREA #2).....	03C-03 - 03C-04
WING TRAILING EDGE SPAR ASSEMBLY (ROOT AREA #3).....	03C-05 - 03C-06
WING TRAILING EDGE SPAR ASSEMBLY (OUTBOARD).....	03C-07 - 03C-08
AILERON INNER BELLCRANK INSTALLATION	03D-01 - 03D-02
AILERON OUTER BELLCRANK INSTALLATION.....	03D-03 - 03D-04
FUEL TANK ASSEMBLY AND INSTALLATION.....	03E-01 - 03E-02
FUEL LINE INSTALLATION - WING	03E-03 - 03E-04
WING SKIN STIFFENER INSTALLATION	03F-01 - 03F-02
WING SKIN INSTALLATION	03F-03 - 03F-04
FWD SKIN REINFORCEMENT RING INSTALLATION.....	03F-05 - 03F-06
LOWER AFT SKIN REINFORCEMENT RING INSTALLATION.....	03F-07 - 03F-08
UPPER AFT SKIN REINFORCEMENT RING INSTALLATION.....	03F-09 - 03F-10
FUEL SCUPPER INSTALLATION	03G-01 - 03G-02
WING TIP INSTALLATION	03G-03 - 03G-04
GAP FILLETS INSTALLATION.....	03G-05 - 03G-06
OPTIONAL WING PITOT/STATIC INSTALLATION	03H-01 - 03H-02
OPTIONAL DYNON PITOT/STATIC INSTALLATION.....	03I-01 - 03I-02
OPTIONAL AVEO STROBE INSTALLATION.....	03J-01 - 03J-02



**RRRNDG S-19 VENTERRA
WING SPAR ASSEMBLY**

MD4795

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	3/16" Bolt	AN3-5A	12
2.	3/16" Bolt	AN3-6A	8
3.	Tie Down - RH	KPFU0391-R	1
3.	Tie Down - LH	KPFU0391-L	1
4.	3/16" Thin Washer	AN960-10L	24
5.	3/16" Tensile Nut	AN365-1032A	20
6.	Bellcrank Mount Angle - RH	KPAL0091-R	4
6.	Bellcrank Mount Angle - LH	KPAL0091-L	4
7.	Spar Stiffener	KPWI0389	2
8.	1/8" Aluminum Rivet - Cherry Q	AAPQ-44	24
9.	Wing Spar Assembly - RH	KAWI0033-R	1
9.	Wing Spar Assembly - LH	KAWI0033-L	1
10.	S-19 Assembly Manual on CD - Wing	S-19 Assembly Manual	1



AFT WING RIB DETAIL

*SEE AFT WING RIB DETAIL (RIB MOUNTS TO OUTBOARD SIDE OF ANGLE)
**ATTACH ANGLES PRE-LOCATED ON AFT SIDE OF SPAR

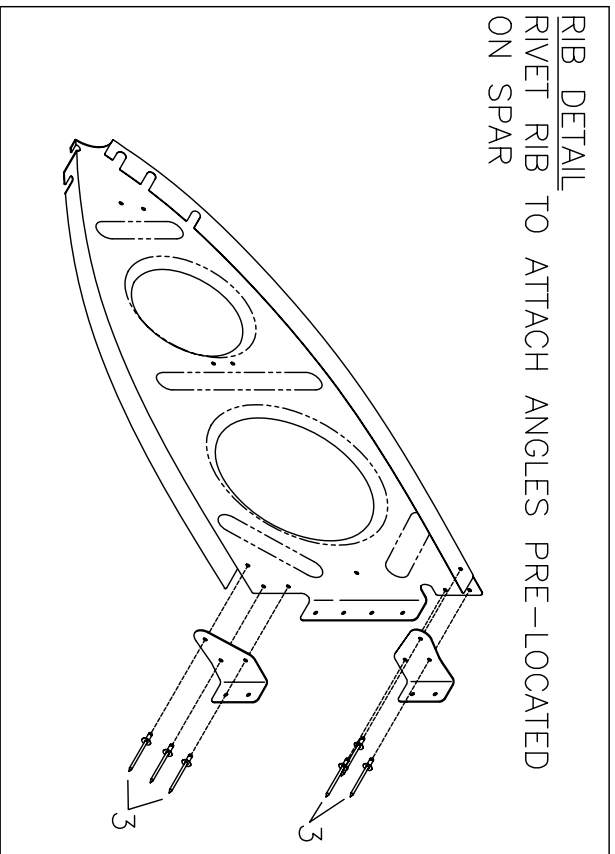
PRATT & WHITNEY S-19 VENTERRA WING FRAME ASSEMBLY - AFT STEP AREA

MD4788

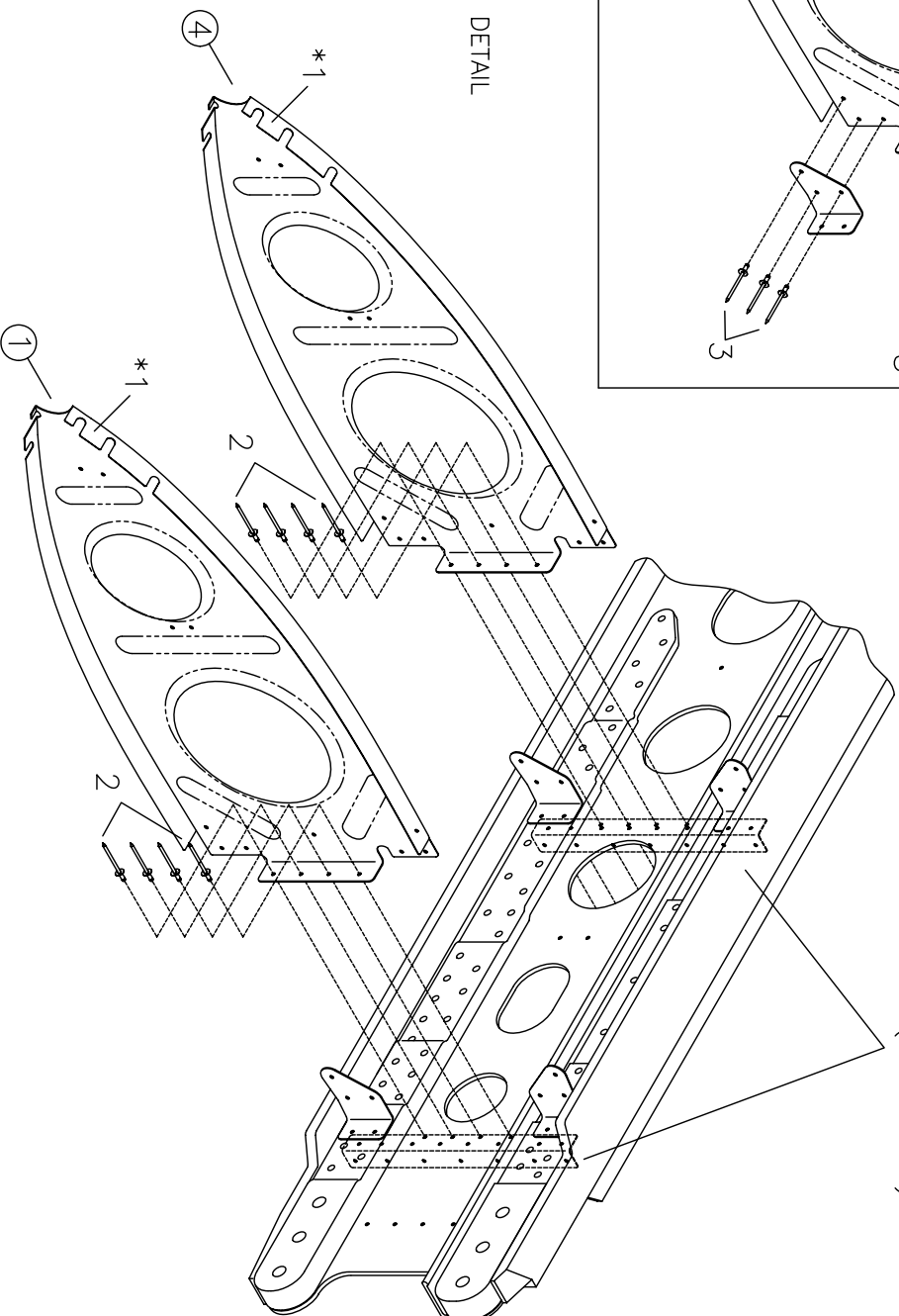
#	DESCRIPTION	PART NUMBER	QUANTITY
1.	Rear Rib #1 - LH	KPWI0396-L	4
1.	Rear Rib #1 - RH	KPWI0396-R	4
2.	1/8" Aluminum Rivet - Cherry Q	AAPQ-41	152
3.	Rib Stiffener - Rear *	KPWI0442	1
4.	Rib Stiffener - FWD *	KPWI0443	2
5.	Wing Rib Gusset - RH	KPWI0444-R	2
5.	Wing Rib Gusset - LH	KPWI0444-L	2
6.	1/8" Aluminum Rivet - Cherry Q	AAPQ-42	24

* Builder modifies.

RIB DETAIL
RIVET RIB TO ATTACH ANGLES PRE-LOCATED
ON SPAR



*SEE RIB DETAIL

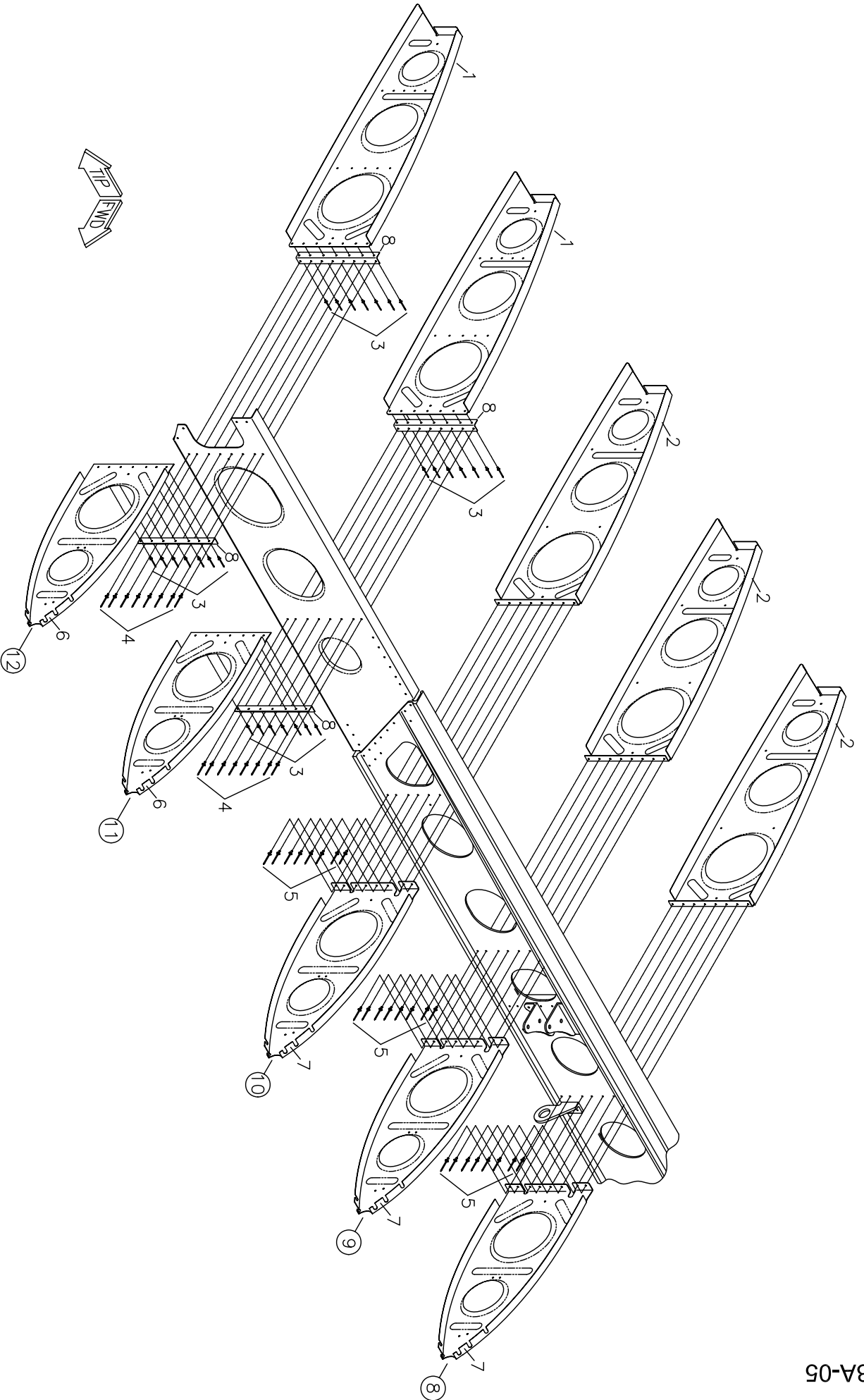


PRE-LOCATED ATTACH
ANGLES (AFT SIDE)

RRRND8 S-19 VENTERRA
WING FRAME ASSEMBLY - FWD STEP AREA

MD4790

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	Nose Rib #1 - LH	KPWI0393-L	2
1.	Nose Rib #1 - RH	KPWI0393-R	2
2.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-46	16
3.	1/8" Aluminum Rivet - Cherry Q	AAPQ-41	24

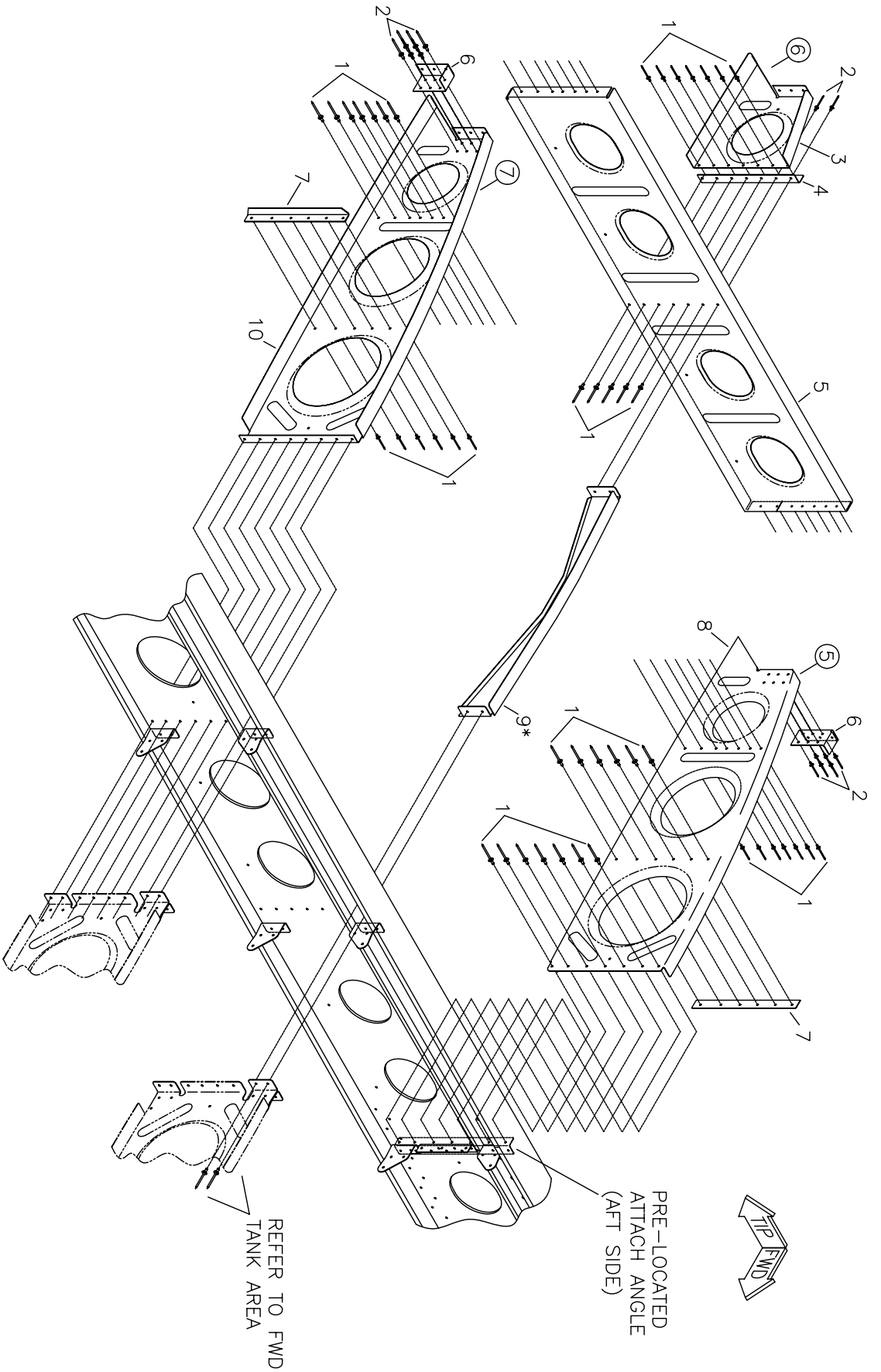


RRRMD S-19 VENTERRA
WING FRAME ASSEMBLY - OUTBOARD

MD4792

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	Rear Rib #3 - RH	KPWI0398-R	2
1.	Rear Rib #3 - LH	KPWI0398-L	2
2.	Rear Rib #2 - RH	KPWI0397-R	3
2.	Rear Rib #2 - LH	KPWI0397-L	3
3.	1/8" Aluminum Rivet - Cherry Q	AAPQ-41	56
4.	1/8" Aluminum Rivet - Cherry Q	AAPQ-42	32
5.	1/8" Aluminum Rivet - Cherry Q	AAPQ-43	48
6.	Nose Rib #4 - RH	KPWI0395-R	2
6.	Nose Rib #4 - LH	KPWI0395-L	2
7.	Nose Rib #3 - RH	KPWI0394-R	3
7.	Nose Rib #3 - LH	KPWI0394-L	3
8.	Rib Attach Angle - Long *	KPWI0387	4

* Builder modifies



*SKIN STIFFENER FACES SAME DIRECTION ON BOTH WINGS

RRRND S-19 VENTERRA

WING FRAME ASSEMBLY - AFT TANK AREA

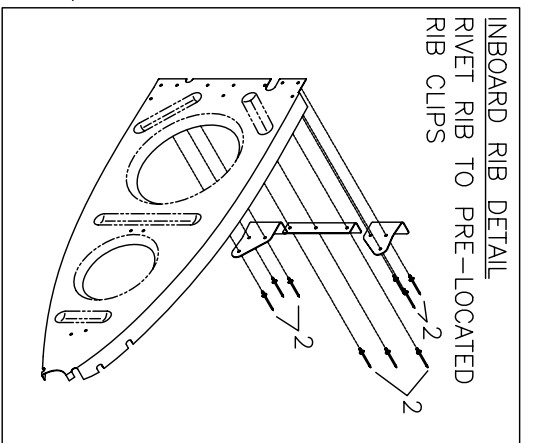
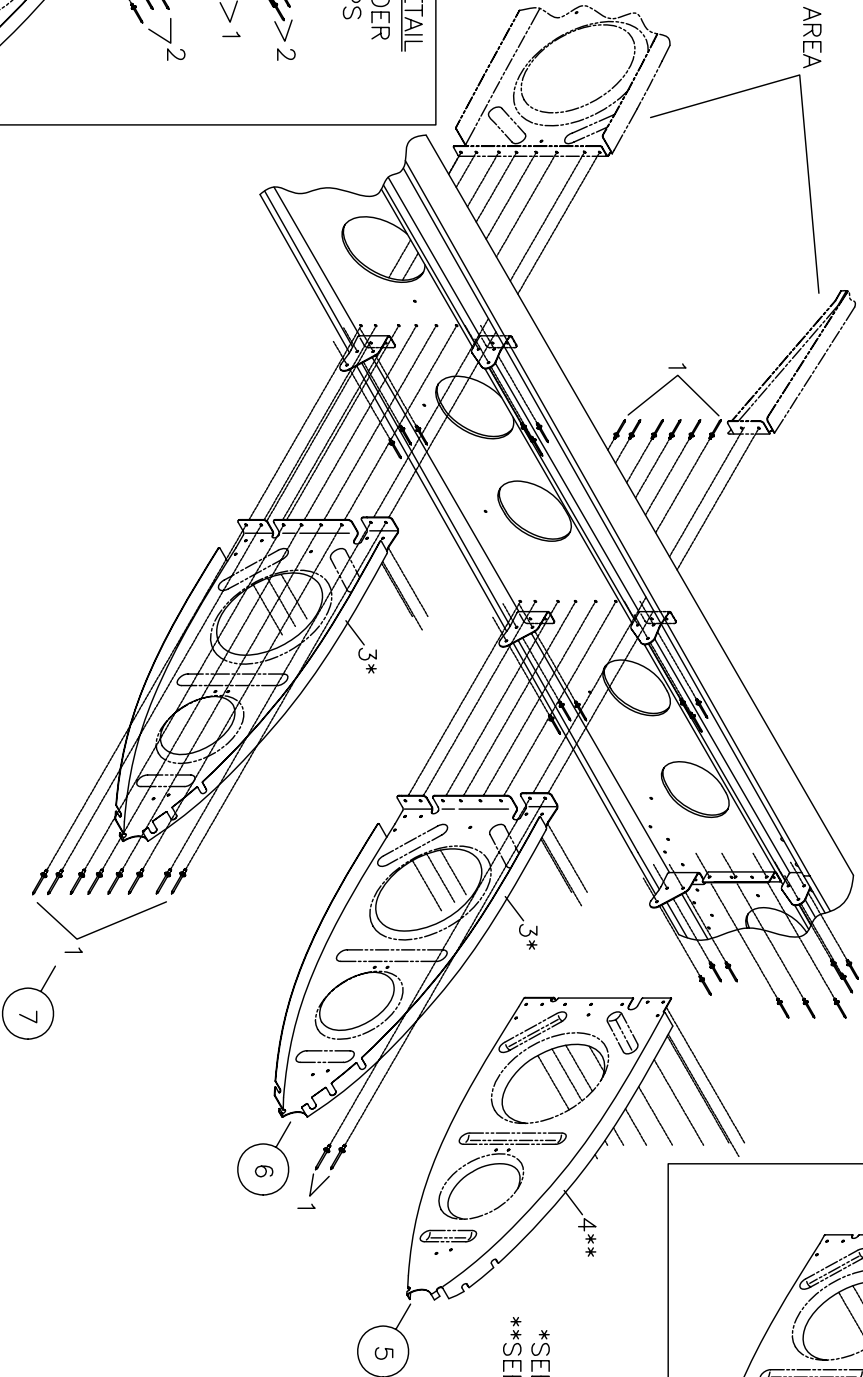
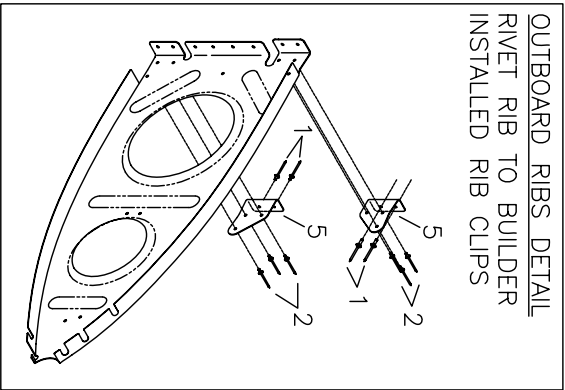
MD4789

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1/8" Aluminum Rivet - Cherry Q	AAPQ-41	78
2.	1/8" Aluminum Rivet - Cherry Q	AAPQ-42	28
3.	Tank Rib - RH	KPWI0436-R	1
3.	Tank Rib - LH	KPWI0436-L	1
4.	Tank Rib Attach Angle - RH	KPWI0438-R	1
4.	Tank Rib Attach Angle - LH	KPWI0438-L	1
5.	Channel - Tank Bay	KPWI0435	2
6.	Wing Rib Gusset - RH	KPWI0444-R	2
6.	Wing Rib Gusset - LH	KPWI0444-L	2
7.	Rib Stiffener - FWD *	KPWI0443	0
8.	Rear Rib #1 - RH	KPWI0396-R	1
8.	Rear Rib #1 - LH	KPWI0396-L	1
9.	Skin Stiffener	KPWI0434	2
10.	Rear Rib #2 - RH	KPWI0397-R	1
10.	Rear Rib #2 - LH	KPWI0397-L	1

* Builder modifies.



REFER TO AFT TANK AREA



*SEE OUTBOARD RIBS DETAIL
**SEE INBOARD RIB DETAIL

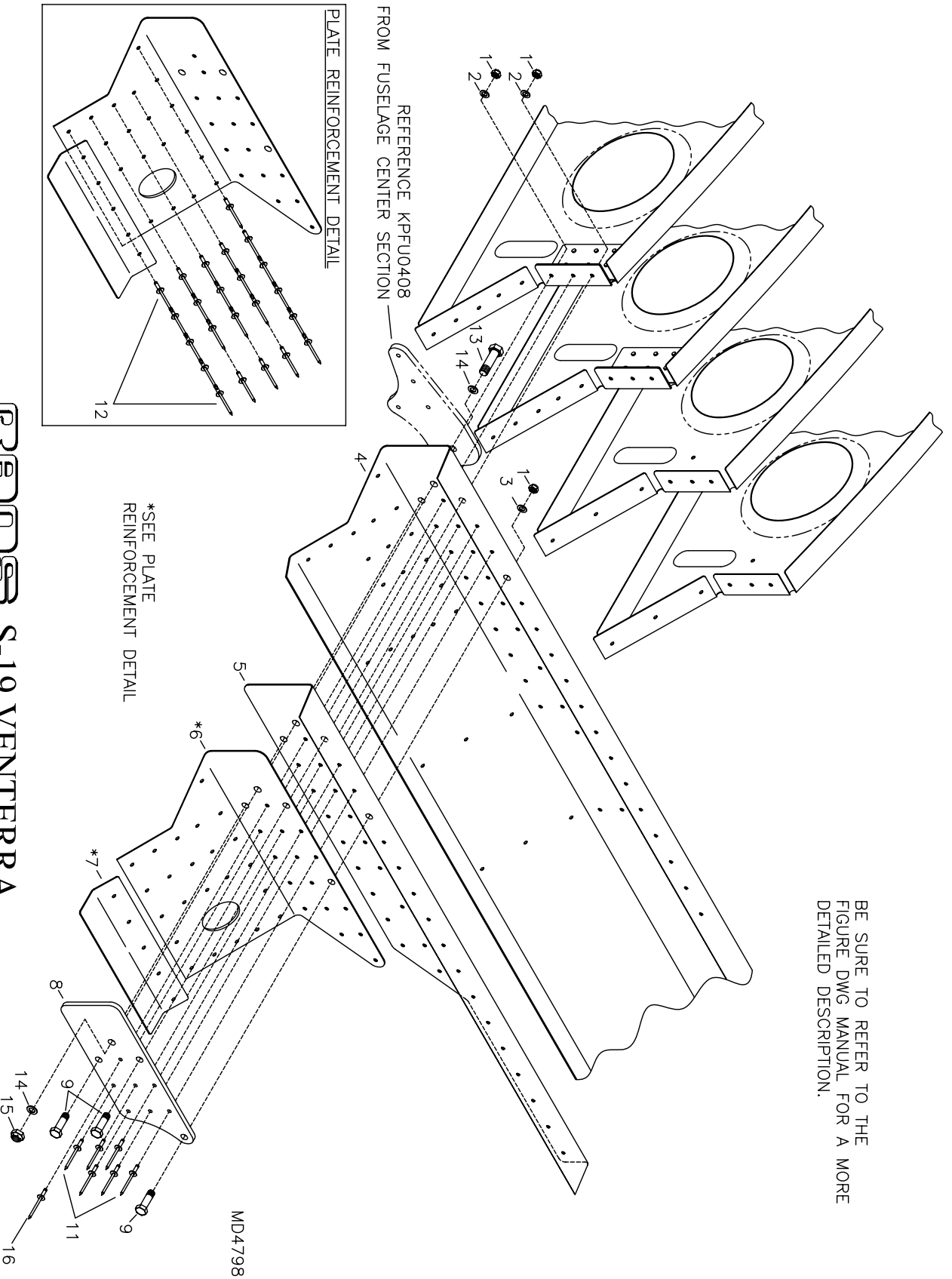
RIPOND S-19 VENTERRA WING FRAME ASSEMBLY - FWD TANK AREA

MD4791

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1/8" Aluminum Rivet - Cherry Q	AAPQ-43	32
2.	1/8" Aluminum Rivet - Cherry Q	AAPQ-41	42
3.	Nose Rib #3 - RH *	KPWI0394-R	2
3.	Nose Rib #3 - LH *	KPWI0394-L	2
4.	Nose Rib #2 - RH	KPWI0407-R	1
4.	Nose Rib #2 - LH	KPWI0407-L	1
5.	Rib Clip - FWD - RH	KPWI0388-R	4
5.	Rib Clip - FWD - LH	KPWI0388-L	4

* Builder modifies.

BE SURE TO REFER TO THE FIGURE DWG. MANUAL FOR A MORE DETAILED DESCRIPTION.

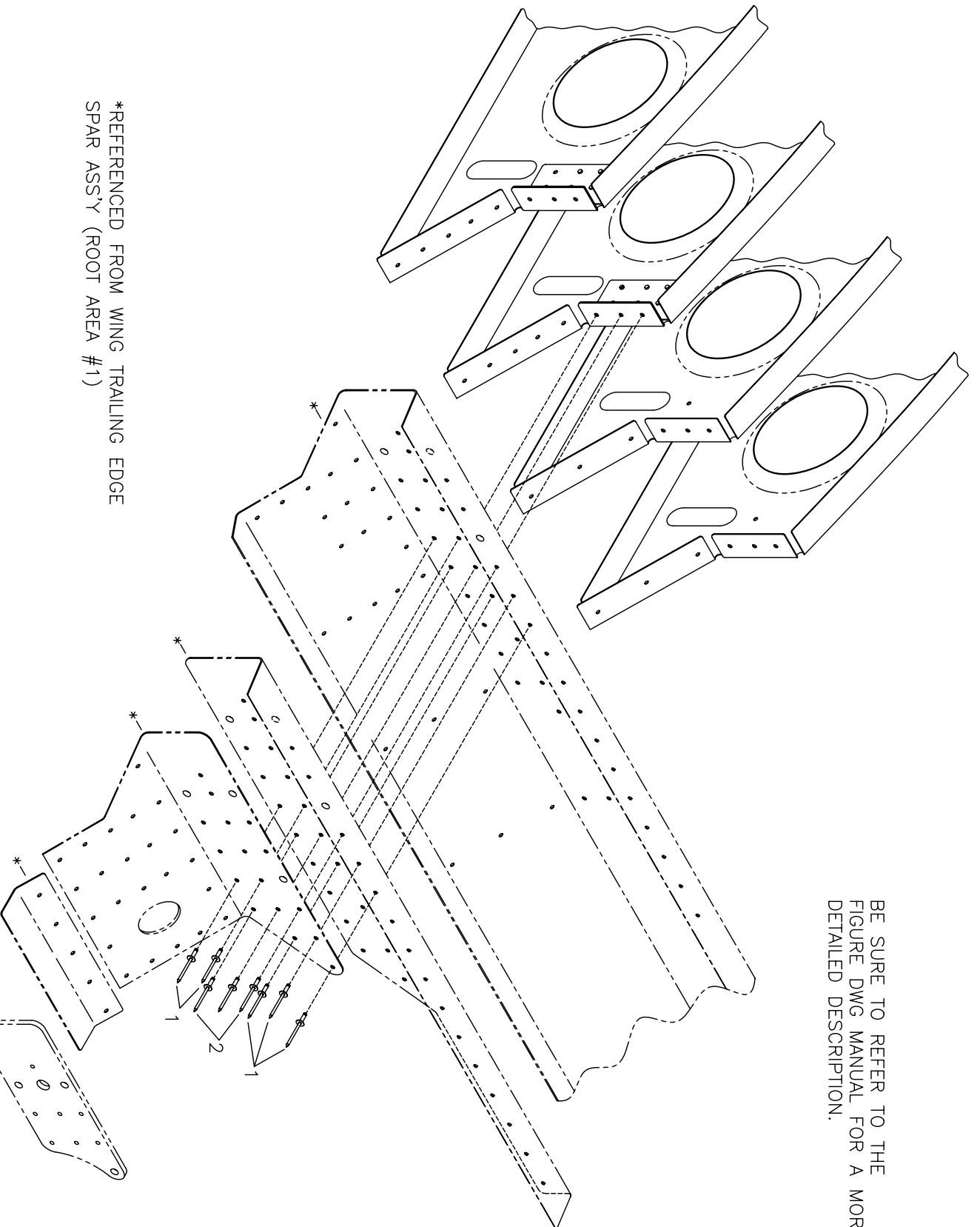


R3R11108 S-19 VENTERRA
WING TRAILING EDGE SPAR ASSEMBLY (ROOT AREA #1)

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	3/16" Tensile Nut	AN365-1032A	6
2.	3/16" Thin Washer	AN960-10L	4
3.	3/16" Thick Washer	AN960-10	2
4.	Trailing Edge Spar - LH	KPWI0437-L	1
4.	Trailing Edge Spar - RH	KPWI0437-R	1
5.	Angle Reinforcement - RH	KPWI0428-R	1
5.	Angle Reinforcement - LH	KPWI0428-L	1
6.	Plate Reinforcement - RH	KPWI0427-R	1
6.	Plate Reinforcement - LH	KPWI0427-L	1
7.	Hinge Support - Aileron & Flap *	KPAL0088	1
8.	Rear Spar Attach Plate	KPWI0426	2
9.	3/16" Bolt	AN3-5A	6
10.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-43	6
11.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-45	12
12.	1/8" Aluminum Rivet - Cherry Q	AAPQ-42	46
13.	1/4" Bolt	AN4-7A	2
14.	1/4" Thick Washer	AN960-416	2
15.	1/4" Shear Nut	AN364-428A	2
16.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-46	2

* Builder modifies.

BE SURE TO REFER TO THE
FIGURE DWG MANUAL FOR A MORE
DETAILED DESCRIPTION.



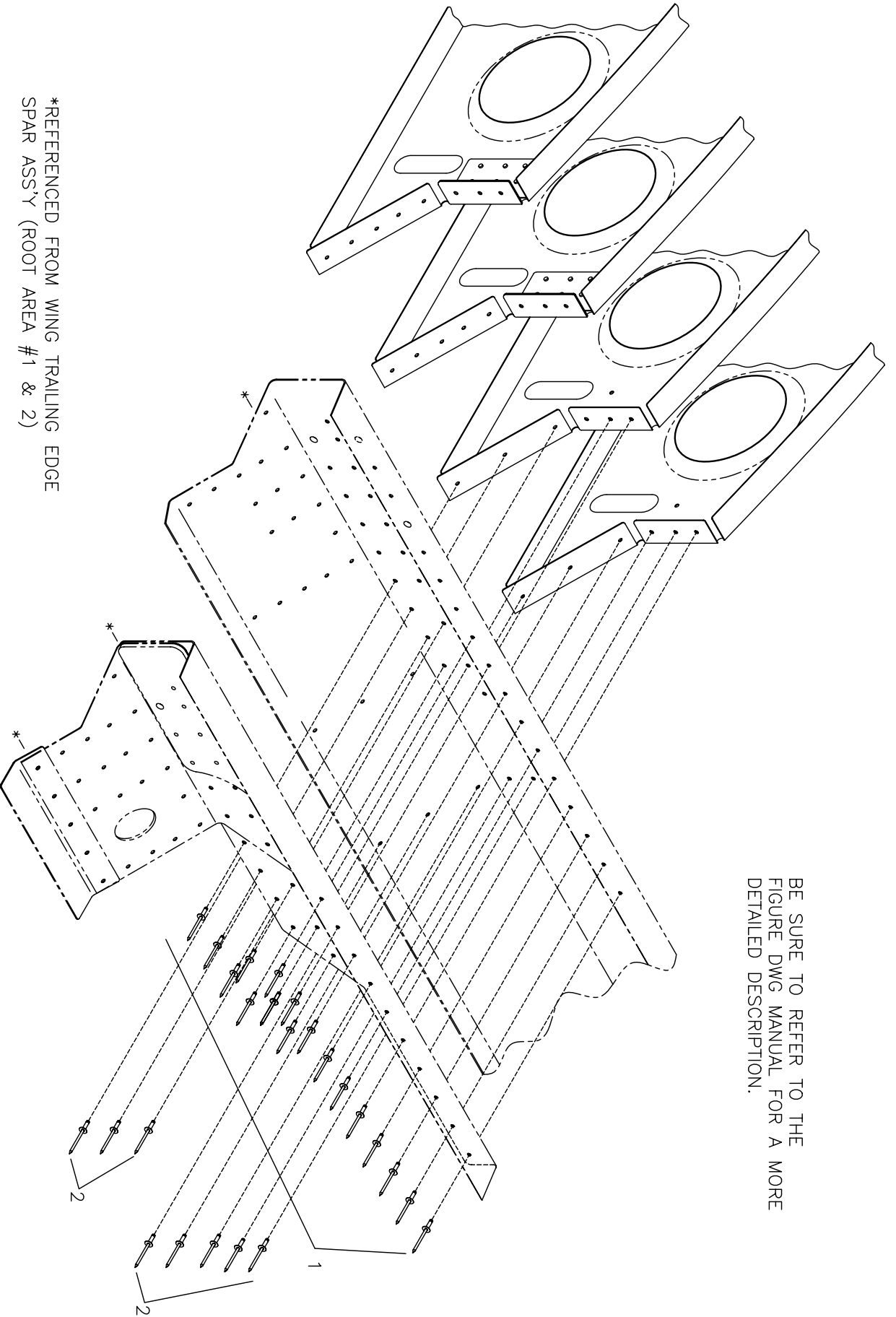
*REFERENCED FROM WING TRAILING EDGE
SPAR ASS'Y (ROOT AREA #1)

RRFDND88 S-19 VENTERRA
WING TRAILING EDGE SPAR ASSEMBLY (ROOT AREA #2)

MD4798

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-42	10
2.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-43	6

BE SURE TO REFER TO THE
FIGURE DWG MANUAL FOR A MORE
DETAILED DESCRIPTION.



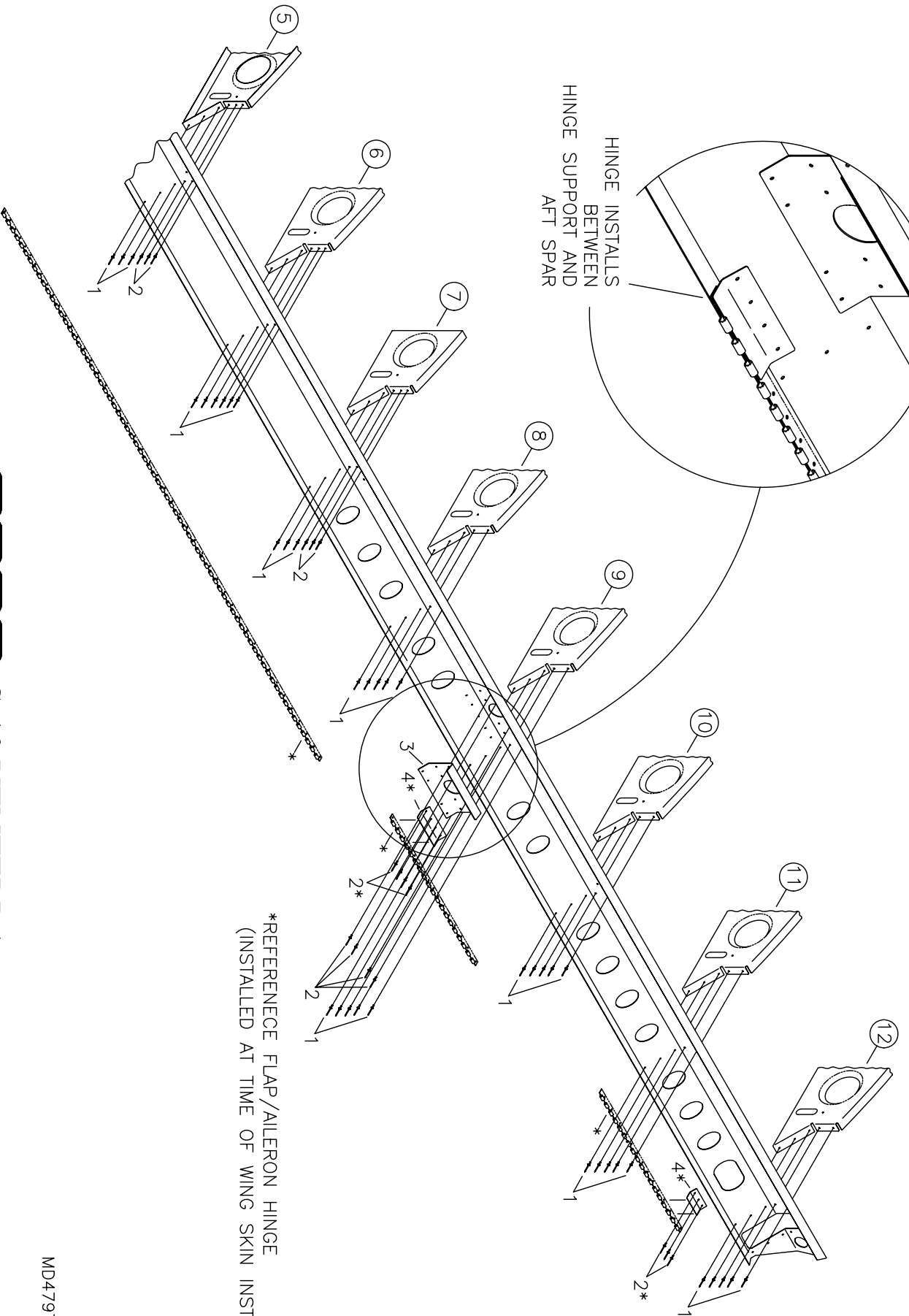
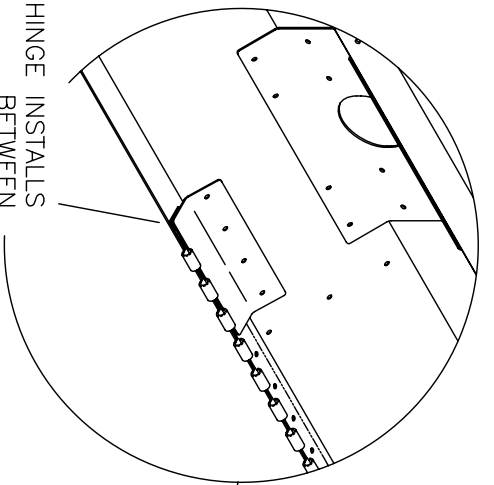
*REFERENCED FROM WING TRAILING EDGE
SPAR ASS'Y (ROOT AREA #1 & 2)

RRRNDG S-19 VENTERRA
WING TRAILING EDGE SPAR ASSEMBLY (ROOT AREA #3)

MD4798

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-42	34
2.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-41	16

HINGE INSTALLS
BETWEEN
HINGE SUPPORT AND
AFT SPAR



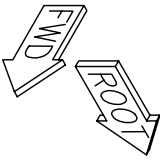
*REFERENCE FLAP/AILERON HINGE
(INSTALLED AT TIME OF WING SKIN INSTALLATION)

RRR S-19 VENTERRA
WING TRAILING EDGE SPAR ASSEMBLY (OUTBOARD)

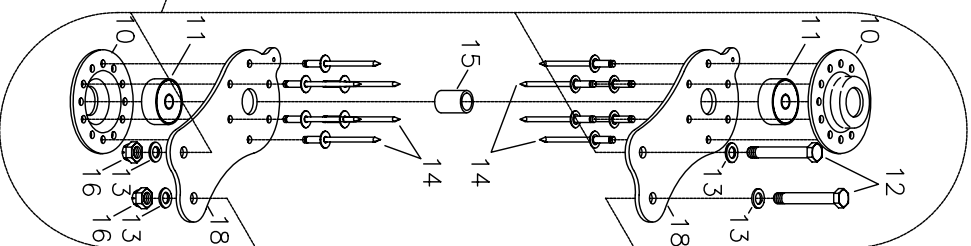
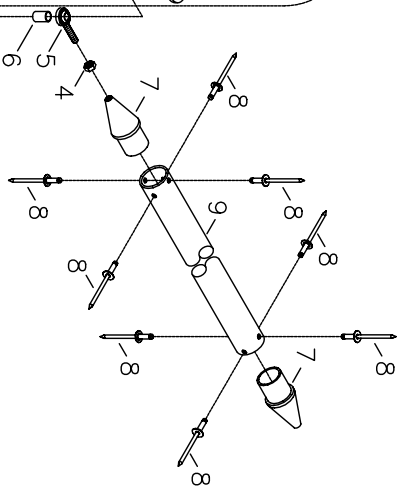
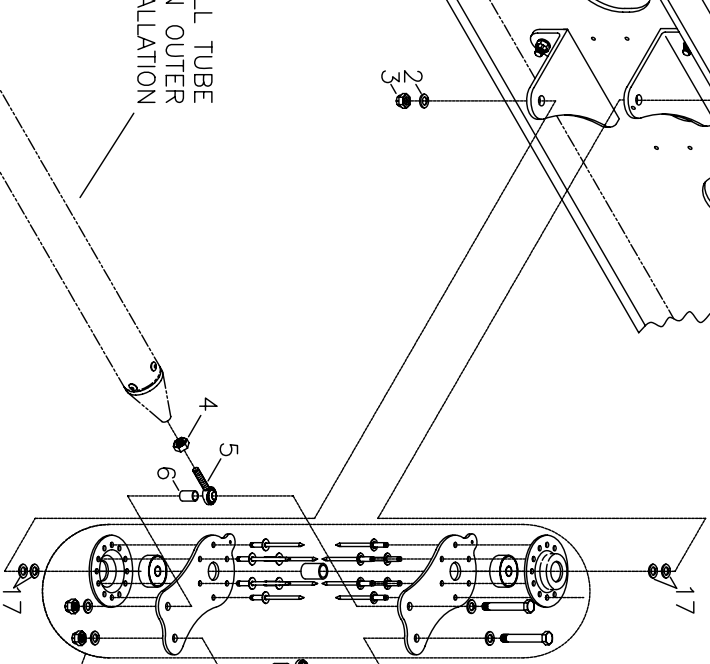
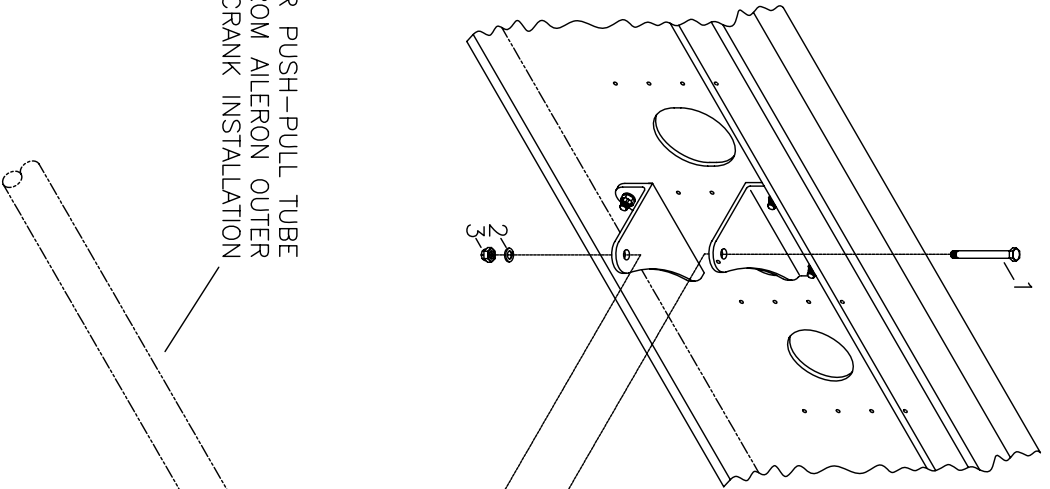
MD4797

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1/8" Aluminum Rivet - Cherry Q	AAPQ-41	74
2.	1/8" Aluminum Rivet - Cherry Q	AAPQ-42	52
3.	Plate Spar Reinforcement	KPWI0441	1
4.	Hinge Support - Aileron & Flap *	KPAL0088	0

* Builder modifies.



AILERON OUTER PUSH-PULL TUBE
REFERENCED FROM AILERON OUTER
BELLCRANK INSTALLATION

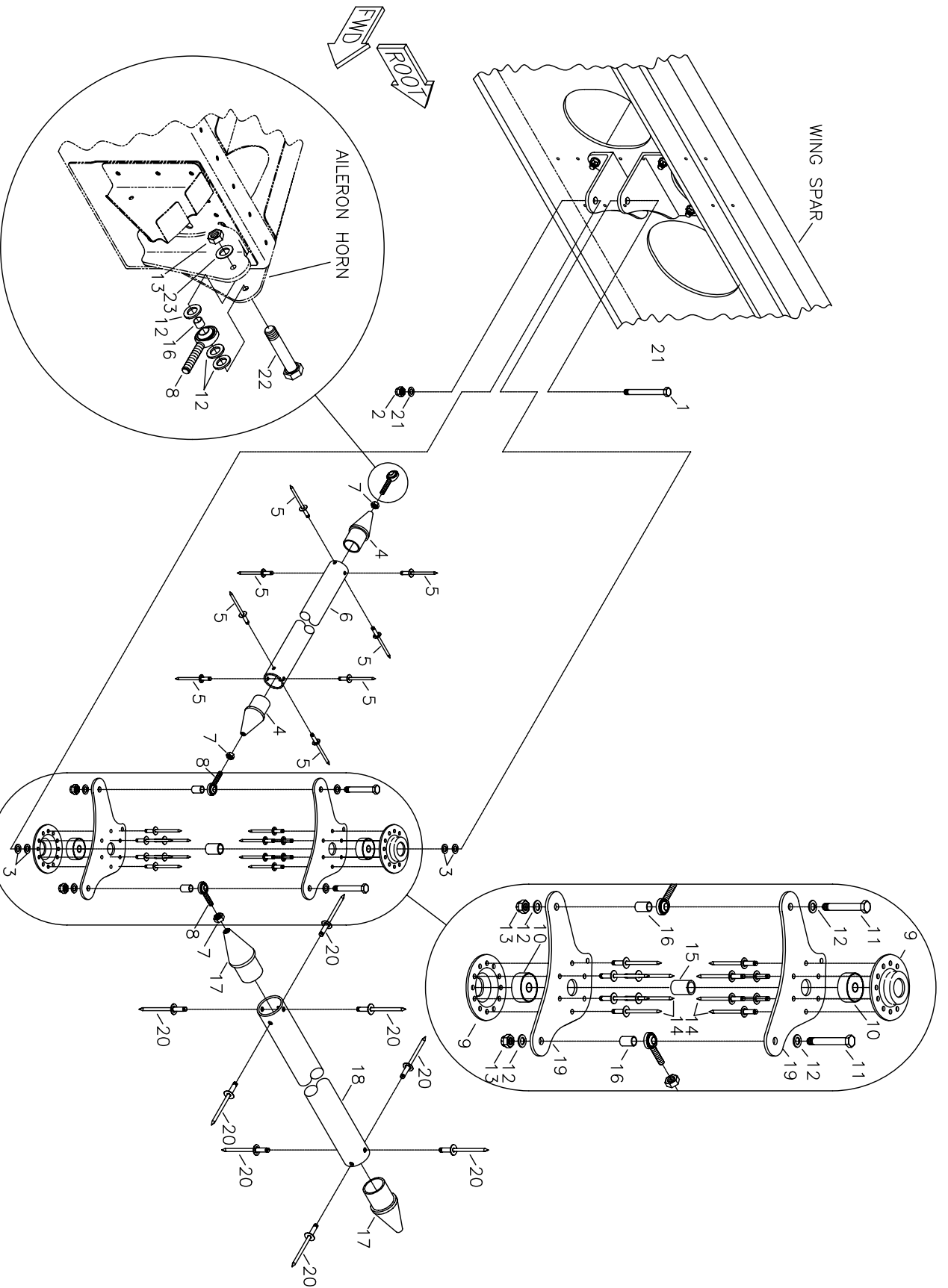


MD4769

RRR S-19 VENTERRA AILERON INNER BELLCRANK INSTALLATION

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1/4" Bolt	AN4-20A	2
2.	1/4" Thin Washer	AN960-416L	2
3.	1/4" Shear Nut	AN364-428A	2
4.	1/4" Plain Nut	AN345-416	4
5.	Male Rod End	NM-4	4
6.	1/4" x .028 x 3/8" Bushing *	KAAC0044-2	0
7.	Push-Pull Tube End Fitting	CS-3/4PTEF	4
8.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-42	16
9.	Aileron Push-Pull Tube	KPCS0235	2
10.	Bearing Flange	BR-FLNG	4
11.	Bearing	SR4APP	4
12.	3/16" Bolt	AN3-10A	4
13.	3/16" Thick Washer	AN960-10	8
14.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-41	24
15.	3/8" x 0.058" x 0.53" Aluminum Bushing *	KAAC0044-3	0
16.	3/16" Shear Nut	AN364-1032A	4
17.	1/4" Thick Washer	AN960-416	8
18.	Aileron Inner Bellcrank	KPAL0090	4

* Builder fabricates from raw stock.

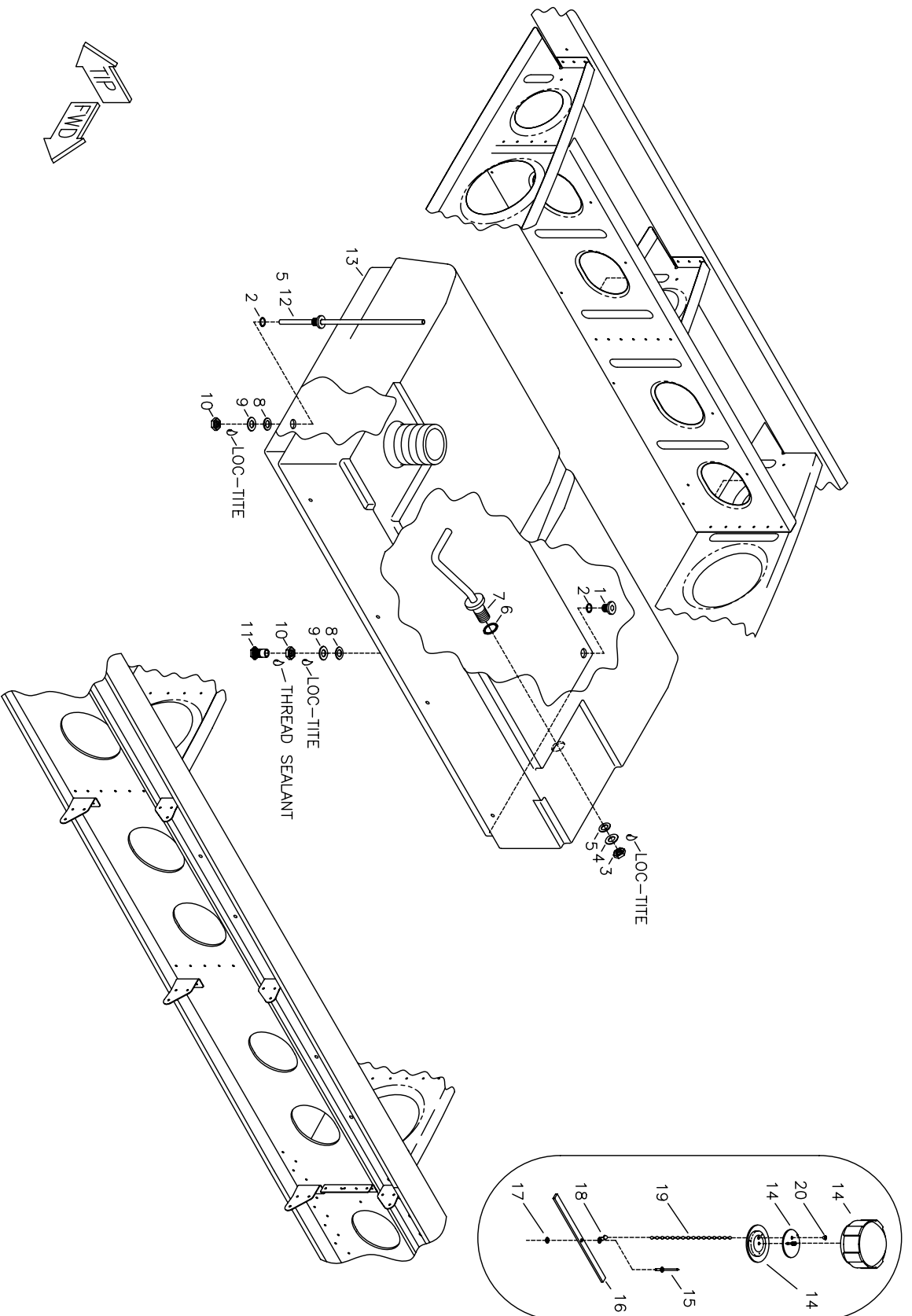


PRATT & WHITNEY S-19 VENTERRA
AILERON OUTER BELLCRANK INSTALLATION

MD4769

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1/4" Bolt	AN4-20A	4
2.	1/4" Shear Nut	AN364-428A	4
3.	1/4" Thick Washer	AN960-416	8
4.	Push-Pull Tube End Fitting	CS-3/4PTEF	4
5.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-42	16
6.	Aileron Push-Pull Tube	KPAL0093	2
7.	1/4" Plain Nut	AN345-416	6
8.	Male Rod End	NM-4	6
9.	Bearing Flange	BR-FLNG	4
10.	Bearing	SR4APP	4
11.	3/16" Bolt	AN3-10A	4
12.	3/16" Thick Washer	AN960-10	14
13.	3/16" Shear Nut	AN364-1032A	6
14.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-41	24
15.	3/8" x 0.058" x 0.53" Aluminum Bushing *	KAAC0044-3	0
16.	1/4" x .028 x 3/8" Bushing *	KAAC0044-2	0
17.	Push-Pull Tube End Fitting	KPCS0016	4
18.	Aileron Push-Pull Tube	KPAL0092	2
19.	Aileron Bellcrank	KPAL0089	4
20.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-43	16
21.	1/4" Thin Washer	AN960-416L	4
22.	3/16" Bolt	AN3-11A	2
23.	3/16" Thin Washer	AN960-10L	2

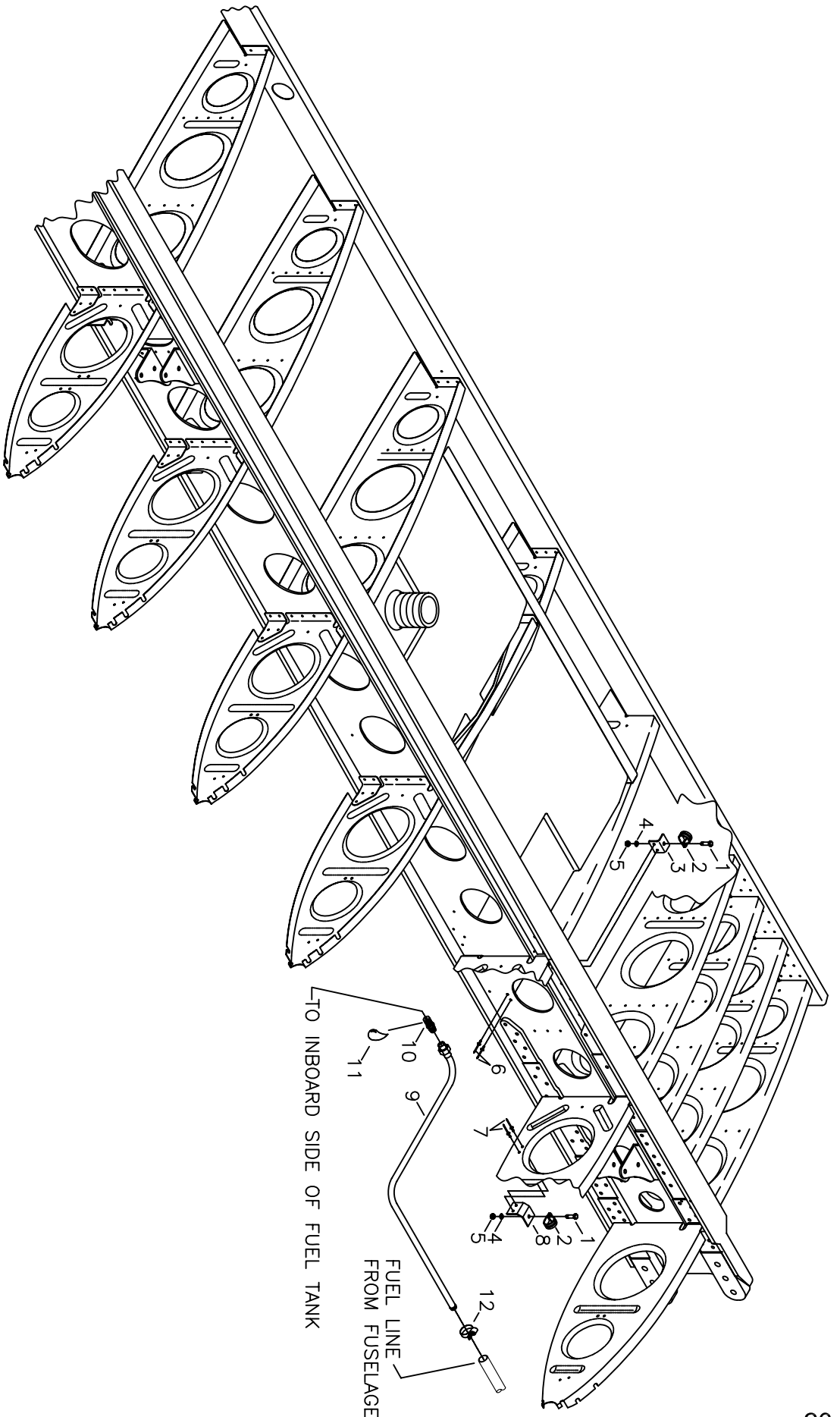
* Builder fabricates from raw stock.



**R3401000 S-19 VENTERRA
FUEL TANK ASSEMBLY & INSTALLATION**

MD4775

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	Tank Withdrawal Fitting	KPFS0017	2
2.	O-Ring	KSFS0009	4
3.	Nut - Flared Tube - Bulkhead	AN924-8D	2
4.	3/4" Thick Washer	AN960-1216	2
5.	Rubber Washer	KSFS0016	2
6.	O-Ring	KSFS0017	2
7.	Pick Up Tube - RH	KPFS0050-R	1
7.	Pick Up Tube - LH	KPFS0050-L	1
8.	Rubber Washer	KSFS0010	4
9.	1/2" Thick Washer	AN960-816	4
10.	Nut - Flared Tube - Bulkhead	AN924-5D	4
11.	Flush Valve	KSFS0011	2
12.	Vent Tube - Tank	KPFS0049	2
13.	Fuel Tank - LH	KPFS0046-L	1
13.	Fuel Tank - RH	KPFS0046-R	1
14.	Fuel Cap	KSFS0007	2
15.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-44	2
16.	Plastic Retainer	KPFS0012	2
17.	1/8" Small Brass Washer	AN960-B4	2
18.	Bead Chain - End Coupling	KSHW0013	2
19.	#3 Bead Chain	KSHW0012	2
20.	Bead Chain - Retainer Sleeve	KSHW0014	2



**RRR00088 S-19 VENTERRA
FUEL LINE INSTALL - WING**

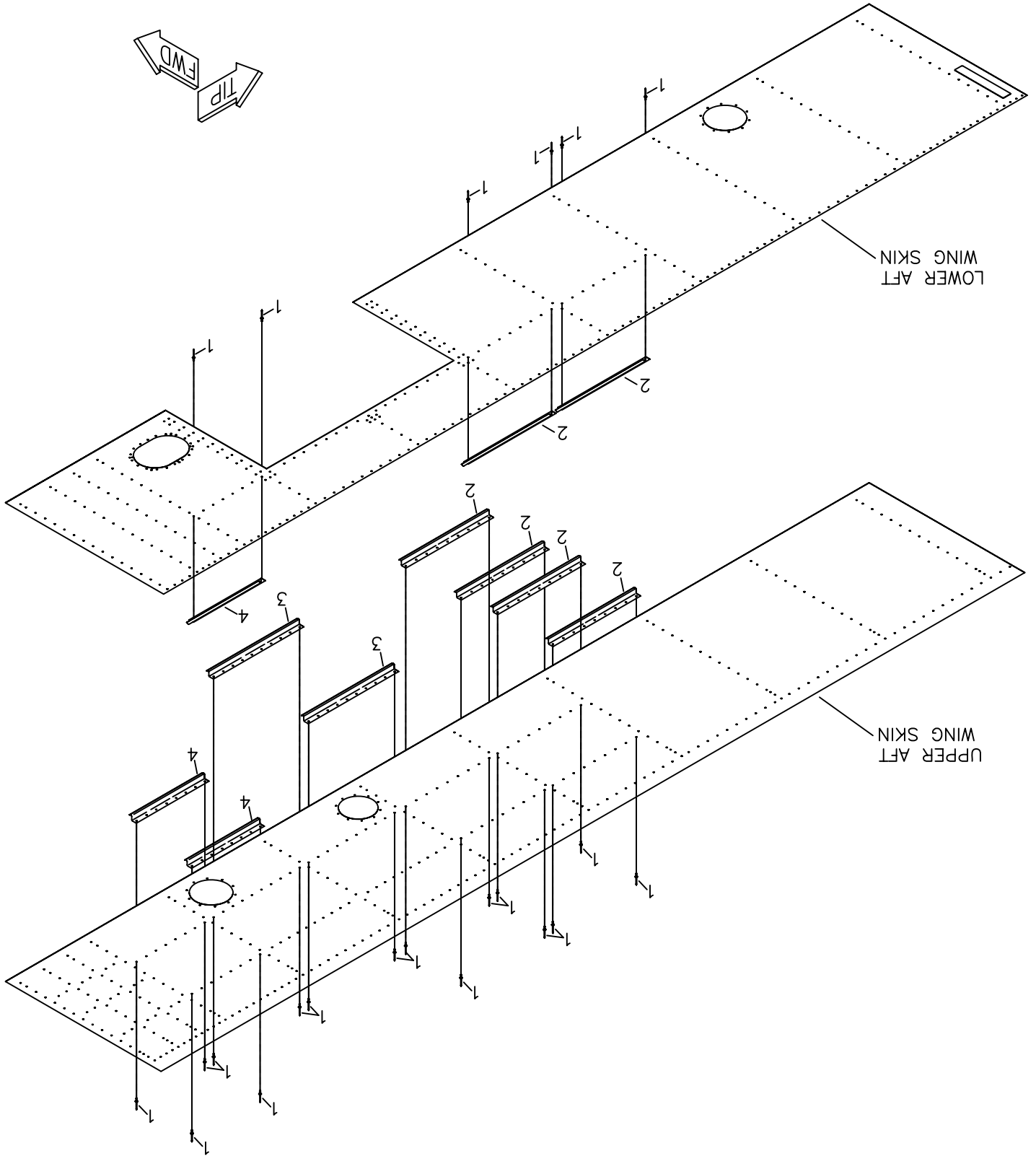
MD4773

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	3/16" Bolt	AN3-3A	4
2.	3/8" Cushioned Clamp	MS21919-WDG6	4
3.	Fuel Line Mount Bracket	KPFS0054	2
4.	3/16" Thick Washer	AN960-10	4
5.	3/16" Shear Nut	AN364-1032A	4
6.	1/8" Aluminum Rivet - Cherry Q	AAPQ-43	4
7.	1/8" Aluminum Rivet - Cherry Q	AAPQ-42	4
8.	Fuel Line Mount Bracket	KPFS0055	2
9.	Fuel Line	KPFS0056	2
10.	Straight Fitting	AN816-6D	2
11.	Thread Sealant*	-----	0
12.	Hose Clamp - 7/8"	5-6203	2

* Builder Supplied.

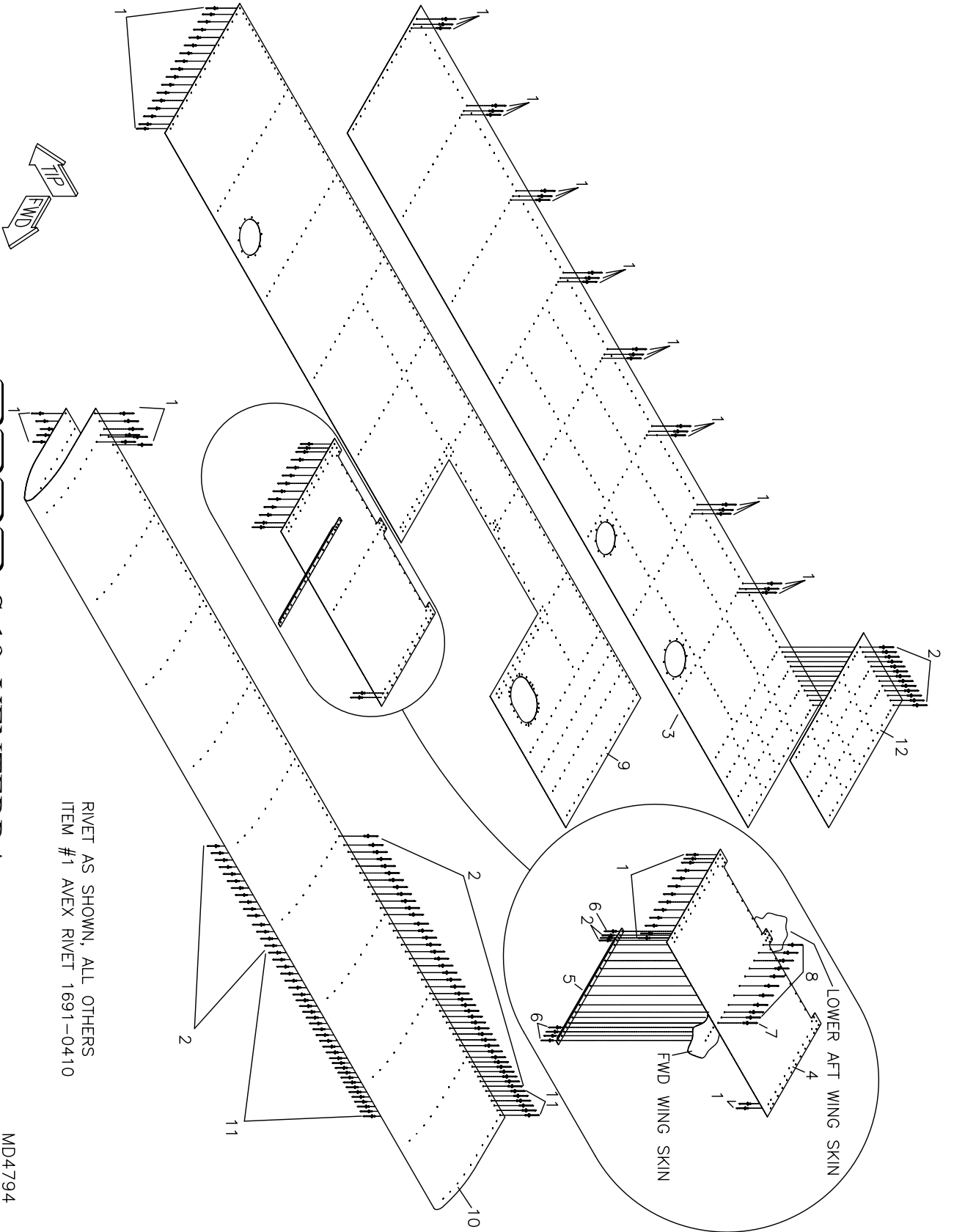
RRMS S-19 VENTURA WING SKIN STIFFENER INSTALLATION

MD4780



#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1/8" Aluminum Rivet - Avex	1691-0410	196
2.	Skin Stiffener Outer *	KPW10440	3
3.	Skin Stiffener - Tank Bay *	KPW10452	2
4.	Skin Stiffener - Inner *	KPW10439	2

* Builder modifies.

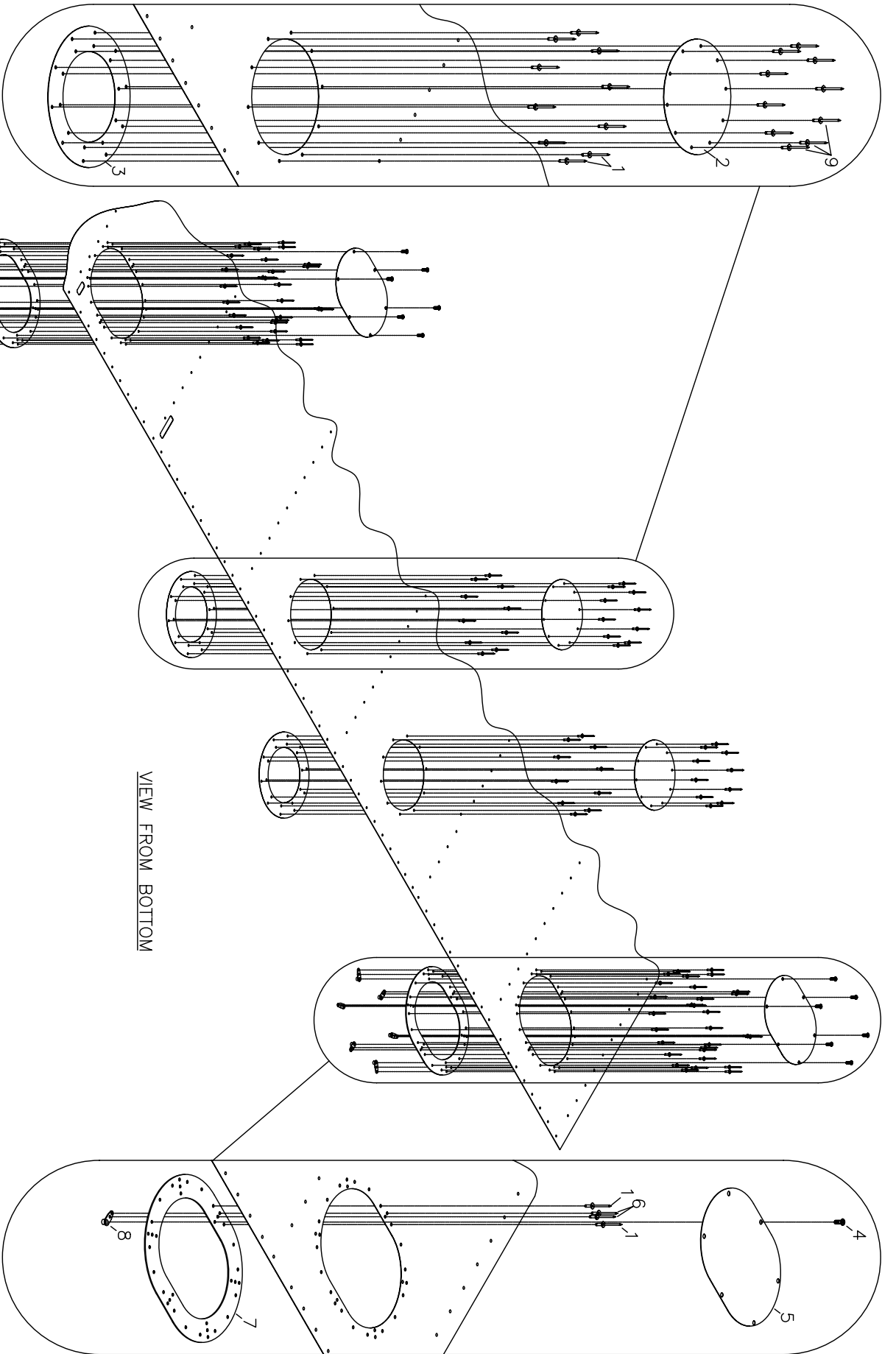


RIVET AS SHOWN, ALL OTHERS
 ITEM #1 AVEX RIVET 1691-0410

S-19 VENTERRA
WING SKIN INSTALLATION

MD4794

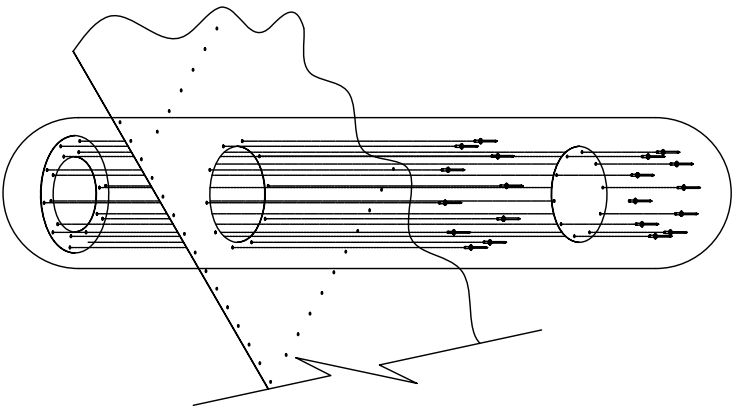
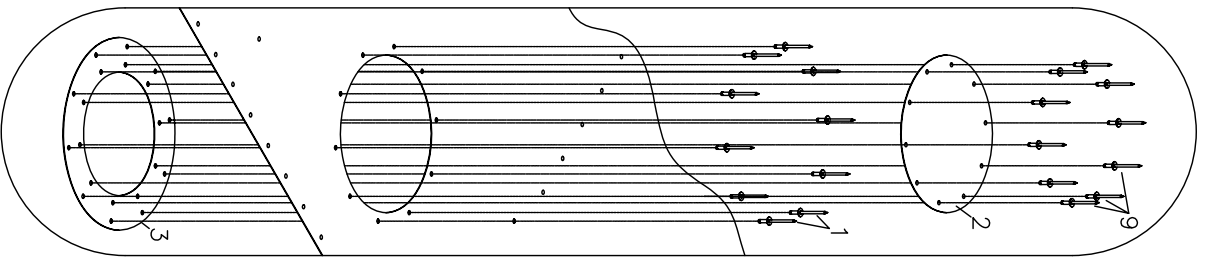
#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1/8" Aluminum Rivet - Avex	1691-0410	2250
2.	1/8" Aluminum Rivet - Cherry Q	AAPQ-43	377
3.	Upper Aft Wing Skin	KPWI0446	2
4.	Skin Panel FWD Tank	KPWI0451	2
5.	Torque Angle	KPWI0453	2
6.	1/8" Aluminum Rivet - Cherry Q	AAPQ-42	10
7.	1/8" Aluminum Rivet - Cherry Q	AAPQ-44	2
8.	1/8" Aluminum Rivet - Cherry Q	AAPQ-41	18
9.	Lower AFT Wing Skin	KPWI0450	2
10.	FWD Wing Skin - RH	KPWI0445-R	1
10.	FWD Wing Skin - LH	KPWI0445-L	1
11.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-43	72
12.	Foot Step Plate	KPWI0447	2



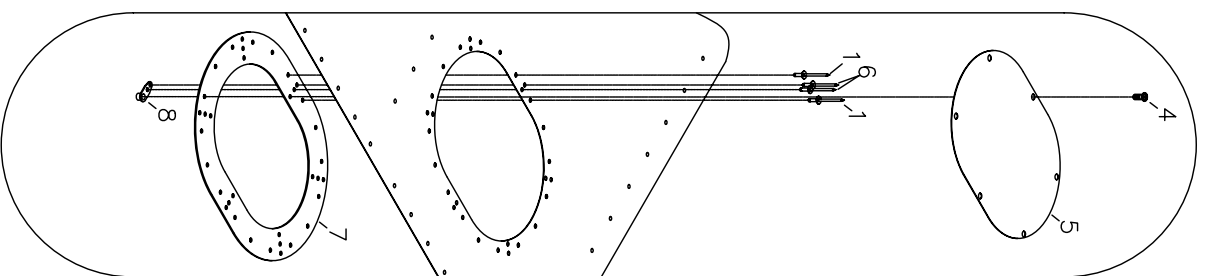
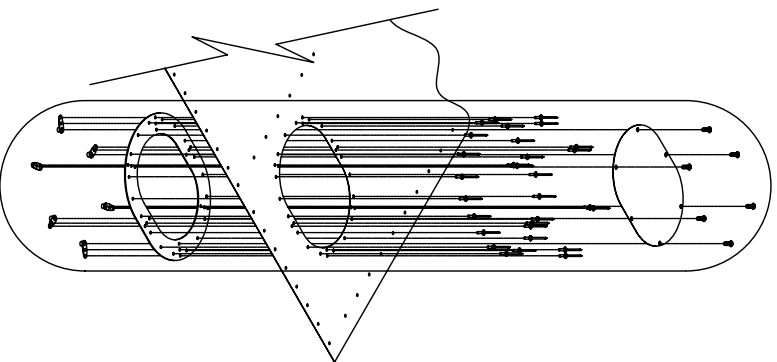
RRRMD08 S-19 VENTERRA
FWD SKIN REINFORCEMENT RING INSTALLATION

MD4779

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1/8" Aluminum Rivet - Cherry Q	AAPQ-41	132
2.	Access Panel - Cover Plate	KPAC0196	4
3.	Access Panel - Ring	KPAC0195	4
4.	#8 Trusshead Screw	AN526-832R6	24
5.	Access Panel - Cover Plate	KPAC0114	4
6.	3/32" Aluminum Rivet	40APR1/8	48
7.	Access Panel - Ring	KPAC0194	4
8.	#8 Single-Ear Nut Plate	MS21051-08	24
9.	1/8" Aluminum Rivet - Avex	1691-0410	20



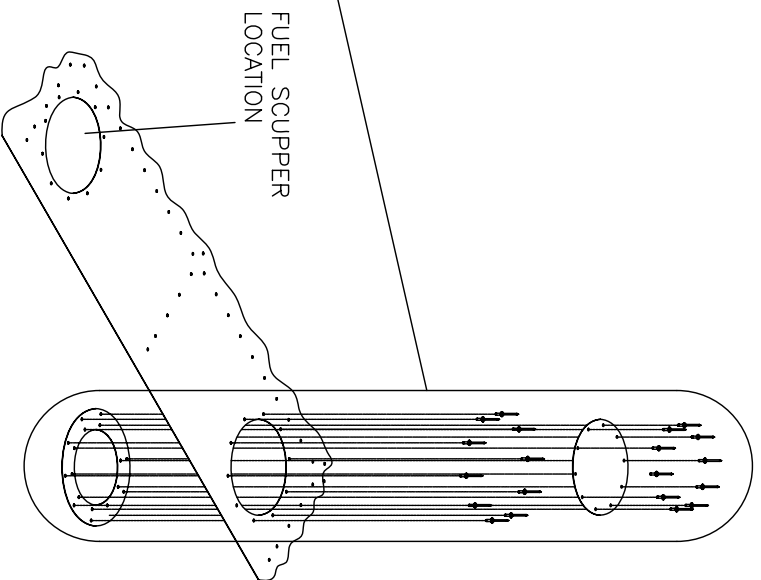
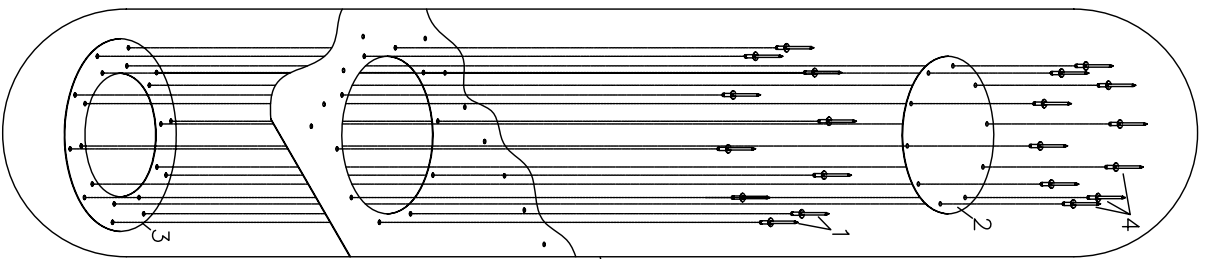
VIEWED FROM BOTTOM



REINFORCE S-19 VENTERRA
 LOWER AFT SKIN REINFORCEMENT RING INSTALLATION

MD4779

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1/8" Aluminum Rivet - Cherry Q	AAPQ-41	56
2.	Access Panel - Cover Plate	KPAC0196	2
3.	Access Panel - Ring	KPAC0195	2
4.	#8 Trusshead Screw	AN526-832R6	12
5.	Access Panel - Cover Plate	KPAC0114	2
6.	3/32" Aluminum Rivet	40APR1/8	24
7.	Access Panel - Ring	KPAC0194	2
8.	#8 Single-Ear Nut Plate	MS21051-08	12
9.	1/8" Aluminum Rivet - Avex	1691-0410	20



VIEWED FROM TOP



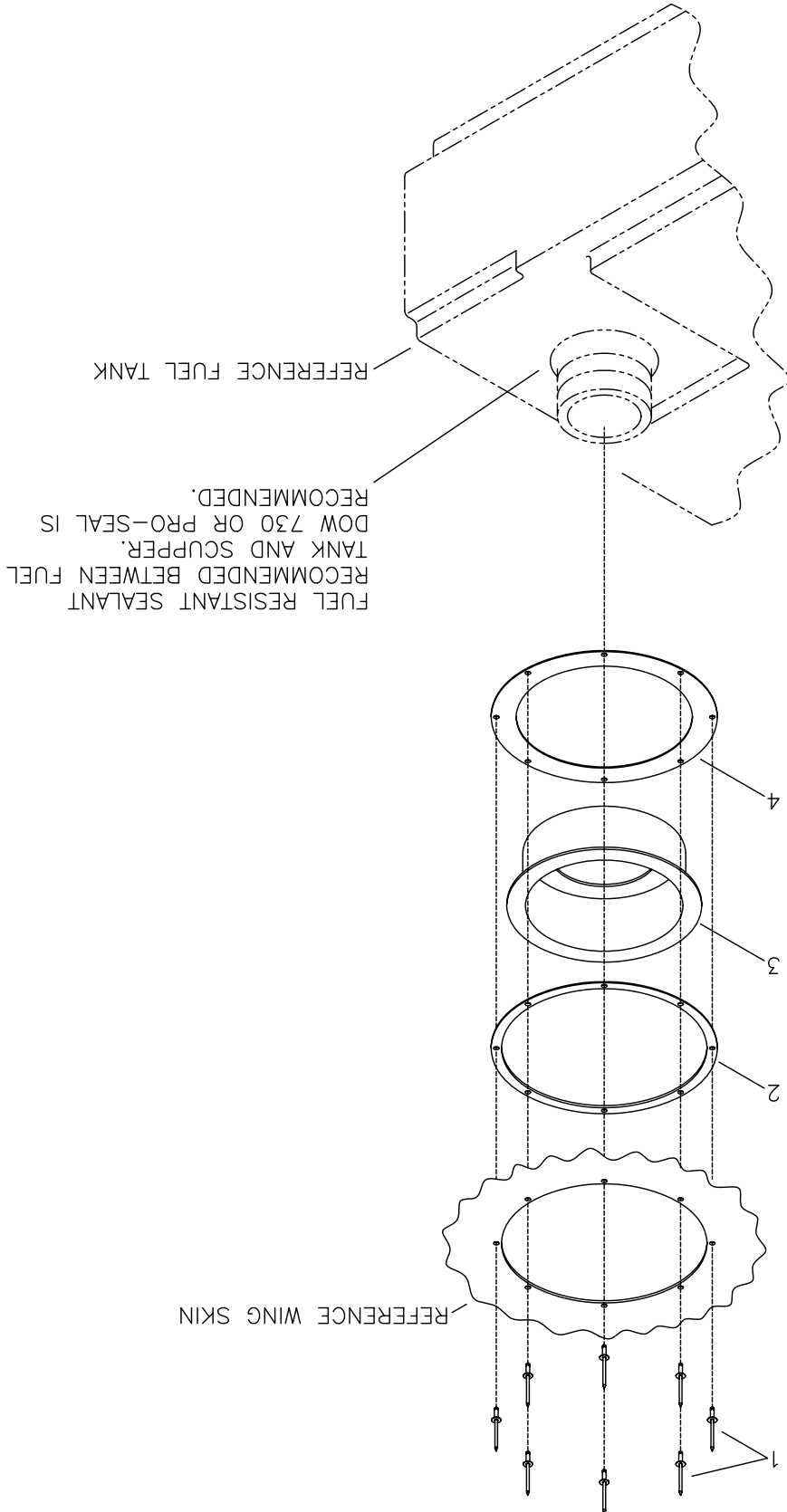
RRPDR S-19 VENTERRA
UPPER AFT SKIN REINFORCEMENT RING INSTALLATION

MD5539

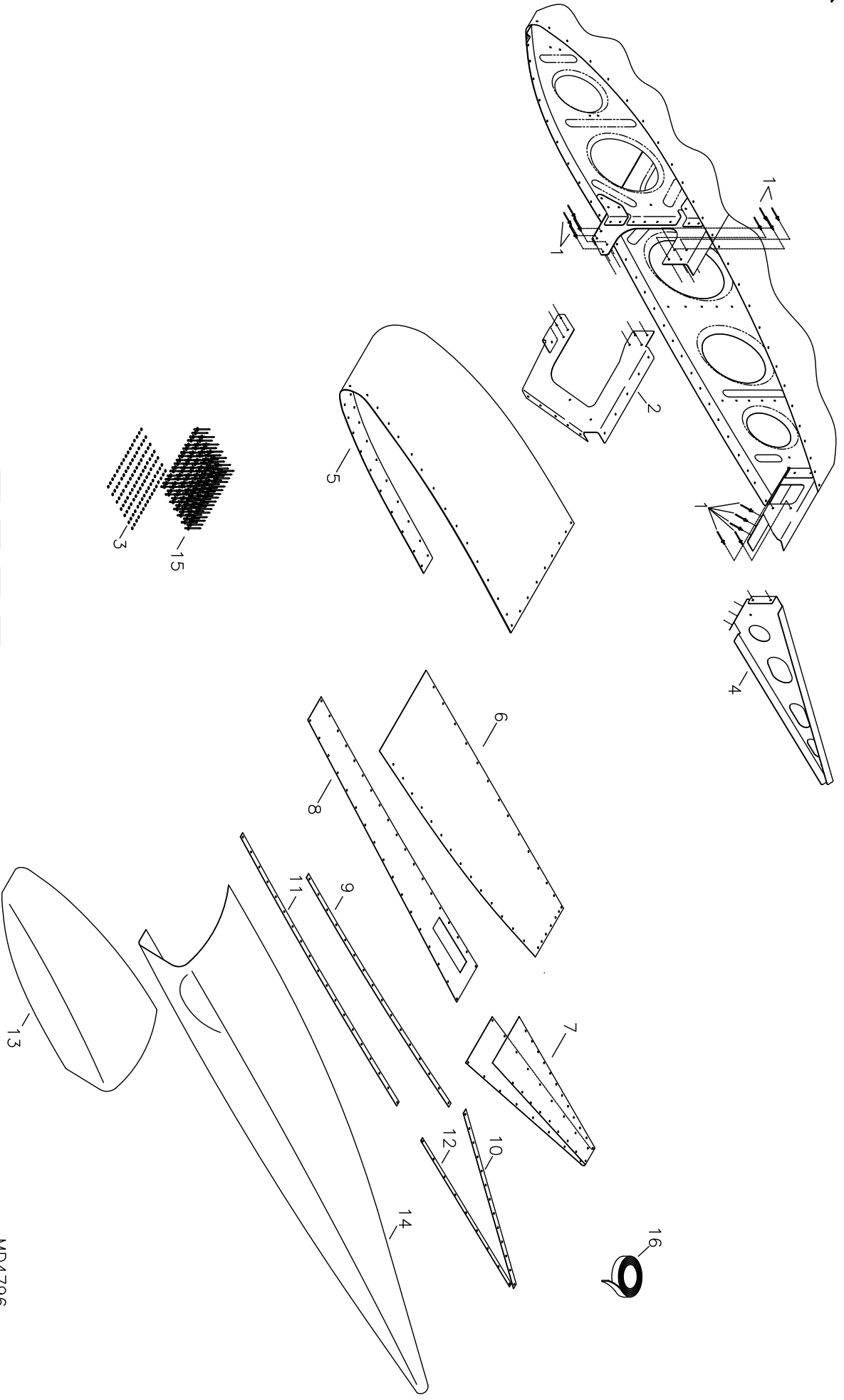
#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1/8" Aluminum Rivet - Cherry Q	AAPQ-41	20
2.	Access Panel - Cover Plate	KPAC0196	2
3.	Access Panel - Ring	KPAC0195	2
4.	1/8" Aluminum Rivet - Avex	1691-0410	20

RANDS S-19 VENTURA FUEL SCUPPER INSTALLATION

MD4774



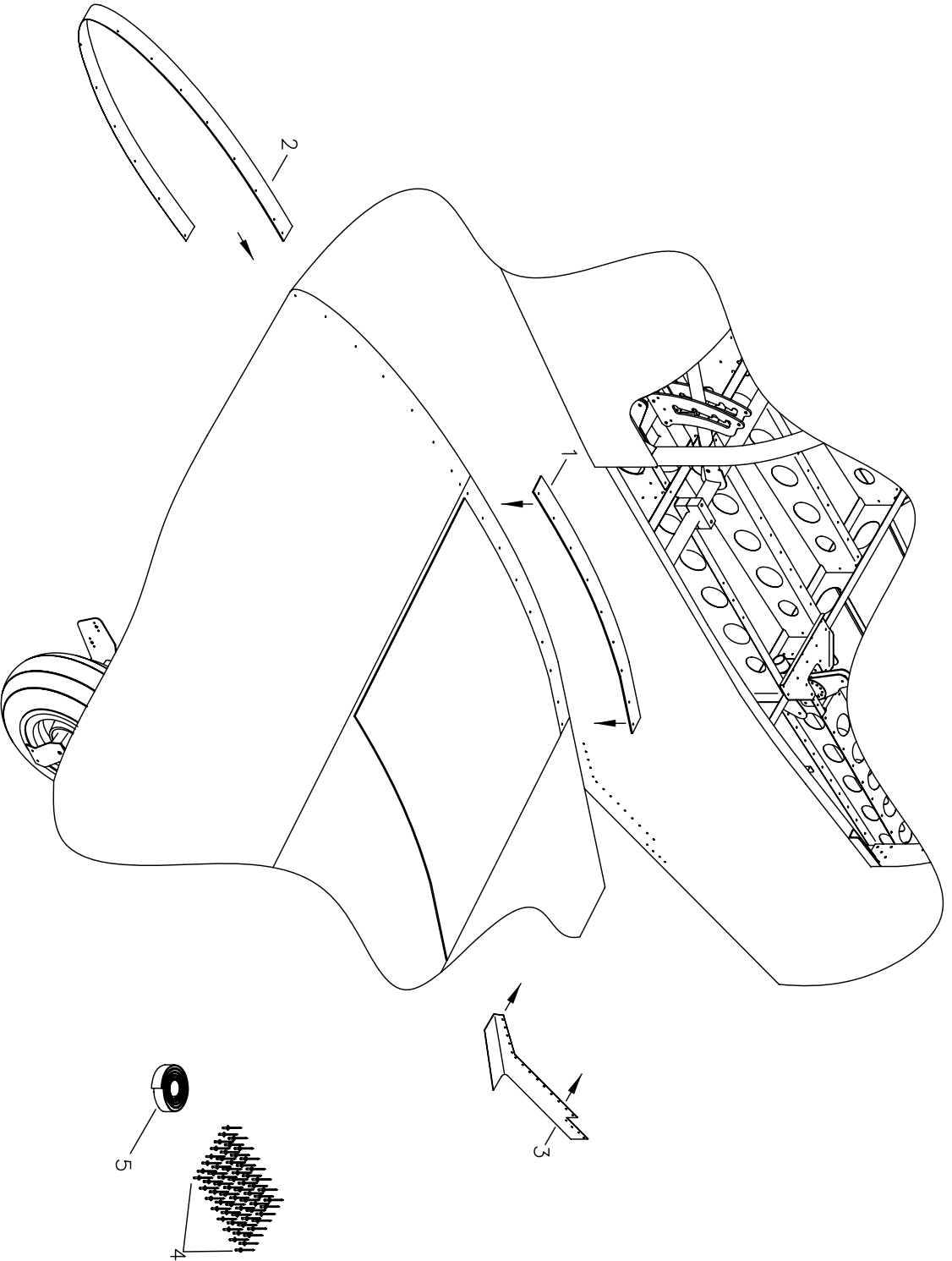
#	DESCRIPTION	PART NUMBER	QUANTITY
1.	3/32" Aluminum Rivet	40APR1/4	16
2.	Fuel Scupper - Spacer	KPFS0076	2
3.	Fuel Scupper	KPFS0074	2
4.	Fuel Scupper - Retainer Ring	KPFS0075	2



**REPAIR S-19 VENTERRA
WING TIP INSTALLATION**

MD4796

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1/8" Aluminum Rivet - Cherry Q	AAPQ-41	30
2.	Wing Tip Stiffener - LH	KPWI0463-L	1
2.	Wing Tip Stiffener - RH	KPWI0463-R	1
3.	1/8" Small Brass Washer	AN960-B4	52
4.	Rib Tip - LH	KPWI0464-L	1
4.	Rib Tip - RH	KPWI0464-R	1
5.	FWD Skin - Tip	KPWI0457	2
6.	Upper Rear Skin - Tip	KPWI0456	2
7.	Closeout Skin - Tip - LH	KPWI0458-L	1
7.	Closeout Skin - Tip - RH	KPWI0458-R	1
8.	Lower Rear Skin - Tip	KPWI0455	2
9.	Wing Tip Stiffener Strip	KPWI0475-1	2
10.	Wing Tip Stiffener Strip	KPWI0475-3	2
11.	Wing Tip Stiffener Strip	KPWI0475-4	2
12.	Wing Tip Stiffener Strip	KPWI0475-2	2
13.	Wing Tip - FWD - LH	KPWI0476-L	1
13.	Wing Tip - FWD - RH	KPWI0476-R	1
14.	Wing Tip - AFT - LH	KPWI0477-L	1
14.	Wing Tip - AFT - RH	KPWI0477-R	1
15.	1/8" Aluminum Rivet - Avex	1691-0410	400
16.	Double Stick Tape	2W-TAPE	12 ft.



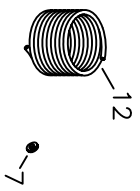
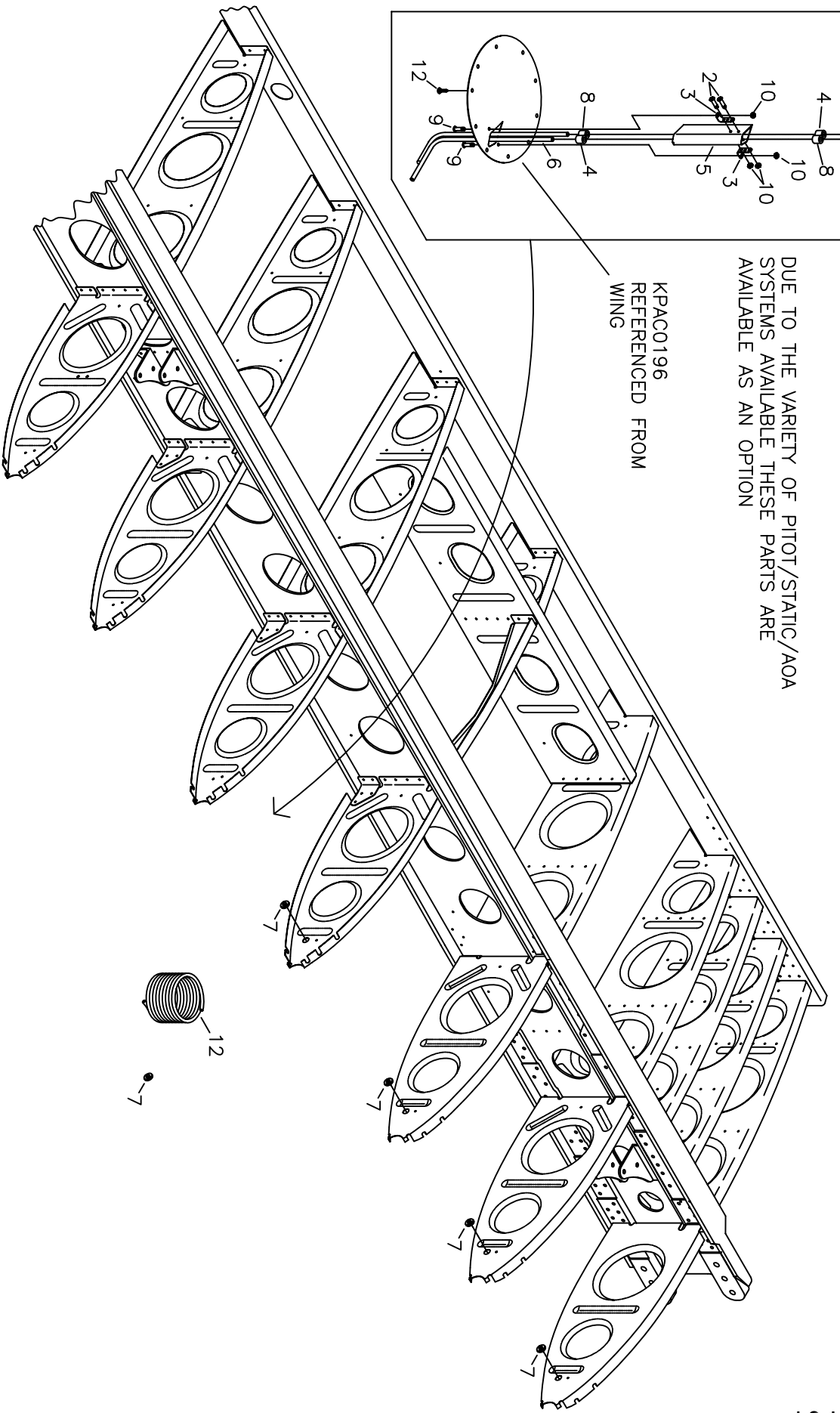
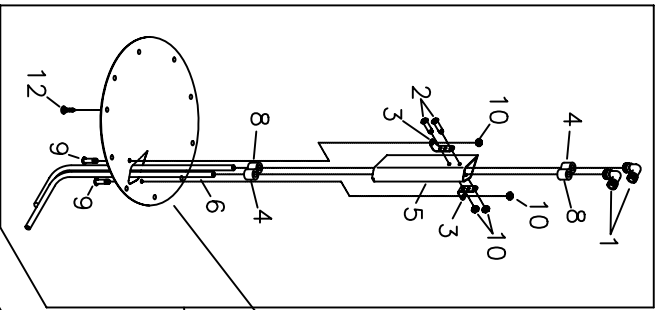
**RFDN S-19 VENTERRA
GAP FILLETS INSTALLATION**

MDS134

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	AFT Wing Fillet	KPWI0512	2
2.	FWD Wing Fillet	KPWI0511	2
3.	Flap Fillet - RH	KPFU0480-R	1
3.	Flap Fillet - LH	KPFU0480-L	1
4.	1/8" Aluminum Rivet - Avex	1691-0410	82
5.	Edge Trim	X1011	124 in.

DUE TO THE VARIETY OF PITOT/STATIC/AOA SYSTEMS AVAILABLE THESE PARTS ARE AVAILABLE AS AN OPTION

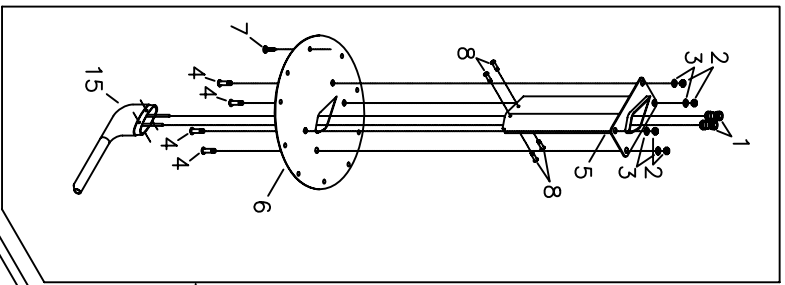
KPAC0196 REFERENCED FROM WING



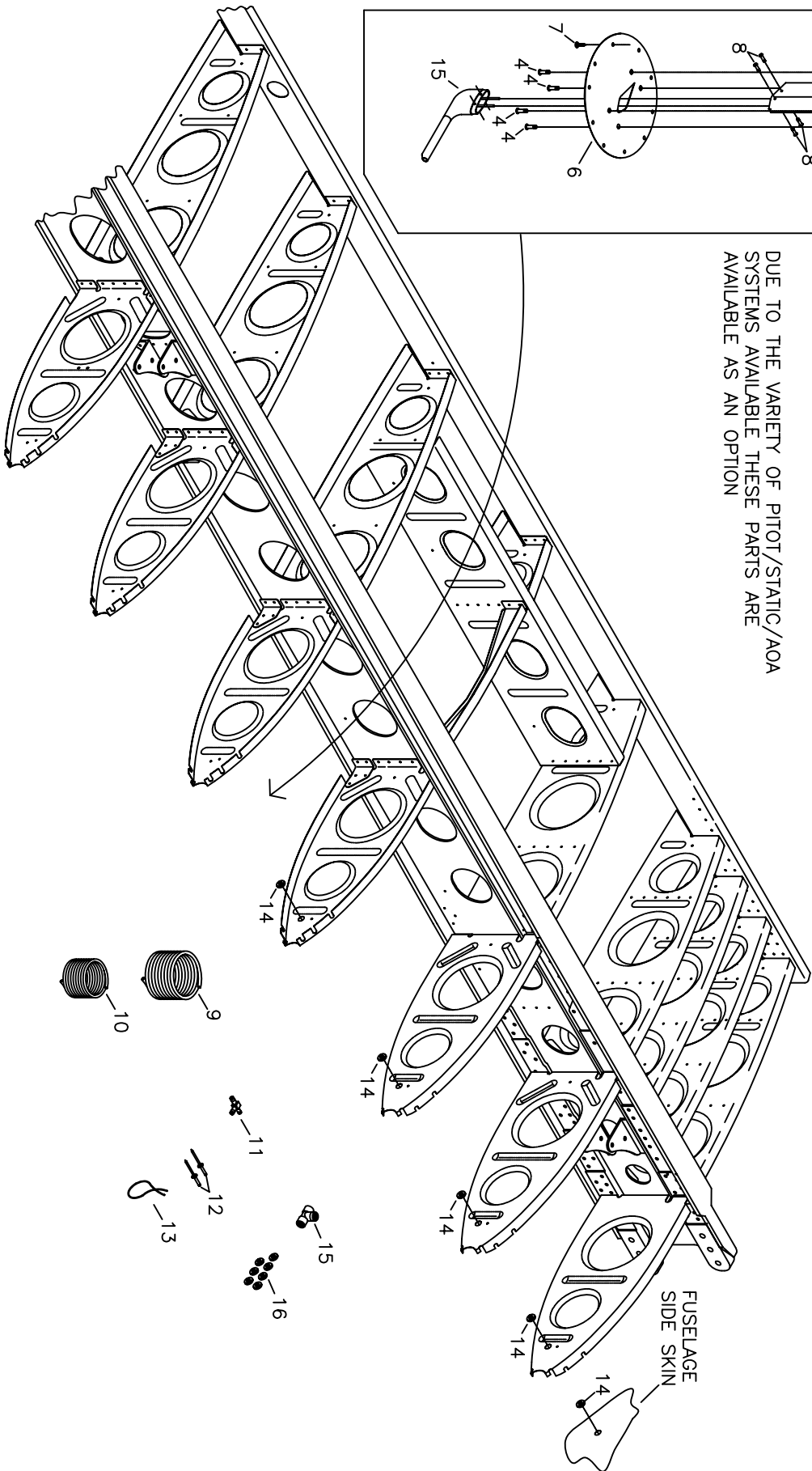
FRONTS S-19 VENTERRA OPTIONAL WING PITOT/STATIC INSTALLATION

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	Union Elbow	KSPT0005	2
2.	#8 Trusshead Screw	AN526-832R16	2
3.	Mount Bracket	KPAC0004	2
4.	1/4" Fuel Line *	KSFS0002	2 in.
5.	Pitot / Static Line Fairing	KPPT0011	1
6.	Pitot/Static Assembly	KPPT0005	1
7.	7/8" Rubber Grommet	MS35489-17	5
8.	1/4" Blue Line *	FS-FL	2 in.
9.	#8 Trusshead Screw	AN526-832R6	2
10.	8-32 Shear Nut	AN364-832A	4
11.	Pitot/Static Tubing	KSPT0004	24 ft.
12.	#6 Pan Head Screw	6RX1/2 PHS	10

* Builder modifies.



DUE TO THE VARIETY OF PITOT/STATIC/AOA SYSTEMS AVAILABLE THESE PARTS ARE AVAILABLE AS AN OPTION



RRRINDOS S-19 VENTERRA
OPTIONAL DYNON PITOT/STATIC INSTALLATION

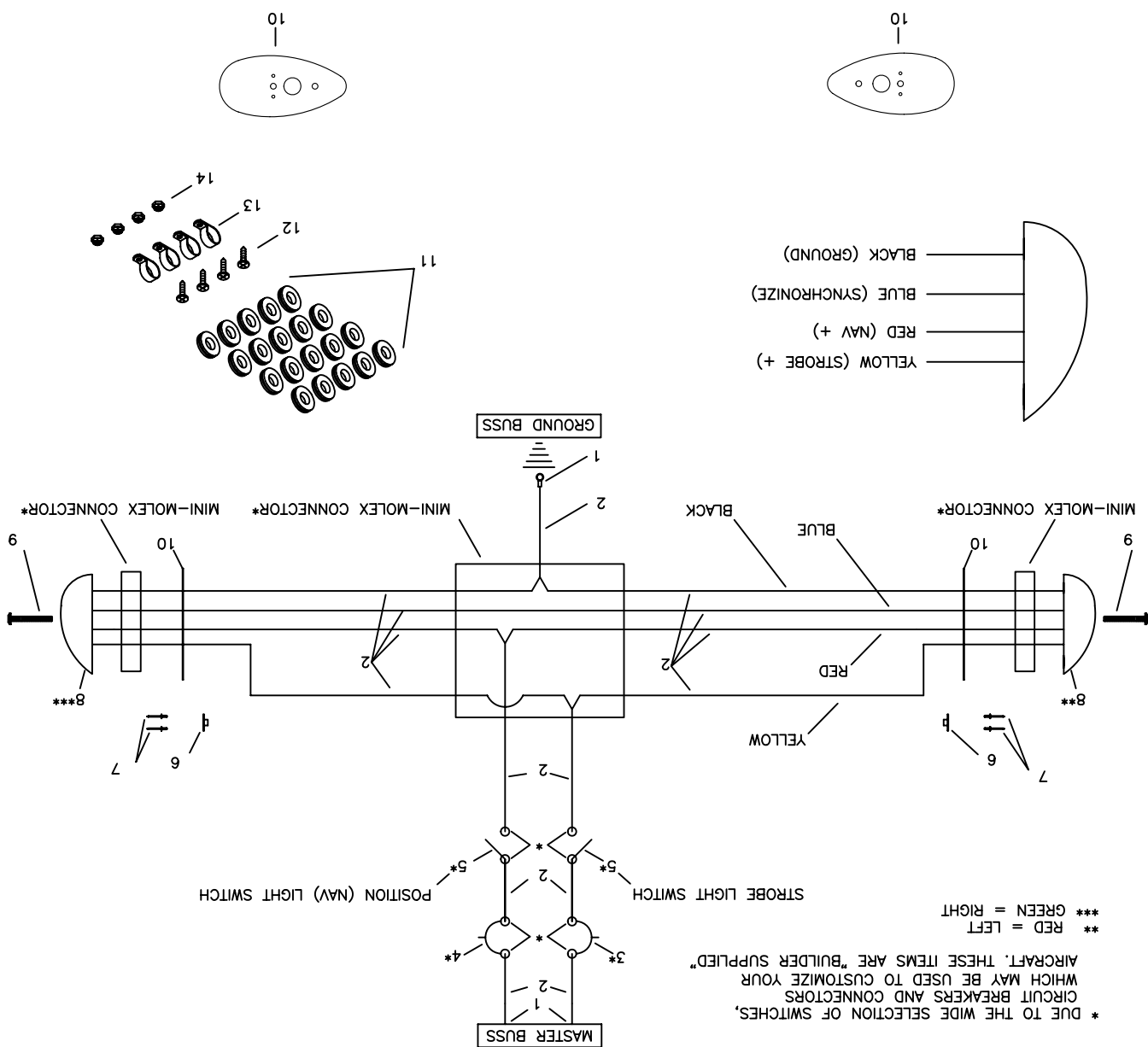
MD5517

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	Reducer Coupling - 1/4" x 3/16"	KSPT0007	2
2.	8-32 Shear Nut	AN364-832A	4
3.	#8 Brass Washer	AN960-B8	4
4.	#8 Trusshead Screw	AN526-832R6	4
5.	Dynon Probe Mount	KPAC0231	1
6.	Access Panel Cover Plate - Dynon Probe	KPAC0230	1
7.	#6 Pan Head Screw	6RX1/2 PHS	10
8.	#8 Pan Head Machine Screw	MS35206-242	4
9.	Pitot/Static Tubing	KSPT0004	24 ft
10.	1/8" Primer Line	PRIMER LINE	20 ft
11.	1/8" Tee	3-71320	1
12.	1/8" Aluminum Rivet - Cherry Q	AAPQ-48	2
13.	Safety Wire *	-----	0
14.	7/8" Rubber Grommet	MS35489-17	5
15.	Dynon Pitot Head *	-----	0
16.	Union Tee	KSPT0003	1
17.	1/4" Rubber Grommet	MS35489-6	7

* Builder Supplied

RRMS S-19 OPTIONAL AVEO STROBE INSTALLATION

MD4787



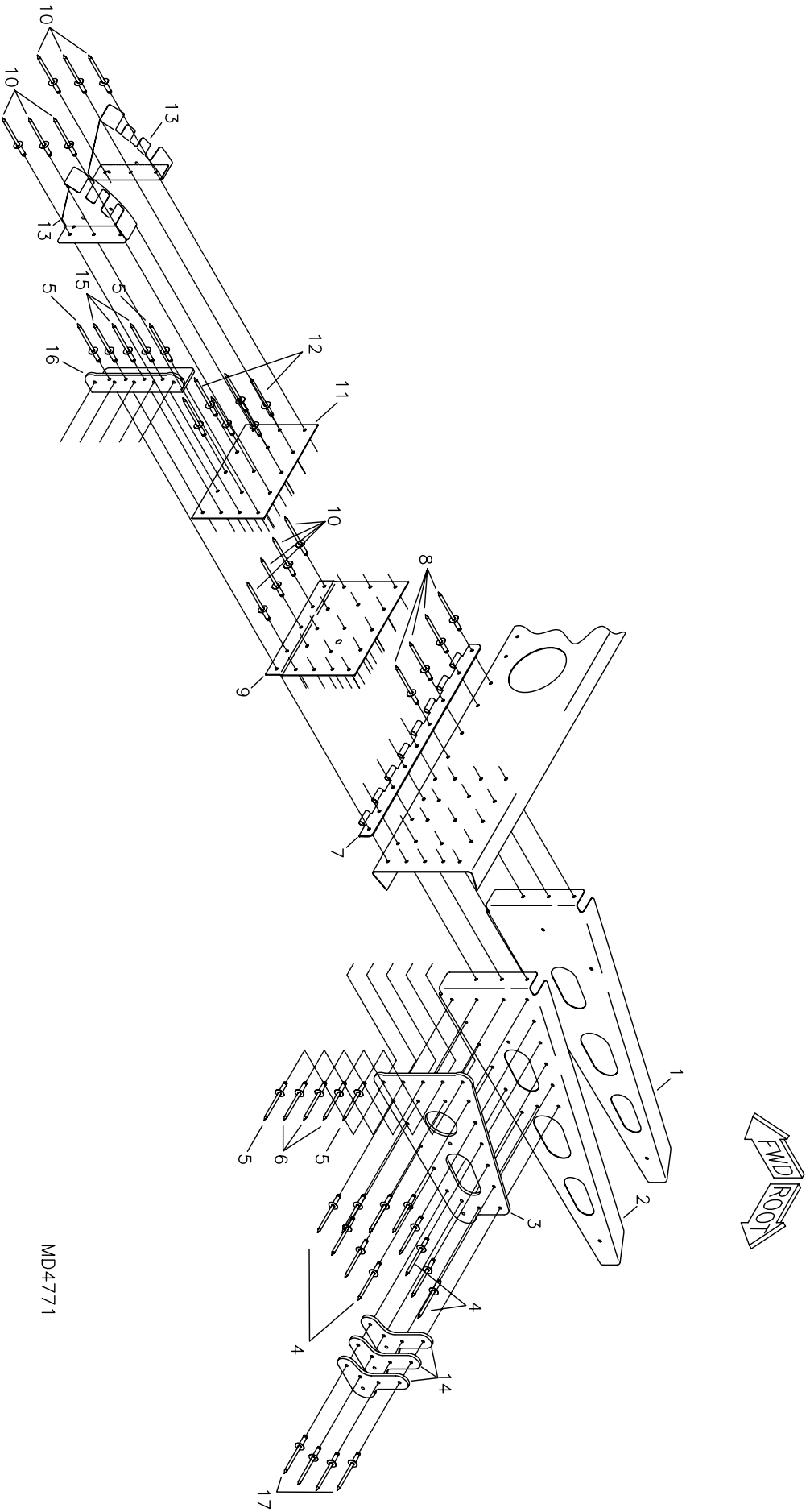
#	DESCRIPTION	PART NUMBER	QUANTITY
1.	14 Gauge Eye Terminal, Blue, 5/32" *	KSES0003	0
2.	4-Wire Bundle - 18 Gauge Wire * **	KSES0060	0 ft.
3.	Circuit Breaker - 5 Amp *	-----	0
4.	Circuit Breaker - 1 Amp *	-----	0
5.	Switch *	-----	0
6.	3/16" Nut Plate	K-1000-3	2
7.	3/32" Aluminum Rivet	40APR1/8	4
8.	Strobe Light Set - AVEO	KSES0059	1 set
9.	3/16" Countersunk Machine Screw	KSHW0088	2
10.	Strobe Light Mount - AVEO	KPWI0541	2
11.	5/8" Rubber Grommet	MS35489-11	22
12.	#8 Trusshead Screw	AN526-832R6	4
13.	Clamp	KSAC0053	4
14.	8-32 Shear Nut	AN364-832A	4

* Builder Supplied

** 4 separate 18 gauge wires may also be used

04 – FLAP AND AILERON ASSEMBLY

FLAP ASSEMBLY (INBOARD)	04-01 - 04-02
FLAP ASSEMBLY (OUTBOARD)	04-03 - 04-04
FLAP SKIN INSTALLATION	04-05 - 04-06
AILERON ASSEMBLY - CENTER	04A-01 - 04A-02
AILERON ASSEMBLY - OUTBOARD	04A-03 - 04A-04
AILERON ASSEMBLY - INBOARD	04A-05 - 04A-06
AILERON ASSEMBLY - SKIN & MASS BALANCE INSTALLATION	04A-07 - 04A-08

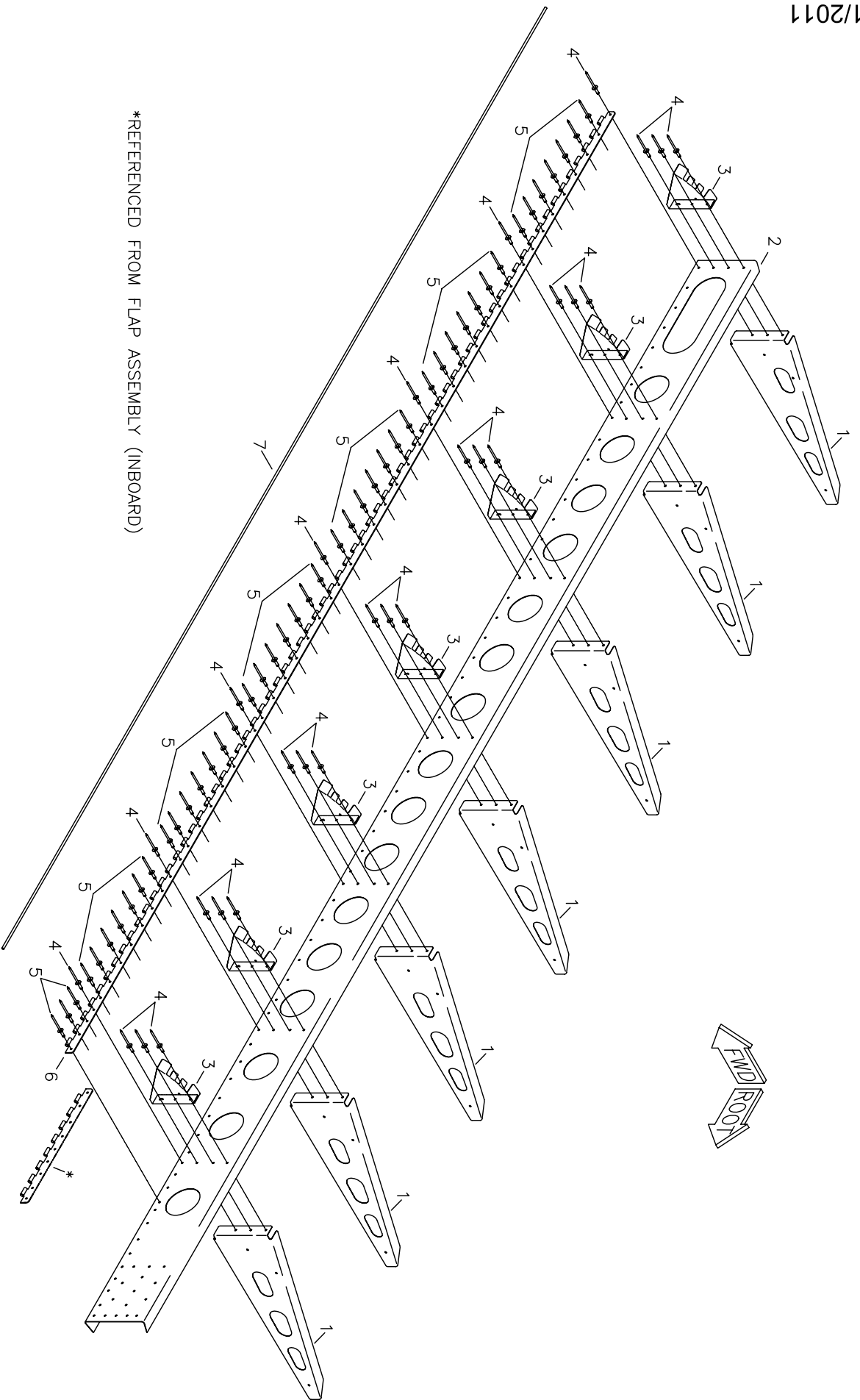


**RRRNDG S-19 VENTERRA
FLAP ASSEMBLY (INBOARD)**

MD4771

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	Rib Aileron/Flap - RH	KPAL0086-R	1
1.	Rib Aileron/Flap - LH	KPAL0086-L	1
2.	Root Rib - Flap - LH	KPFL0117-L	1
2.	Root Rib - Flap - RH	KPFL0117-R	1
3.	Flap Horn Plate	KPFL0113	2
4.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-43	20
5.	3/16" Stainless Steel Rivet - Cherry Q	CCPQ-64	8
6.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-44	6
7.	1-1/4" x .040 Hinge *	MS20257-3	0
8.	1/8" Aluminum Rivet - Avex	1691-0410	8
9.	Plate Spar Reinforcement *	KPFL0115	1
10.	1/8" Aluminum Rivet - Cherry Q	AAPQ-43	20
11.	Plate Spar Reinforcement	KPFL0114	2
12.	1/8" Aluminum Rivet - Cherry Q	AAPQ-42	12
13.	Nose Rib - LH	KPFL0099-L	2
13.	Nose Rib - RH	KPFL0099-R	2
14.	Doubler Plate	KPFL0121	6
15.	1/8" Stainless Steel Rivet - Cherry Q	CCPQ-45	6
16.	Flap Horn Angle - LH	KPFL0119-L	1
16.	Flap Horn Angle - RH	KPFL0119-R	1
17.	3/16" Steel Rivet	SSPQ-610	8

* Builder modifies.



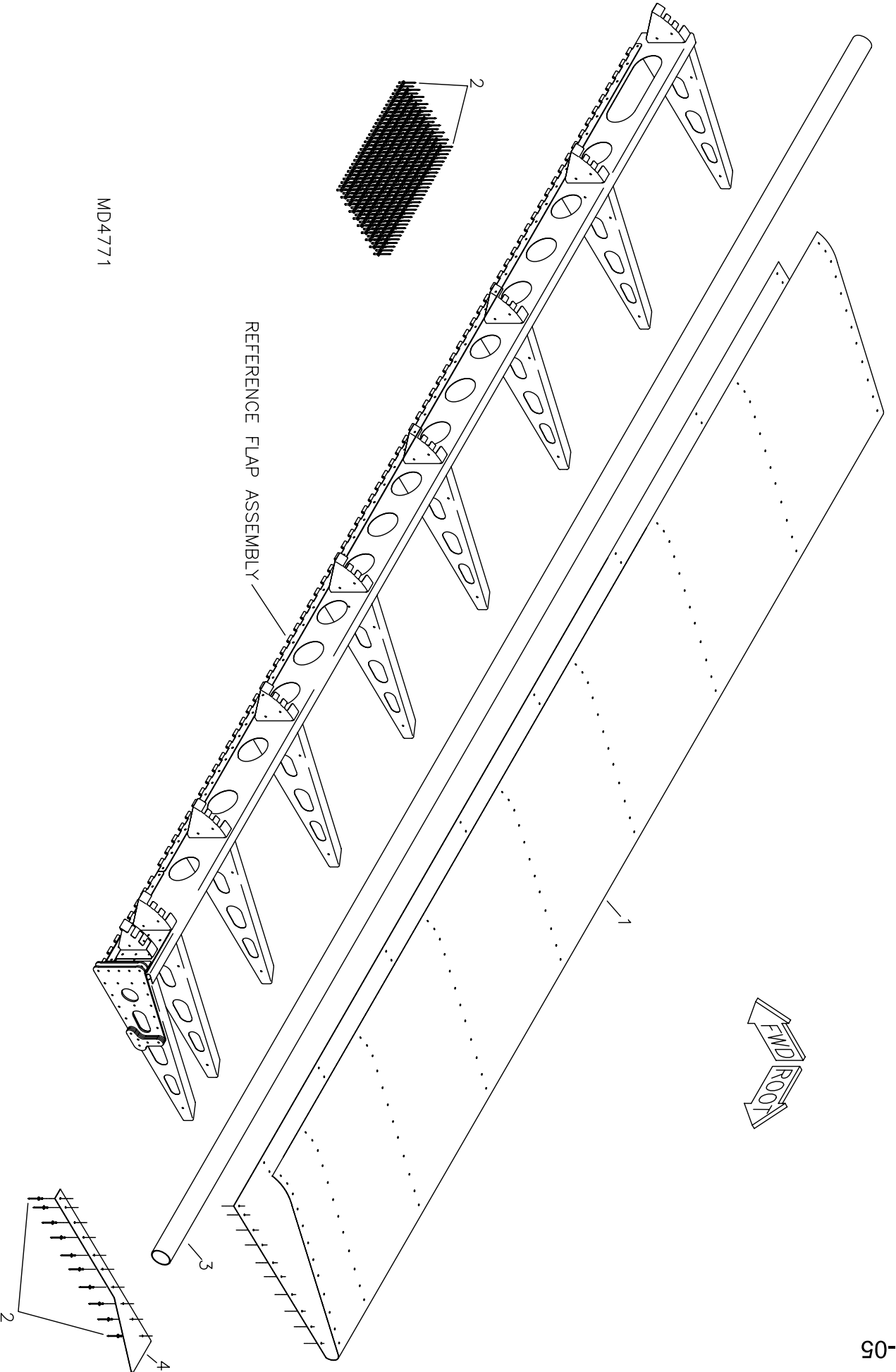
*REFERENCED FROM FLAP ASSEMBLY (INBOARD)

MD4771

**RRRMD088 S-19 VENTERRA
FLAP ASSEMBLY (OUTBOARD)**

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	Rib Aileron/Flap - RH	KPAL0086-R	7
1.	Rib Aileron/Flap - LH	KPAL0086-L	7
2.	Flap Spar - RH	KPFL0116-R	1
2.	Flap Spar - LH	KPFL0116-L	1
3.	Nose Rib - RH	KPFL0099-R	7
3.	Nose Rib - LH	KPFL0099-L	7
4.	1/8" Aluminum Rivet - Cherry Q	AAPQ-42	56
5.	1/8" Aluminum Rivet - Avex	1691-0410	90
6.	1-1/4" x .040 Hinge *	MS20257-3	2
7.	Flap Hinge Pin *	KSFL0001	1

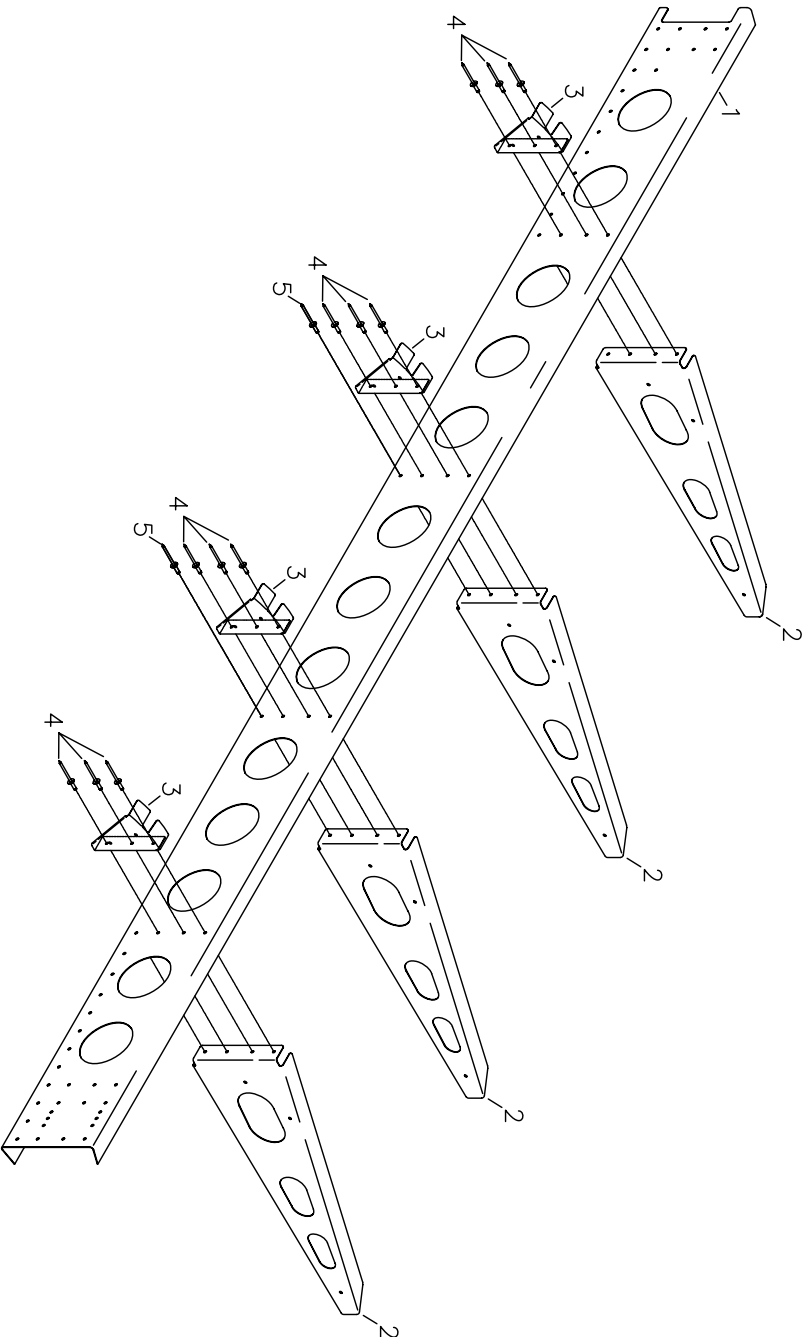
* Builder modifies.



RRR S-19 VENTERRA
 FLAP SKIN INSTALLATION

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	Flap Skin - RH	KPFL0118-R	1
1.	Flap Skin - LH	KPFL0118-L	1
2.	1/8" Aluminum Rivet - Avex	1691-0410	730
3.	1-1/2" x 95" Tubing *	-----	0
4.	Flap Fillet - Lower - RH	KPFU0619-R	1
4.	Flap Fillet - Lower - LH	KPFU0619-L	1

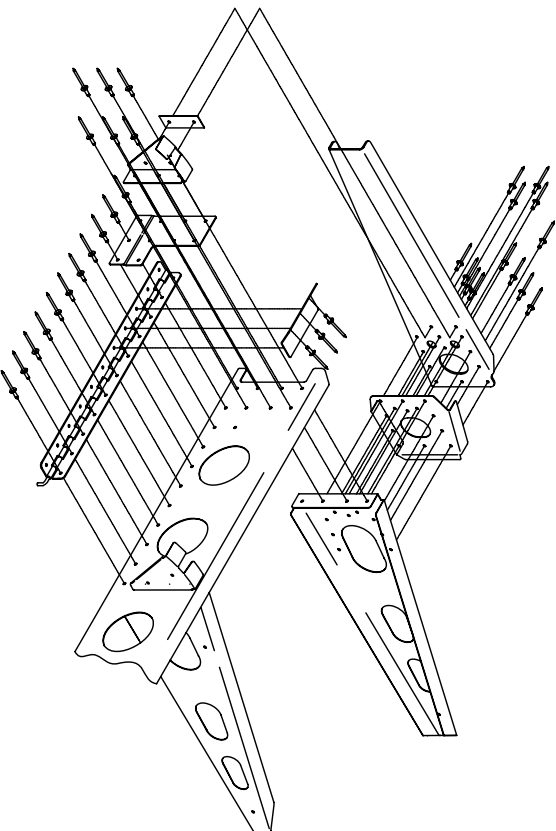
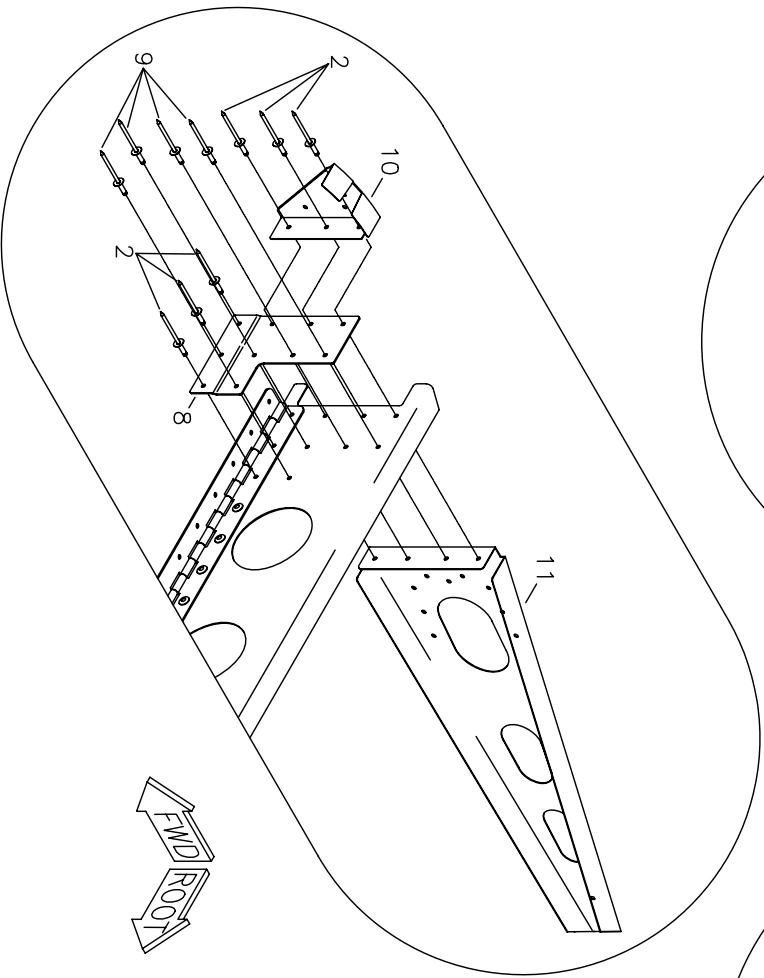
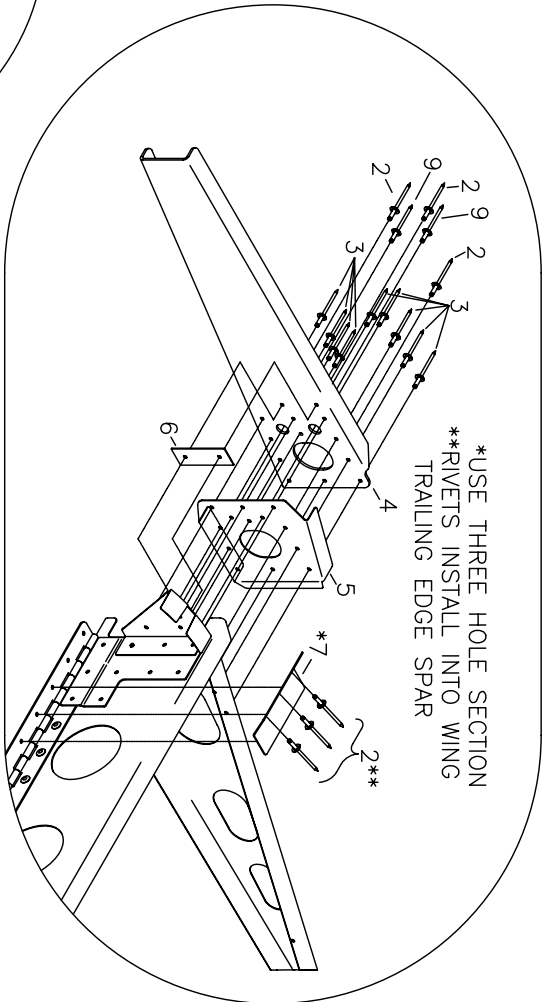
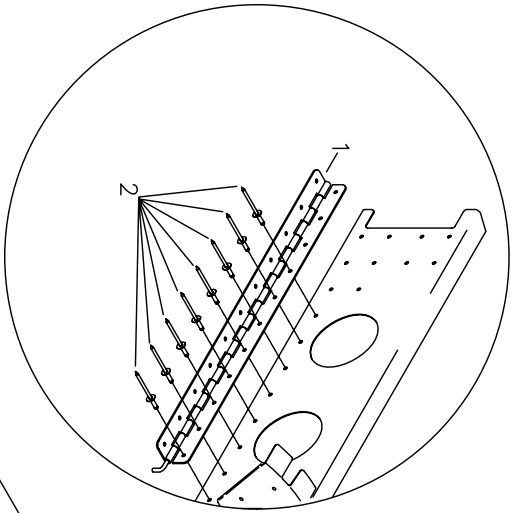
* Builder Supplied



RRRNDG S-19 VENTERRA
AILERON ASSEMBLY - CENTER

MD4768

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	Aileron Spar - LH	KPAL0087-L	1
1.	Aileron Spar - RH	KPAL0087-R	1
2.	Rib Aileron/Flap - LH	KPAL0086-L	4
2.	Rib Aileron/Flap - RH	KPAL0086-R	4
3.	Nose Rib - Aileron - RH	KPAL0073-R	4
3.	Nose Rib - Aileron - LH	KPAL0073-L	4
4.	1/8" Aluminum Rivet - Cherry Q	AAPQ-42	24
5.	1/8" Aluminum Rivet - Cherry Q	AAPQ-41	4



**RRRMD08 S-19 VENTERRA
AILERON ASSEMBLY - OUTBOARD**

MD4768

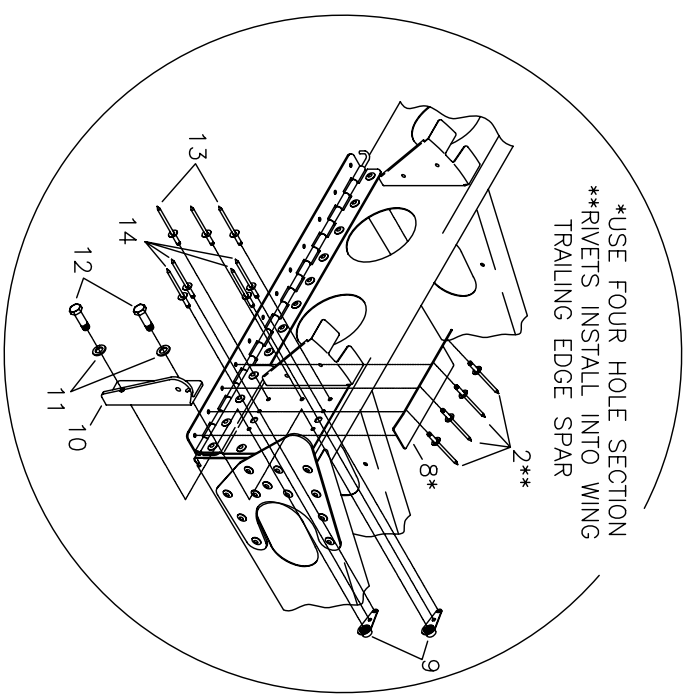
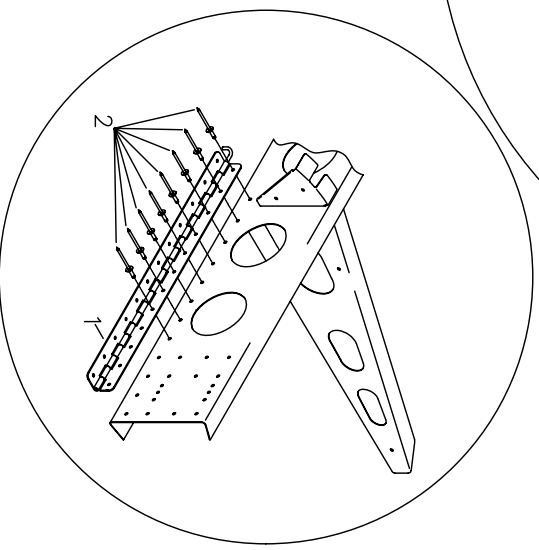
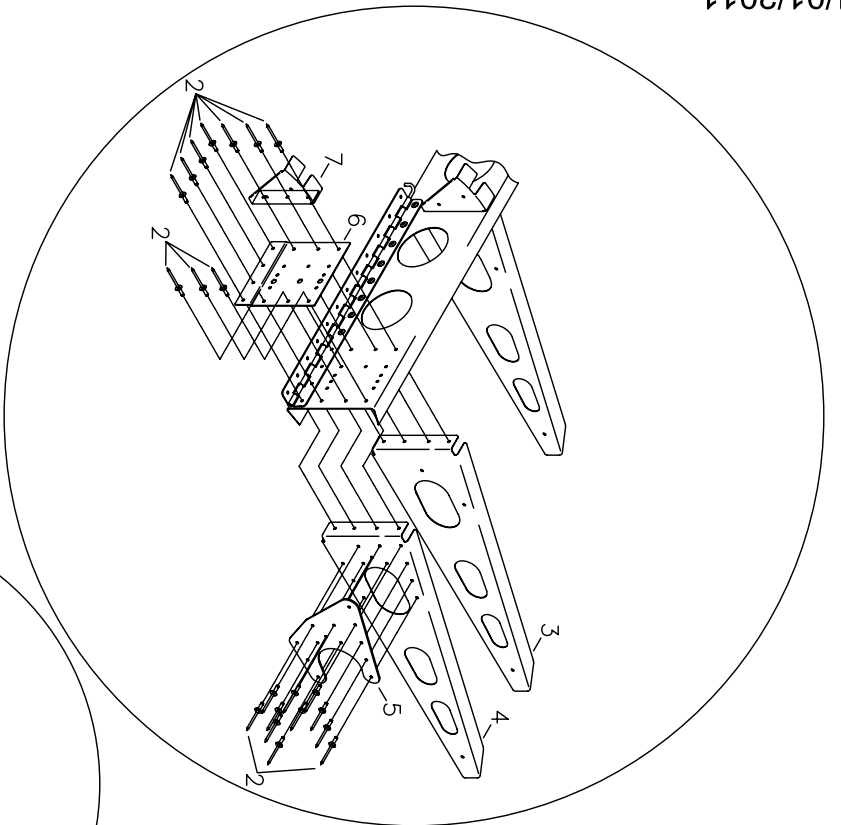
#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1-1/4" x .040 Hinge **	MS20257-3	1
2.	1/8" Aluminum Rivet - Cherry Q	AAPQ-42	40
3.	1/8" Aluminum Rivet - Cherry Q	AAPQ-43	18
4.	Balance Arm - Aileron - LH	KPAL0083-L	1
4.	Balance Arm - Aileron - RH	KPAL0083-R	1
5.	Rib Doubler - LH	KPAL0084-L	1
5.	Rib Doubler - RH	KPAL0084-R	1
6.	0.025" Shim, 1 3/4 x 5/8 x .025 *	KAAC0044-1	0
7.	Hinge Support - Aileron & Flap ** ***	KPAL0088	0
8.	Plate Spar Reinforcement **	KPAL0072	1
9.	1/8" Aluminum Rivet - Cherry Q	AAPQ-41	10
10.	Nose Rib - Aileron - RH	KPAL0073-R	1
10.	Nose Rib - Aileron - LH	KPAL0073-L	1
11.	End Rib Aileron/Flap - RH	KPAL0085-R	1
11.	End Rib Aileron/Flap - LH	KPAL0085-L	1

* Builder fabricates from raw stock.

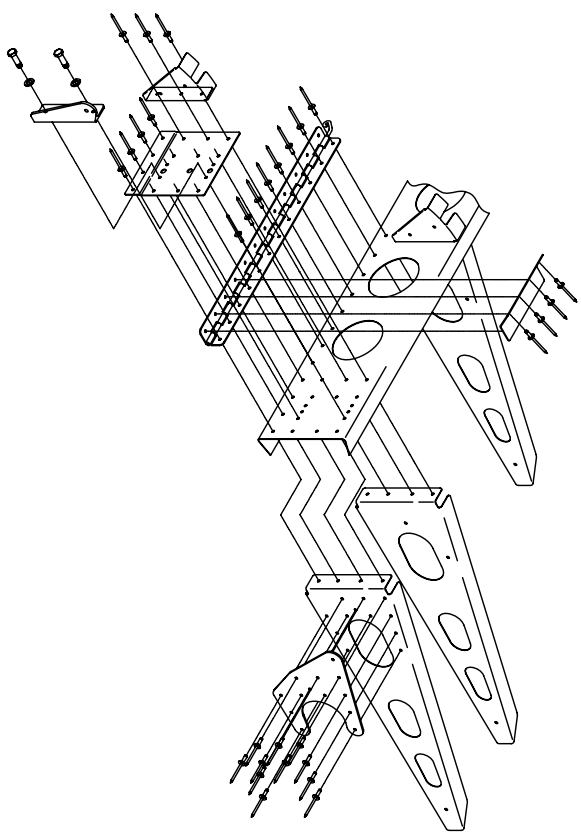
** Builder modifies.

*** Referenced from Wing Trailing Edge Spar Assembly (Root Area)

4/1/2011



*USE FOUR HOLE SECTION
 **RIVETS INSTALL INTO WING
 TRAILING EDGE SPAR



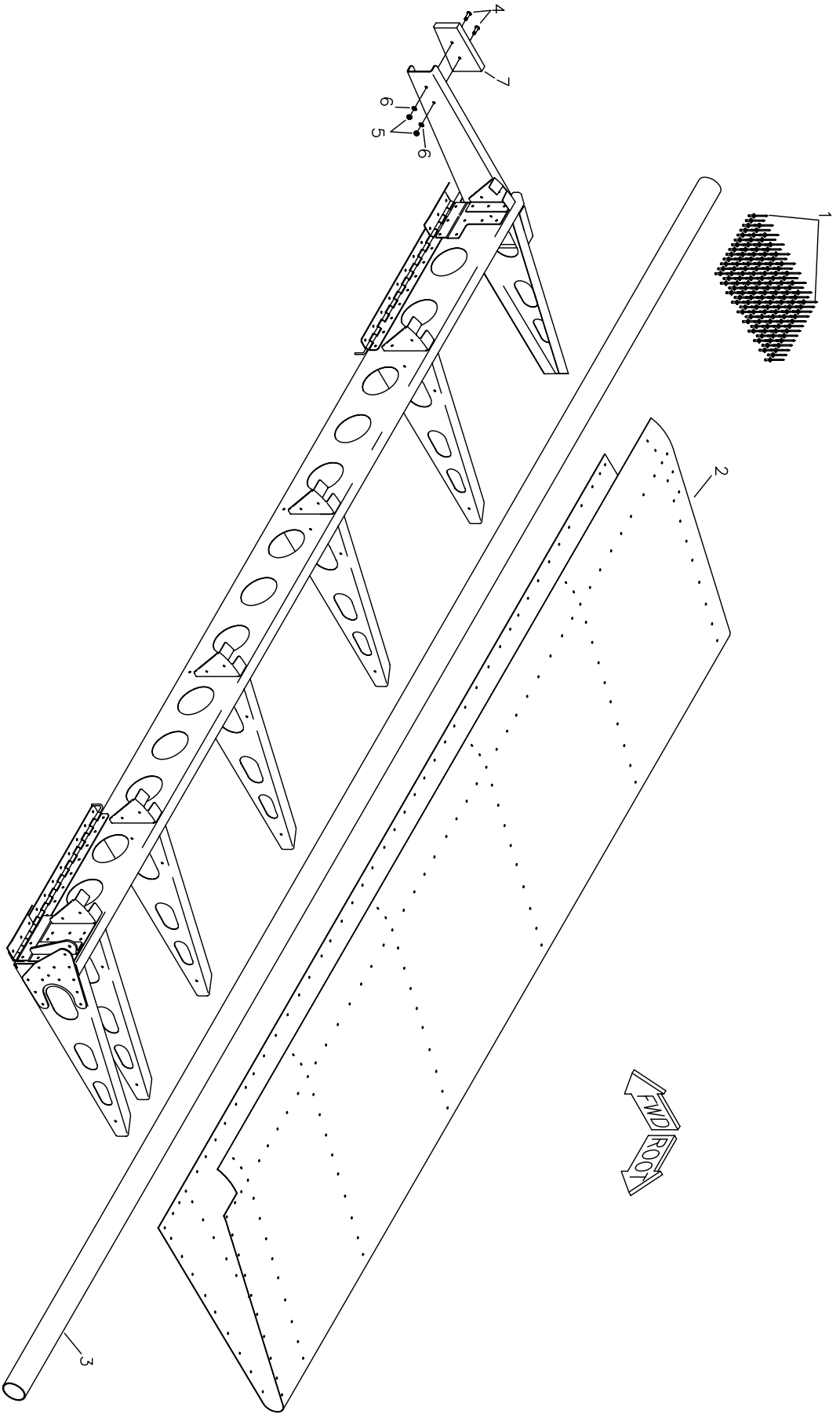
**RRR S-19 VENTERRA
 AILERON ASSEMBLY - INBOARD**

MD4768

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1-1/4" x .040 Hinge **	MS20257-3	0
2.	1/8" Aluminum Rivet - Cherry Q	AAPQ-42	66
3.	Rib Aileron/Flap - RH	KPAL0086-R	1
3.	Rib Aileron/Flap - LH	KPAL0086-L	1
4.	End Rib Aileron/Flap - RH	KPAL0085-R	1
4.	End Rib Aileron/Flap - LH	KPAL0085-L	1
5.	Aileron Horn Plate	KPAL0071	2
6.	Plate Spar Reinforcement *	KPAL0072	0
7.	Nose Rib - Aileron - LH	KPAL0073-L	1
7.	Nose Rib - Aileron - RH	KPAL0073-R	1
8.	Hinge Support - Aileron & Flap *	KPAL0088	0
9.	3/16" Single-Ear Nut Plate	MS21051-L3	4
10.	Aileron Horn Angle - RH	KPAL0070-R	1
10.	Aileron Horn Angle - LH	KPAL0070-L	1
11.	3/16" Thin Washer	AN960-10L	4
12.	3/16" Bolt	AN3-4A	4
13.	1/8" Aluminum Rivet - Cherry Q	AAPQ-41	6
14.	3/32" Aluminum Rivet	40APR1/8	8

* Builder modifies.

** Builder fabricates from raw stock.



RRRRII S-19 VENTURA
AILERON SKIN & MASS BALANCE INSTALLATION

MD4768

#	DESCRIPTION	PART NUMBER	QUANTITY
1.	1/8" Aluminum Rivet - Avex	1691-0410	550
2.	Aileron Skin - LH	KPAL0094-L	1
2.	Aileron Skin - RH	KPAL0094-R	1
3.	1-1/2" x 95" Tubing *	-----	0
4.	3/16" Countersunk Machine Screw	AN509-1032R16	4
5.	3/16" Shear Nut	AN364-1032A	4
6.	3/16" Thin Washer	AN960-10L	4
7.	Aileron Mass Balance - RH *	-----	0
7.	Aileron Mass Balance - LH *	-----	0

* Builder Supplied