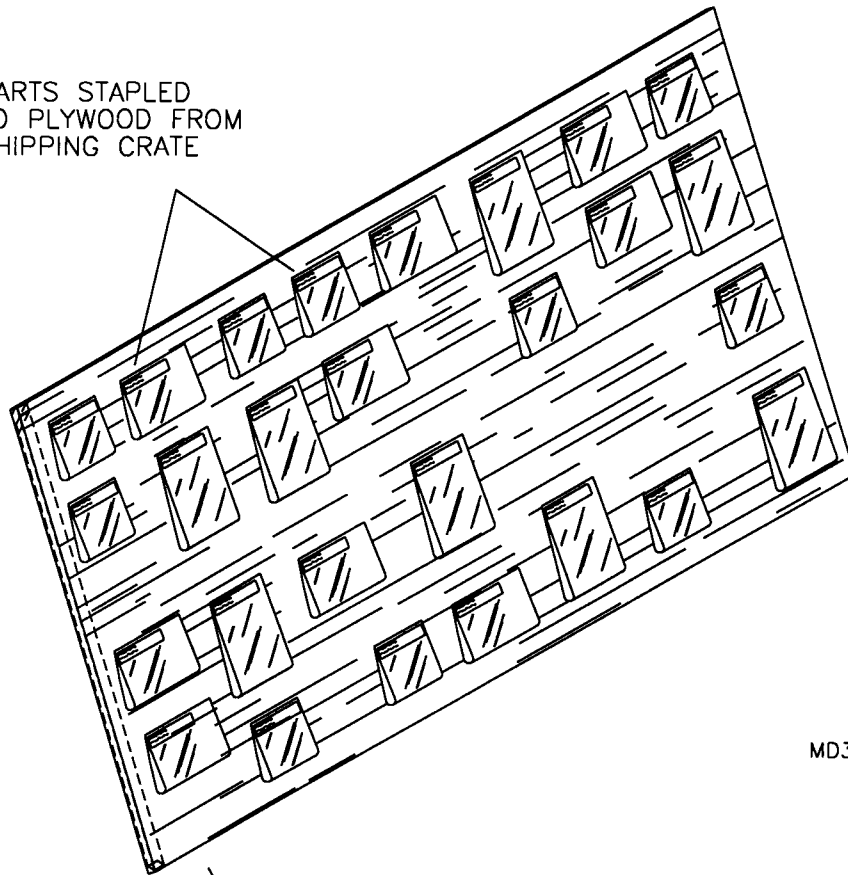




# ORGANIZE

PARTS STAPLED  
TO PLYWOOD FROM  
SHIPPING CRATE



MD3817

NAIL BOARD TO  
SHOP WALL

FIGURE 0-1  
S-18 STINGER II

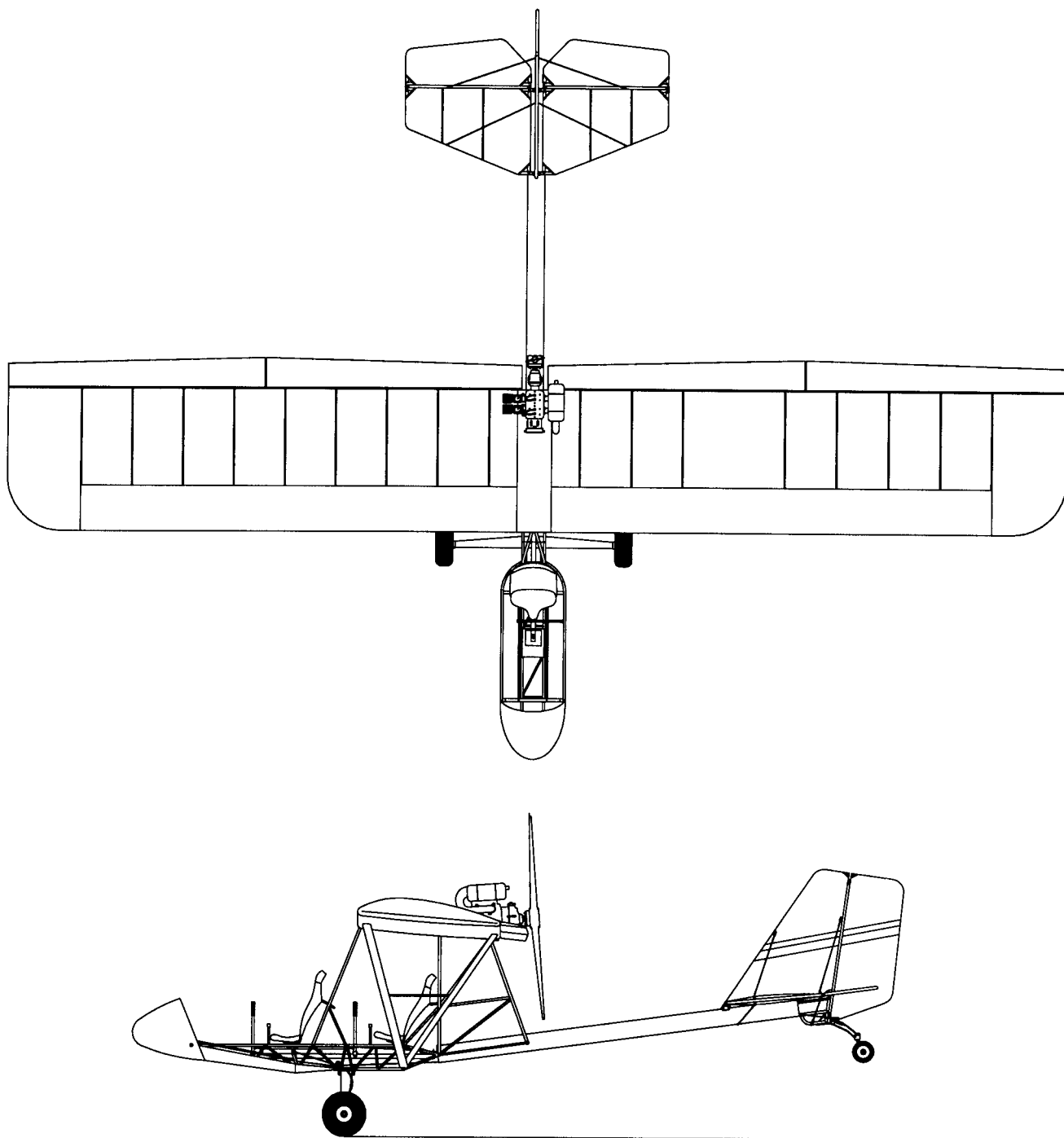
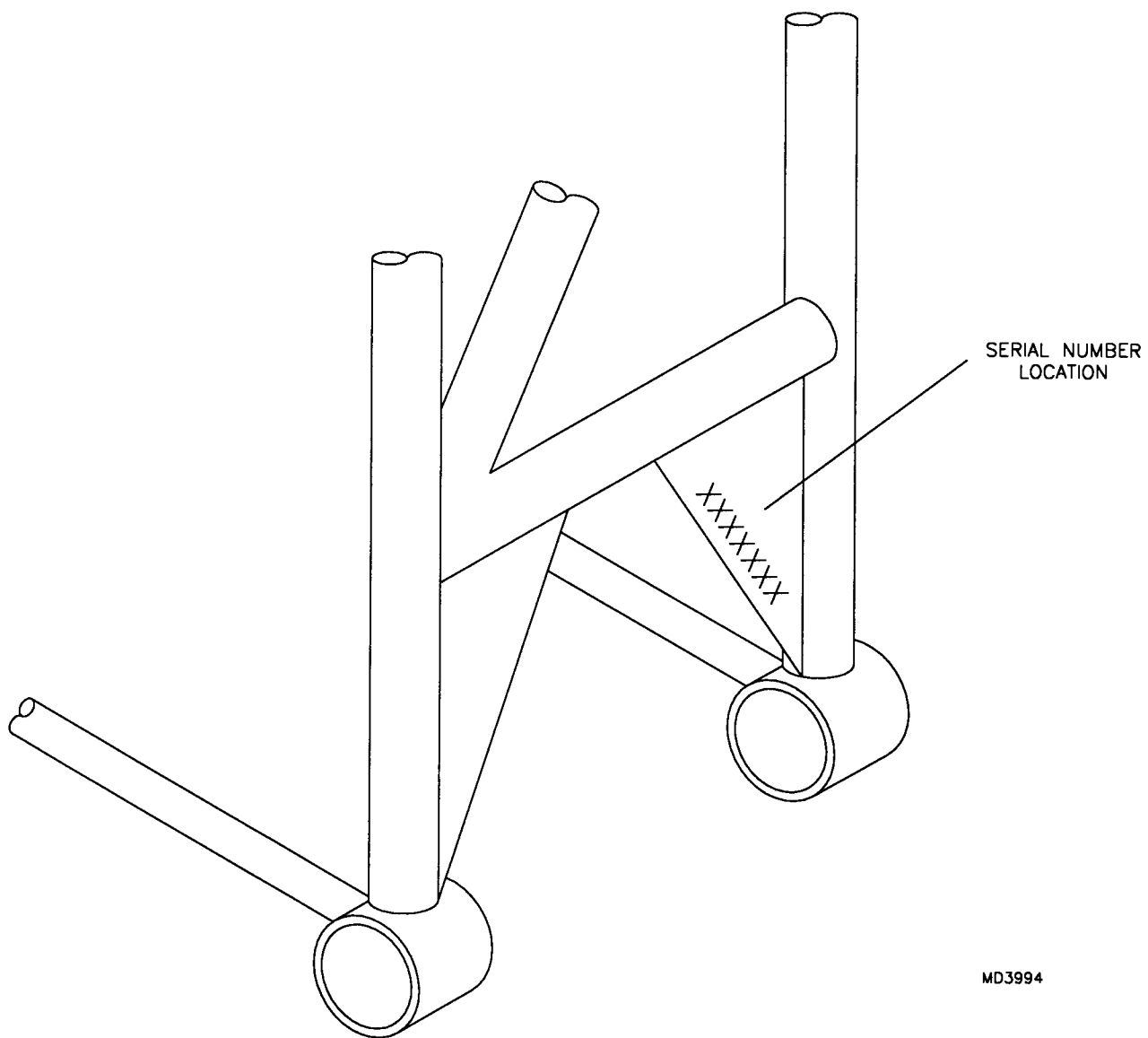


FIGURE 0-2  
S-18 STINGER II

MD3993

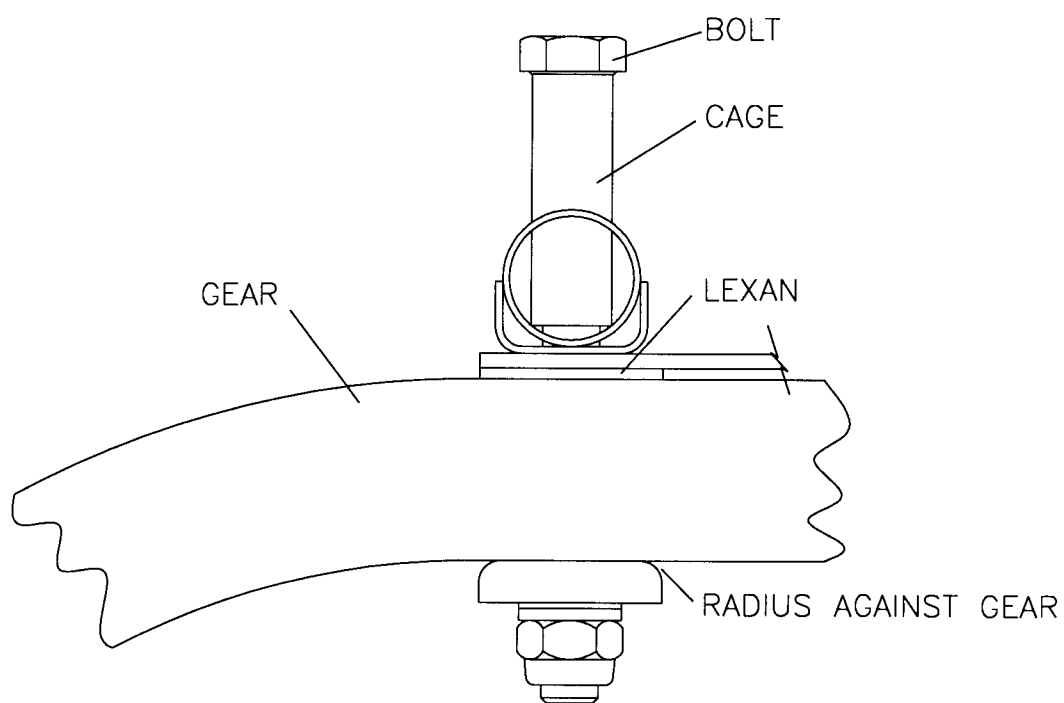


MD3994

FIGURE 0-3  
S-18 STINGER II







MD4119

**FIGURE 1-2A  
S-18 STINGER II**

07/02/01

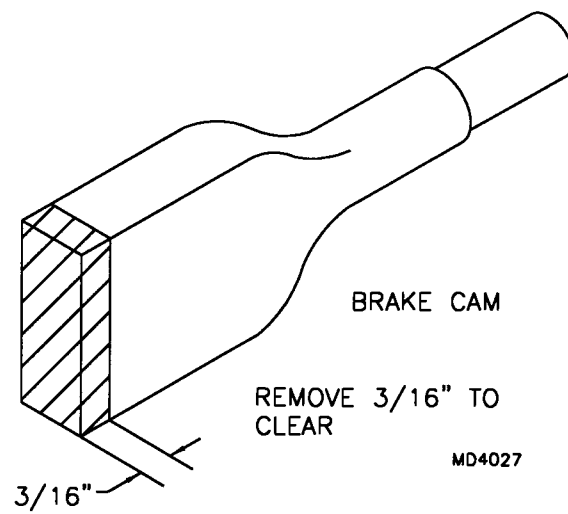
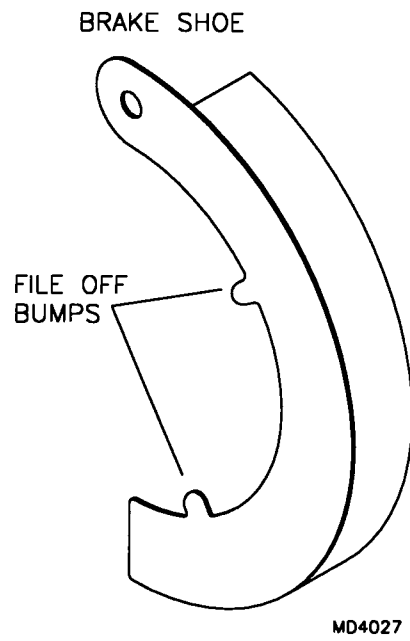
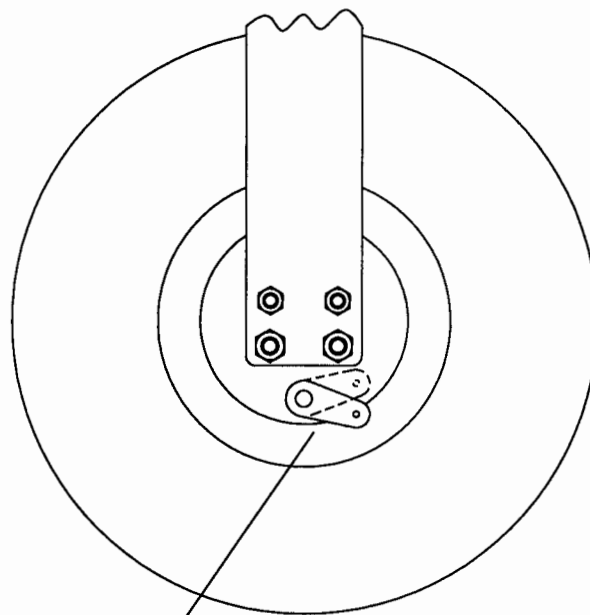
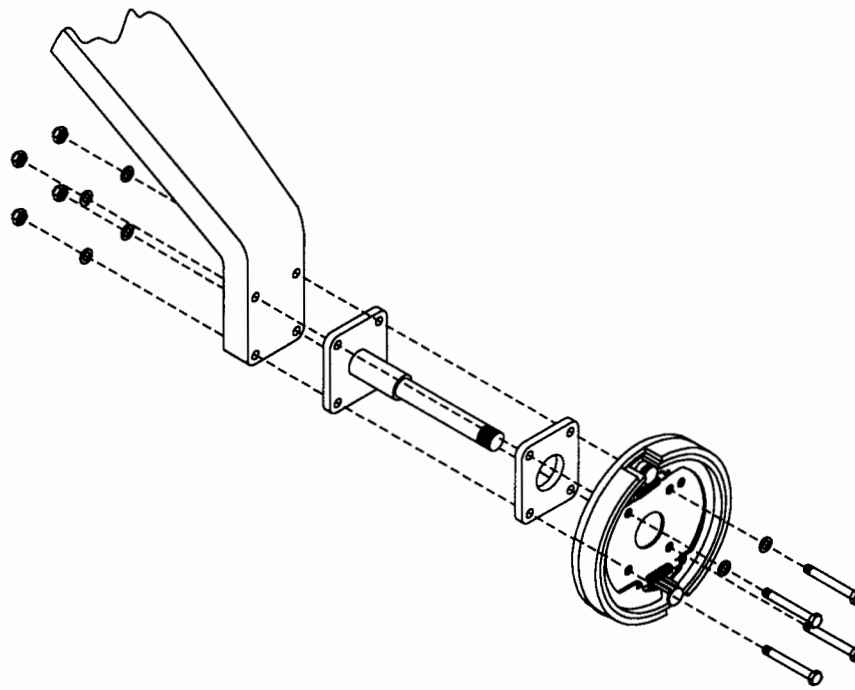


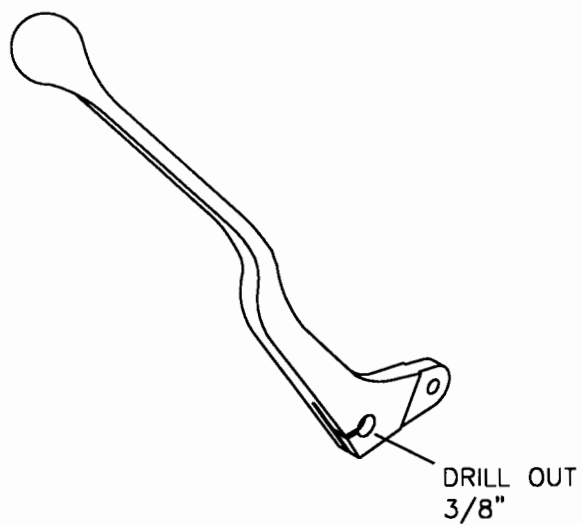
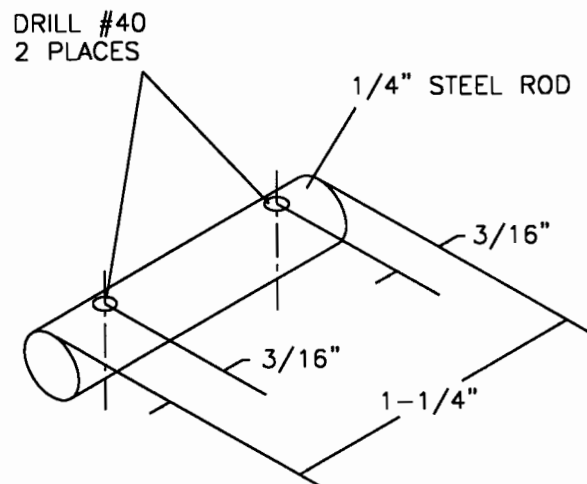
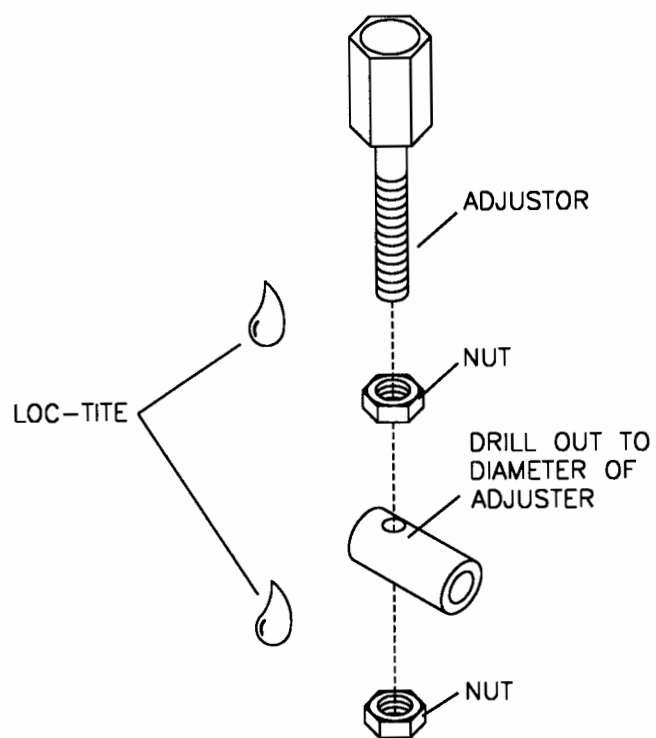
FIGURE 1-3  
S-18 STINGER II



RE-POSITION BRAKE  
ARM TO CLEAR LANDING GEAR

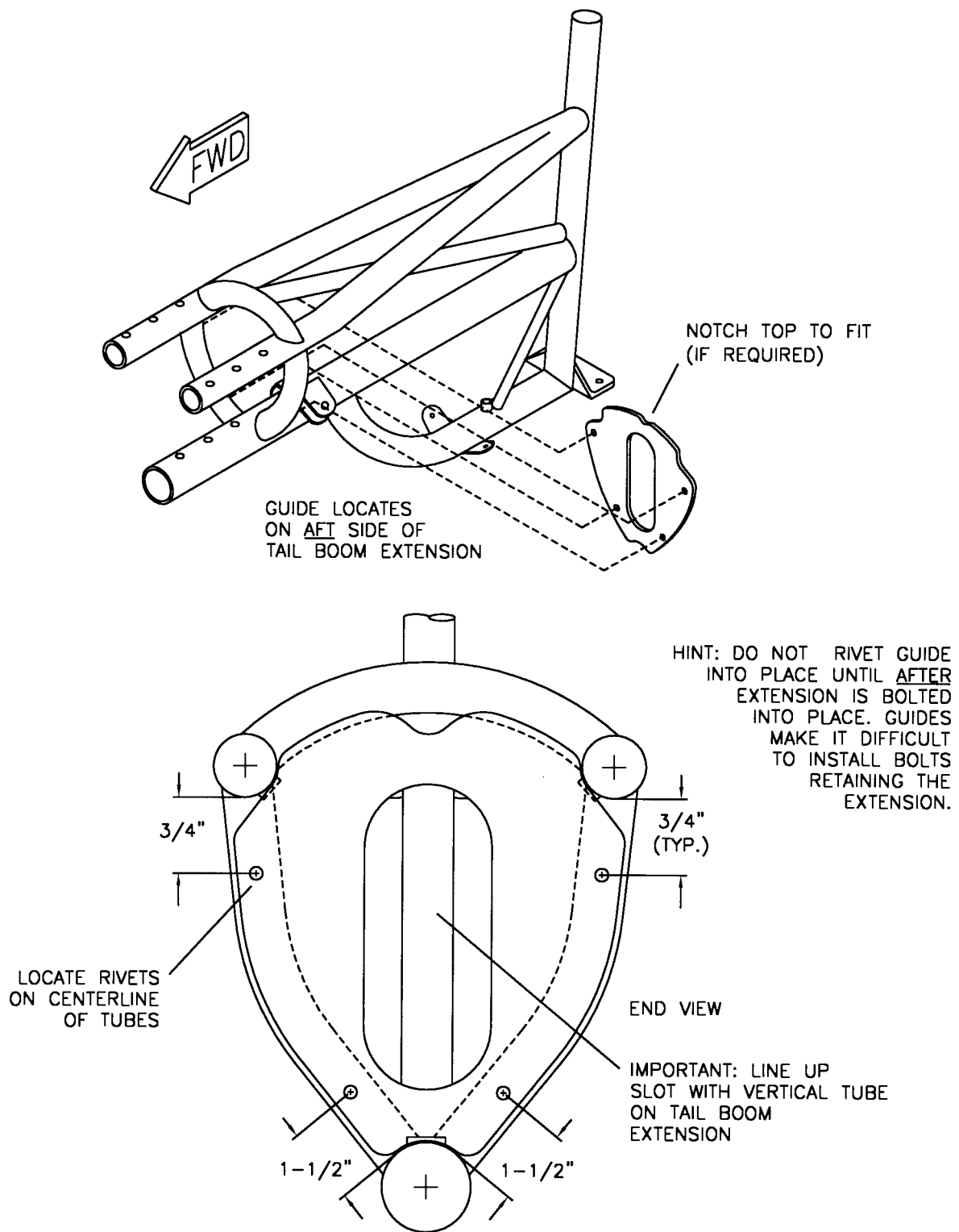
MD4032

FIGURE 1-4  
S-18 STINGER II



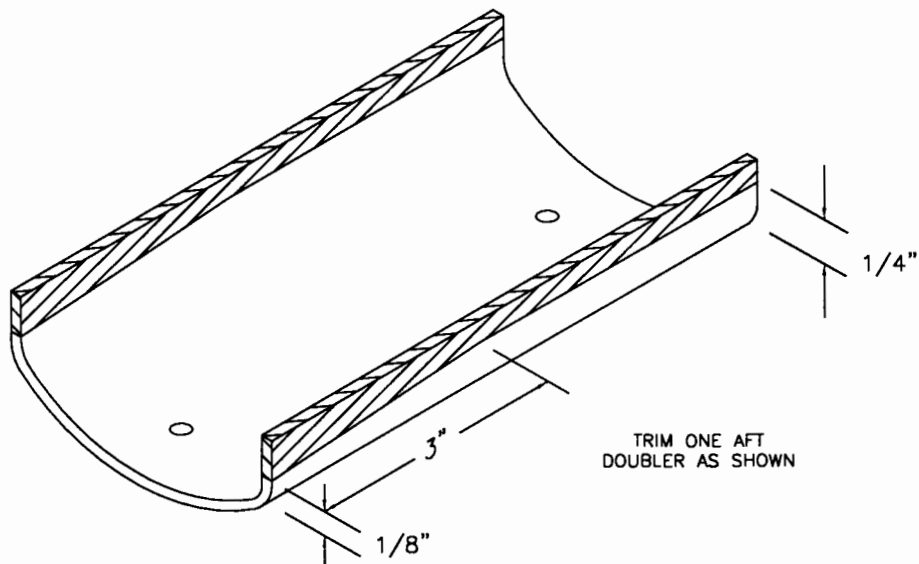
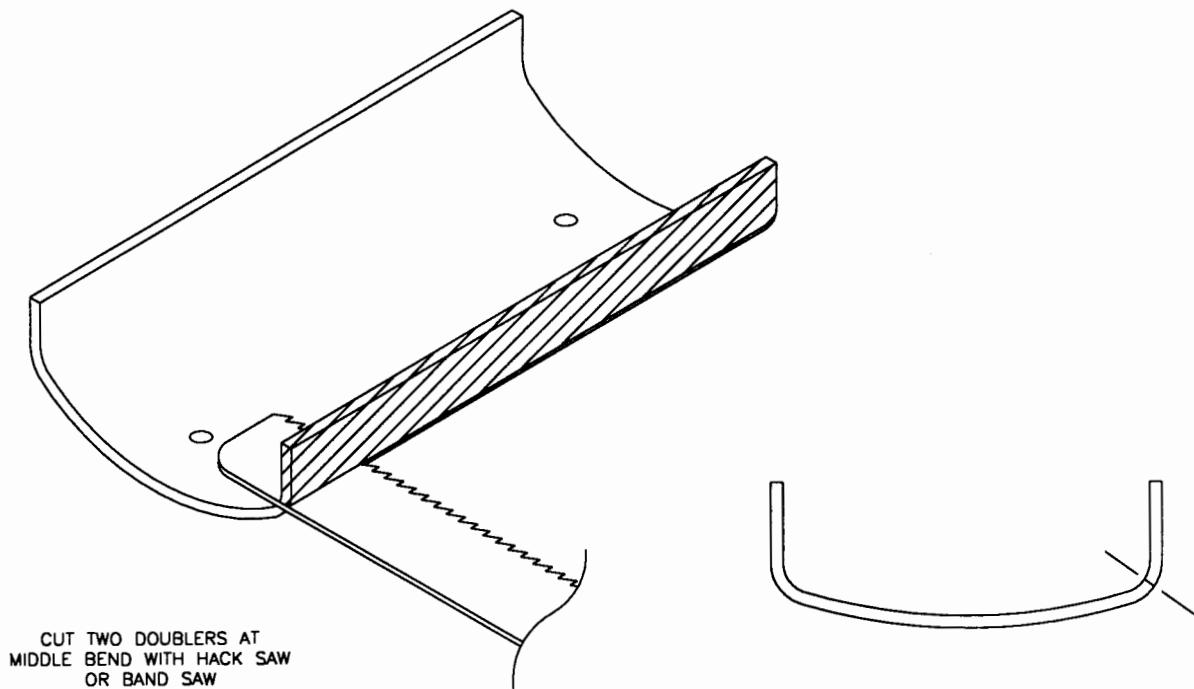
MD4026

FIGURE 1-5  
S-18 STINGER II



MD4064

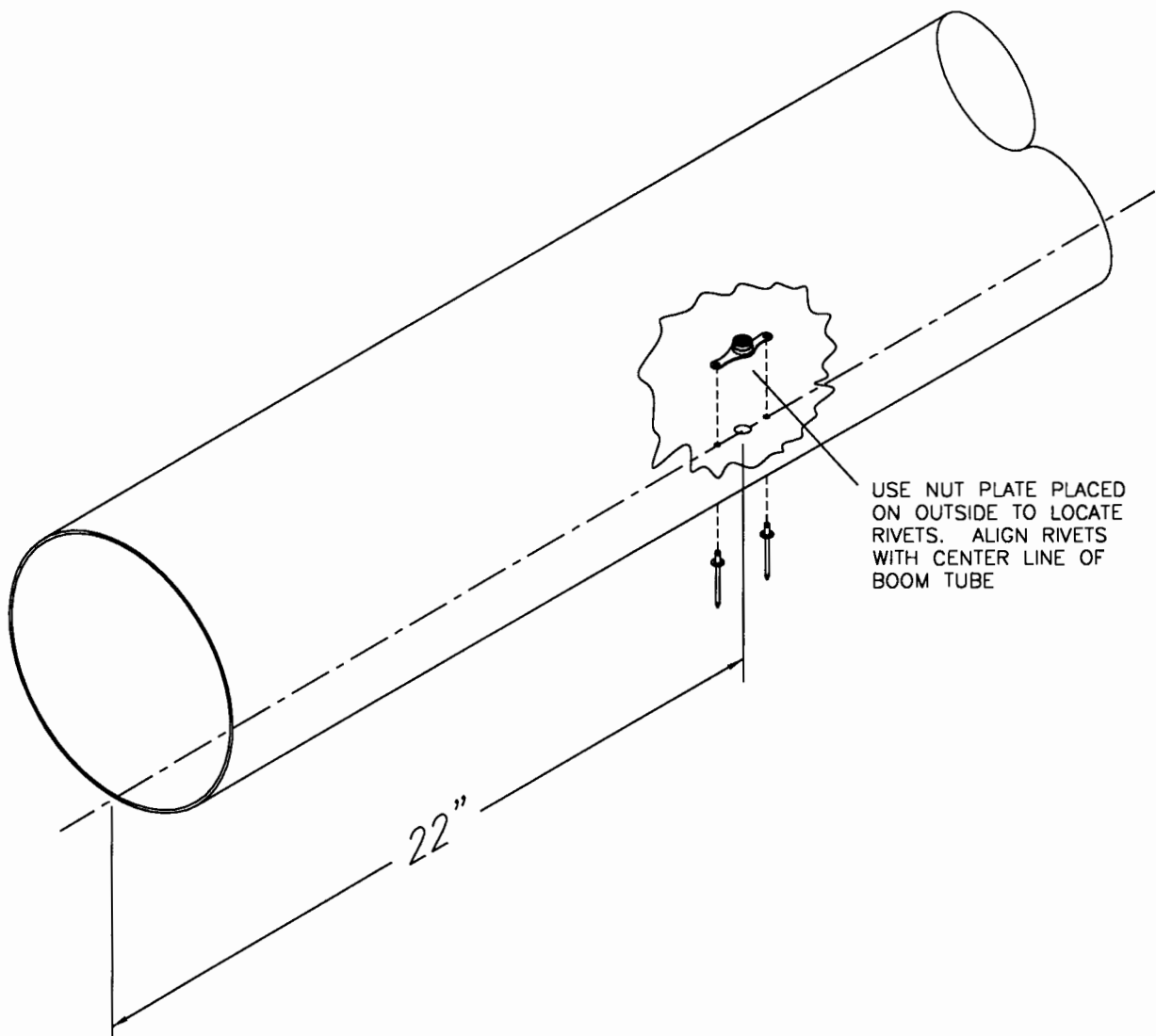
**FIGURE 1-5A**  
**S-18 STINGER II**



MD3966

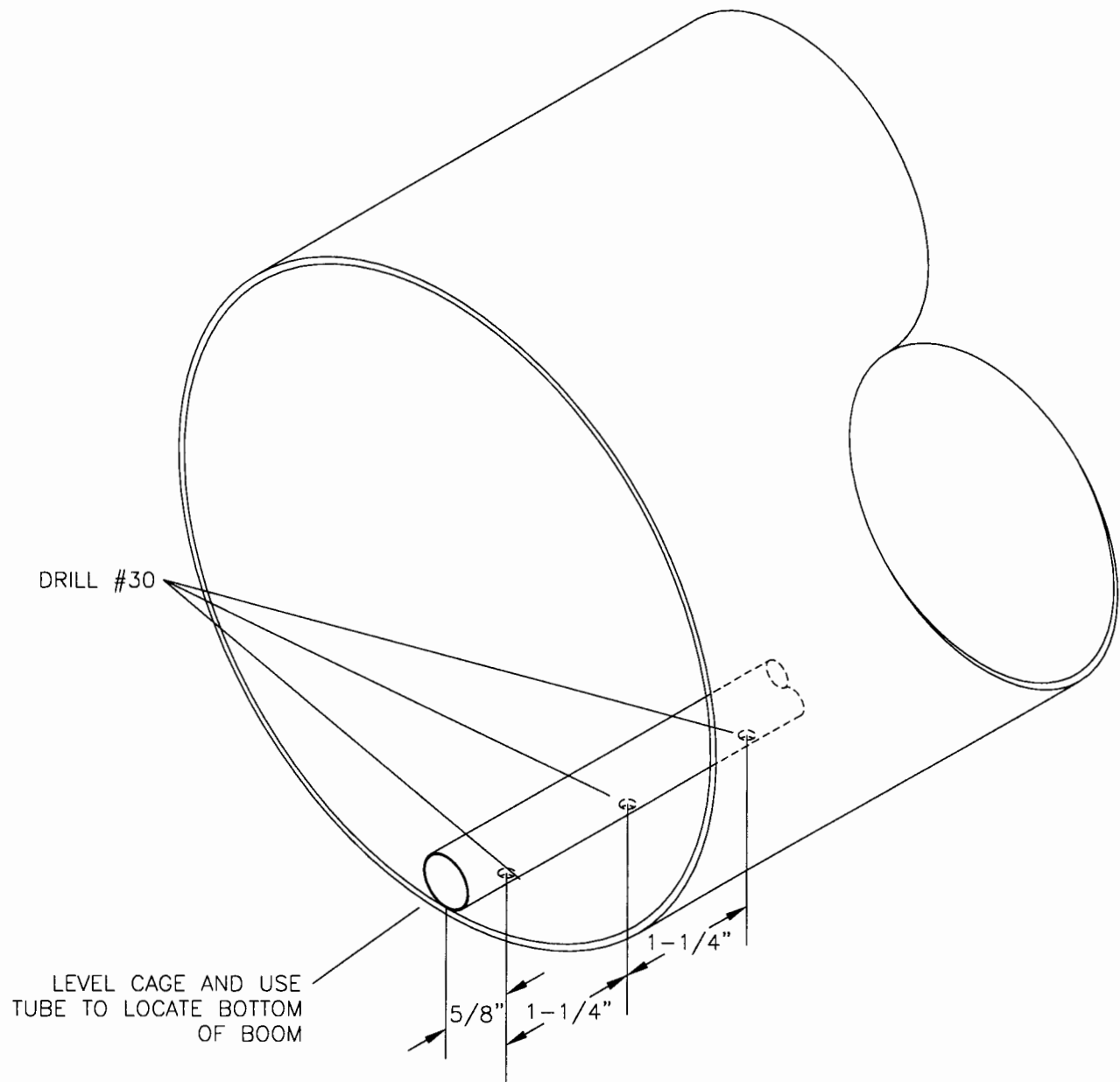
IMPORTANT: FILE AND SAND SMOOTH CUT EDGES  
OF DOUBLERS TO REMOVE STRESS RISERS.

FIGURE 1-6  
S-18 STINGER II



MD4031

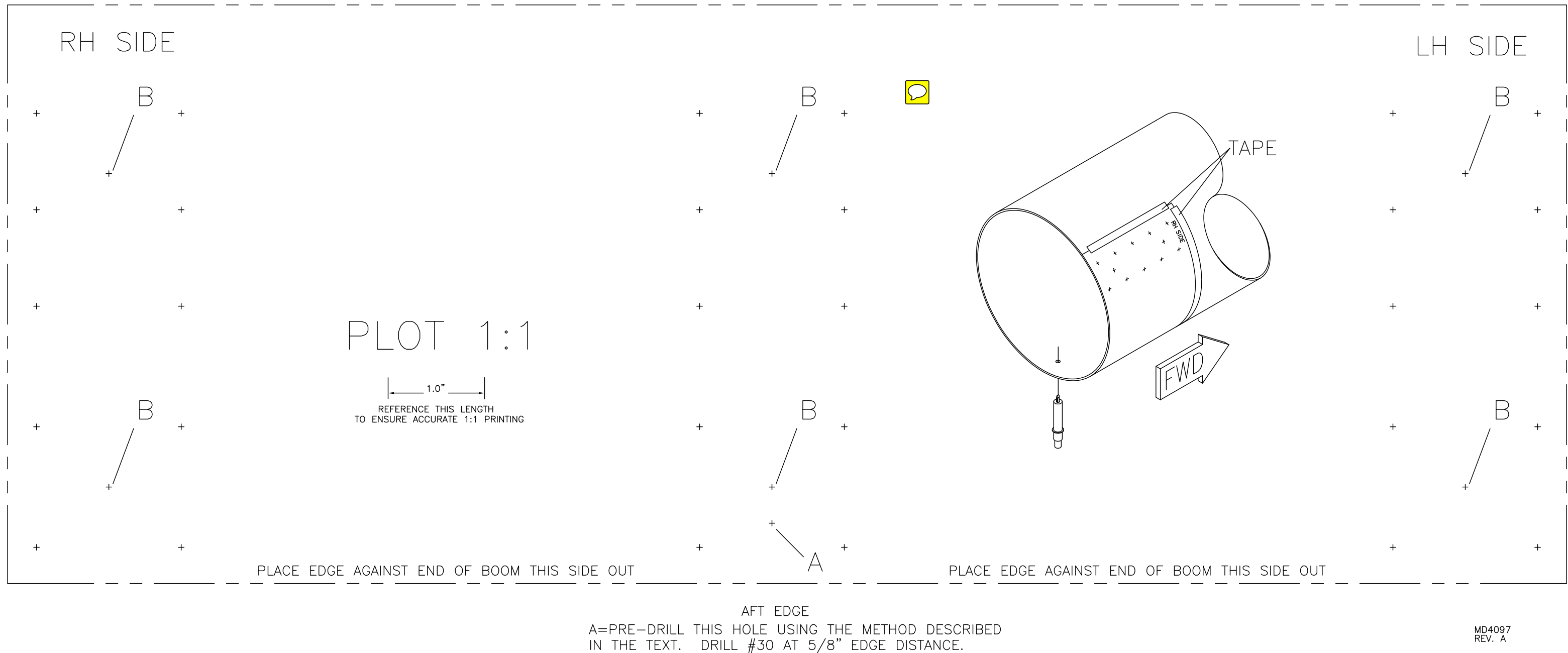
FIGURE 1-7  
S-18 STINGER II



MD4096

**FIGURE 1-7A**  
**S-18 STINGER II**

**03/01/02**



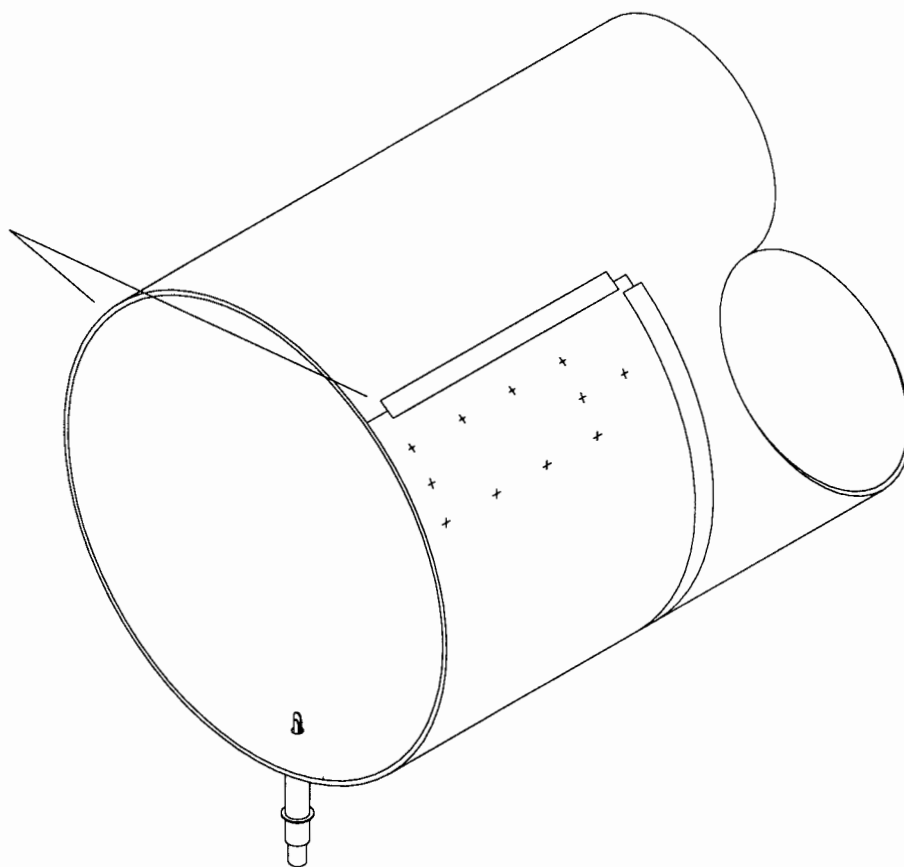
MD4097  
REV. A

1. CUT OUT AND LOCATE TEMPLATE AT HOLE "A" AND TAPE TO BOOM. NOTE: RIGHT SIDE MUST BE PLACED ON RH.
2. AT "B" LOCATIONS CLICK PUNCH AND DRILL #30.
3. AT ALL REMAINING LOCATIONS CLICK PUNCH, BUT DO NOT DRILL.

4. CLECO DOUBLERS TO INSIDE OF BOOM AND DRILL #30 ALL CLICK-PUNCH LOCATIONS. NOTE: HOLD WOOD BLOCK INSIDE FOR SUPPORT WHEN DRILLING.
5. MARK DOUBLERS AND INSIDE OF BOOM TUBE (1,2,3) TO HELP RELOCATE DOUBLERS AFTER DE-BURR,
6. REMOVE, DEBURR, CLECO AND RIVET.

**FIGURE 1-7B**  
**S-18 STINGER II**

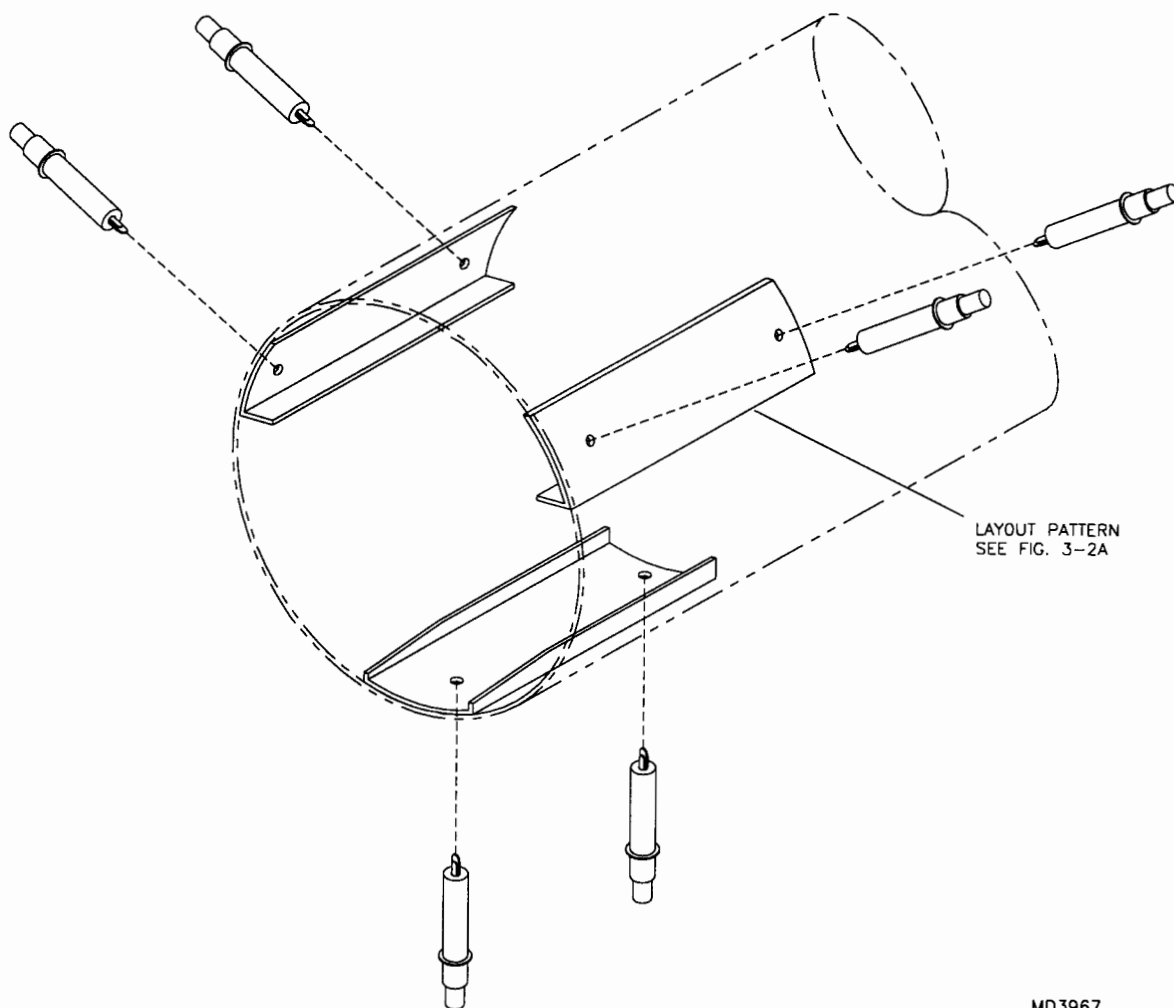
TAPE IN PLACE, KEY  
OFF OF BOTTOM HOLE.  
PLACE EVEN WITH  
AFT EDGE.



MD4098

FIGURE 1-7C  
S-18 STINGER II

06/05/01



MD3967

FIGURE 1-8  
S-18 STINGER II

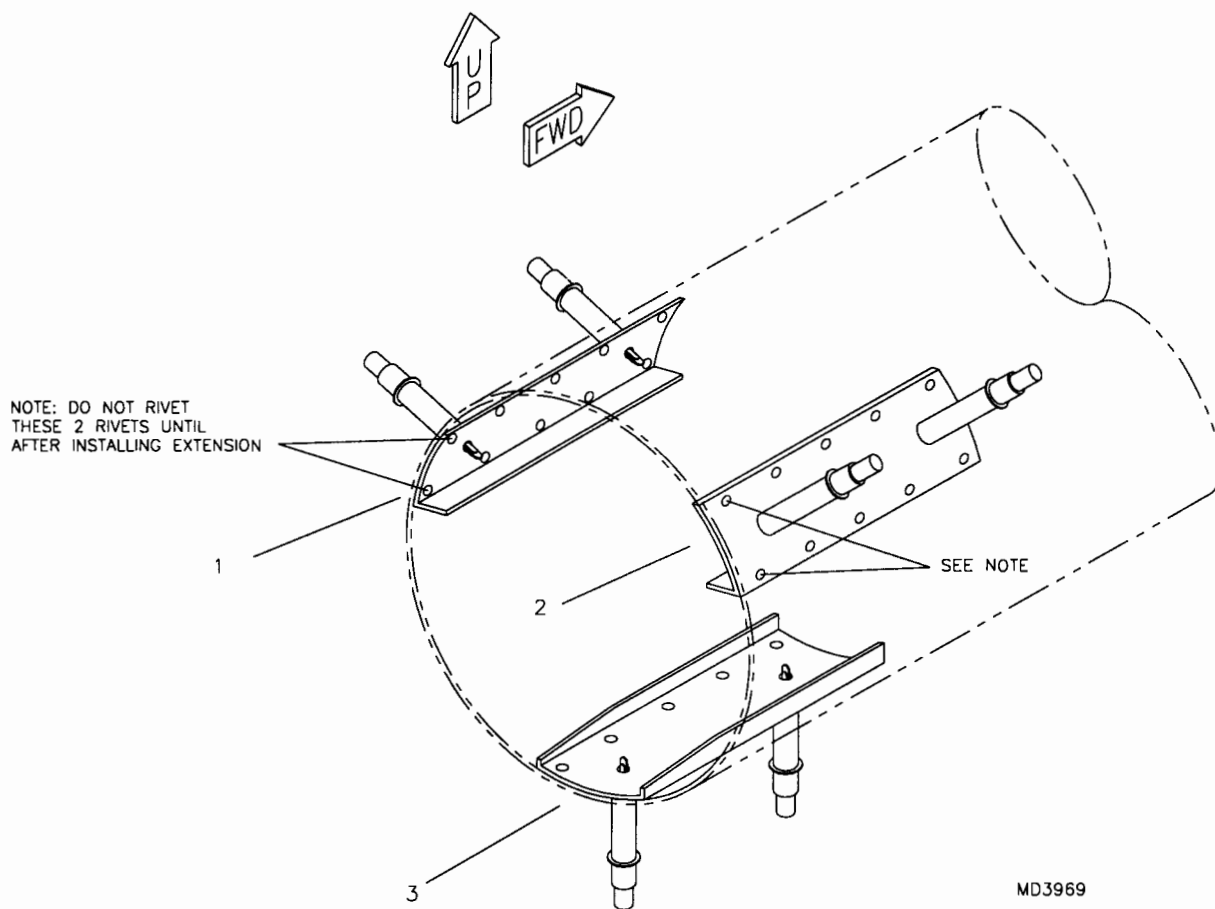
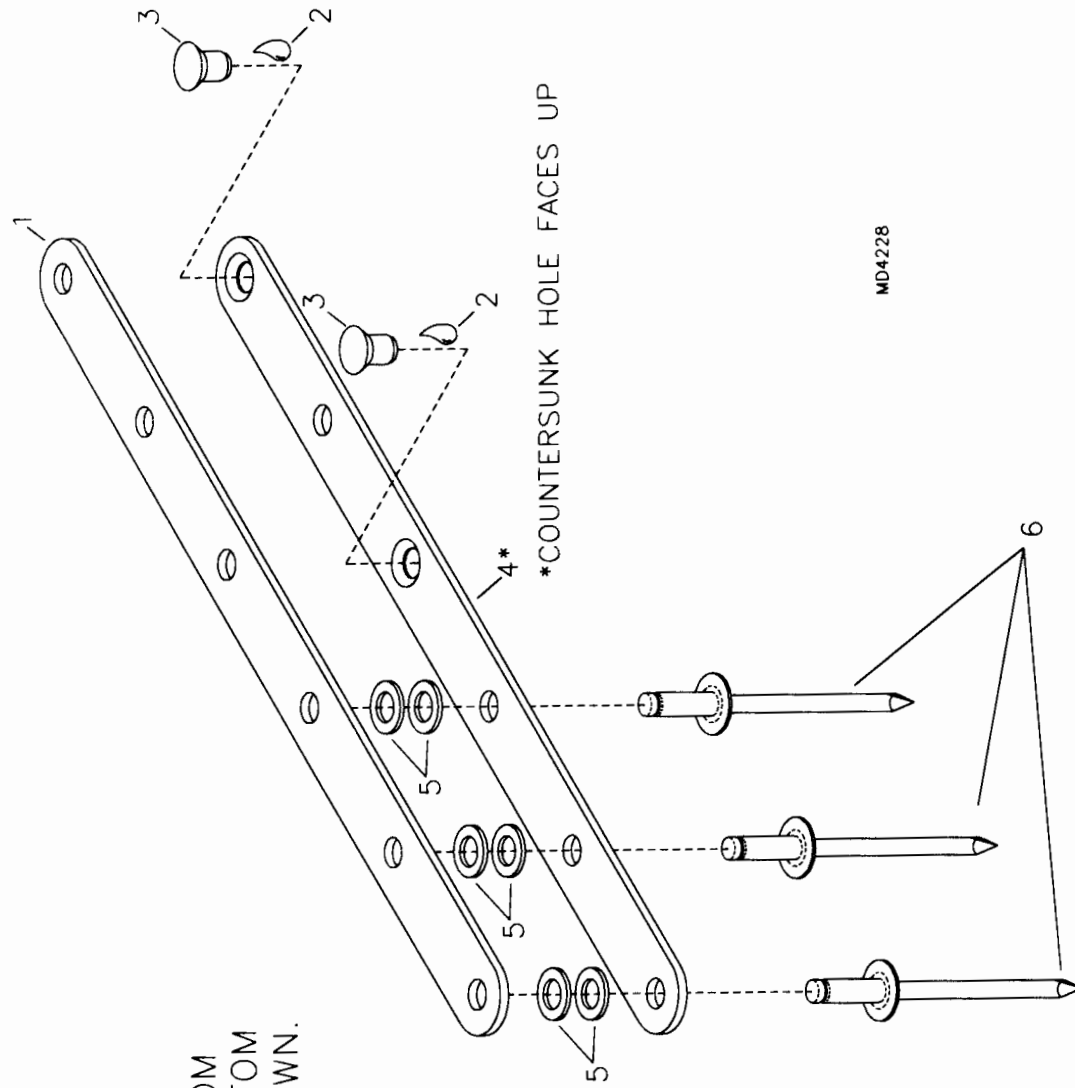
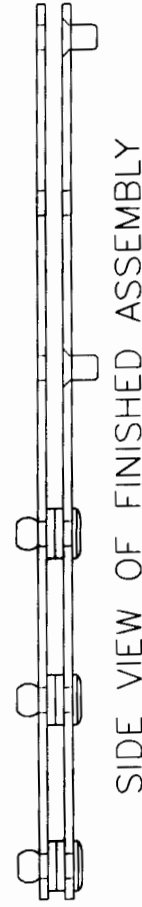


FIGURE 1-9  
S-18 STINGER II

1. GLUE THE (2) 3/16" FLUSH RIVETS INTO THE BOTTOM STRAP WITH 5-MIN EPOXY AND LET CURE FOR 10 MIN.
2. ASSEMBLE THE TOP STRAP TO THE BOTTOM STRAP BY INSTALLING RIVETS FROM BOTTOM AND WASHERS BETWEEN STRAPS AS SHOWN.



ITEM:	QTY
1. TOP STRAP	1
2. 5-MIN. EPOXY (BUILDER PROVIDES)	0
3. 3/16" FLUSH RIVETS	2
4. BOTTOM STRAP	1
5. 3/16" THICK WASHERS	6
6. 3/16" ALUM. POP RIVETS	3



**S-18 STINGER II FIGURE 1-9A  
TAIL EXTENSION HOLE FINDER**

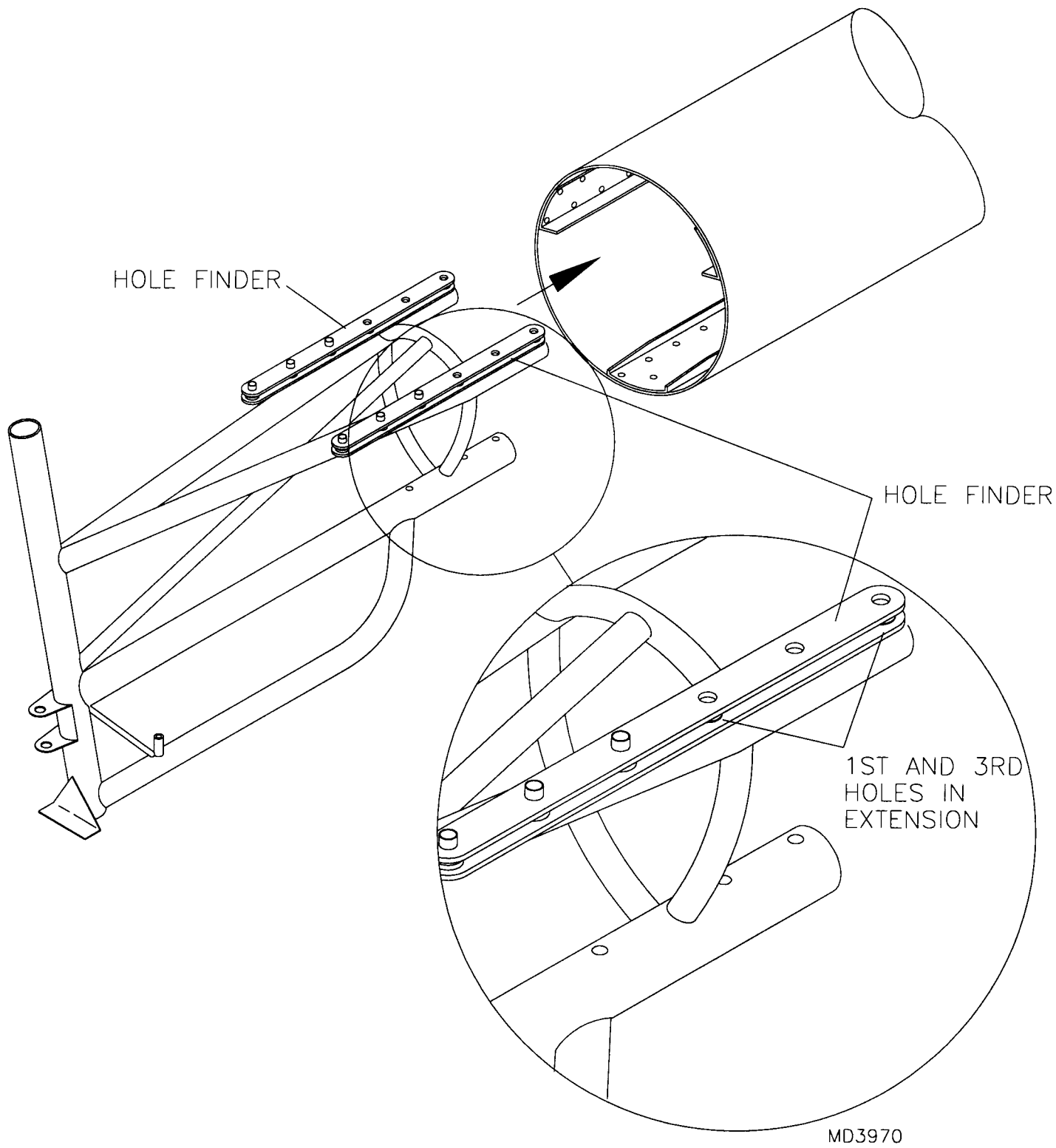
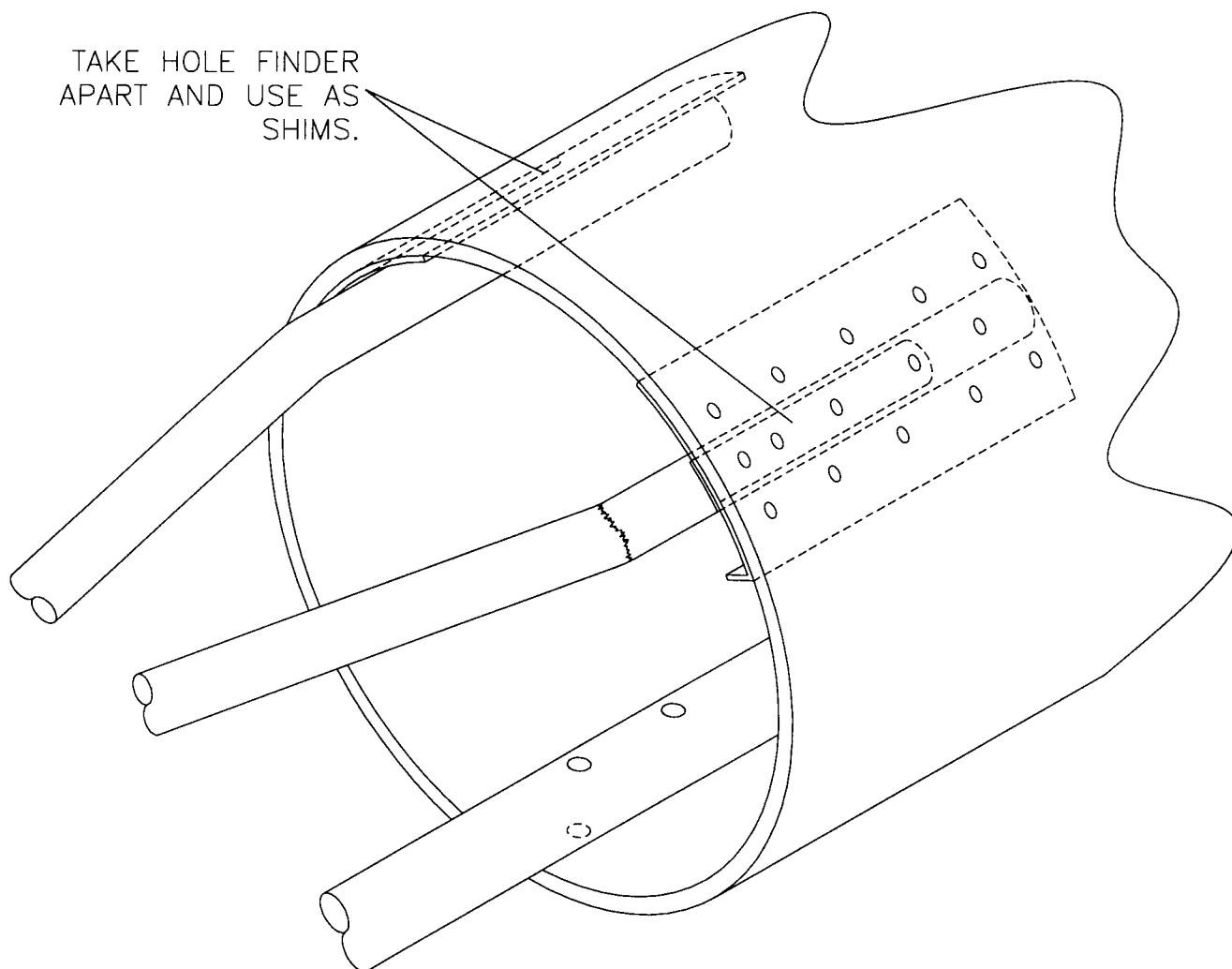


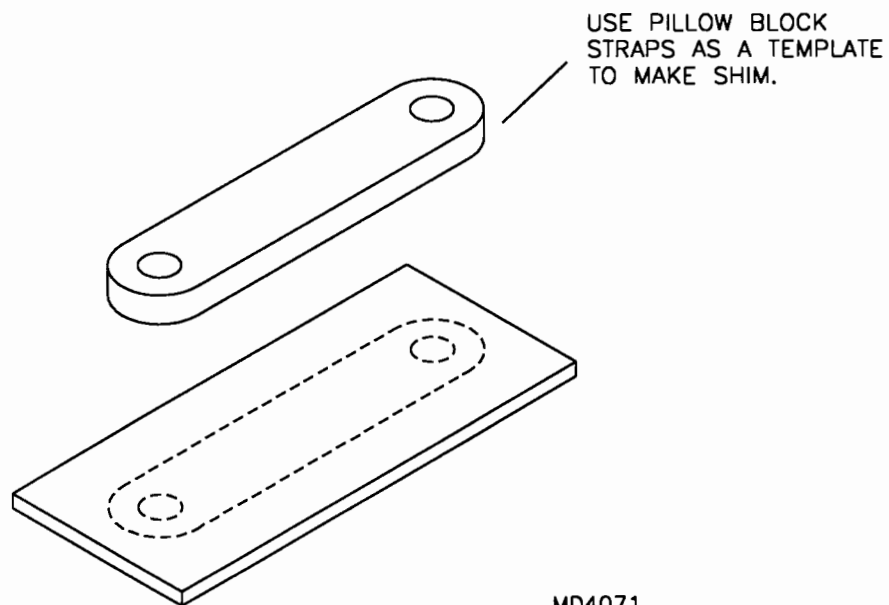
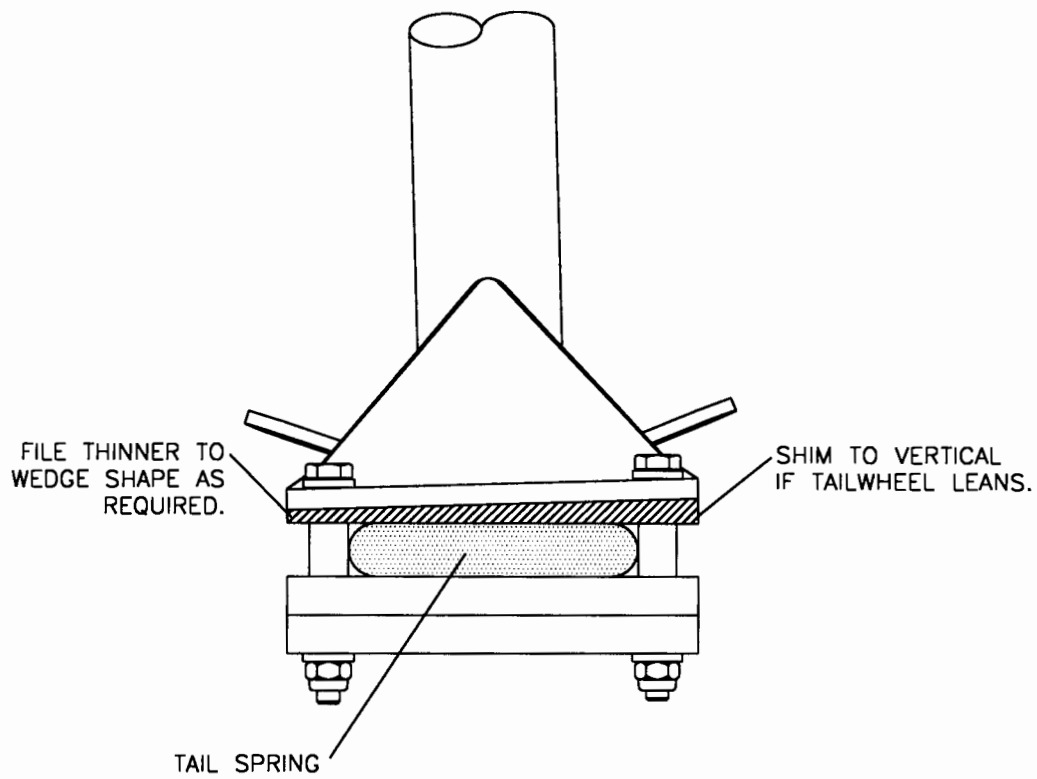
FIGURE 1-10  
S-18 STINGER II



MD4230

FIGURE 1-11A  
S-18 STINGER II

03/01/02



MD4071

FIGURE 1-12  
S-18 STINGER II

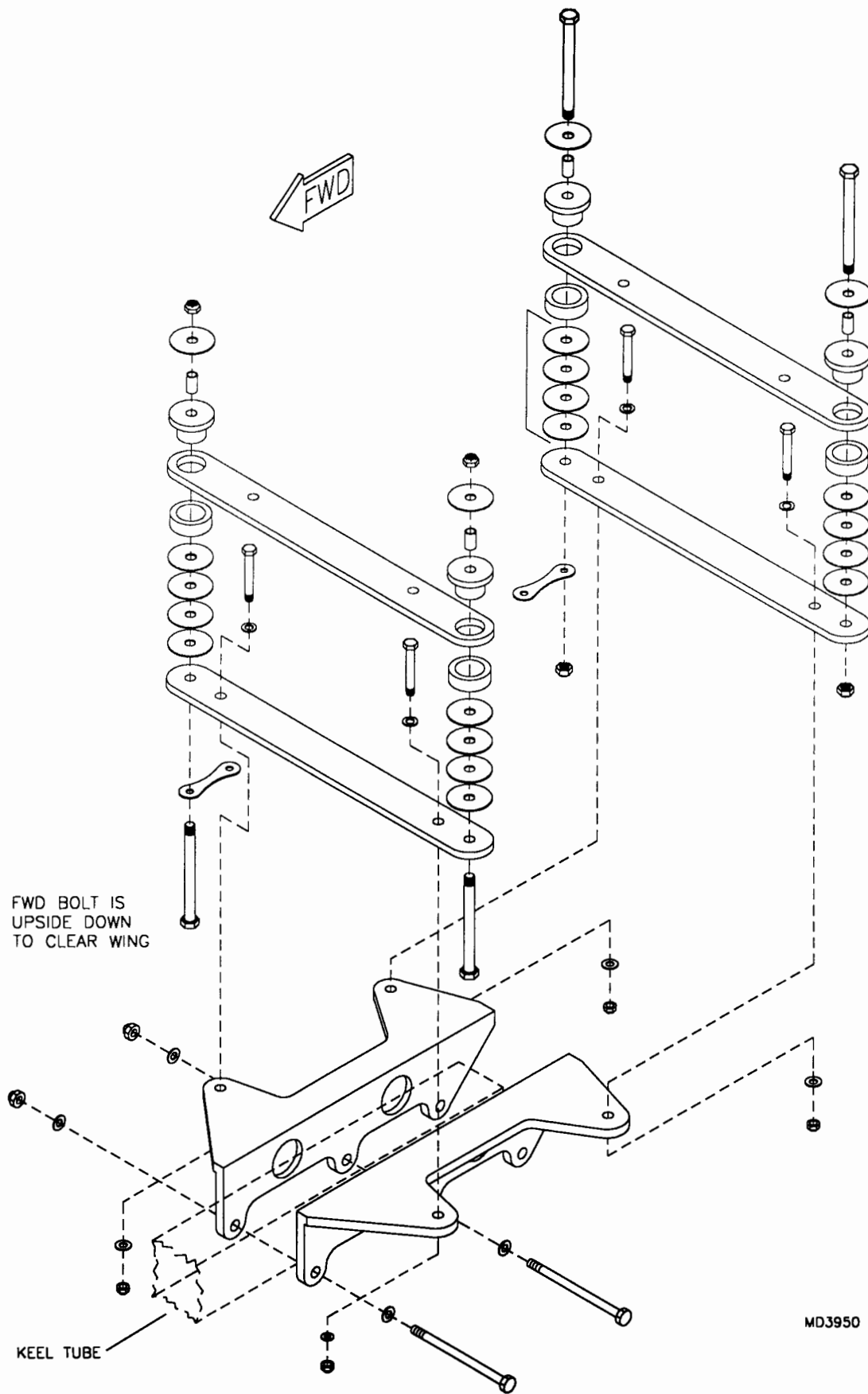


FIGURE 1-13  
S-18 STINGER II

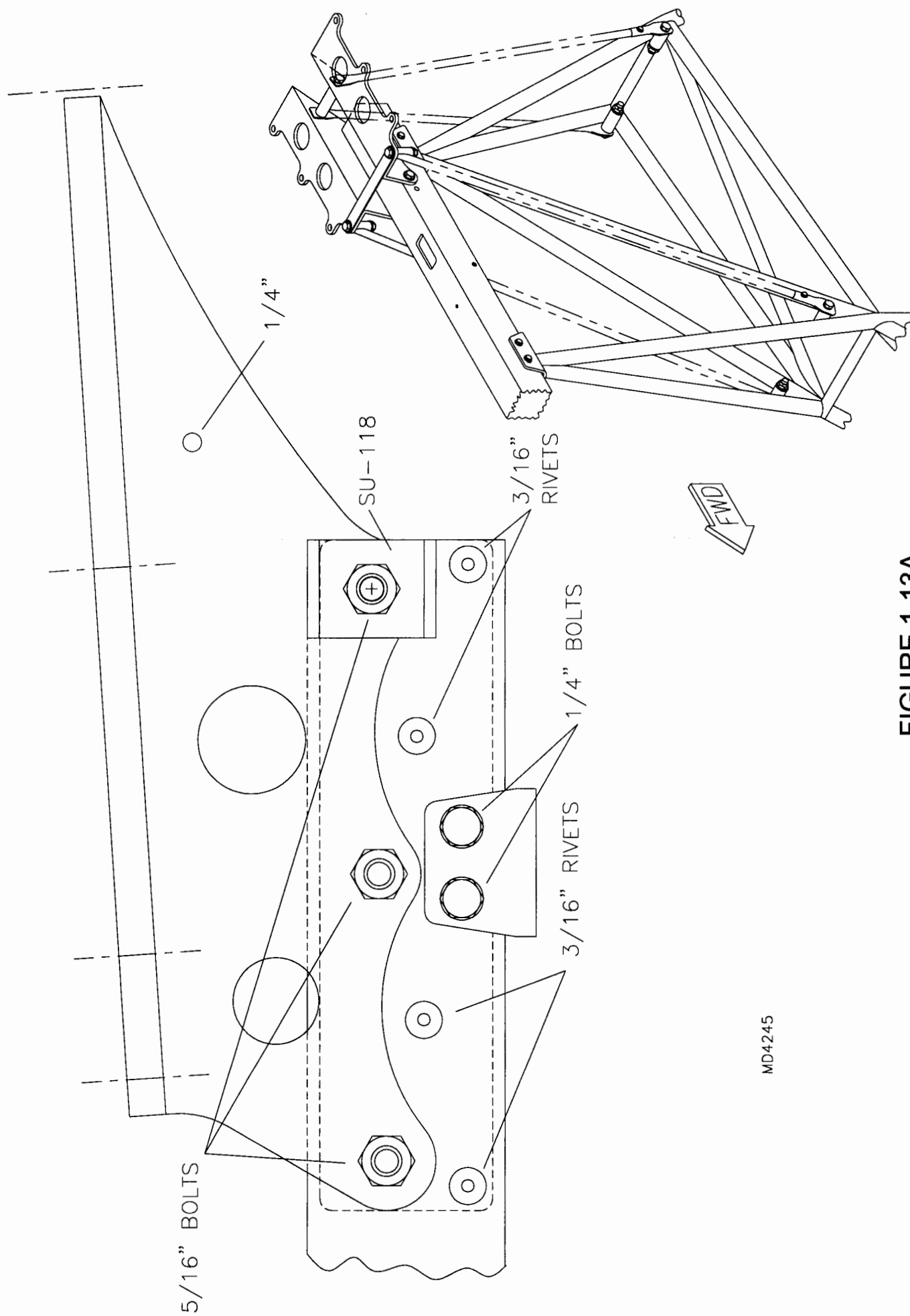
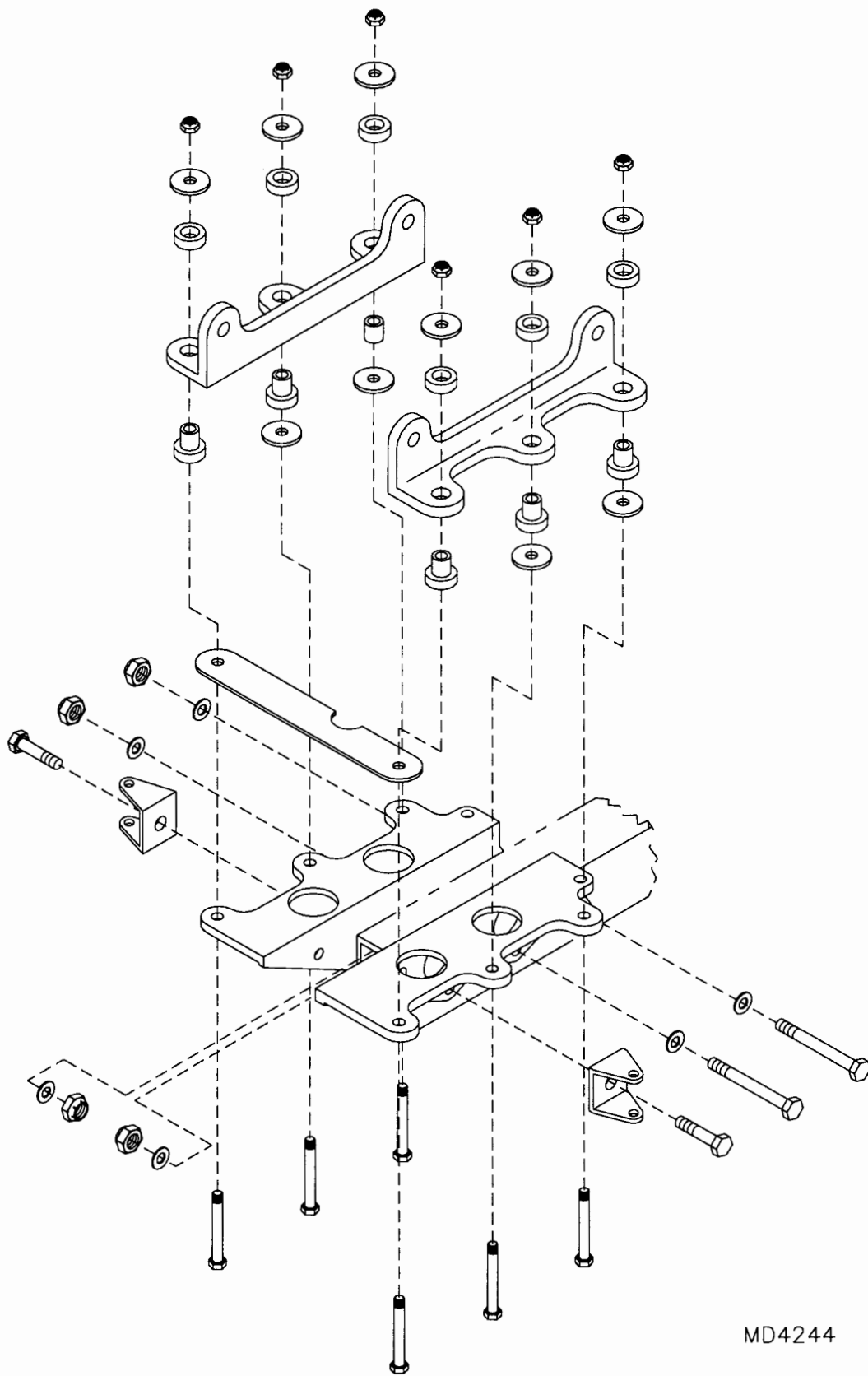
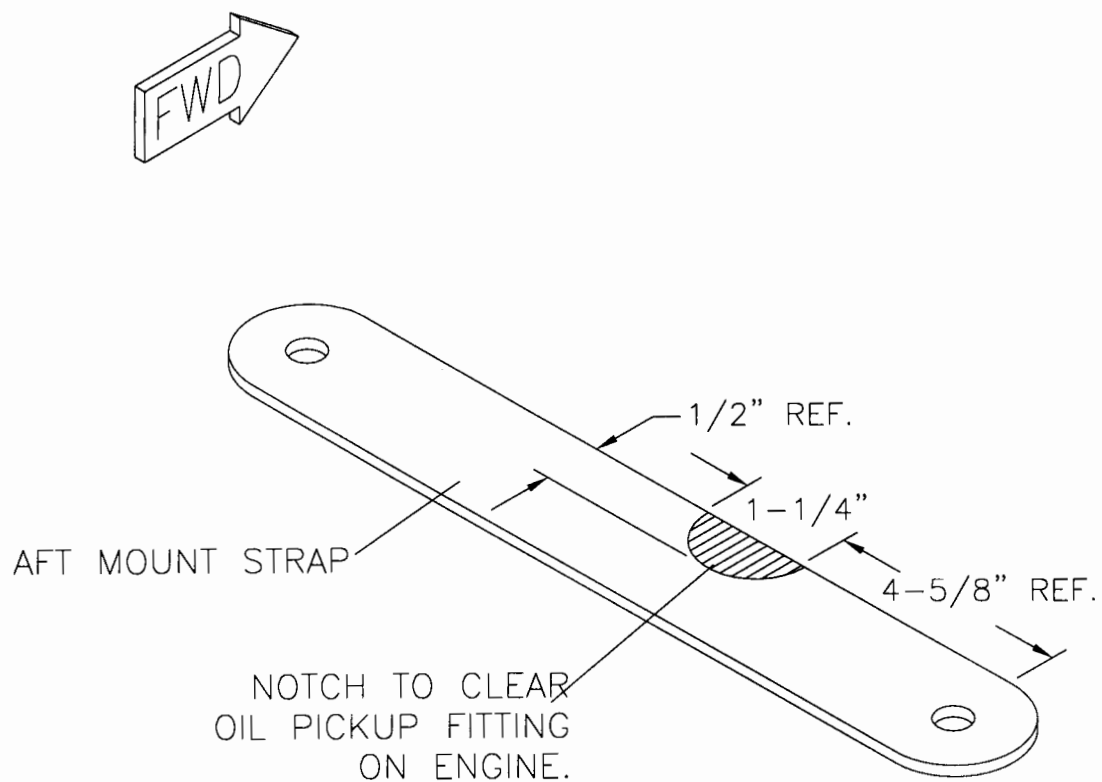


FIGURE 1-13A  
S-18 STINGER II



MD4244

FIGURE 1-13B  
S-18 STINGER II



MD4243

**FIGURE 1-13C**  
**S-18 STINGER II**

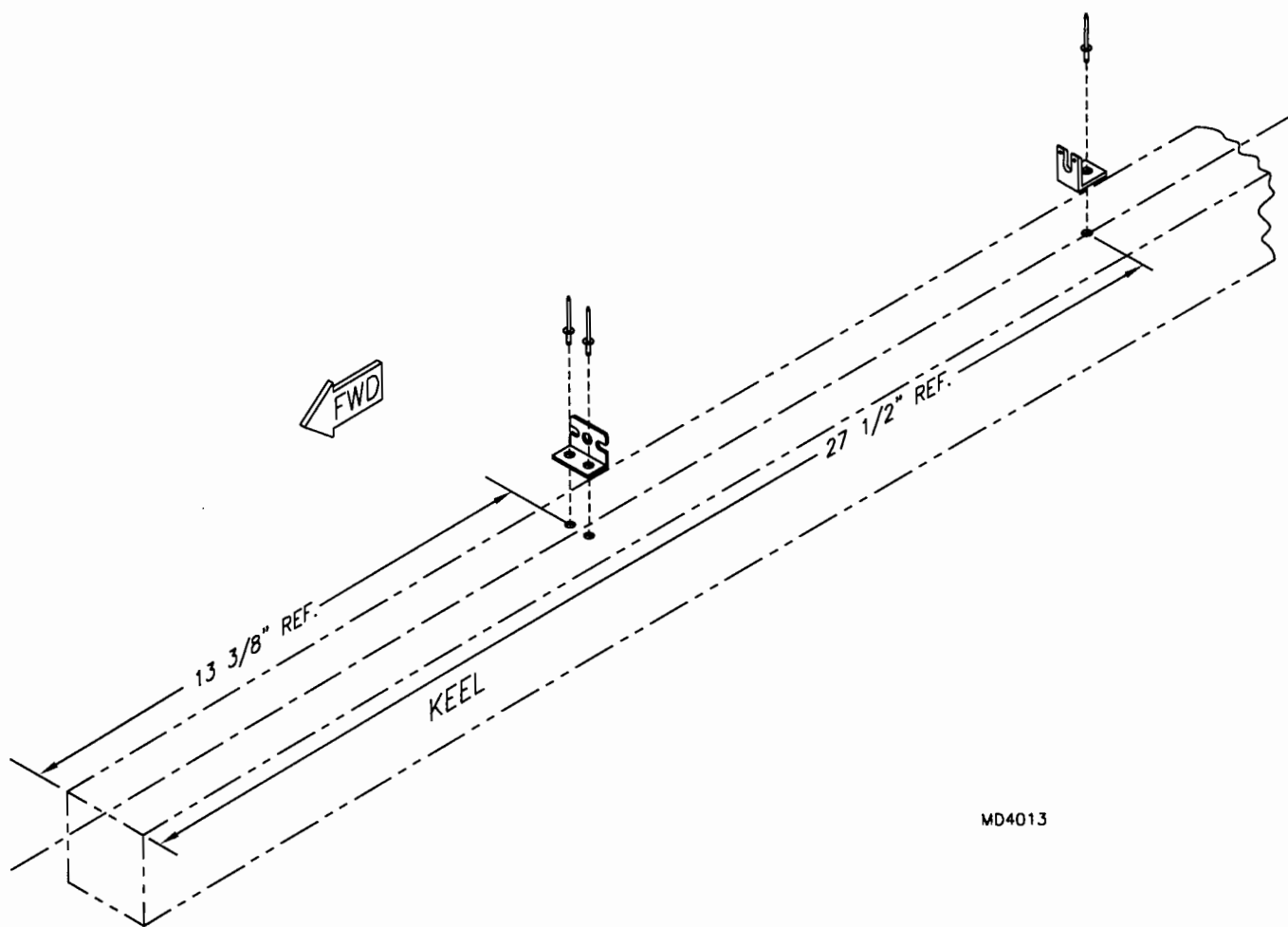
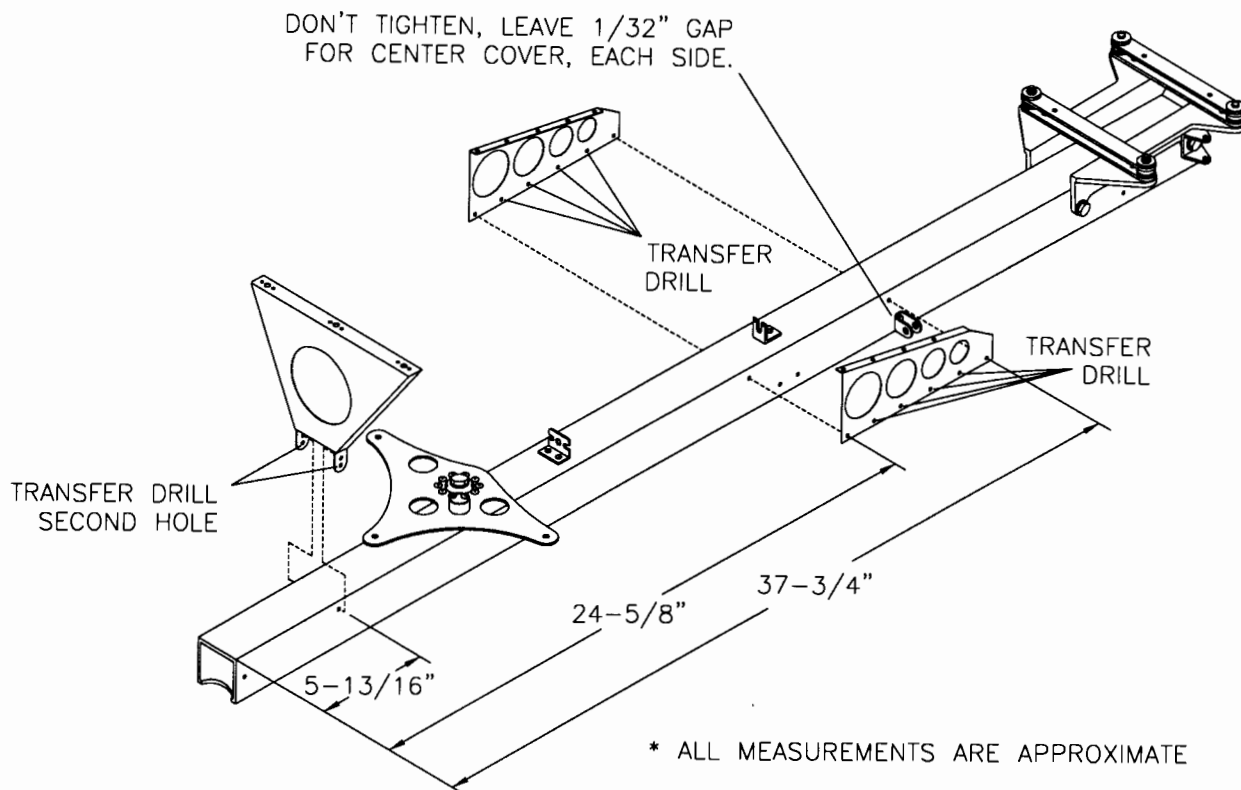
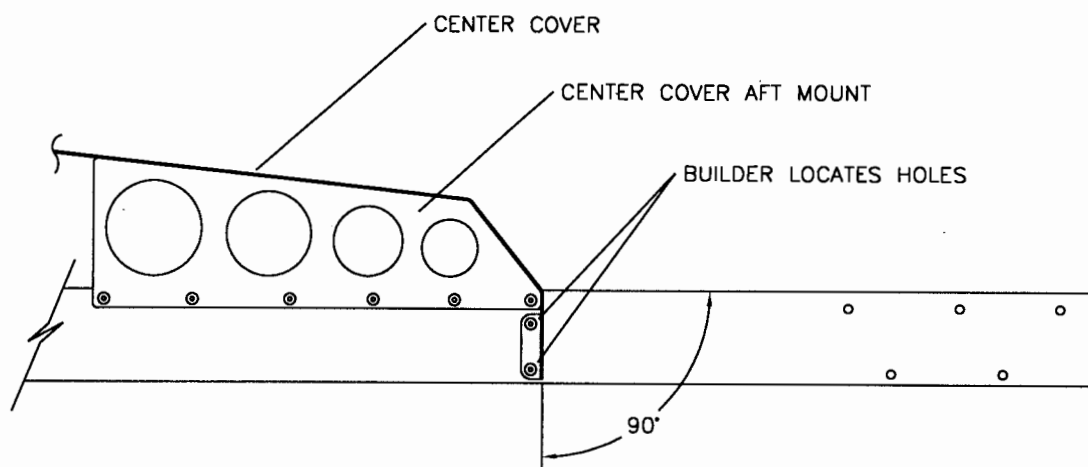
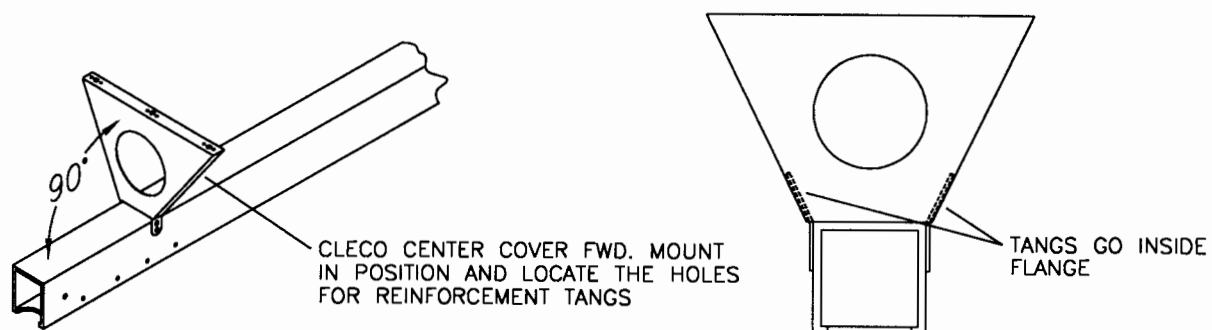


FIGURE 1-14  
S-18 STINGER II



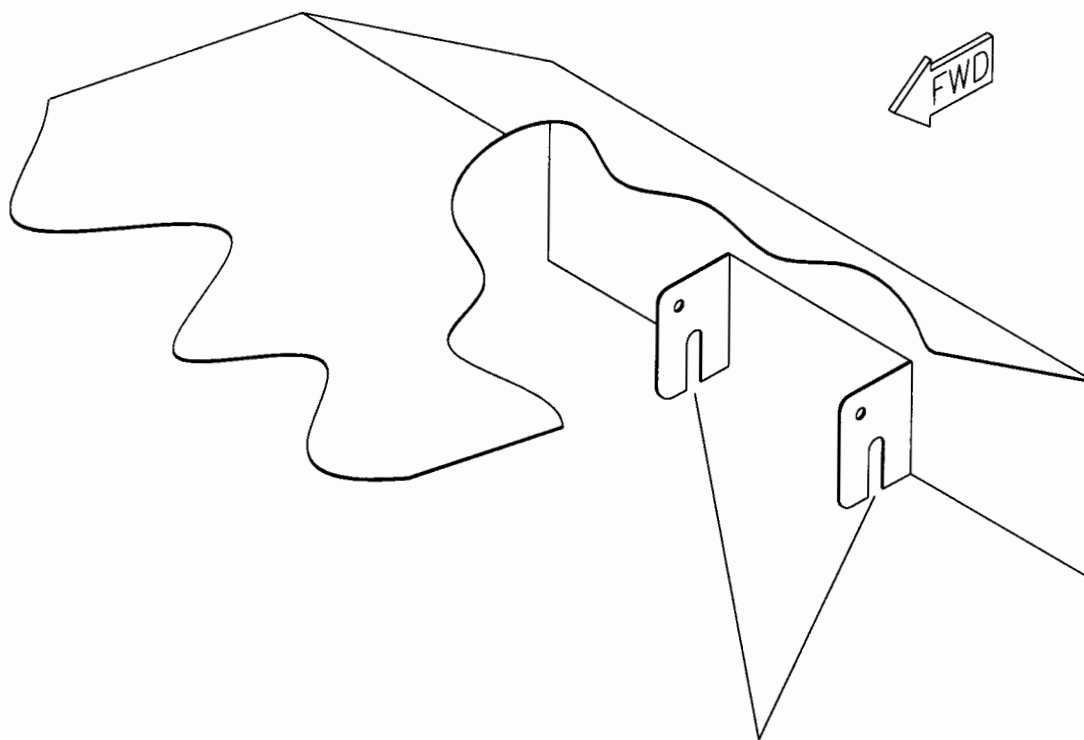
MD4022

**FIGURE 1-15**  
**S-18 STINGER II**



MD2417

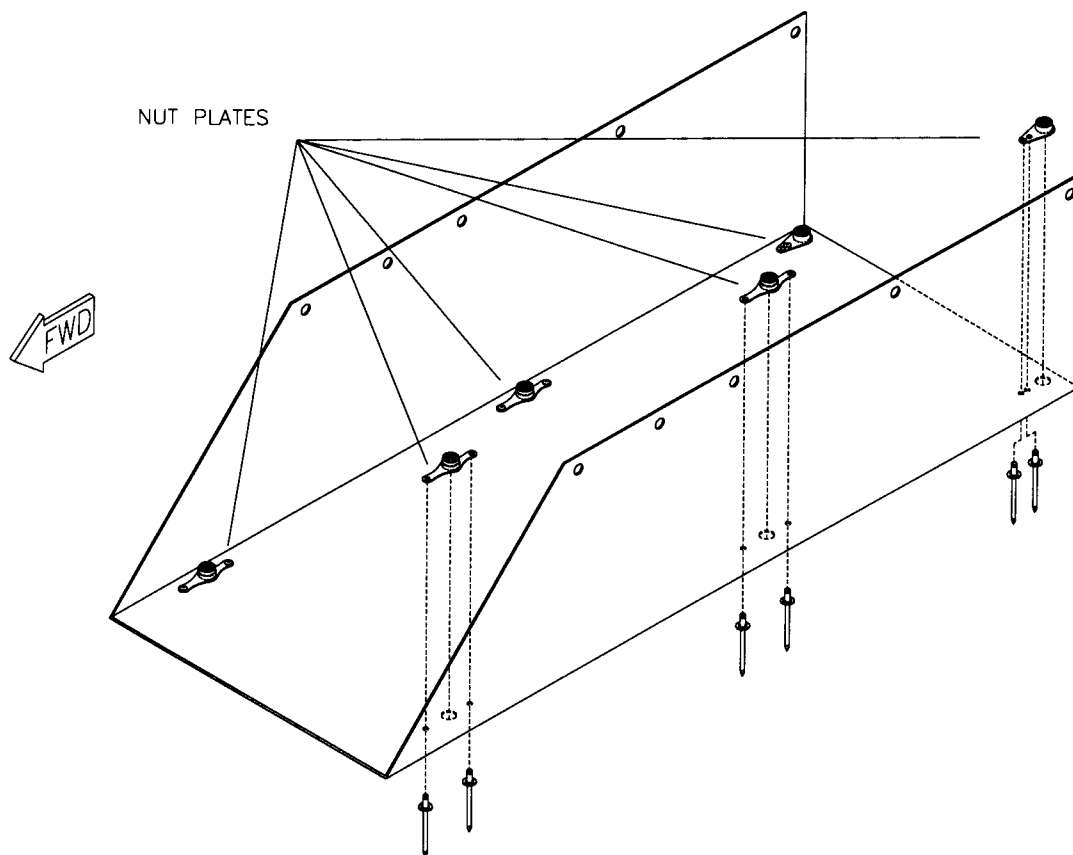
FIGURE 1-16  
S-18 STINGER II



SLOT TO SLIP UNDER  
BOLT HOLDING AILERON  
PULLEY BRACKETS

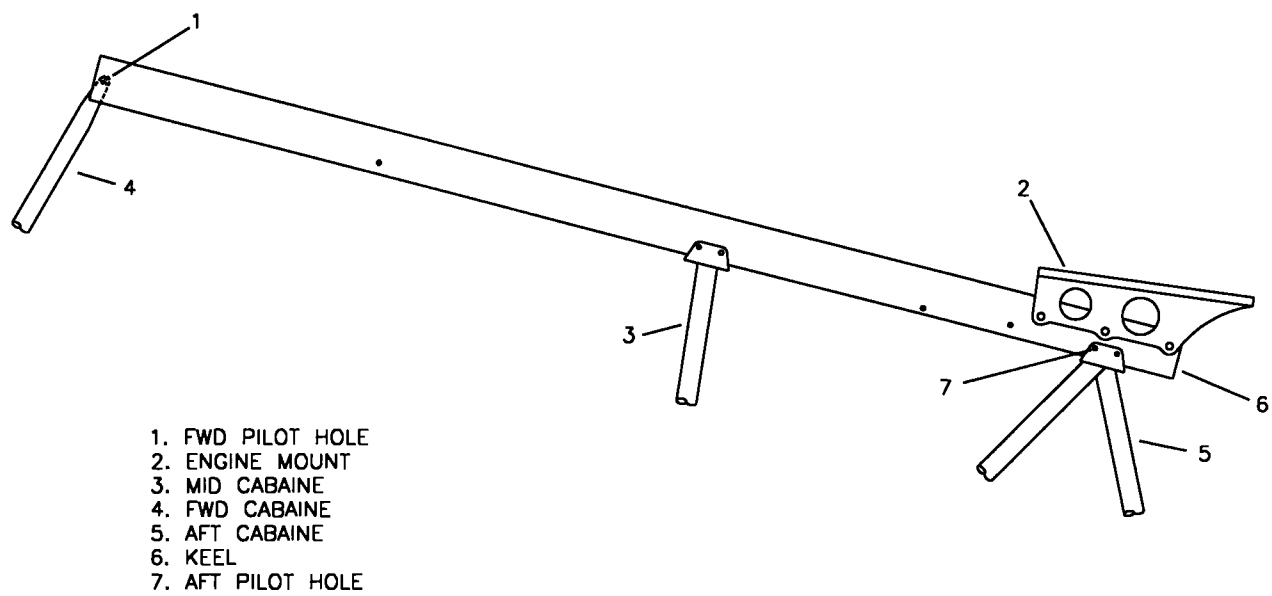
MD4023

**FIGURE 1-17**  
**S-18 STINGER II**



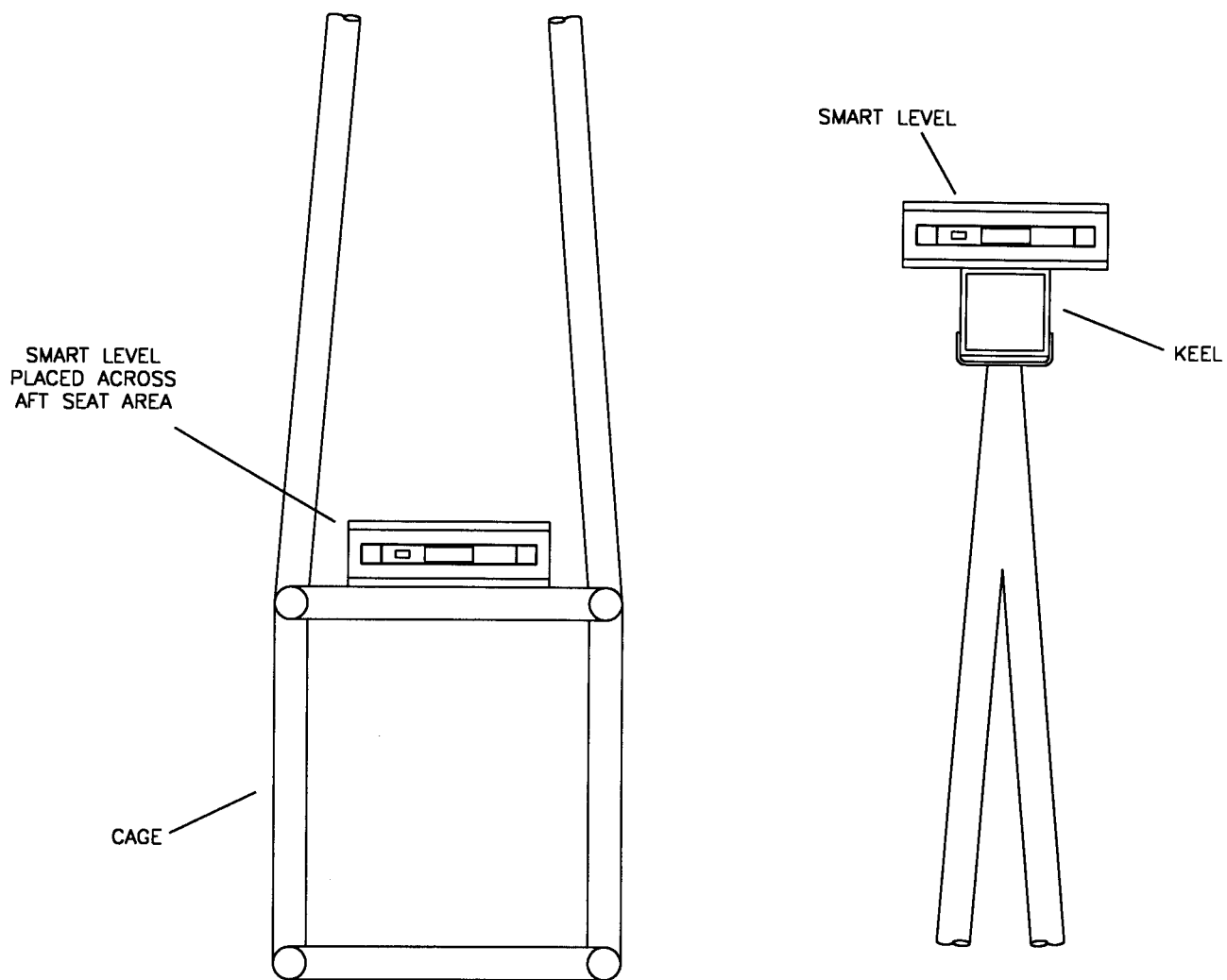
MD4024

FIGURE 1-18  
S-18 STINGER II



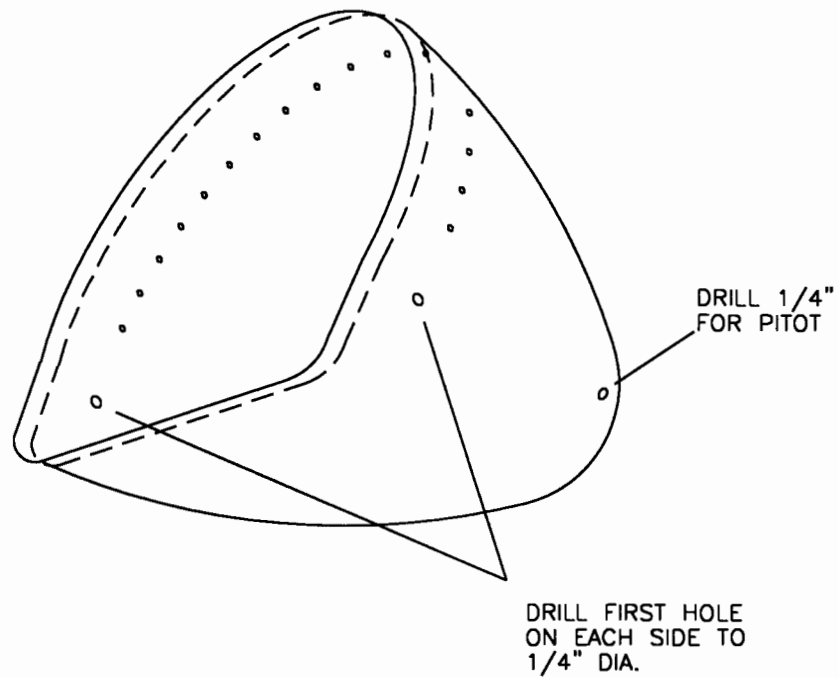
MD3951

FIGURE 1-19  
S-18 STINGER II

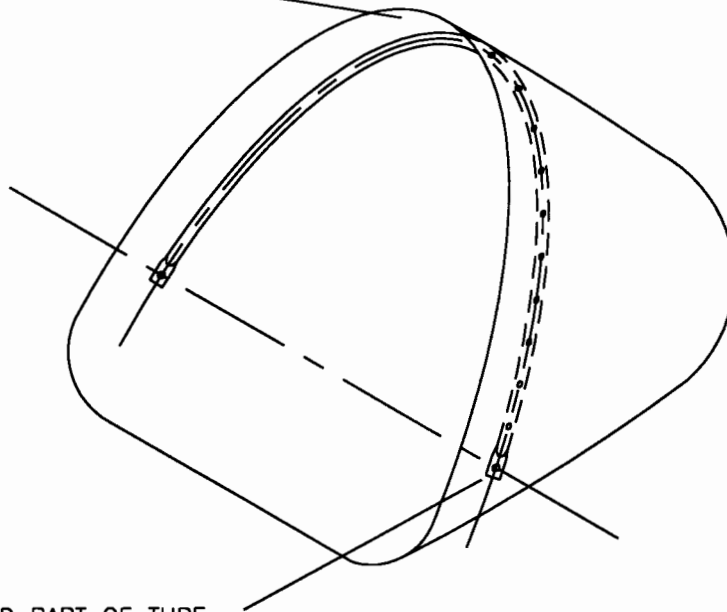


MD3952

FIGURE 1-20  
S-18 STINGER II



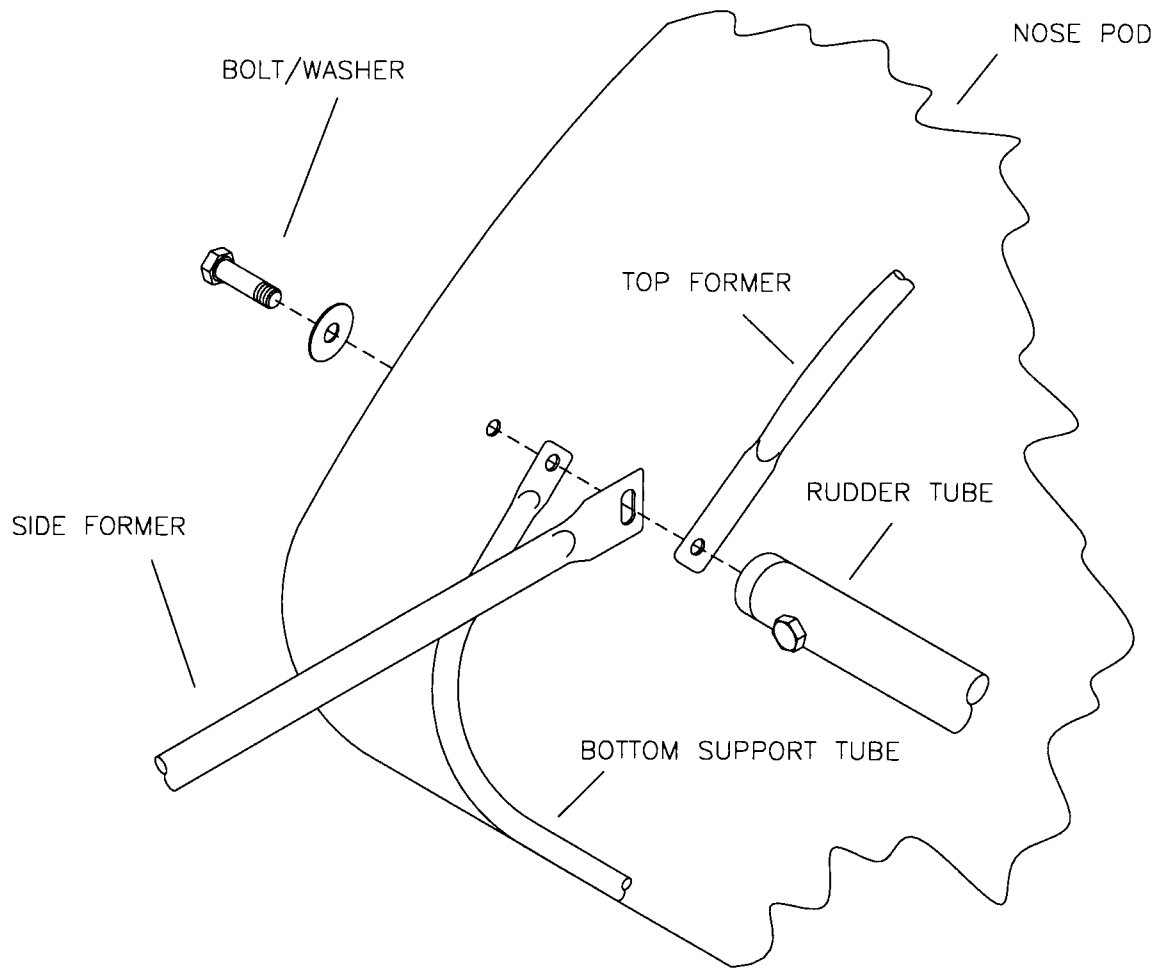
PLACE ARCH TUBE TIGHT AGAINST POD, CENTERED OVER TOP CENTER #30 HOLE



LINE-UP FLATTENED PART OF TUBE ON CENTER OVER 1/4" HOLE AND START TO DRILL 1/4". REMOVE AND DRILL THRU. TUBE ALL THE WAY. CLECO ARCH TUBE TO TOP AND PIN BOTTOM WITH 1/4" BOLTS. DRILL THE REMAINING #30 HOLES CENTERED ON TUBE.

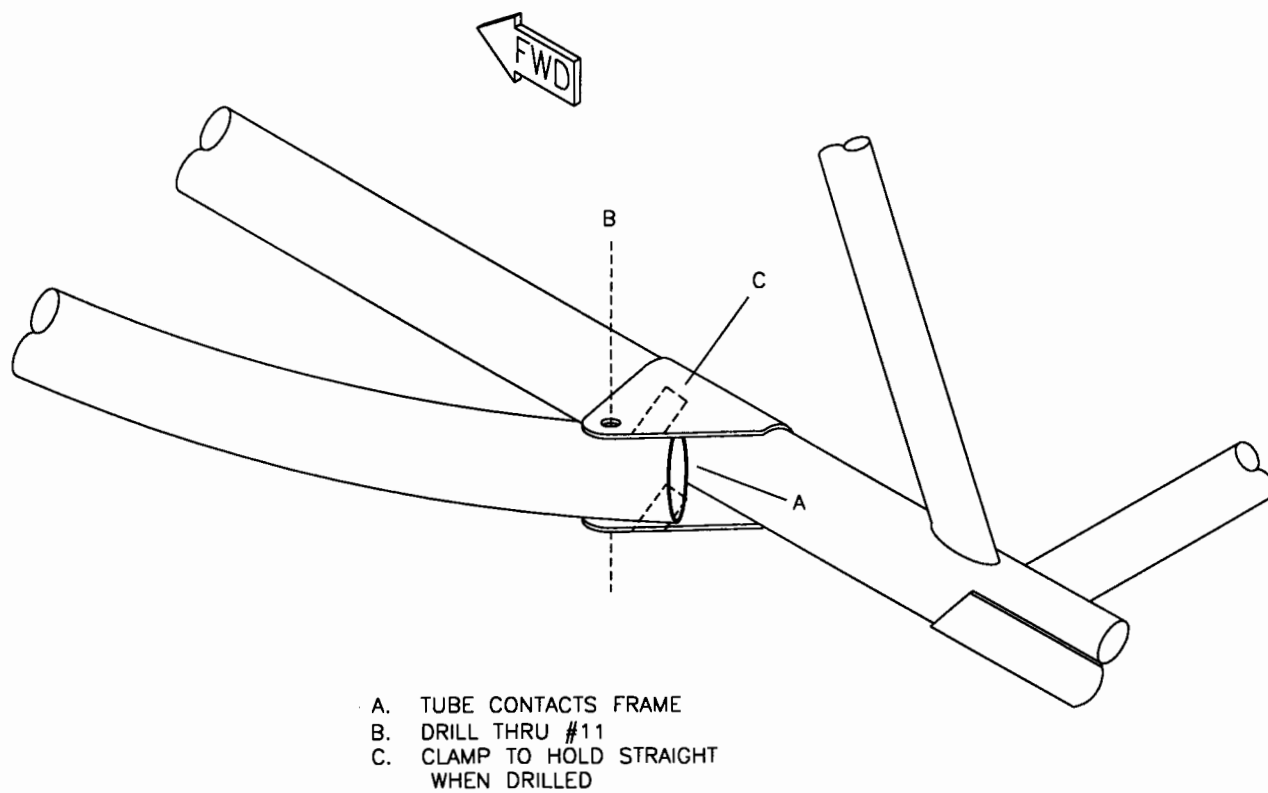
WD3836

FIGURE 1-21  
S-18 STINGER II



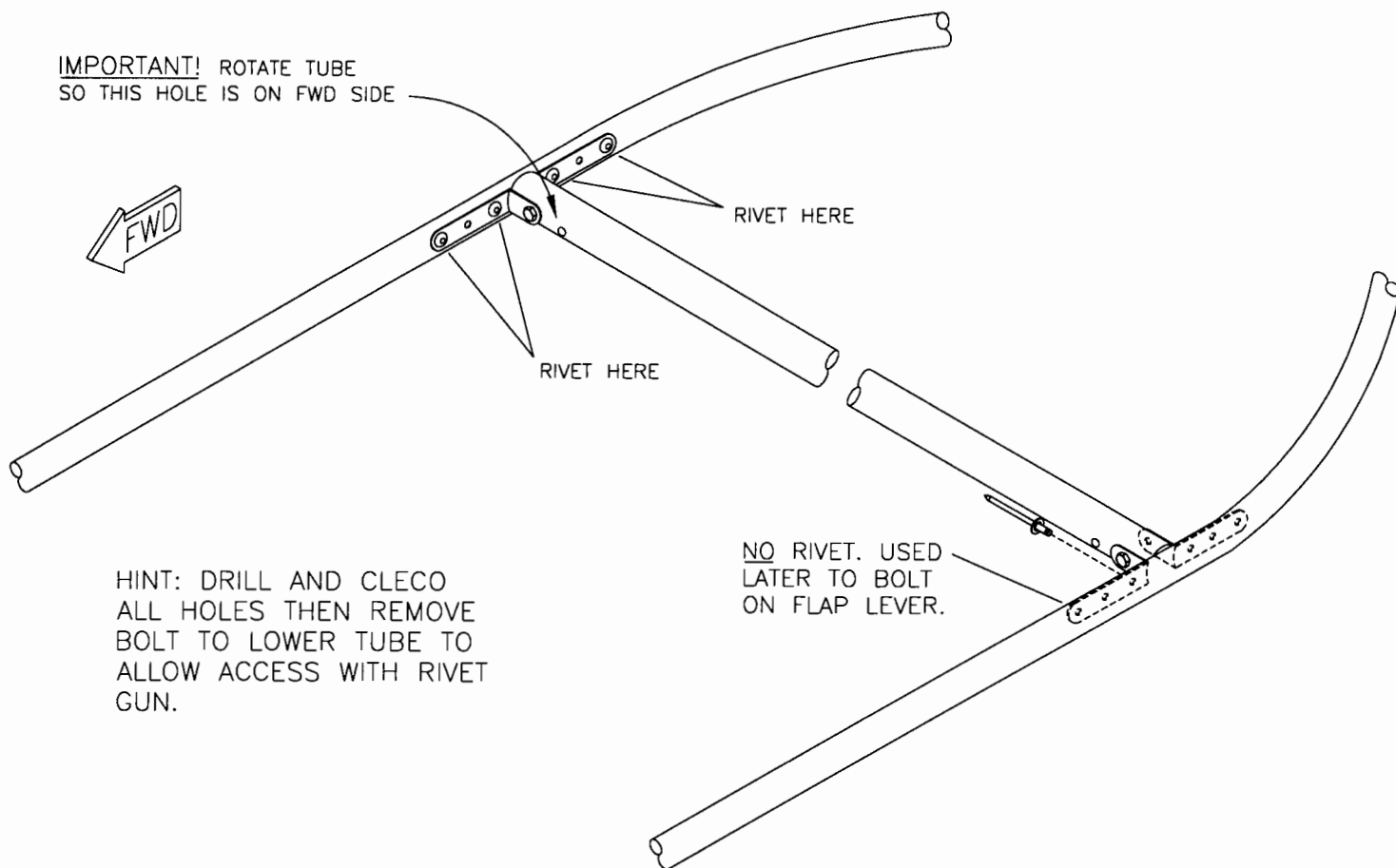
MD3995

**FIGURE 1-22**  
**S-18 STINGER II**



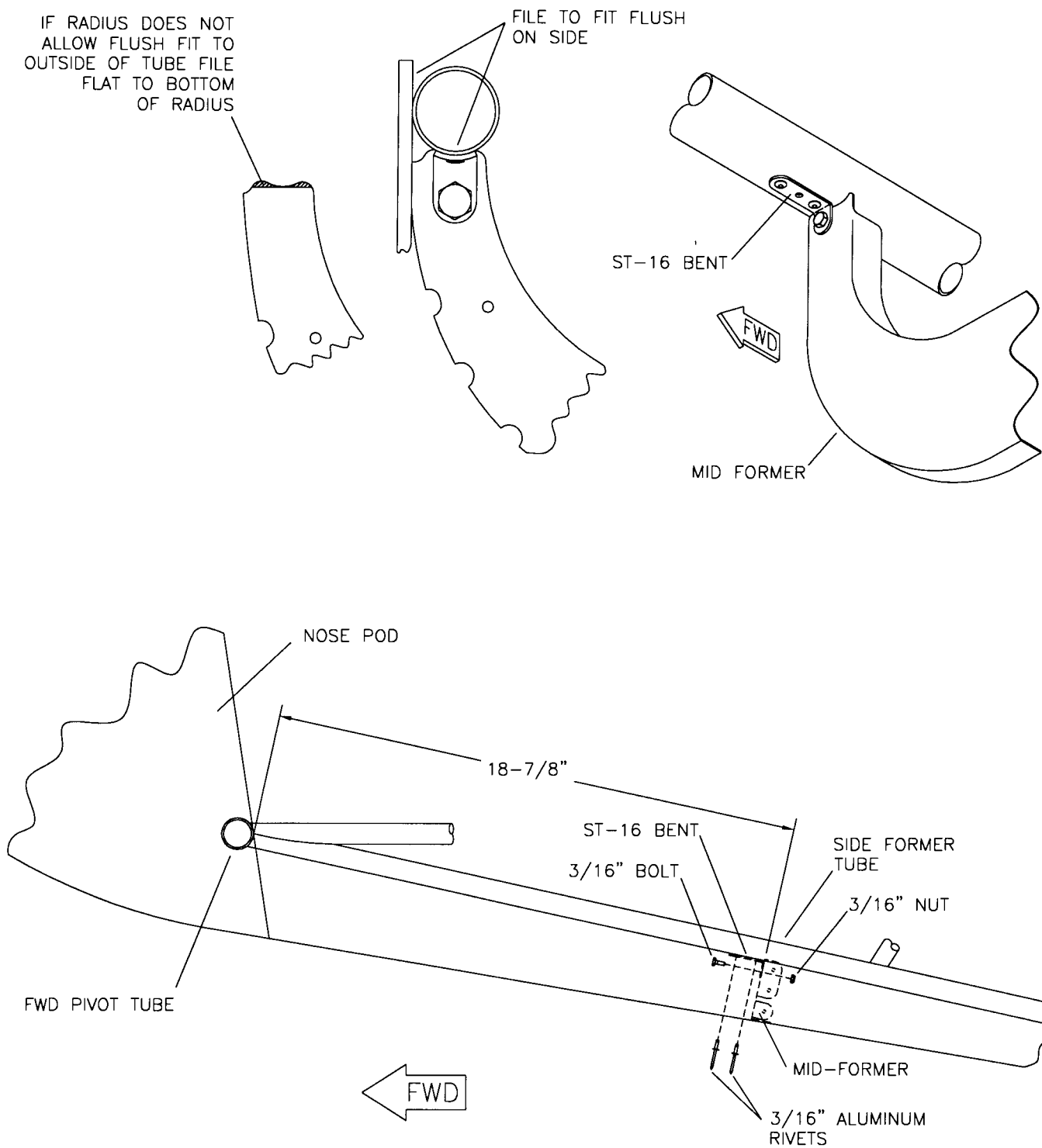
MD3996

FIGURE 1-23  
S-18 STINGER II



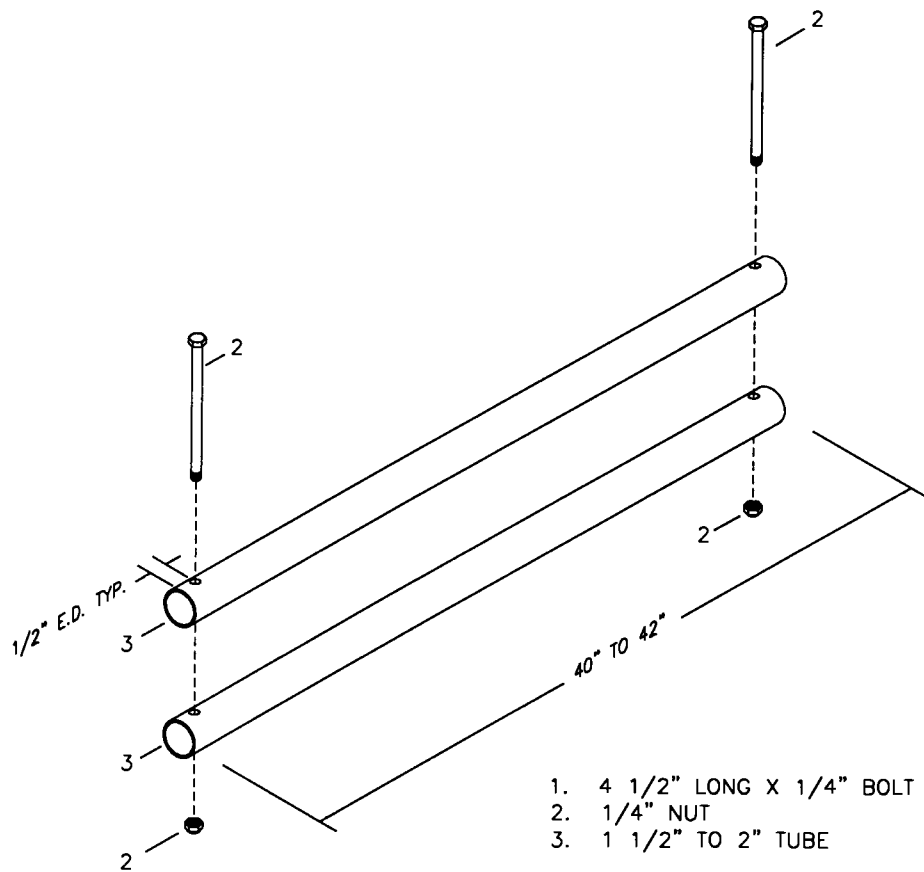
MD4002

**FIGURE 1-24**  
**S-18 STINGER II**



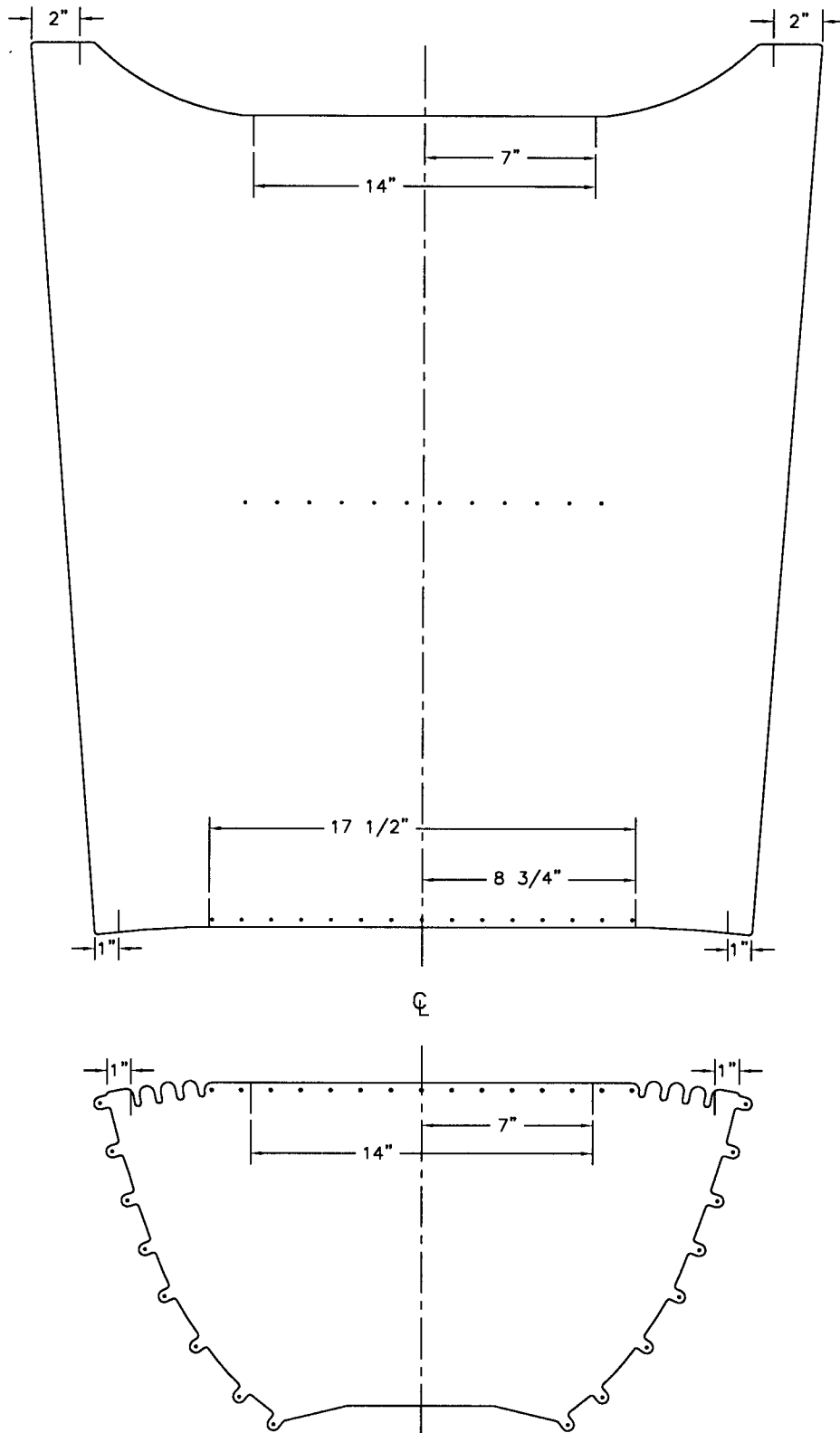
MD4004

**FIGURE 1-24A**  
**S-18 STINGER II**



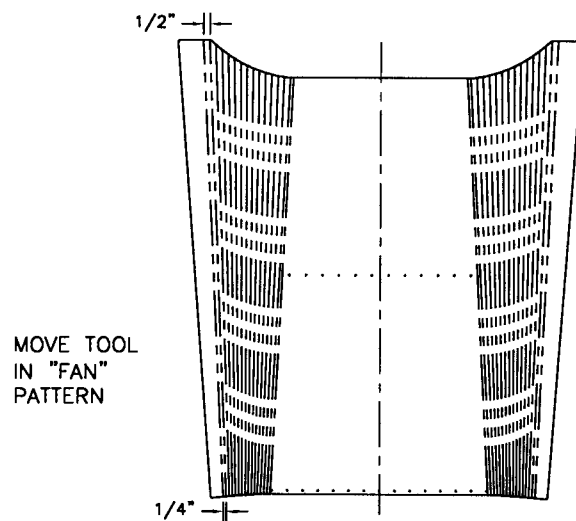
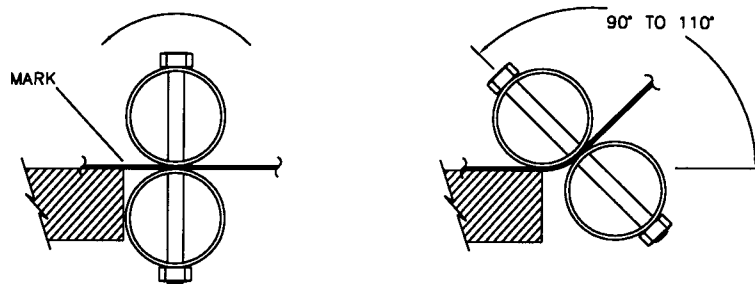
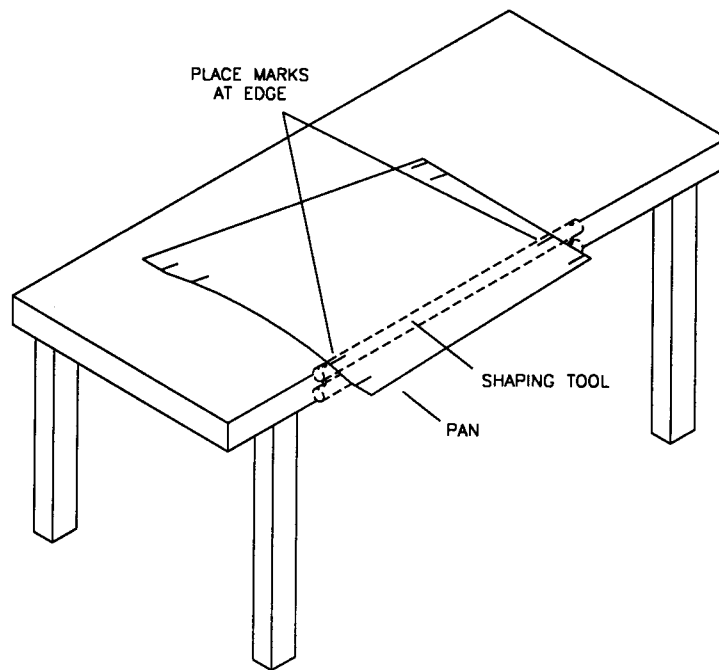
MD4012

FIGURE 1-25  
S-18 STINGER II



MD3997

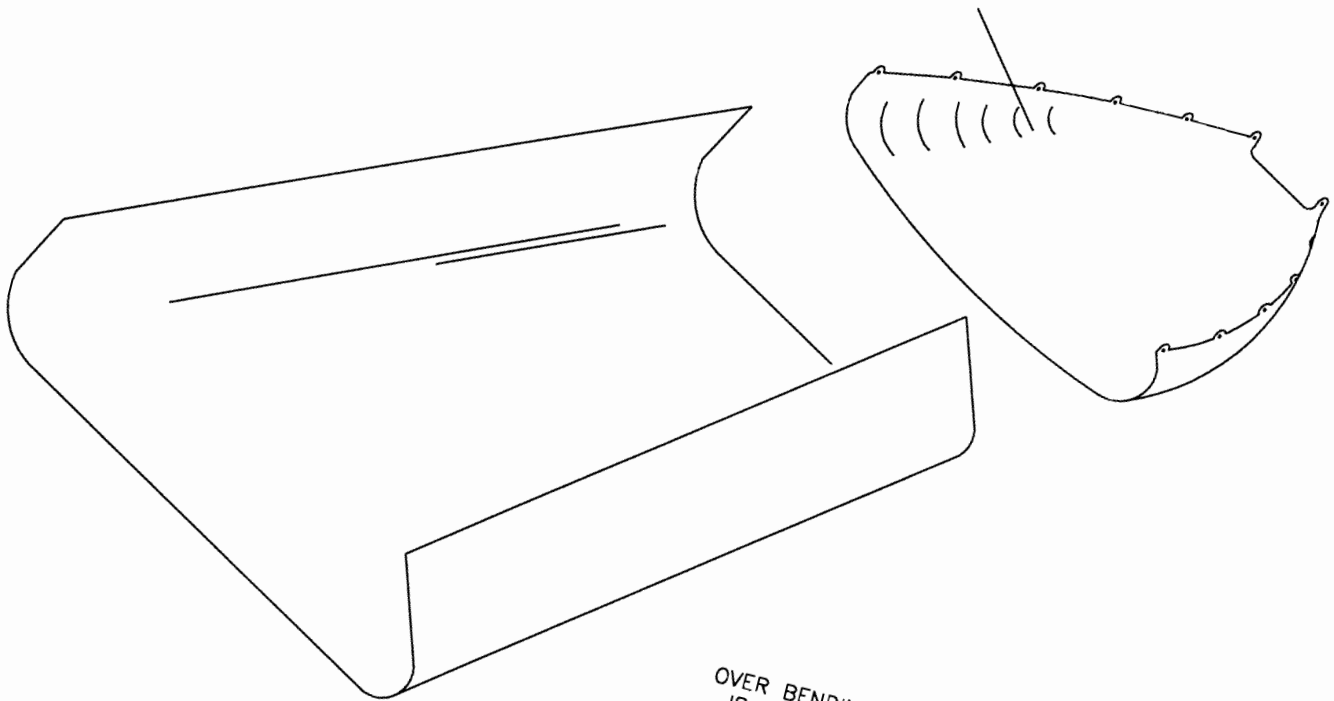
FIGURE 1-26  
S-18 STINGER II



MD3998

FIGURE 1-27  
S-18 STINGER II

HINT: BOW THE ENTIRE  
PAN ACROSS THE  
BOTTOM FOR BEST FIT.

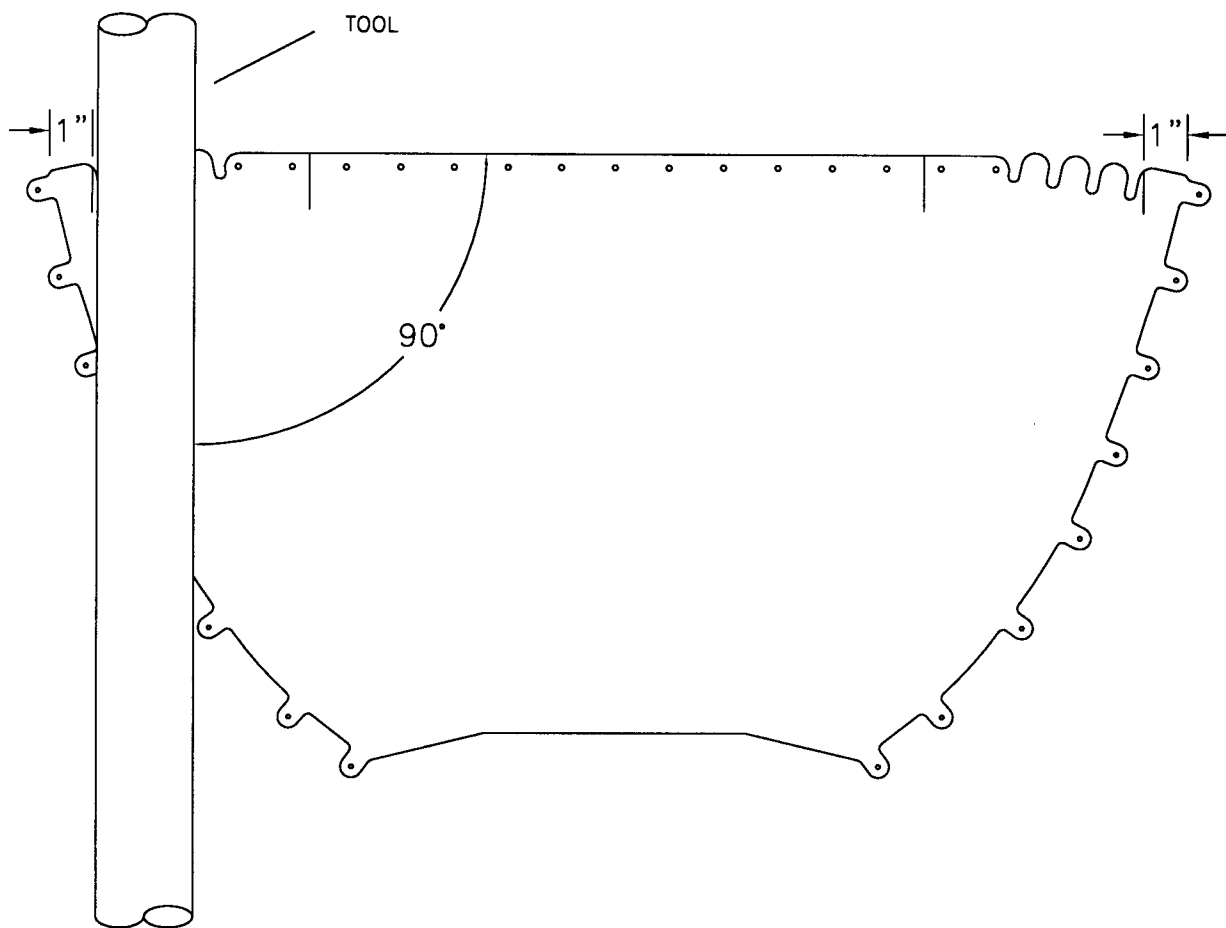


OVER BENDING  
IS DESIRED

FIGURE 1-28  
S-18 STINGER II

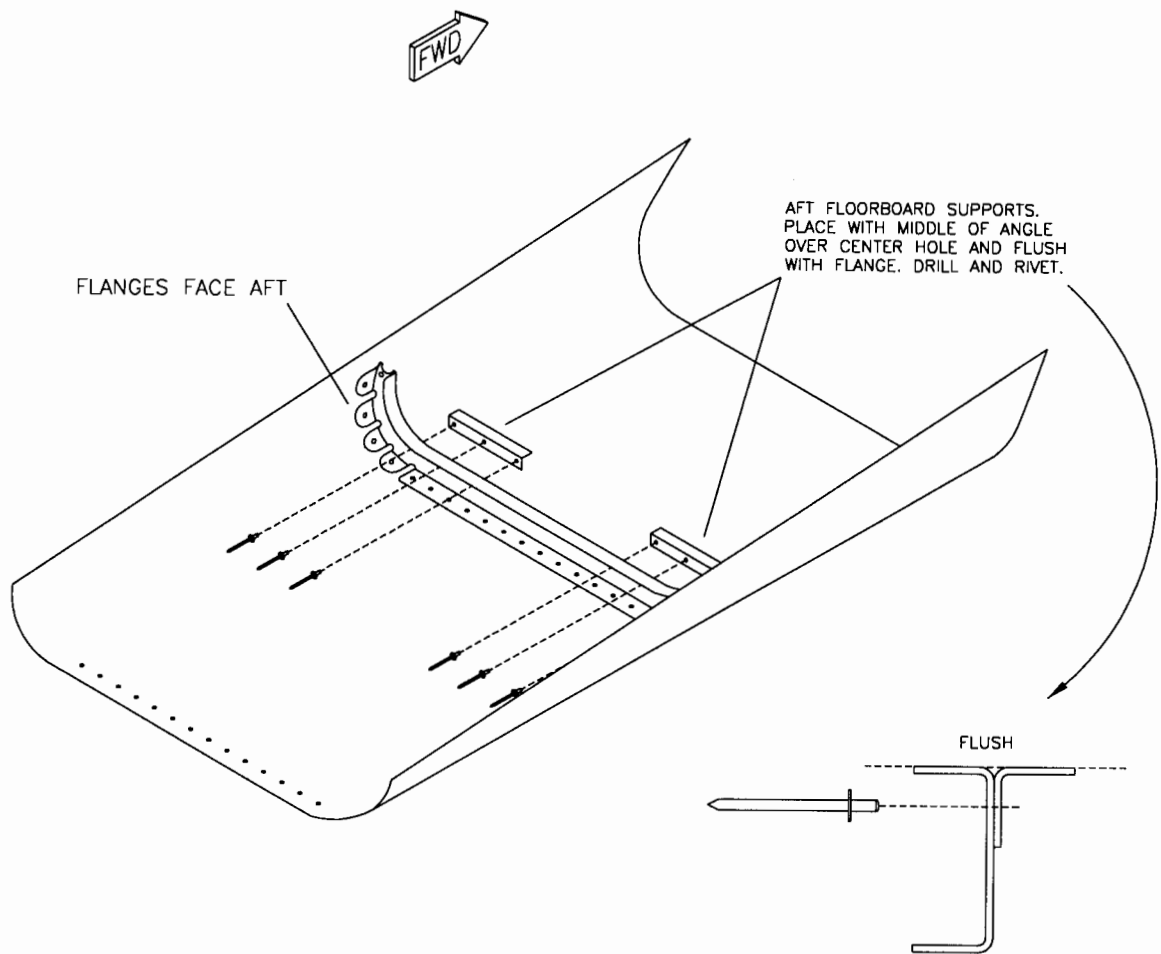
MD3999

3/6/01



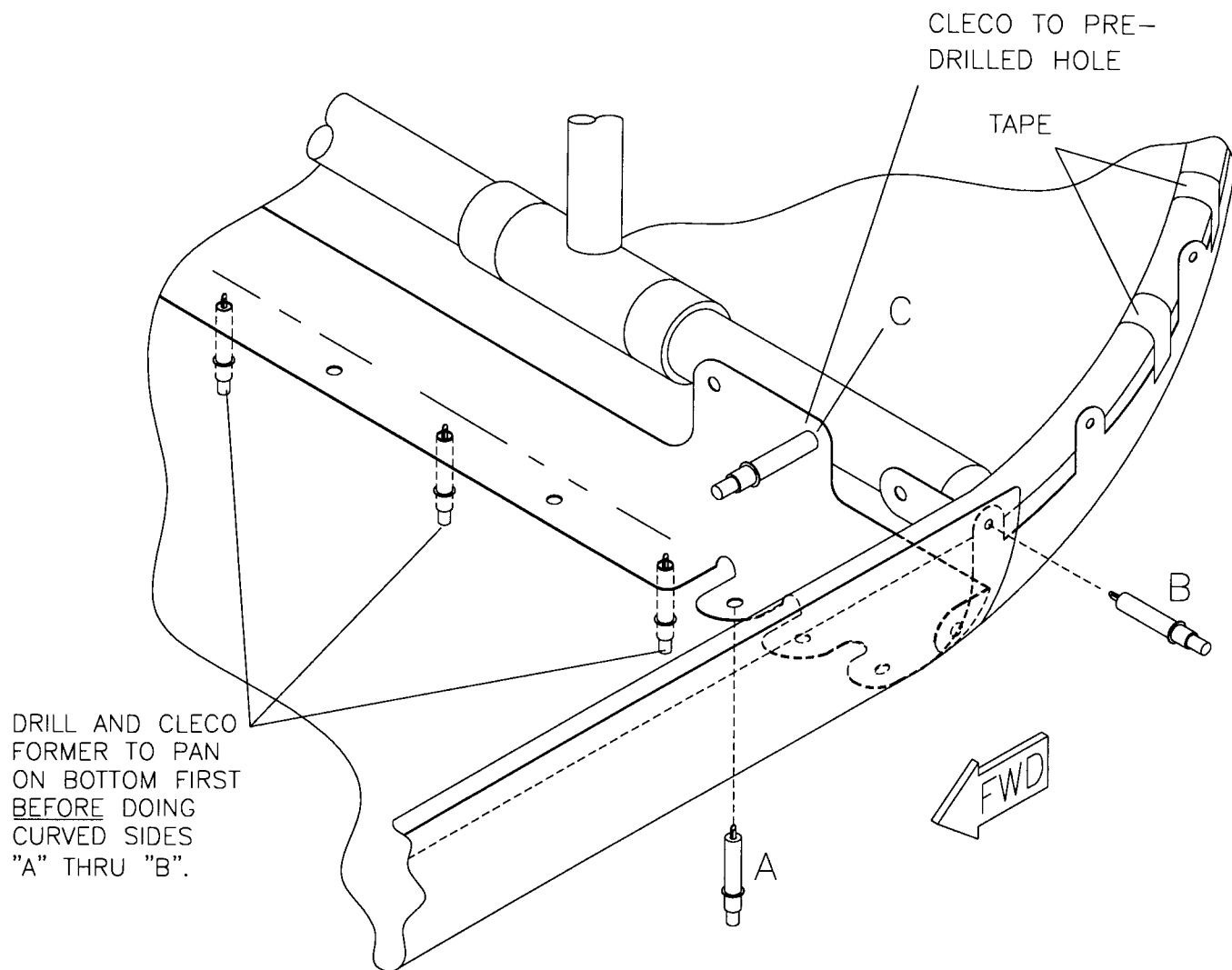
MD4000

FIGURE 1-29  
S-18 STINGER II



MD4001

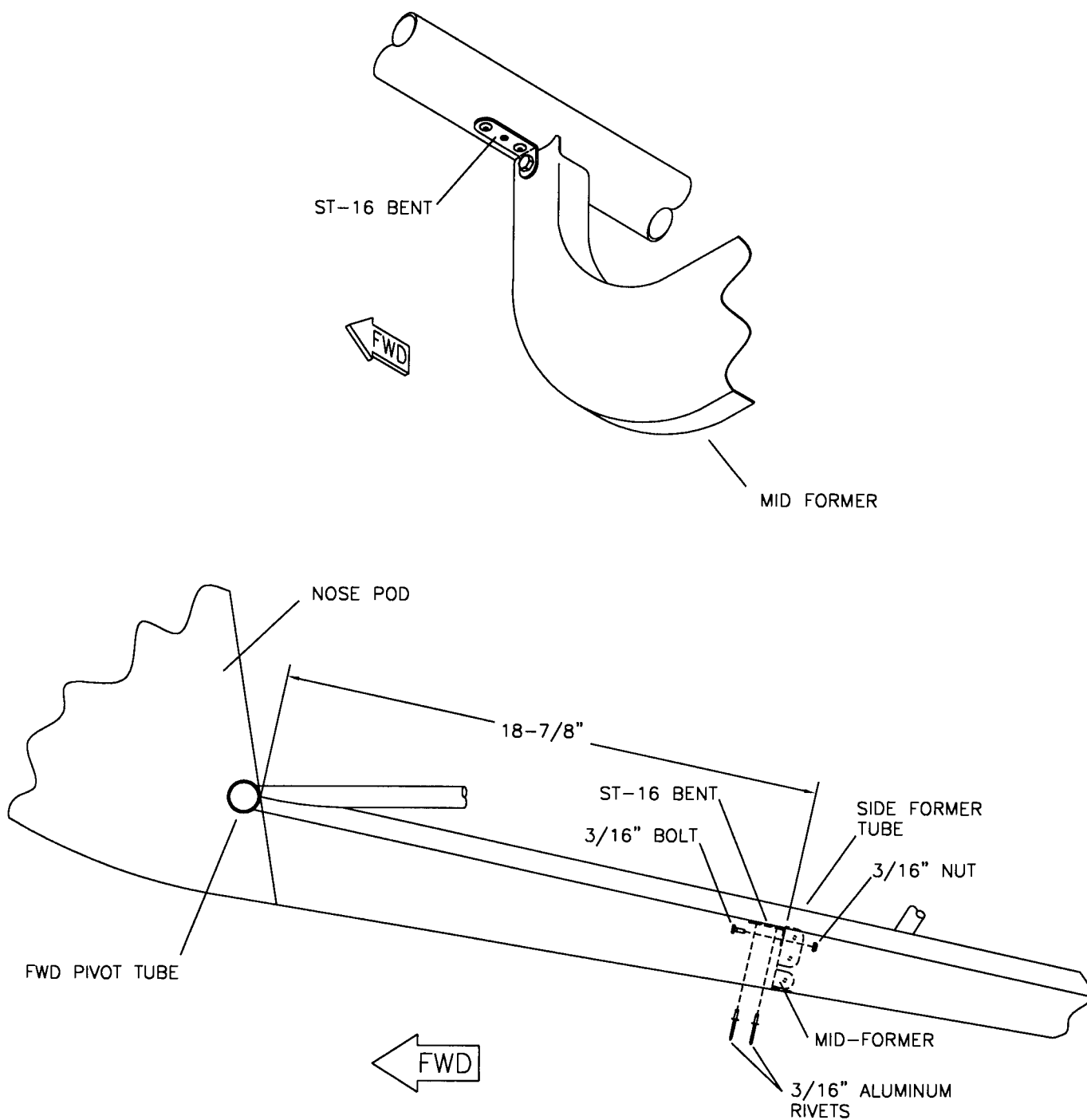
FIGURE 1-30  
S-18 STINGER II



NOTE: DRILLING FROM TOP WILL BE LIMITED DUE TO THE FRAME, AFTER A FEW CLECOS ARE IN FROM THE TOP USE PRE-DRILLED HOLES IN FWD PAN TO LOCATE AND THRU AFT PAN.

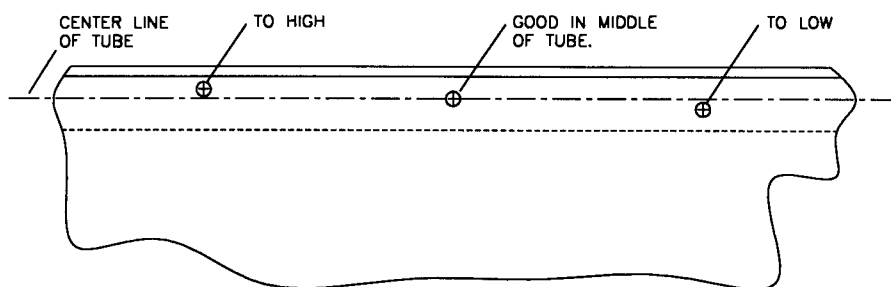
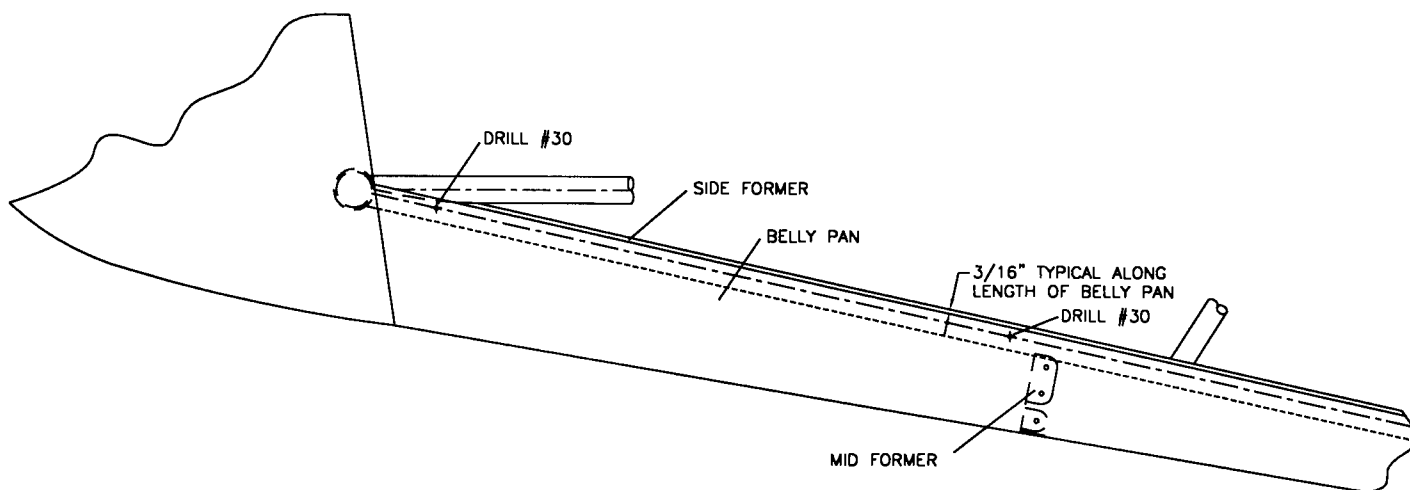
MD4003

**FIGURE 1-31**  
**S-18 STINGER II**



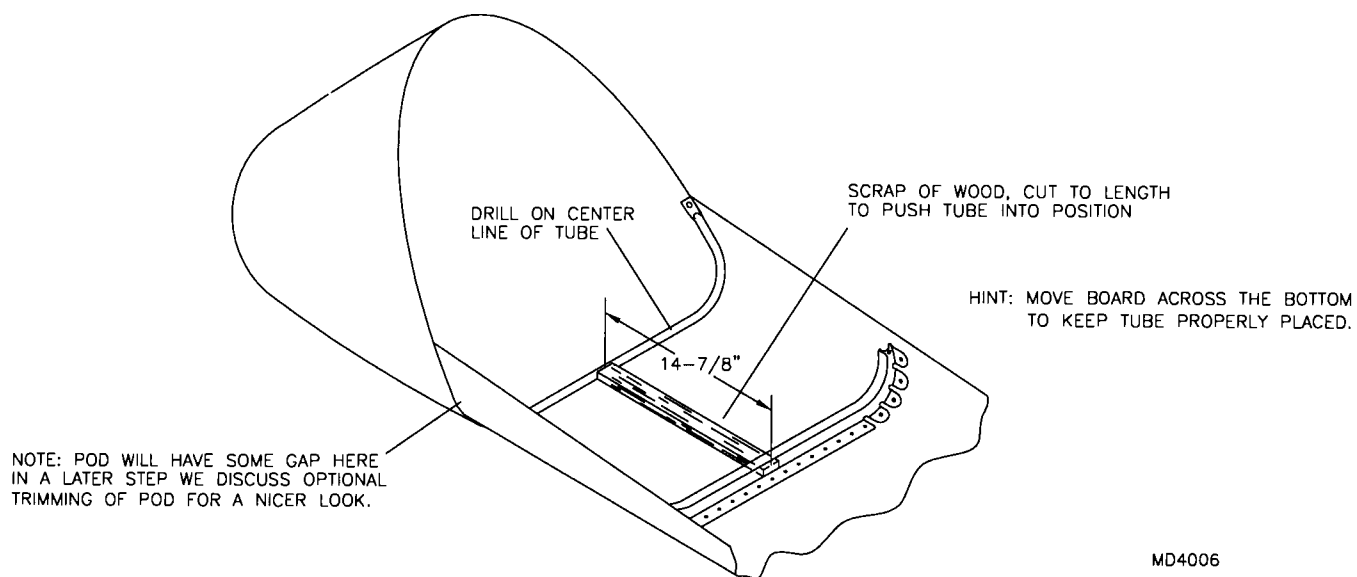
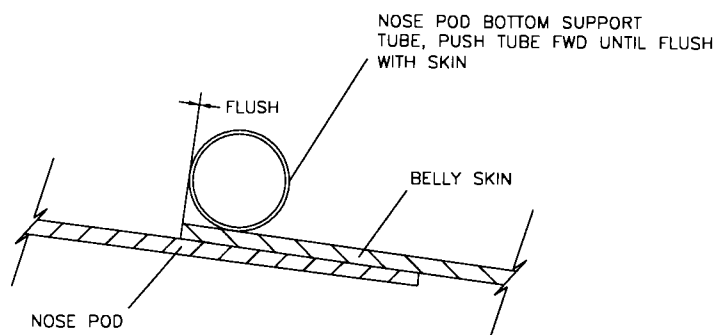
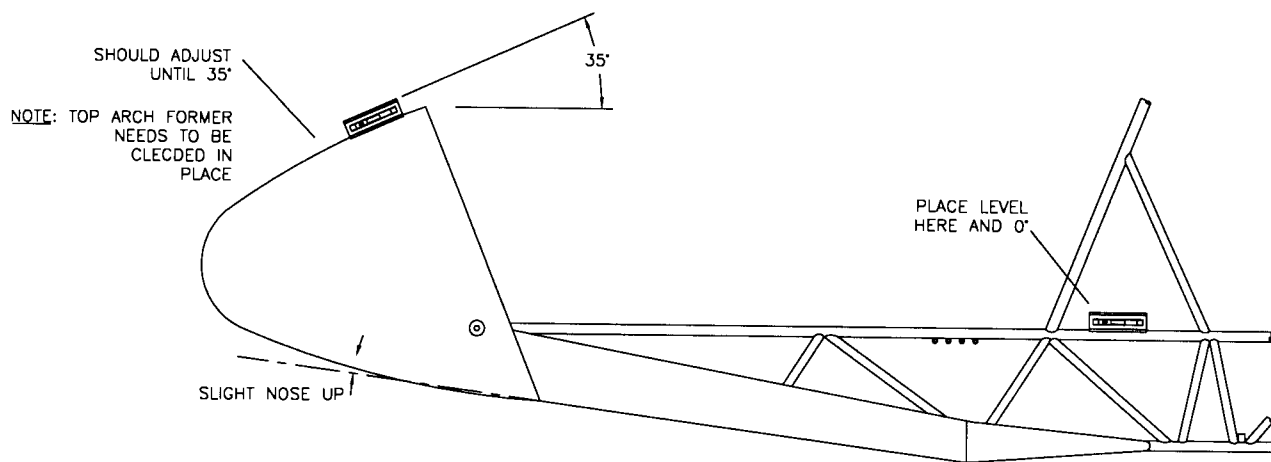
MD4004

FIGURE 1-32  
S-18 STINGER II



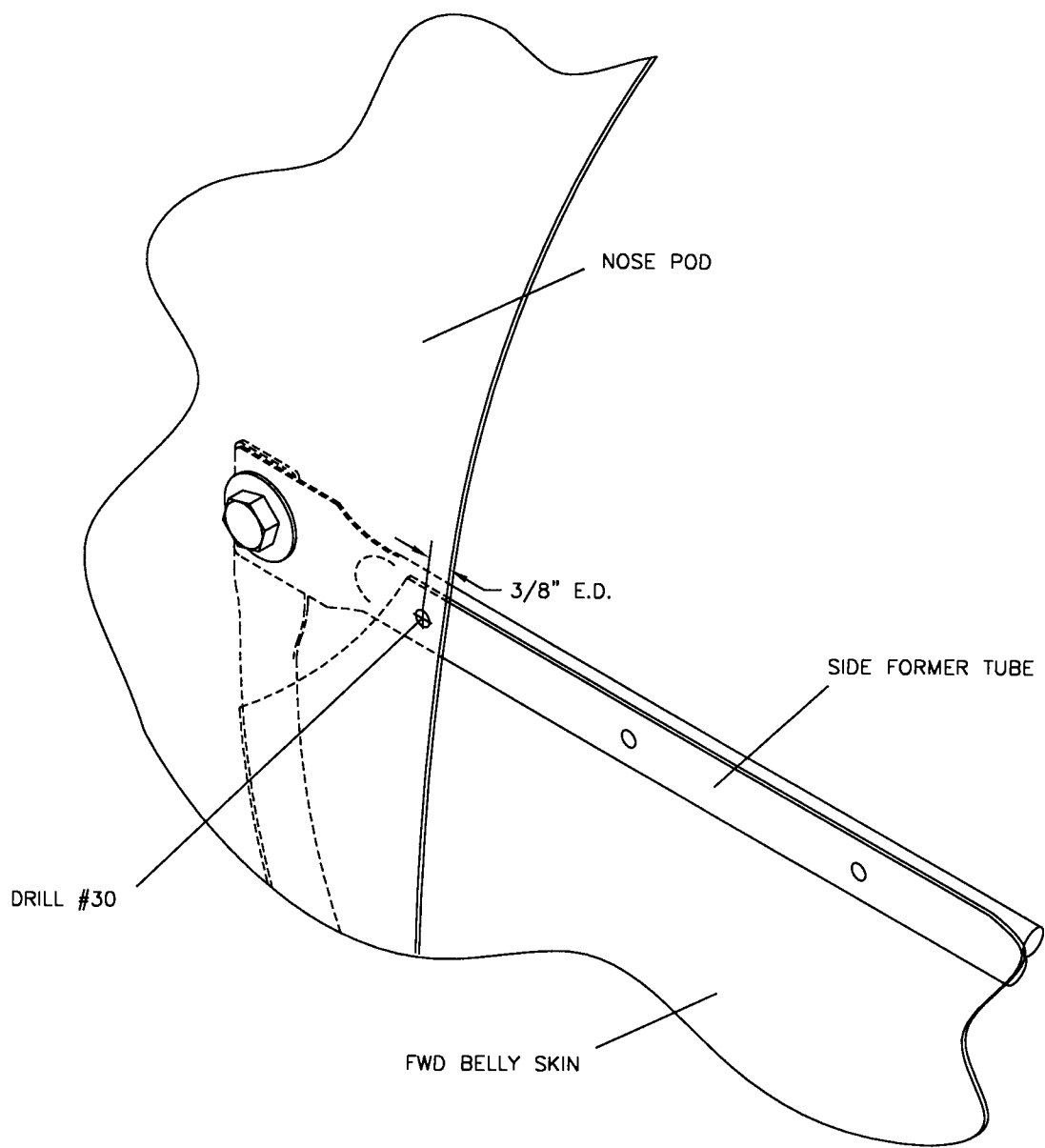
MD4005

FIGURE 1-33  
S-18 STINGER II



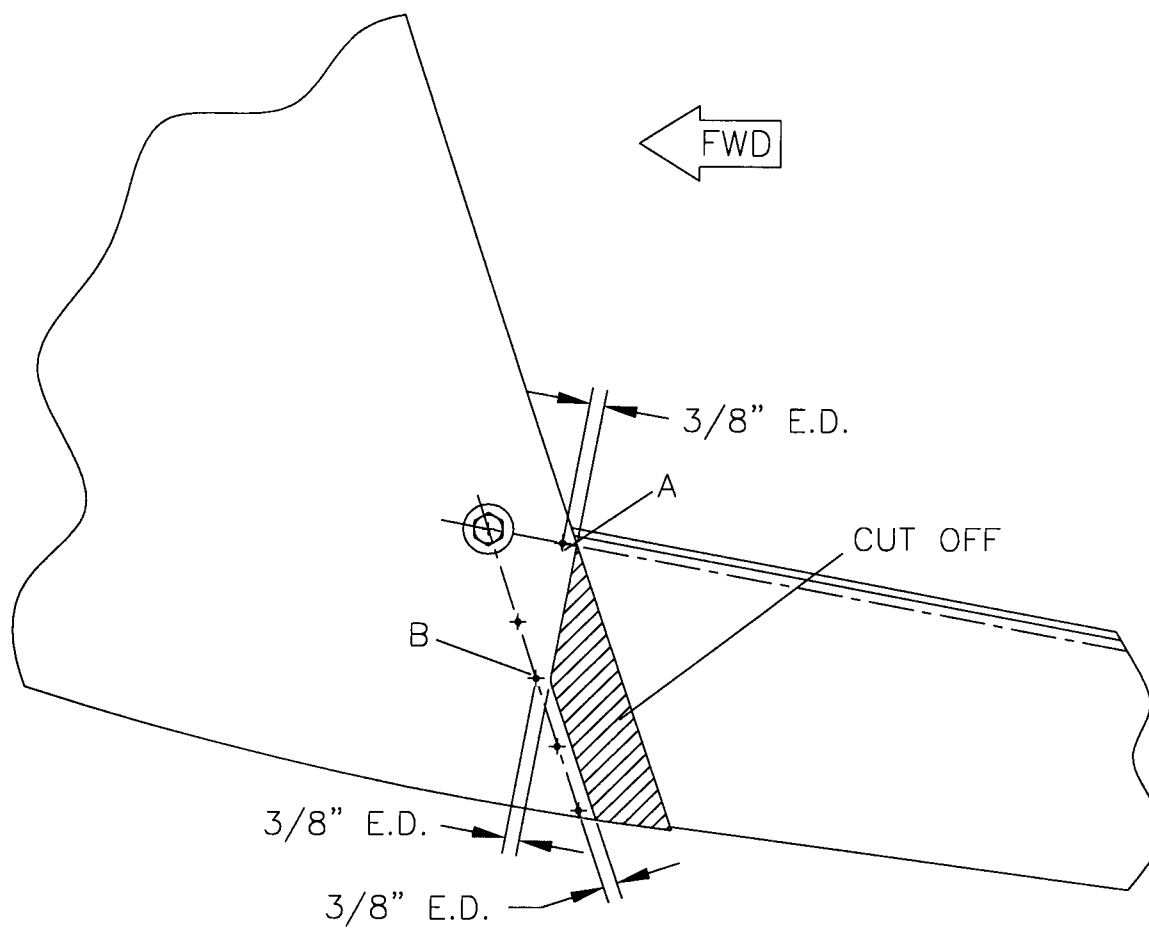
MD4006

**FIGURE 1-34**  
**S-18 STINGER II**



MD4007

FIGURE 1-35  
S-18 STINGER II



MD4008

FIGURE 1-36  
S-18 STINGER II

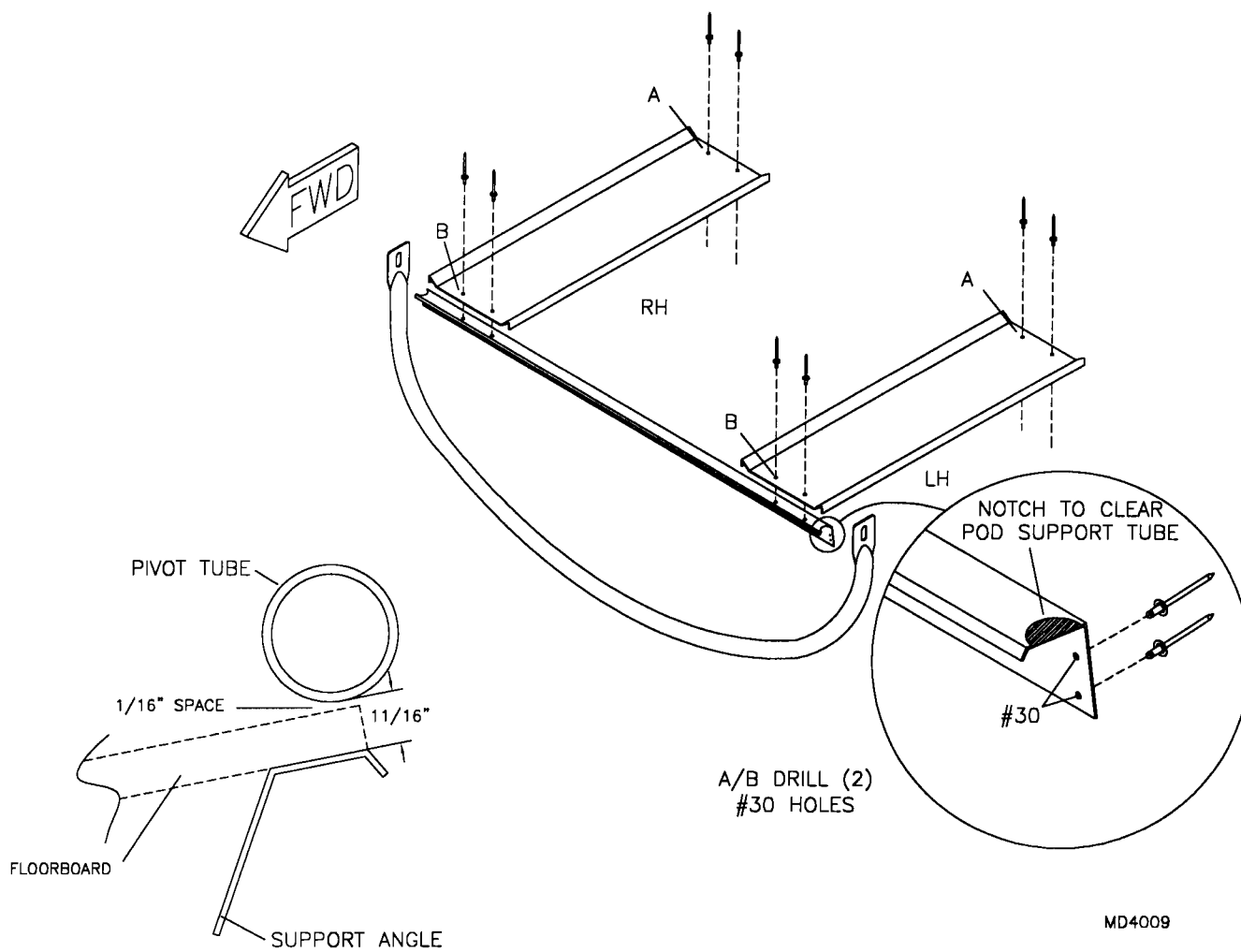


FIGURE 1-37  
S-18 STINGER II

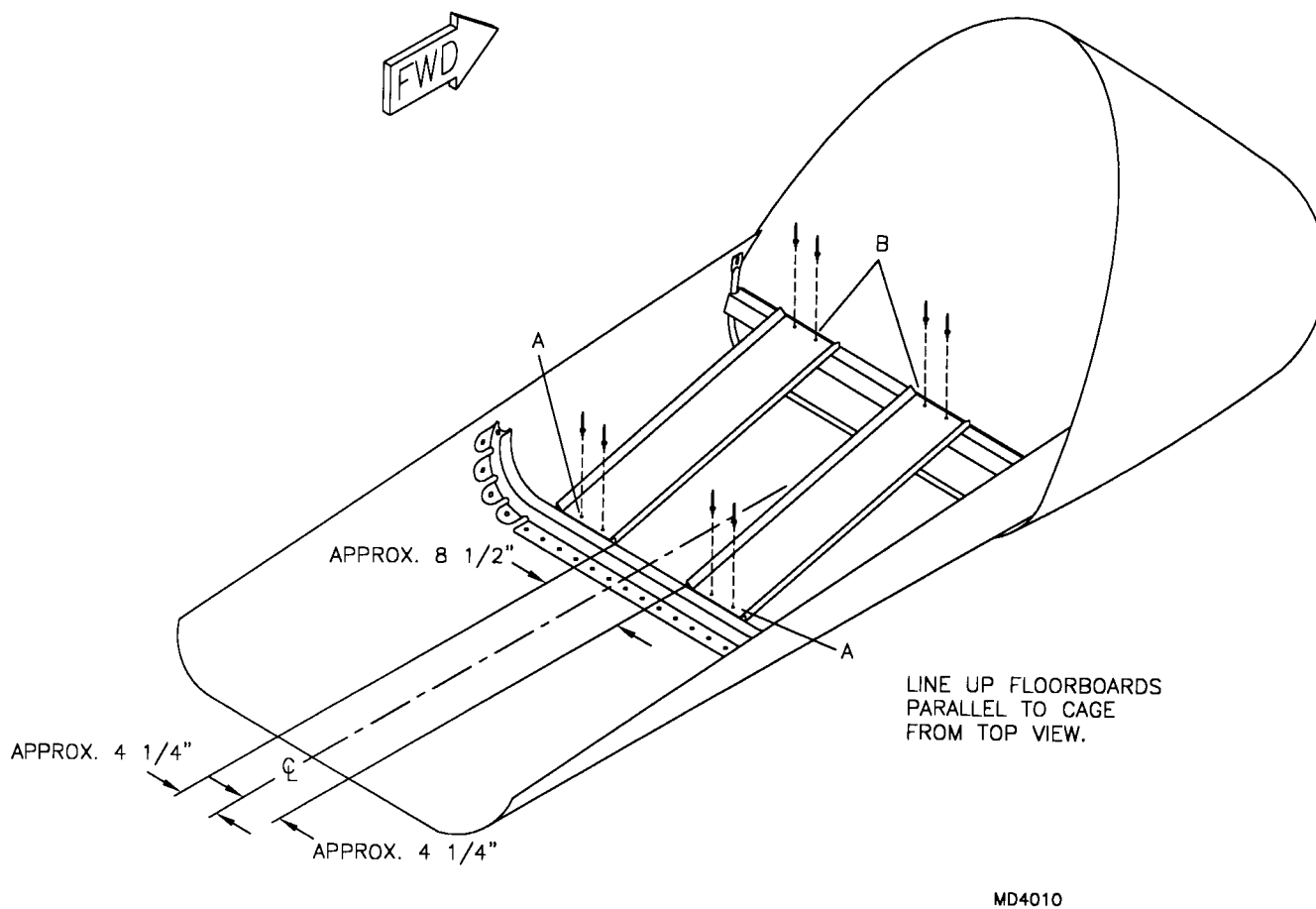
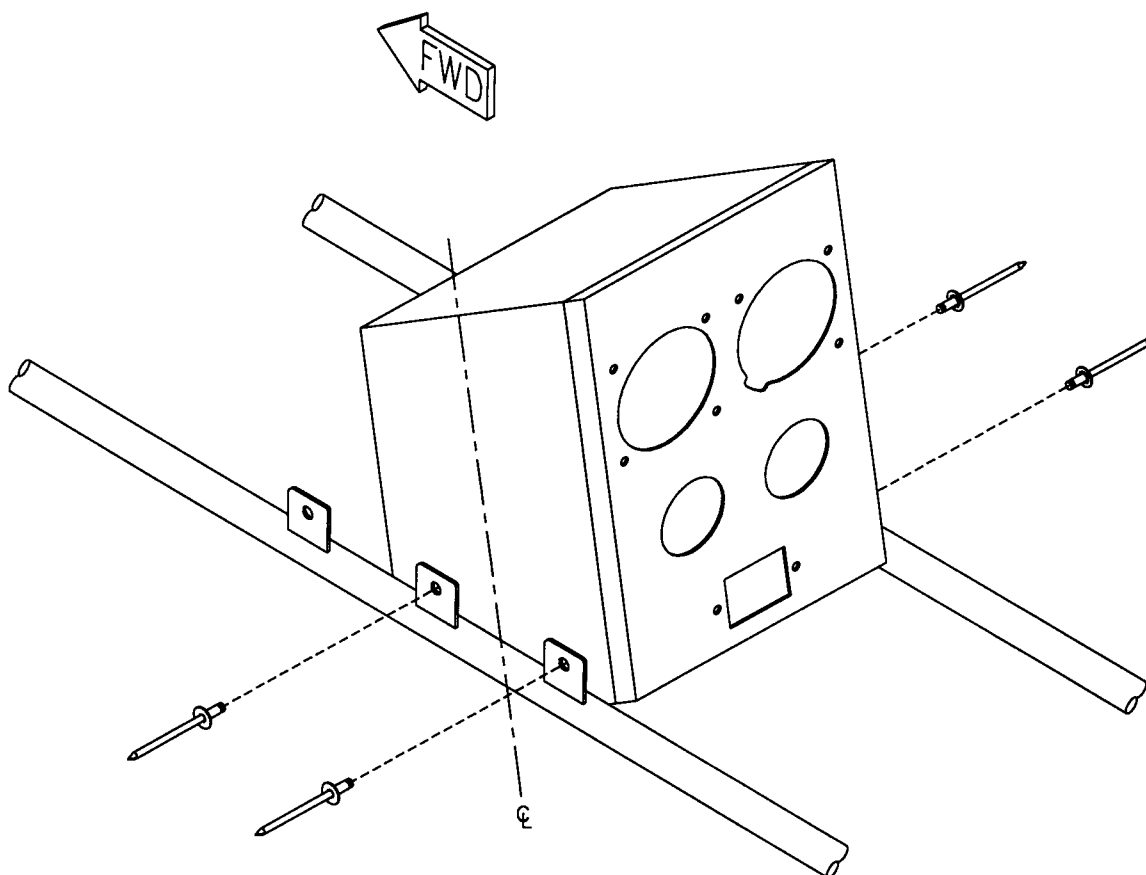


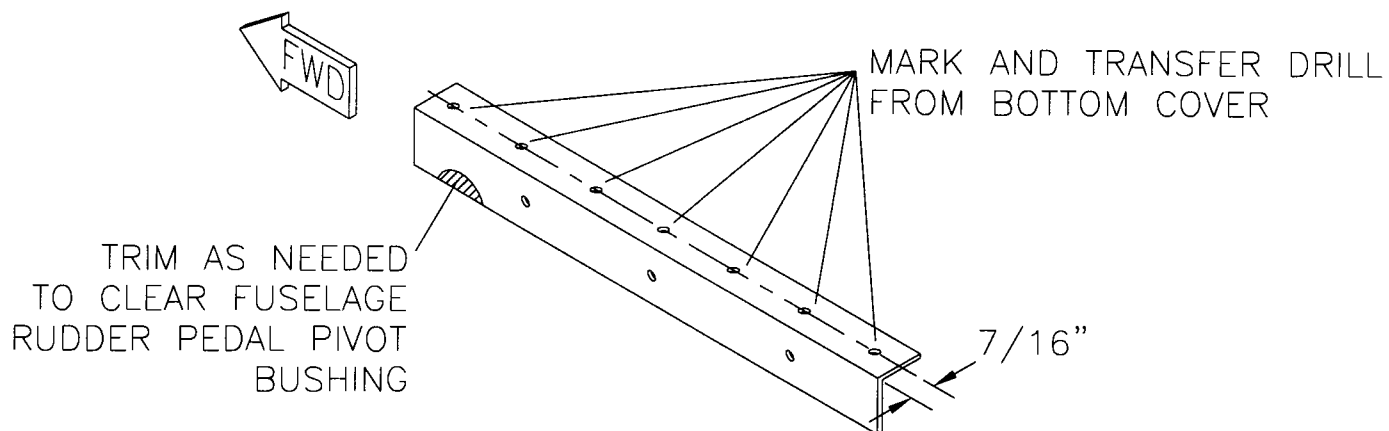
FIGURE 1-38  
S-18 STINGER II



CENTER INSTRUMENT PANEL  
BETWEEN AFT SET OF TABS

MD4037

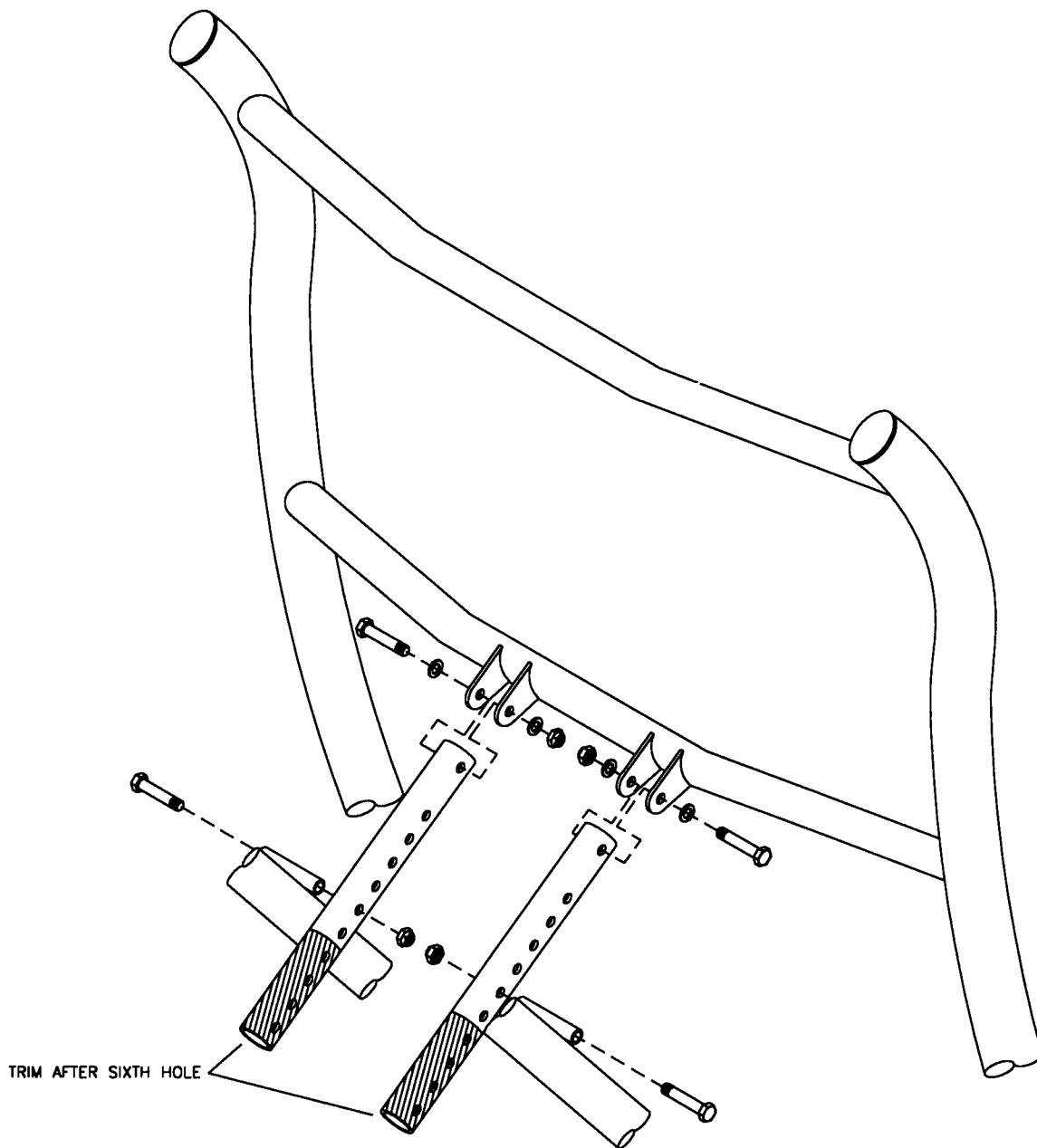
FIGURE 1-39  
S-18 STINGER II



FABRICATE 1 LH/ 1 RH  
(LH SHOWN)

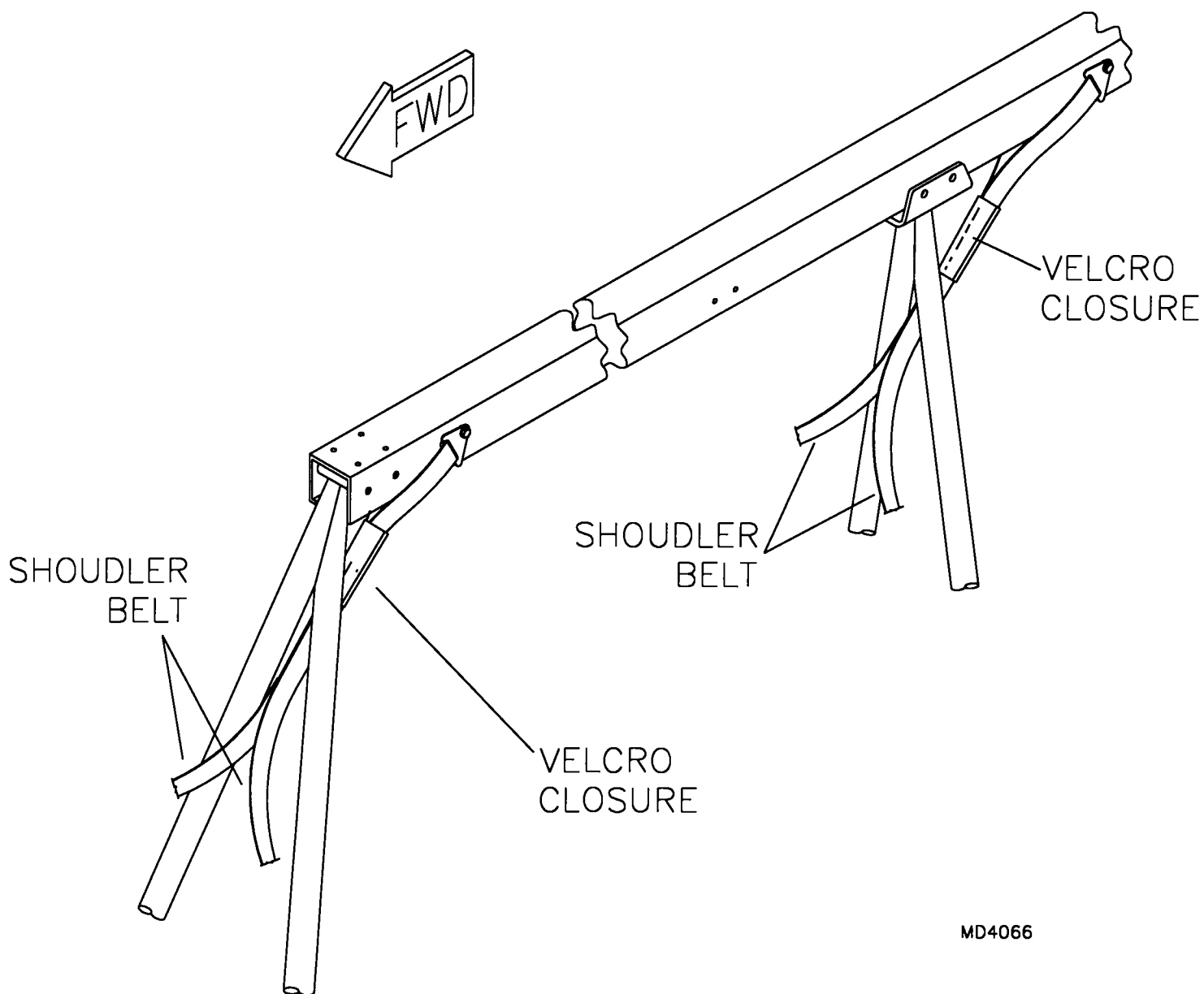
MD4240

**FIGURE 1-39A**  
**S-18 STINGER II**



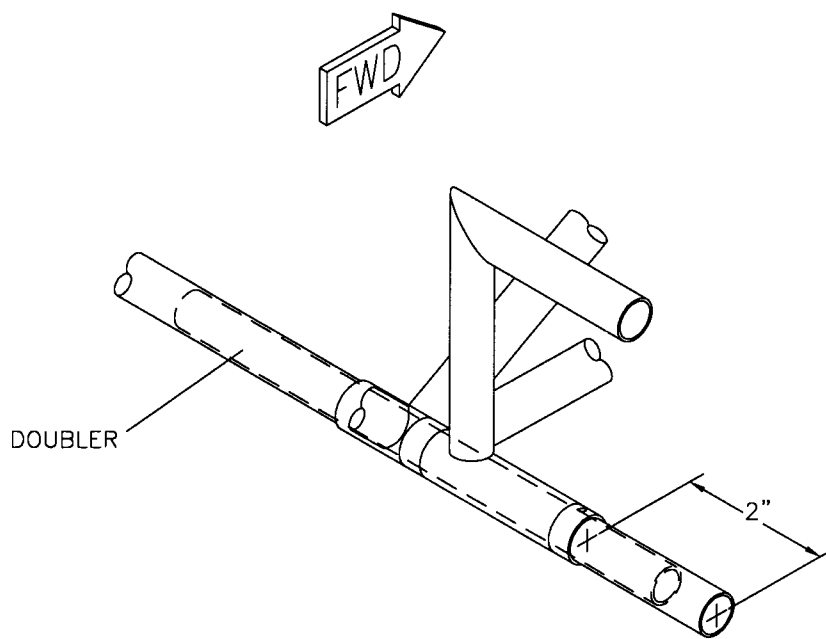
MD3820

FIGURE 1-40  
S-18 STINGER II



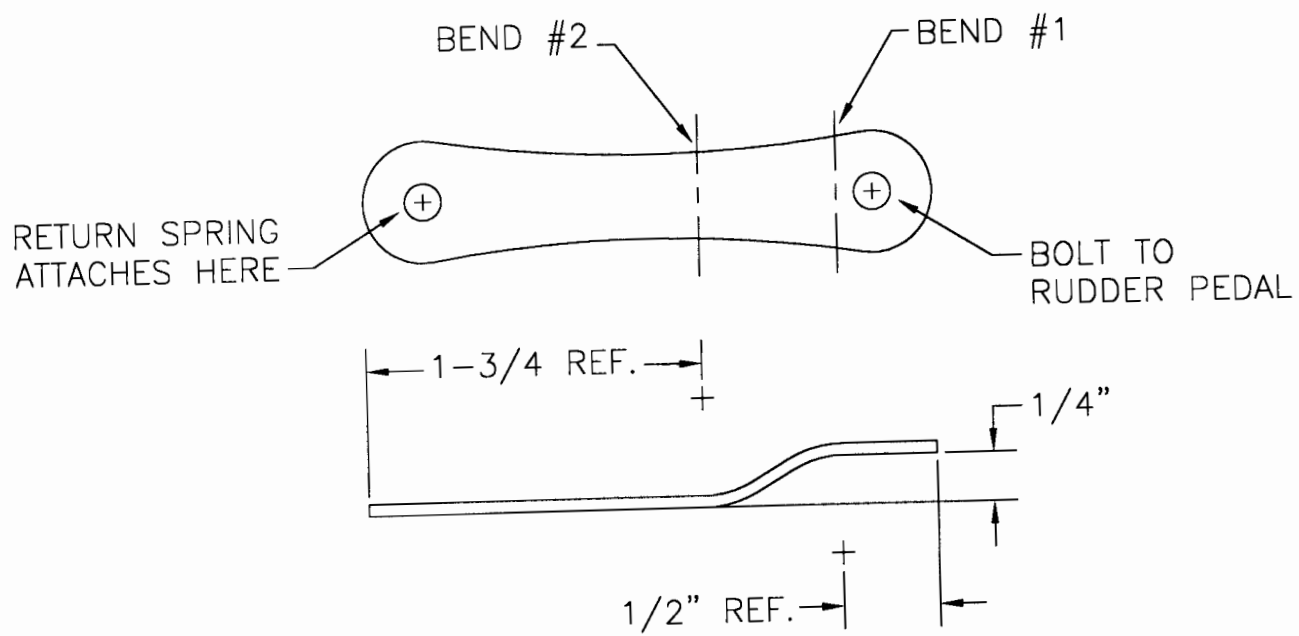
MD4066

FIGURE 1-41  
S-18 STINGER II



MD4124

**FIGURE 2-1**  
**S-18 STINGER II**



MD4470

FIGURE 2-1A  
S-18 STINGER II

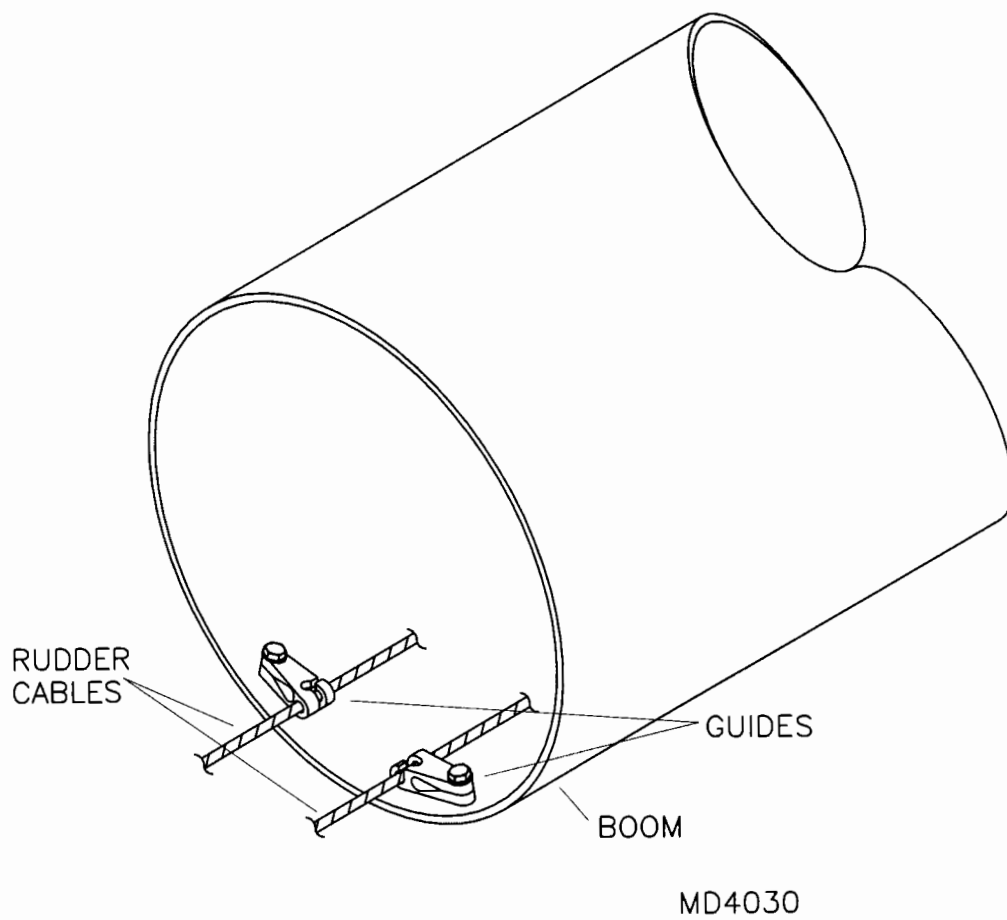


FIGURE 2-1B  
S-18 STINGER II

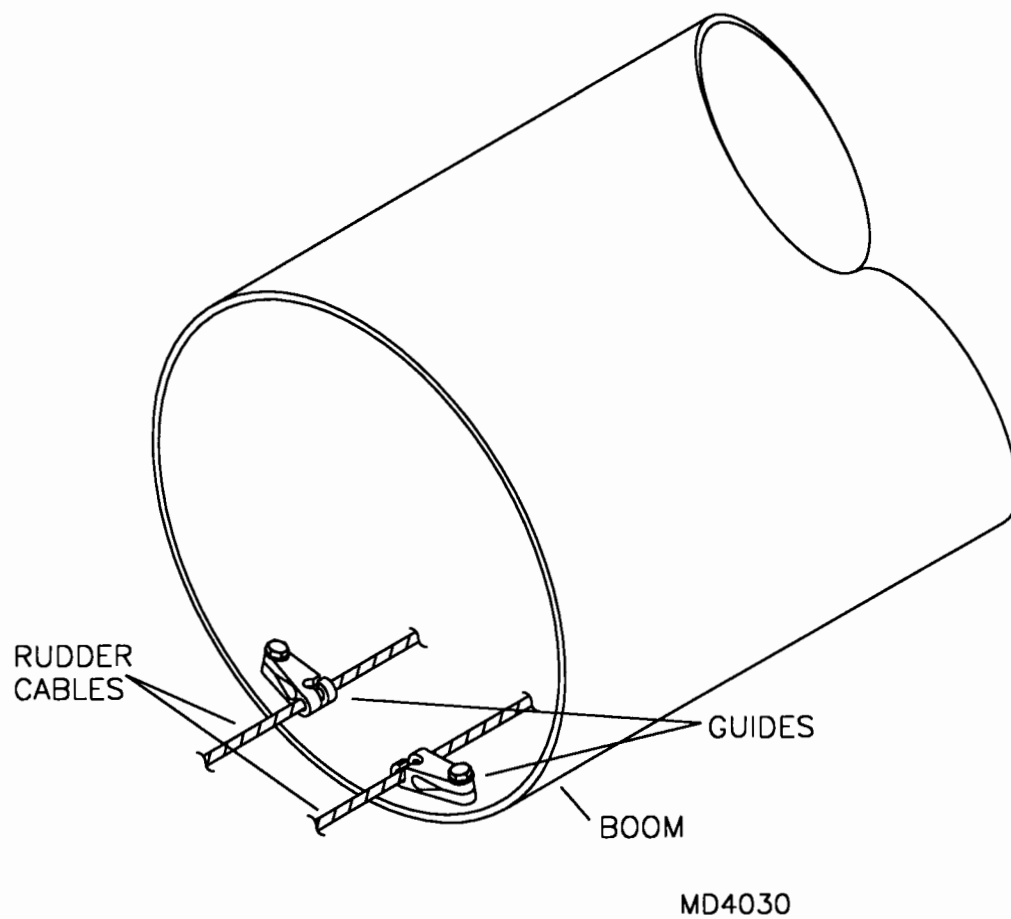
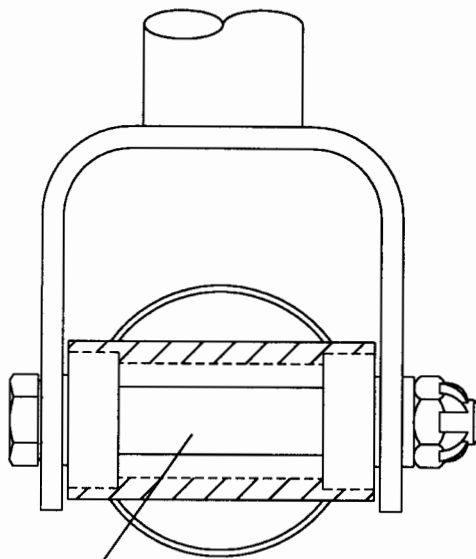


FIGURE 2-1A  
S-18 STINGER II



BUSHING: SIZE TO INSIDE  
SPACE BETWEEN BEARINGS

MD4036

FIGURE 2-2  
S-18 STINGER II

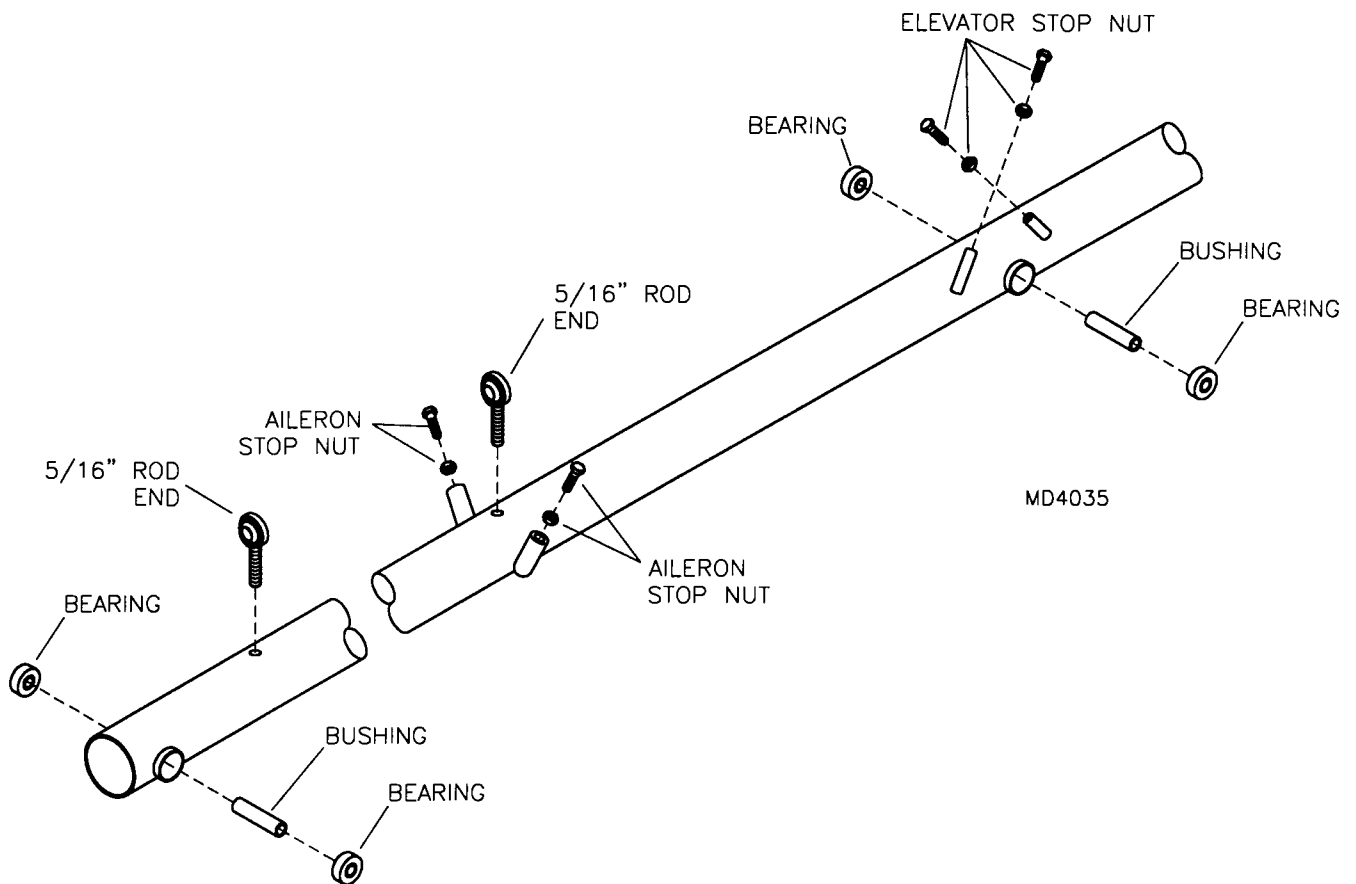
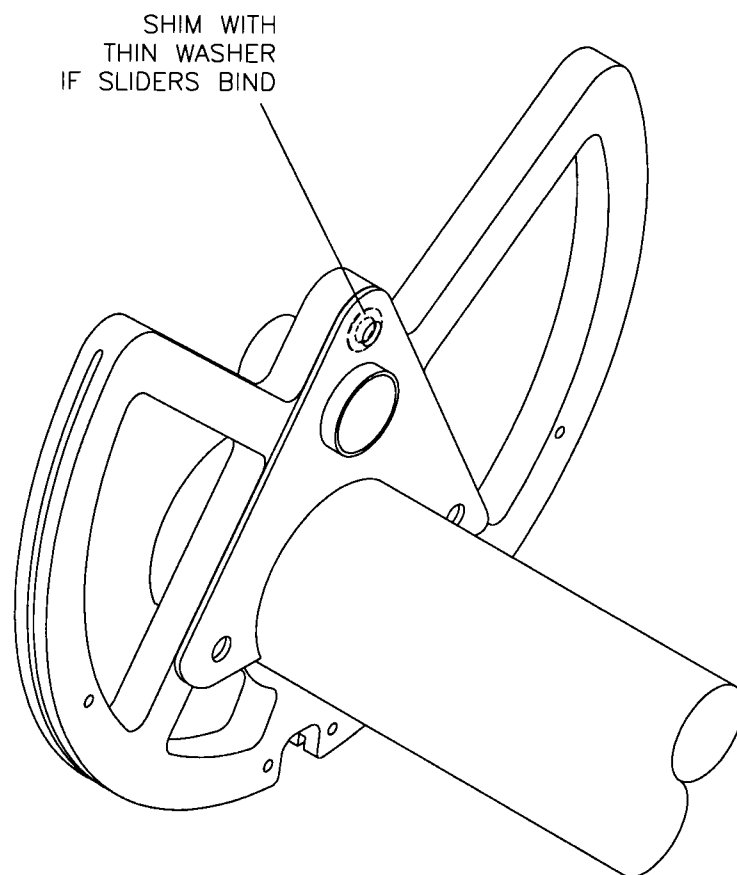


FIGURE 2-3  
S-18 STINGER II



MD4105

**FIGURE 2-3A**  
**S-18 STINGER II**

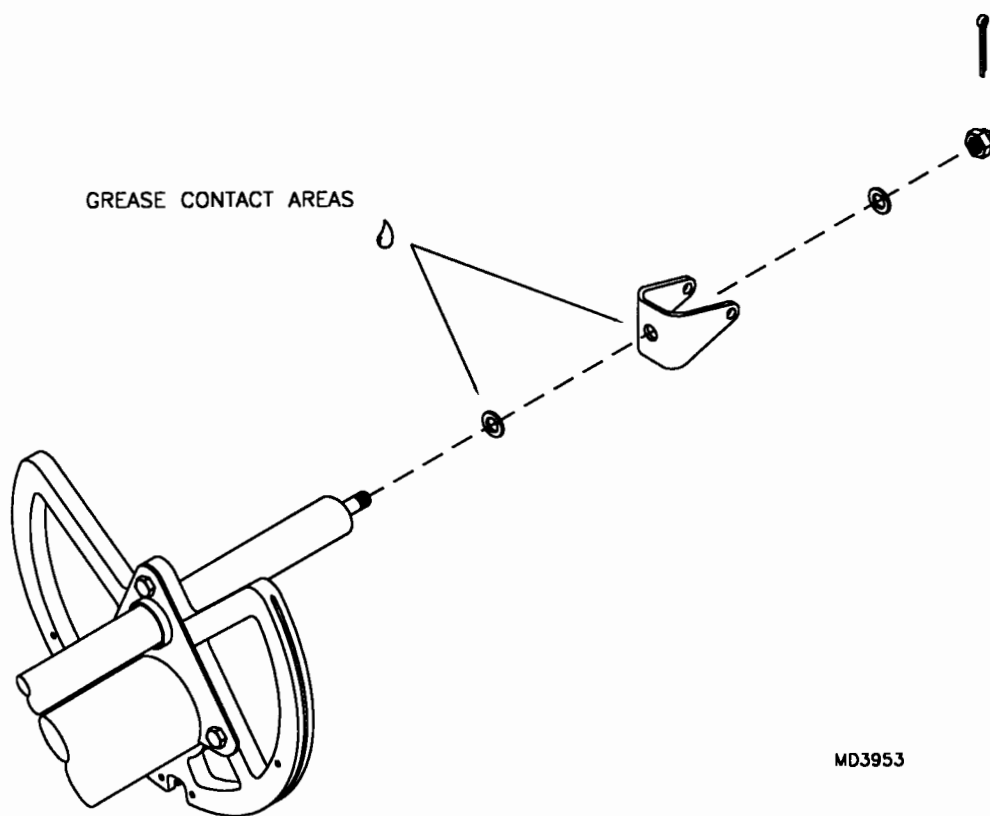
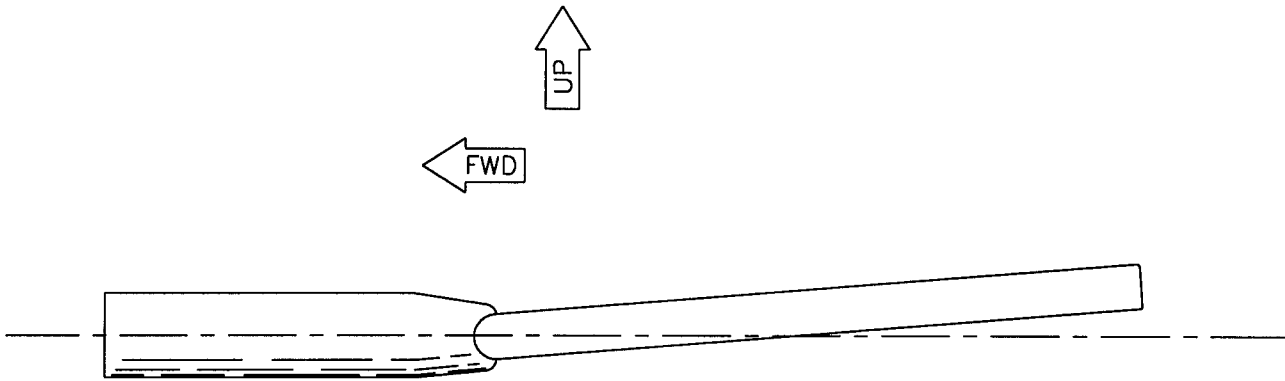
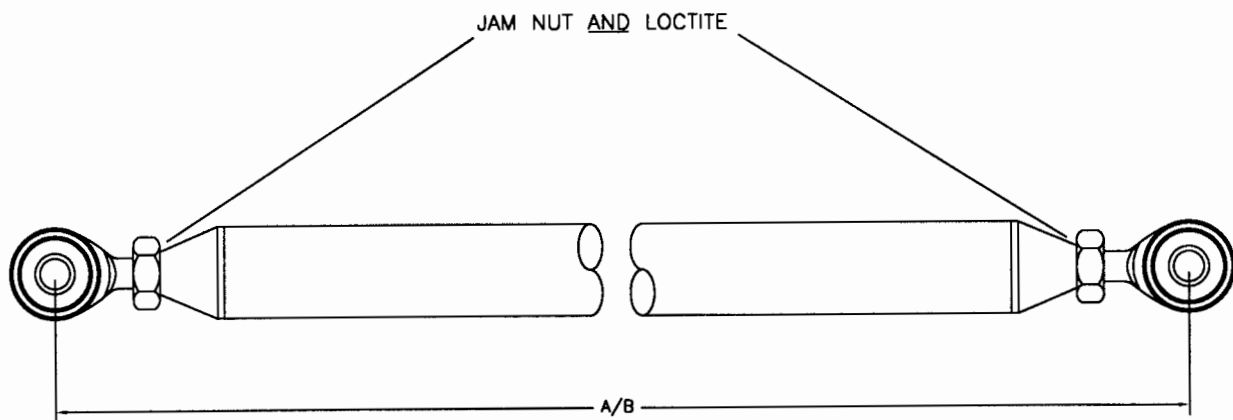
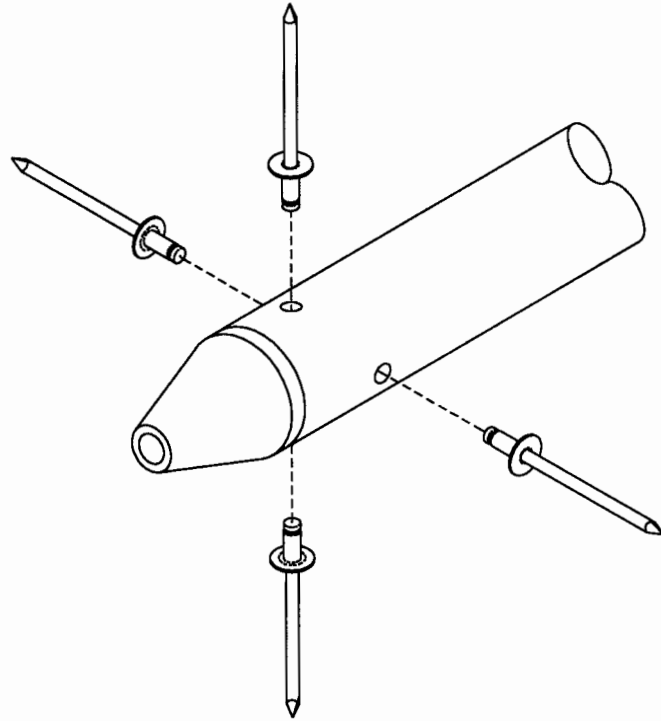


FIGURE 2-4  
S-18 STINGER II



MD2239

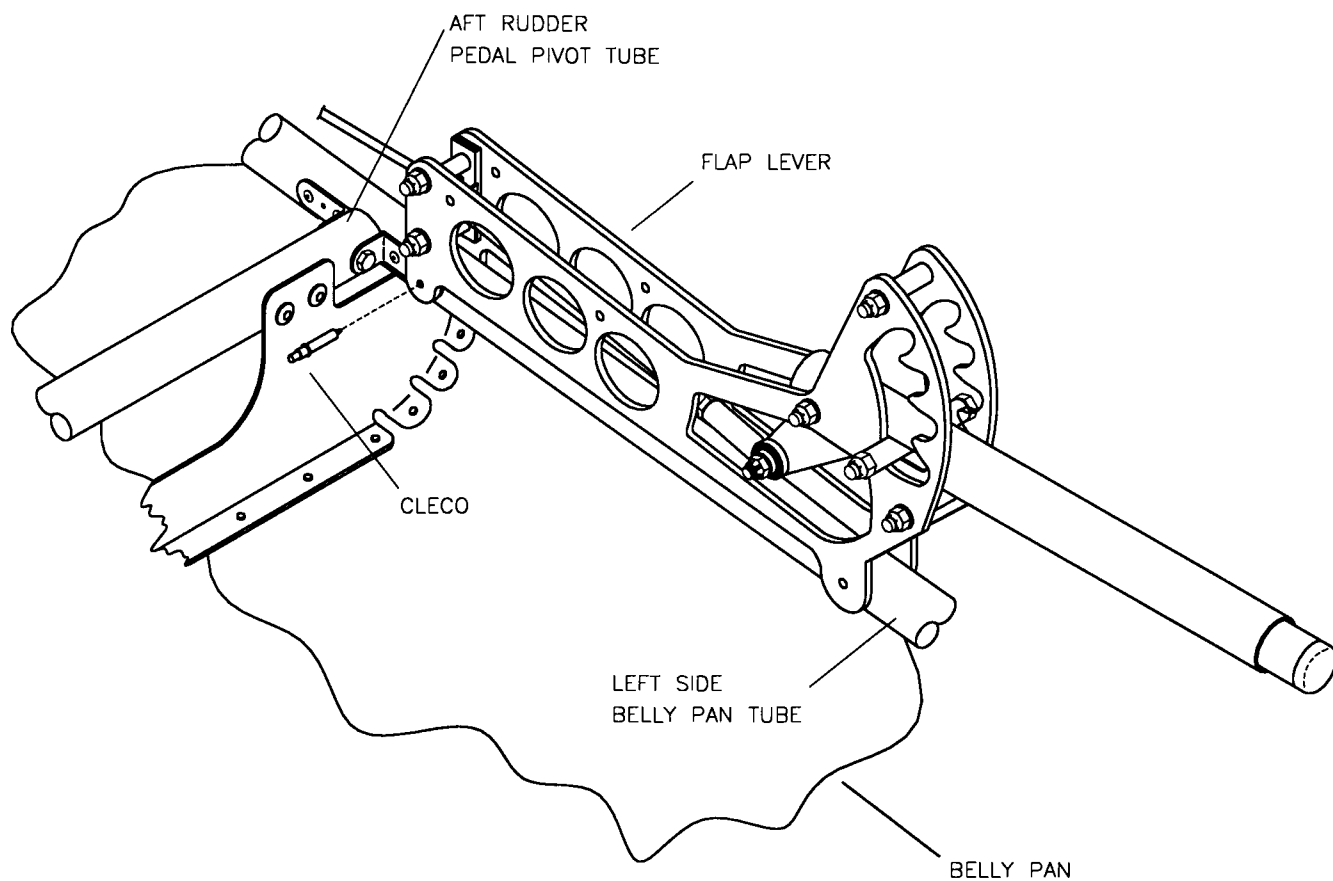
FIGURE 2-5  
S-18 STINGER II



- A. AFT 1" PPT=24 1/4"
- B. FWD 1" PPT=34 3/8"

MD4038

**FIGURE 2-6**  
**S-18 STINGER II**



MD4033

**FIGURE 2-7**  
**S-18 STINGER II**

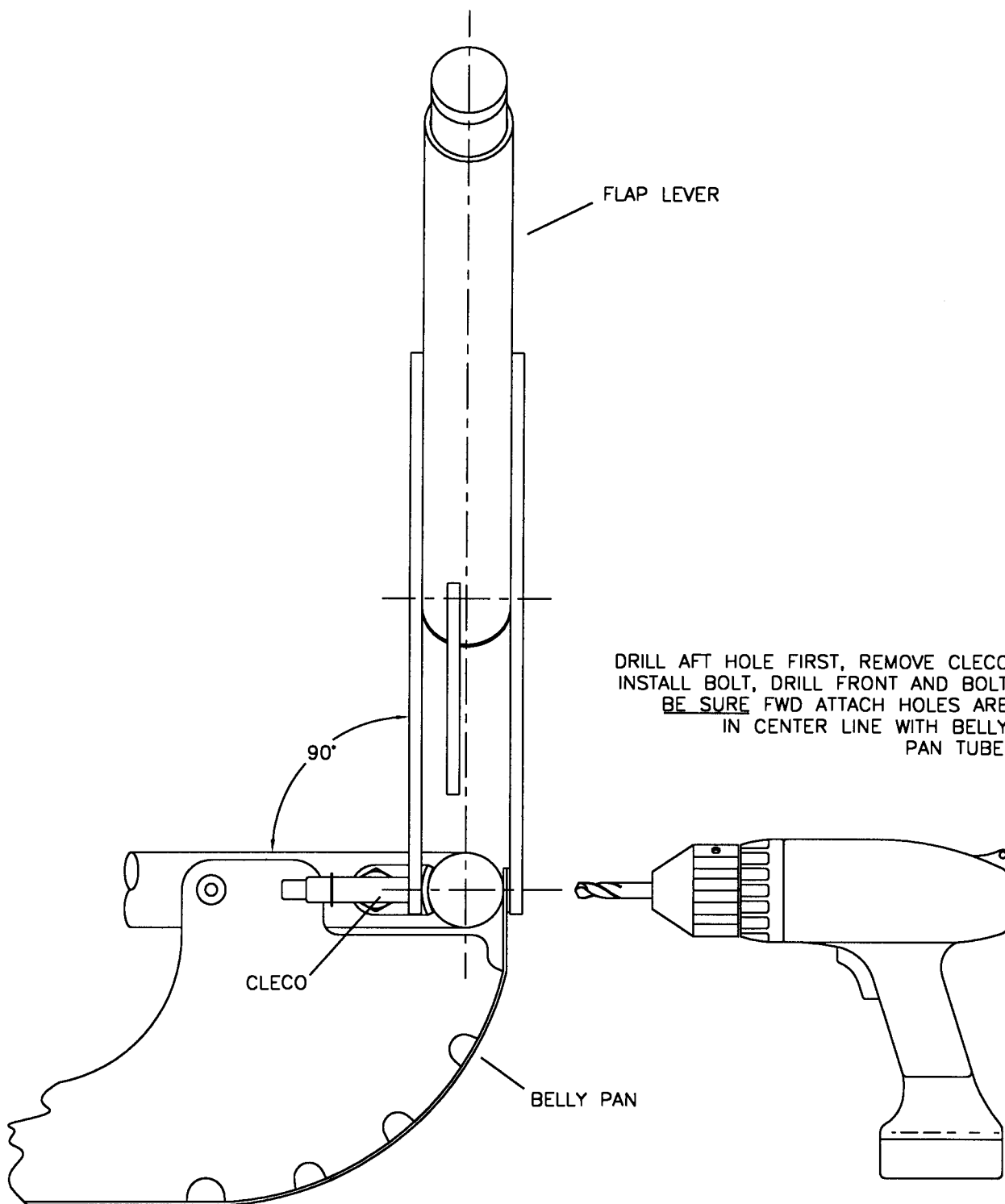
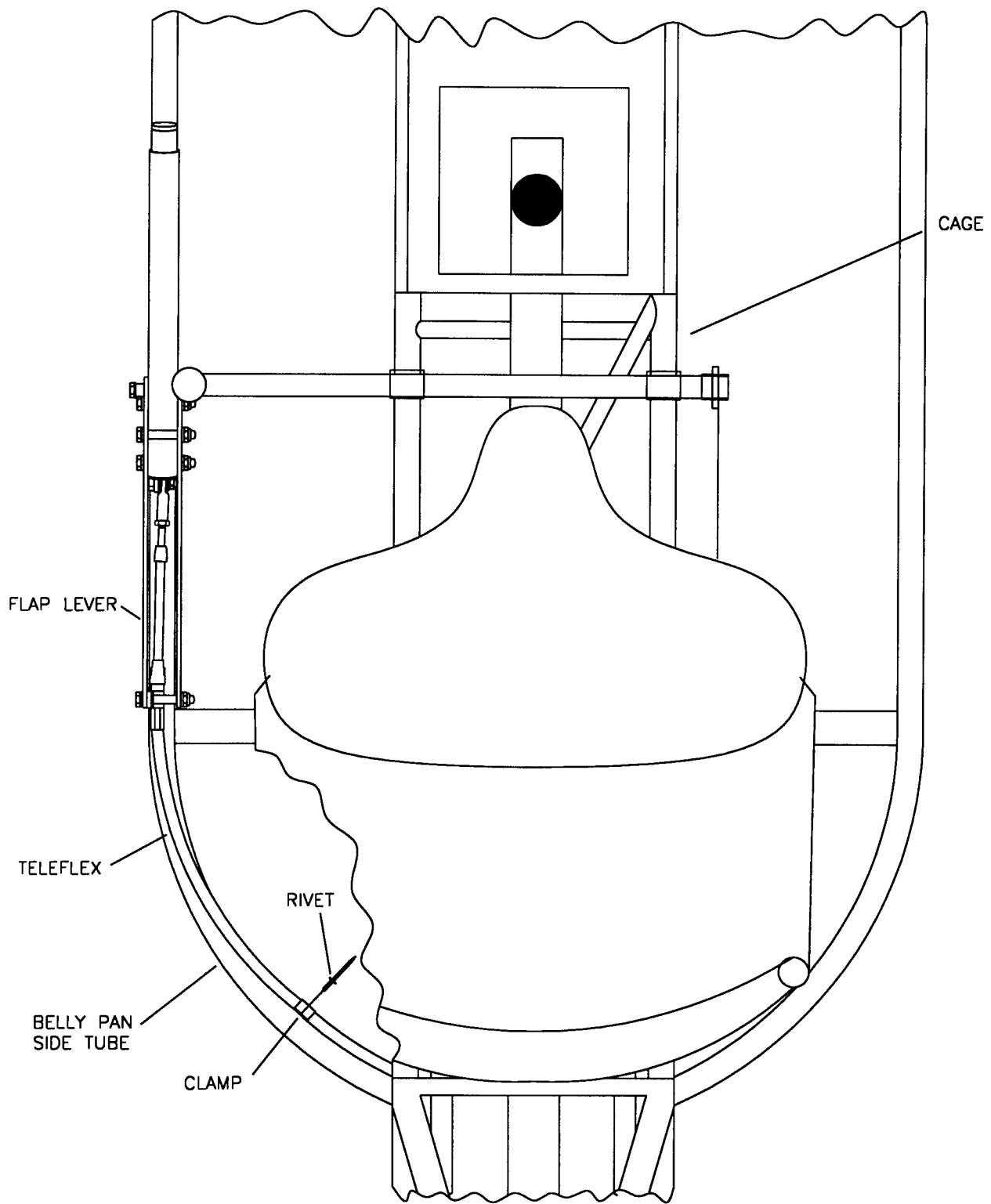


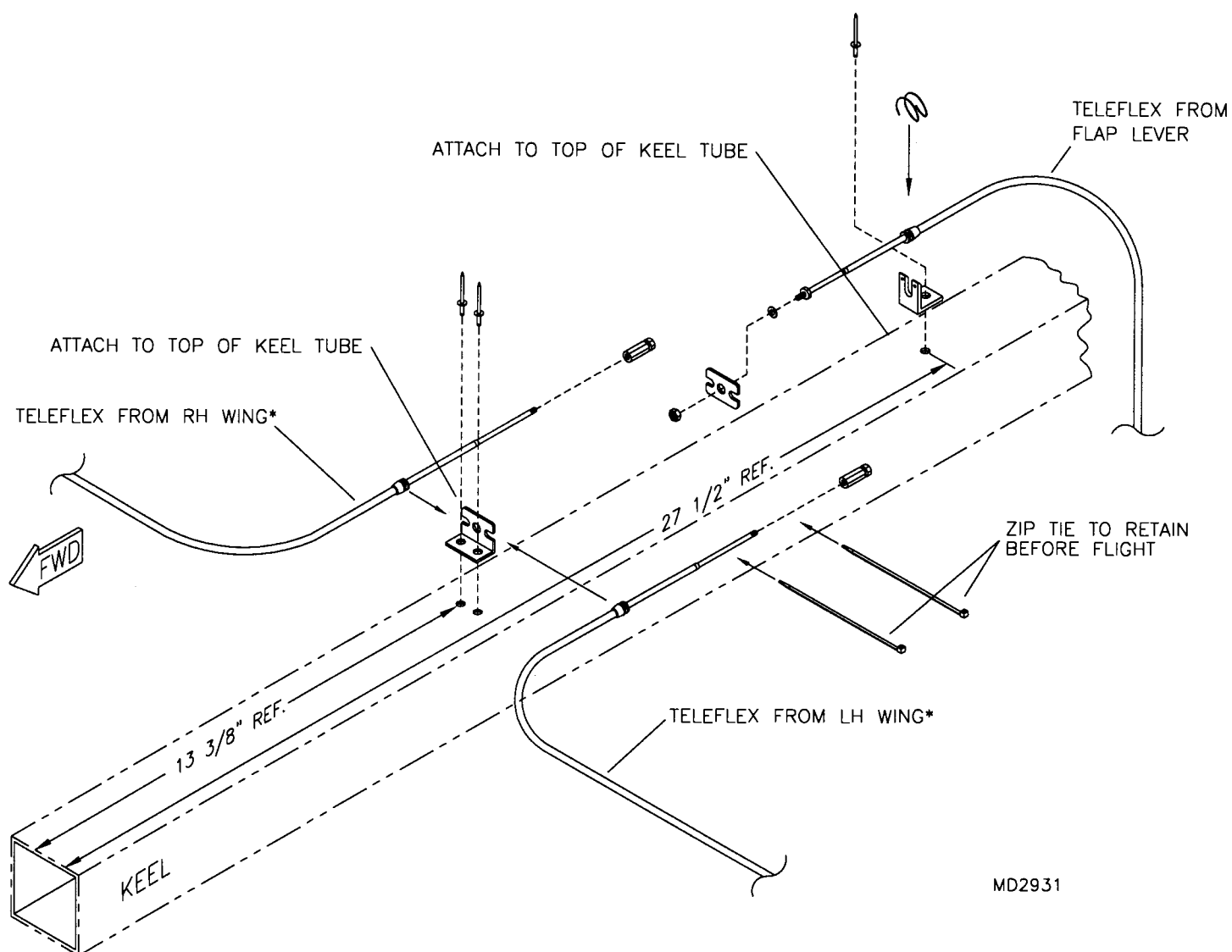
FIGURE 2-8  
S-18 STINGER II

MD4034



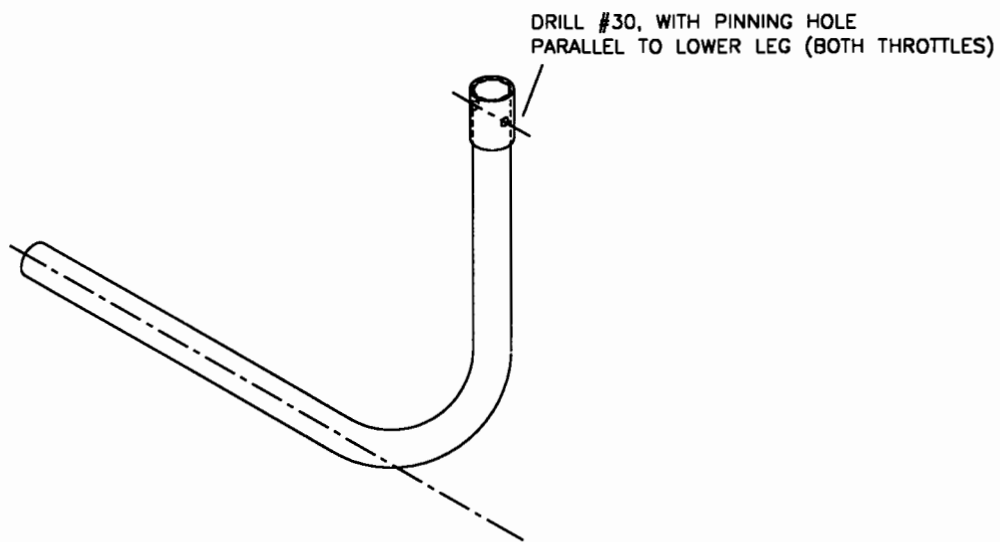
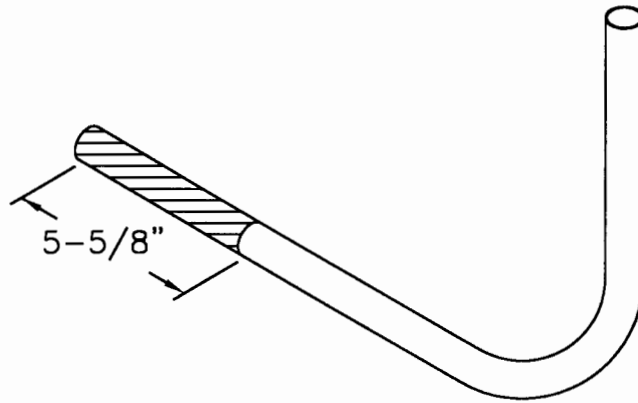
MD4056

FIGURE 2-8A  
S-18 STINGER II



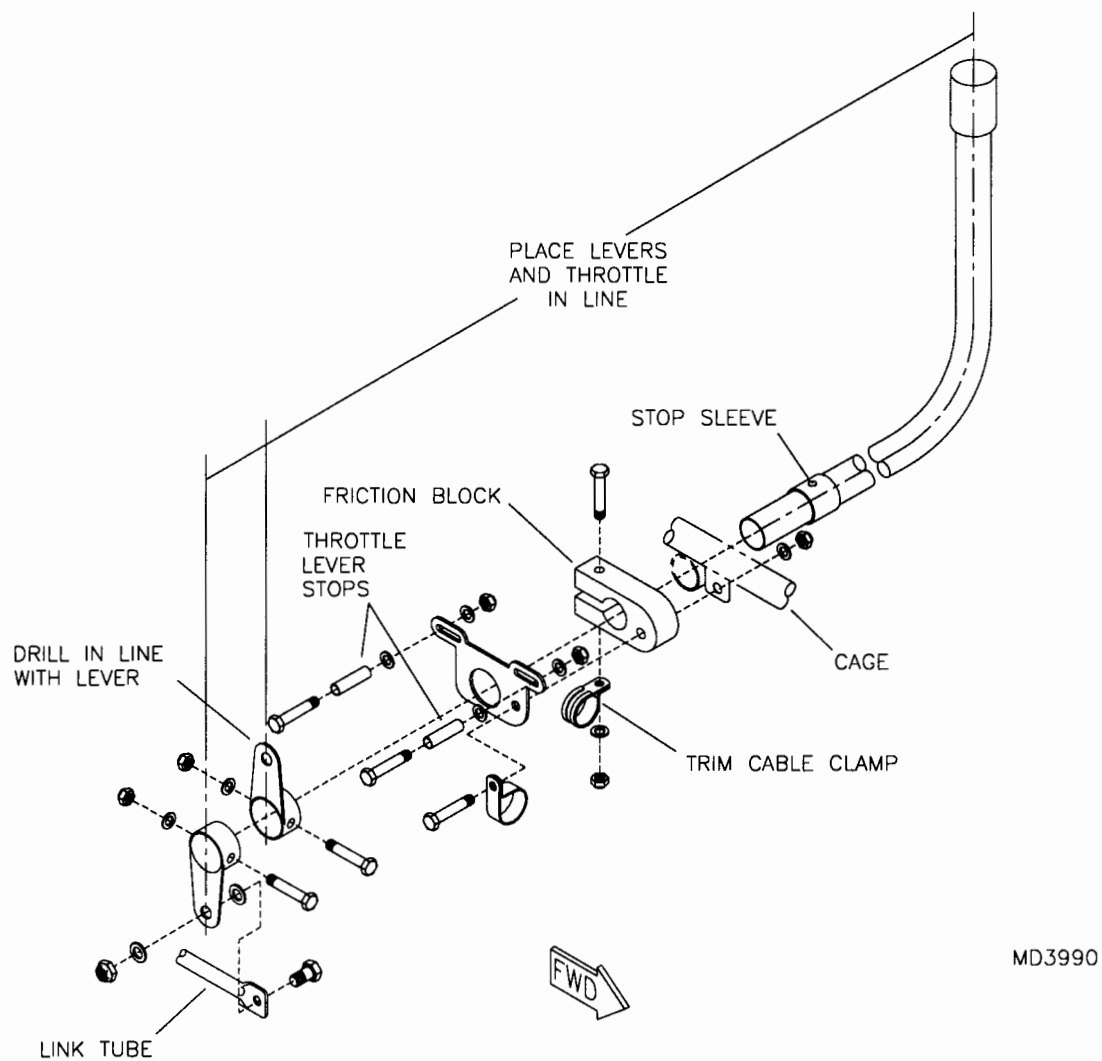
MD2931

**FIGURE 2-9**  
**S-18 STINGER II**



MD3988

FIGURE 2-10  
S-18 STINGER II



503/582

FIGURE 2-11  
S-18 STINGER II

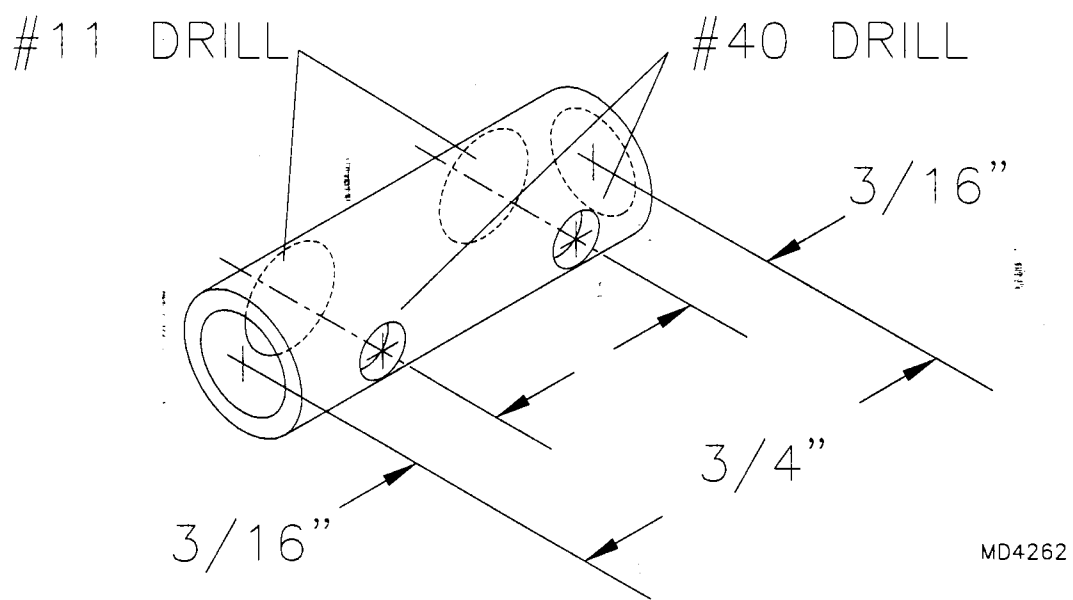
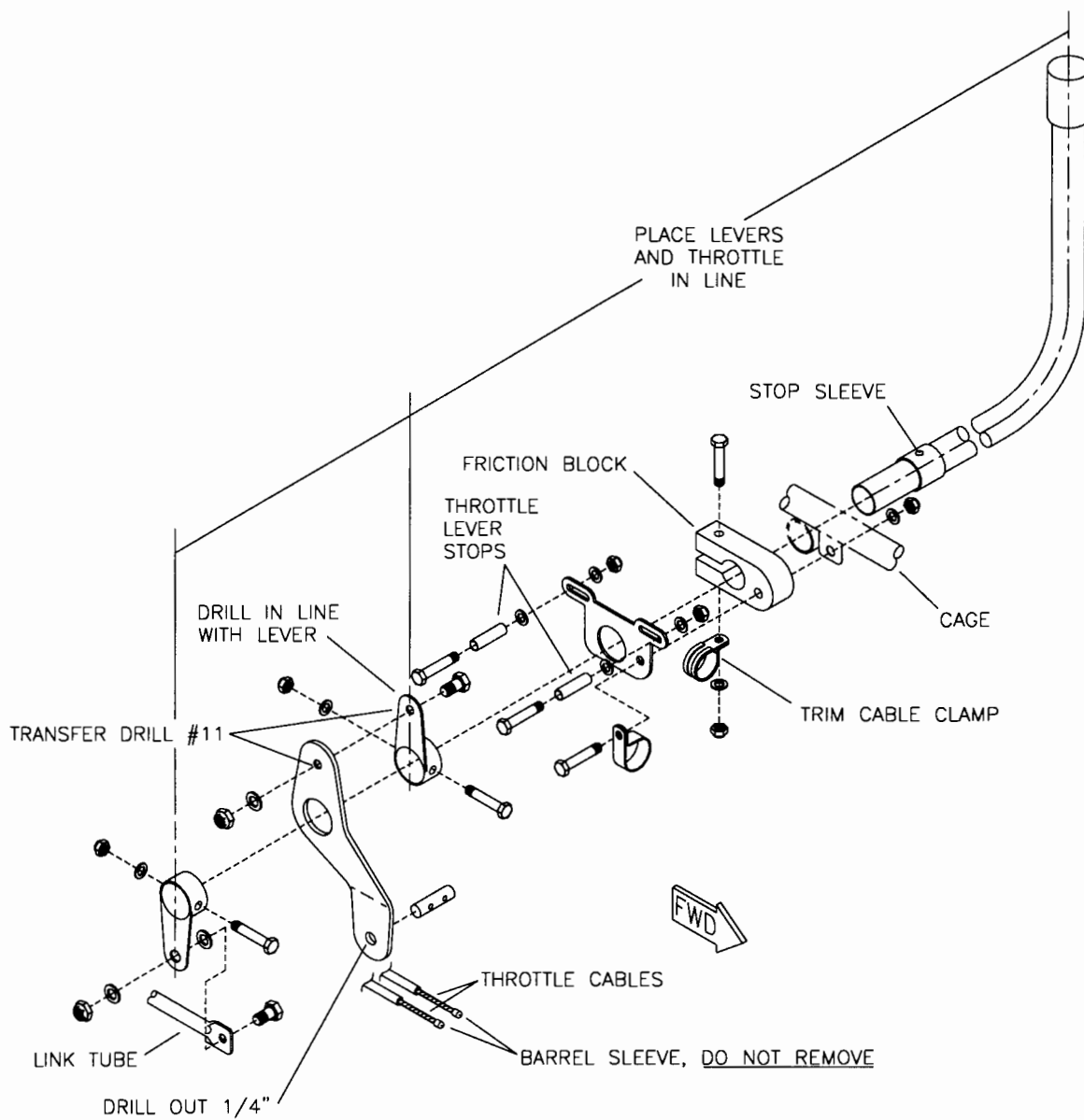


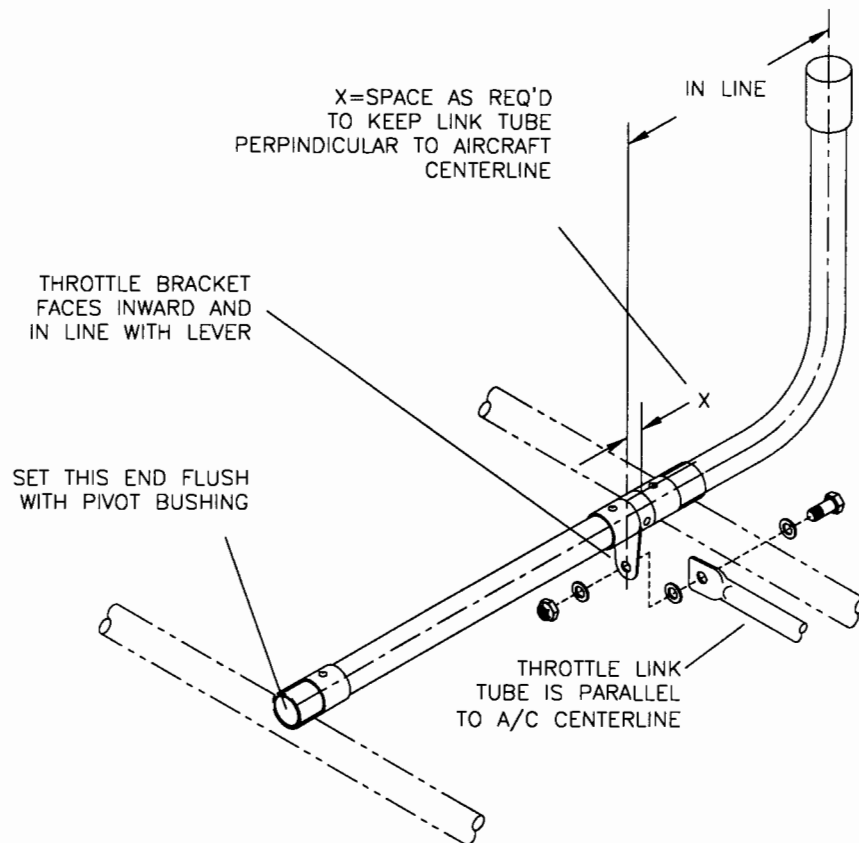
FIGURE 2-11A  
S-18 STINGER II



MD4259

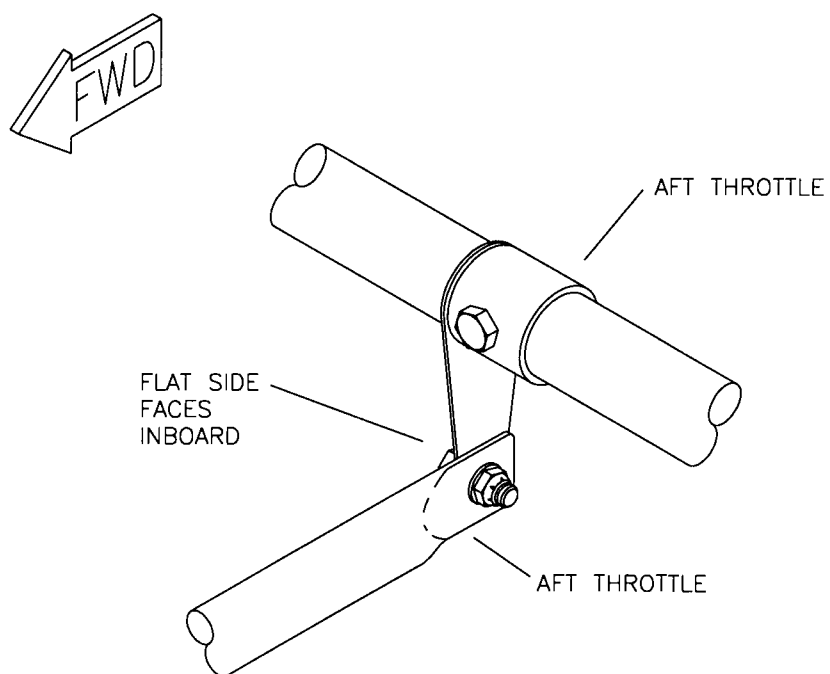
912

**FIGURE 2-11B**  
**S-18 STINGER II**



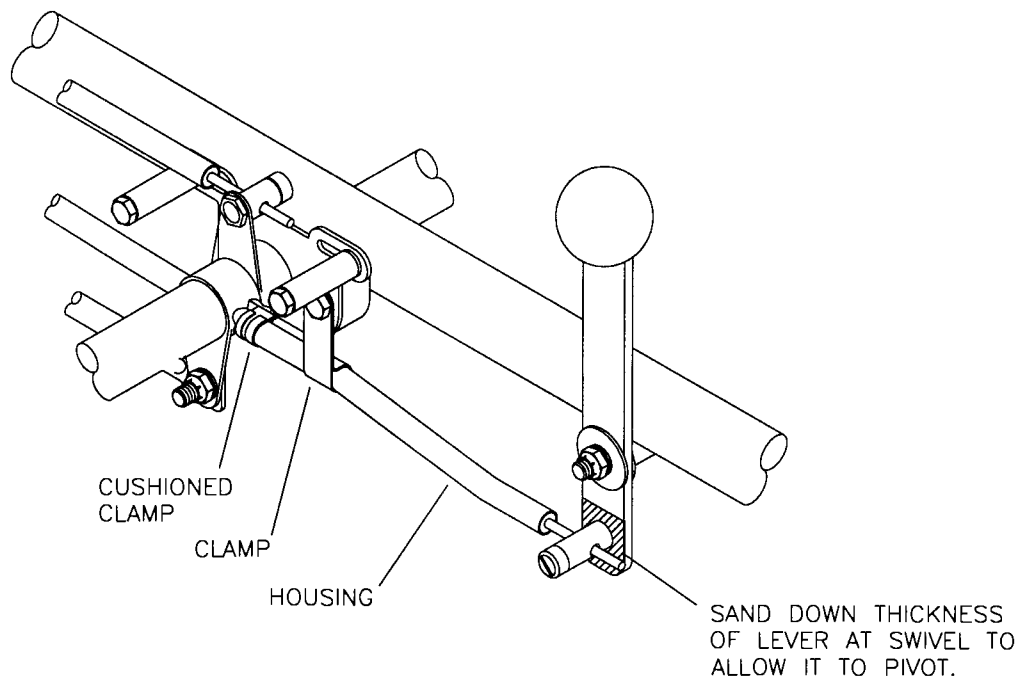
MD3991

FIGURE 2-12  
 S-18 STINGER II



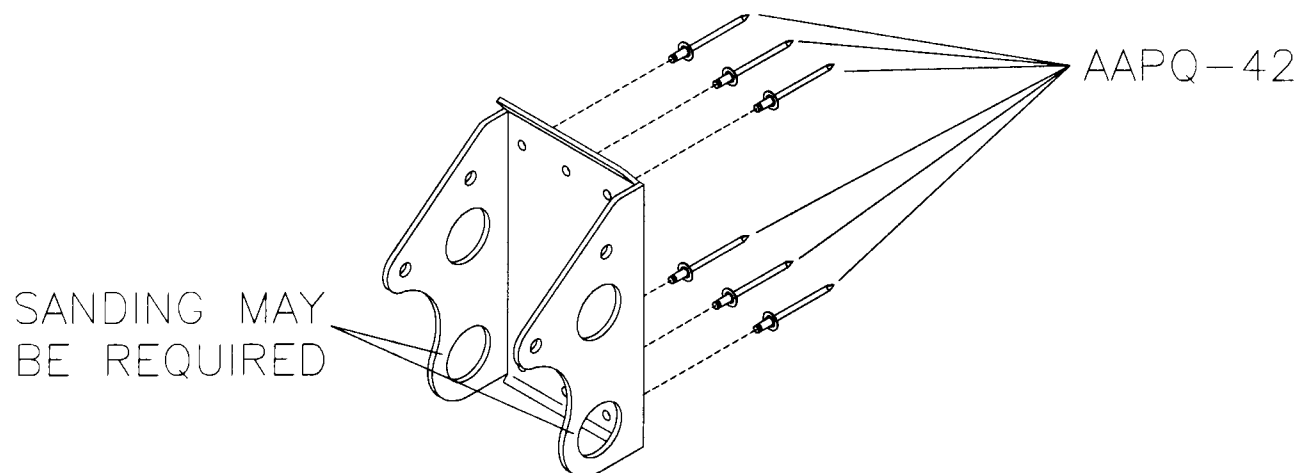
MD4125

**FIGURE 2-13**  
**S-18 STINGER II**



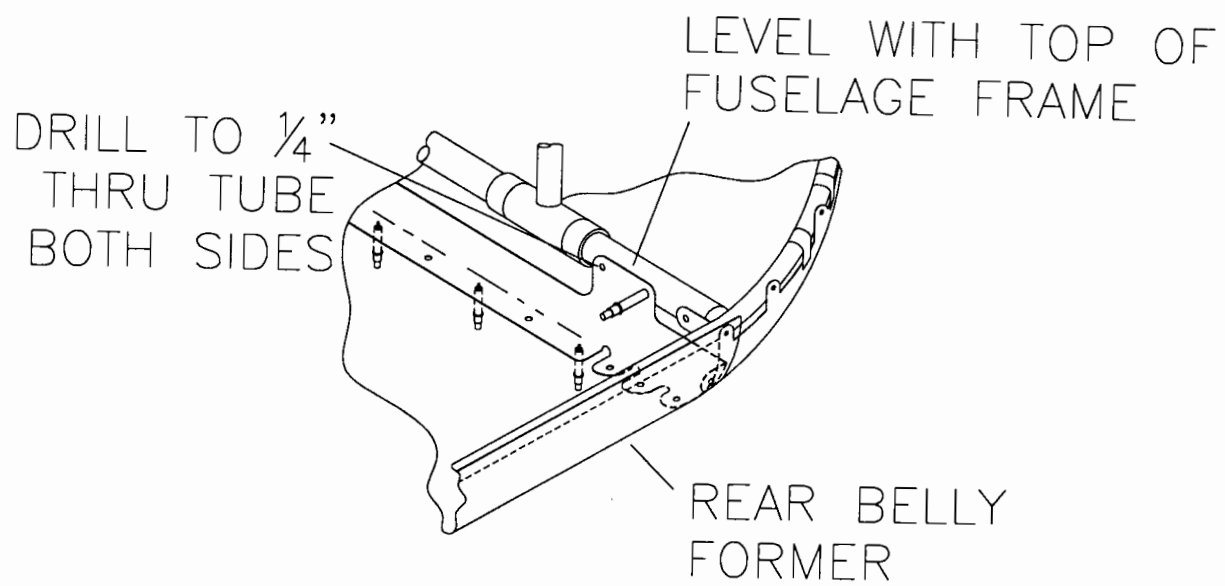
MD4126

**FIGURE 2-14**  
**S-18 STINGER II**



MD4453  
REV. A

FIGURE 2-15  
S-18 STINGER II



MD4451

FIGURE 2-16  
S-18 STINGER II

# HYDRAULIC BRAKE LINE ROUTING

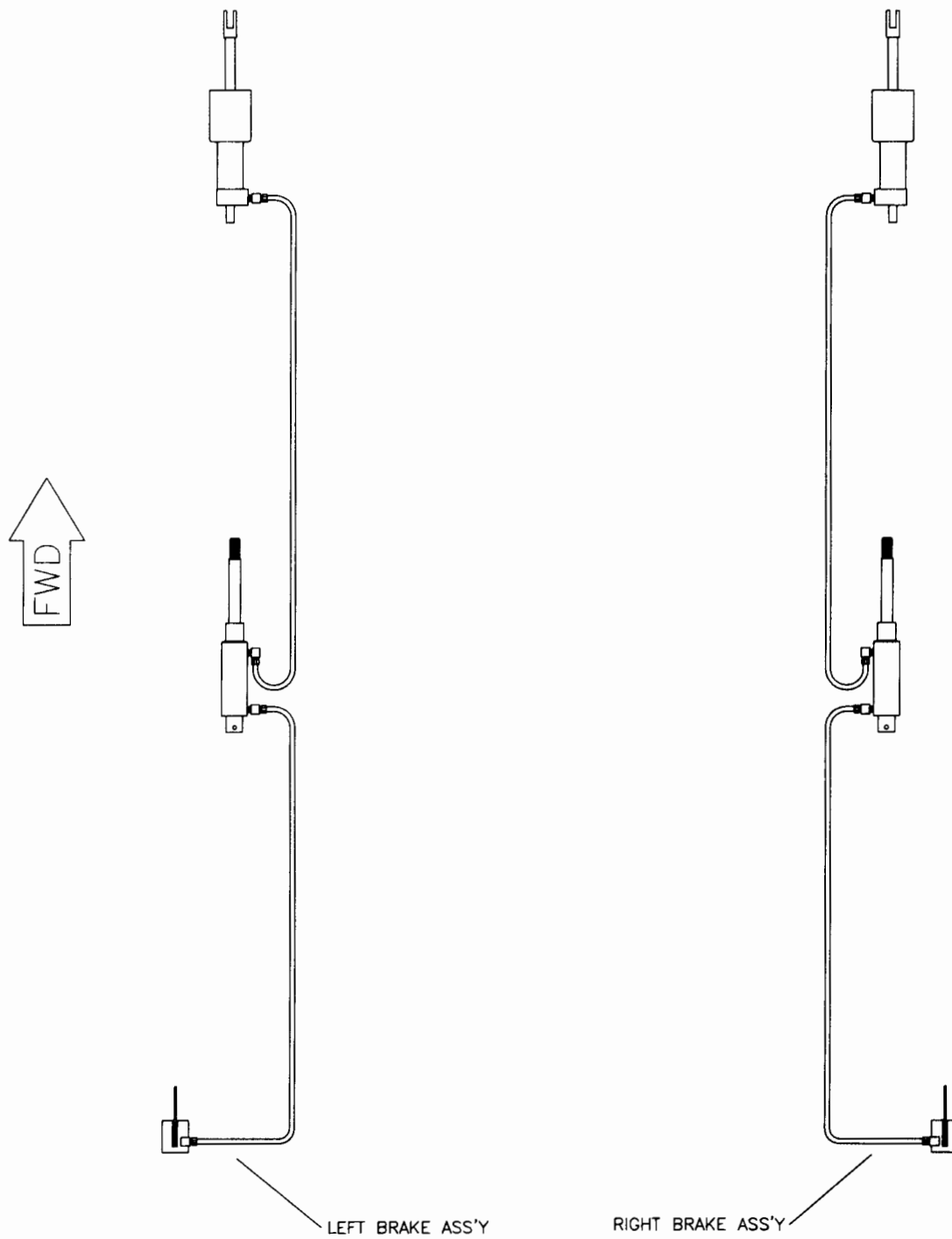
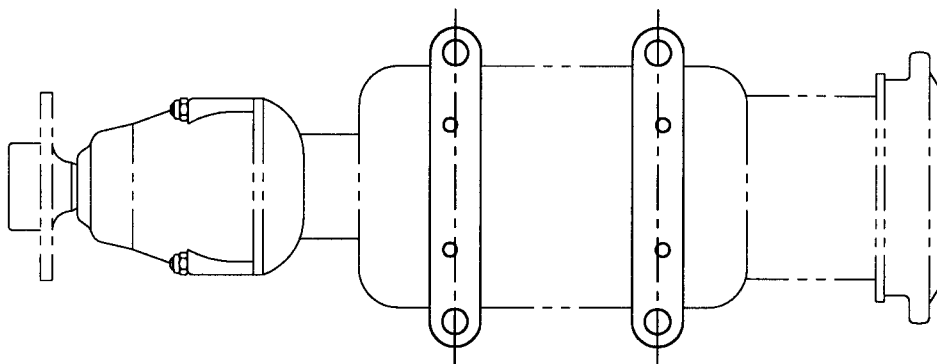


FIGURE 2-17  
S-18 STINGER II

MD4495

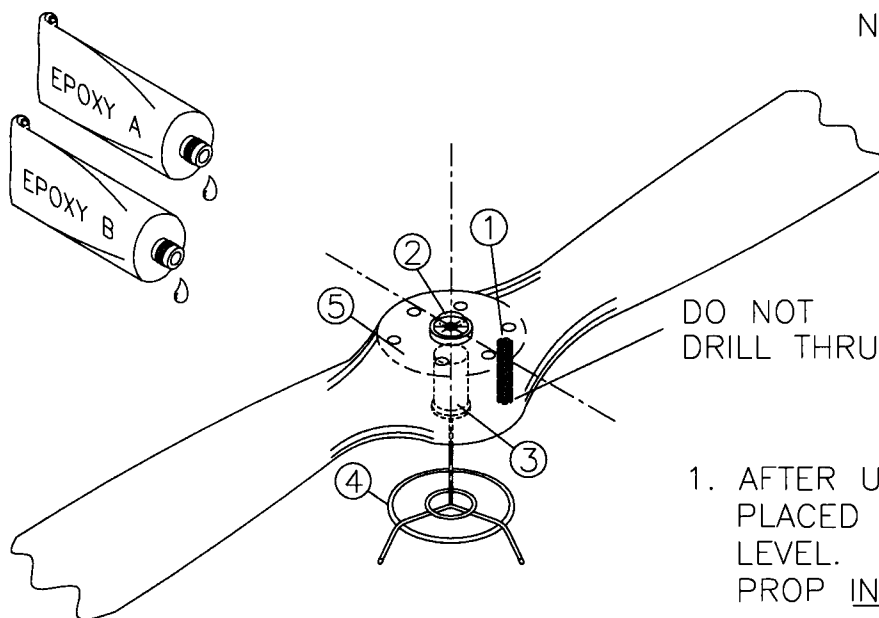


**503**



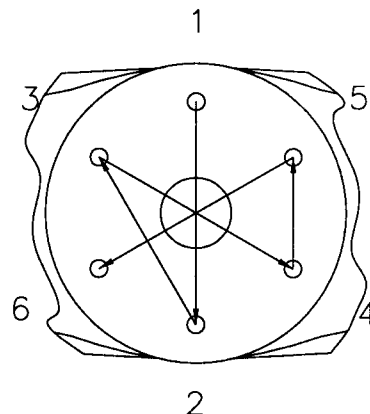
MD3919

FIGURE 3-1  
S-18 STINGER II



1. AFTER USING COINS  
PLACED TO CENTER BUBBLE  
LEVEL. DRILL A HOLE INTO  
PROP INSIDE OF CRUSH PLATE  
ZONE. FILL WITH LEAD "BB'S"  
SEAL WITH EPOXY.

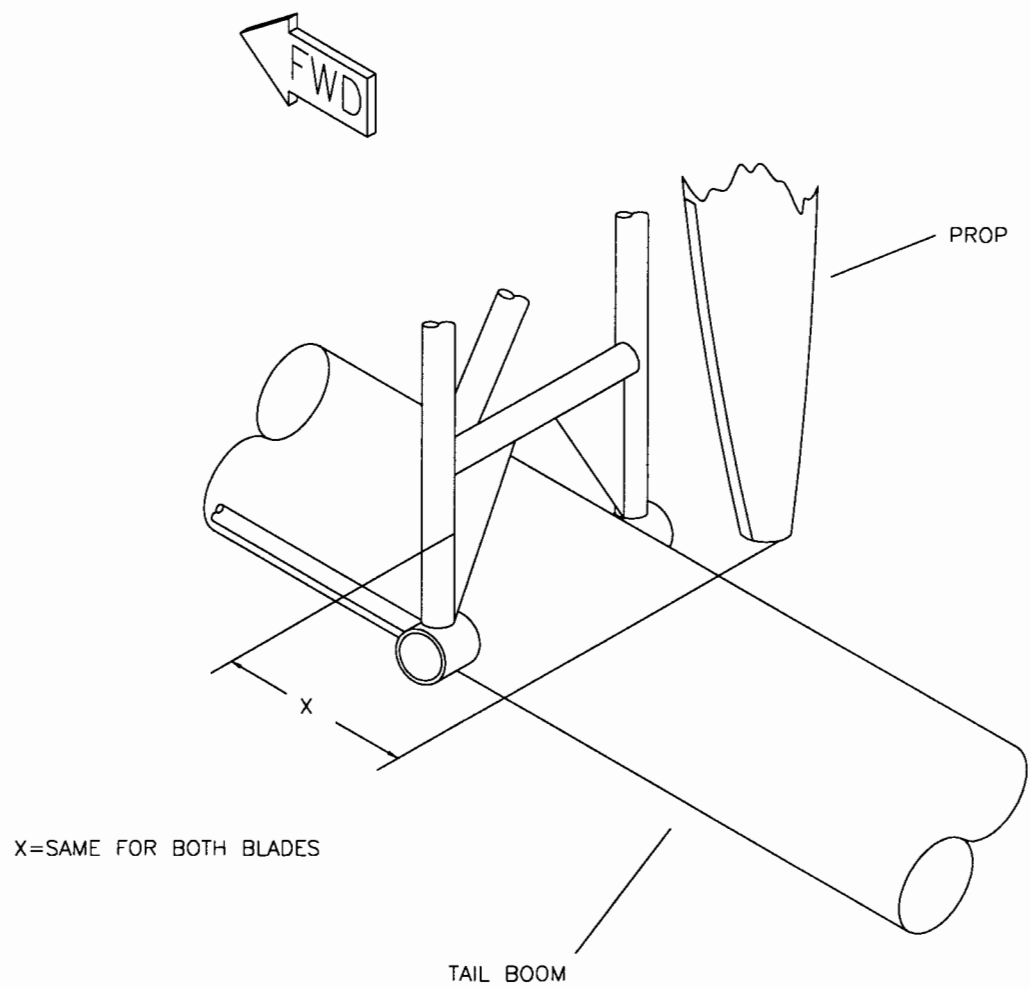
2. CENTER LEVEL
3. DUAL AXIS PROP BALANCER INSERT  
SPECIFY PROP INSIDE DIAMETER WHEN  
ORDERING.
4. STAND FOR INSERT
5. CRUSH PLATE ZONE



MD4039

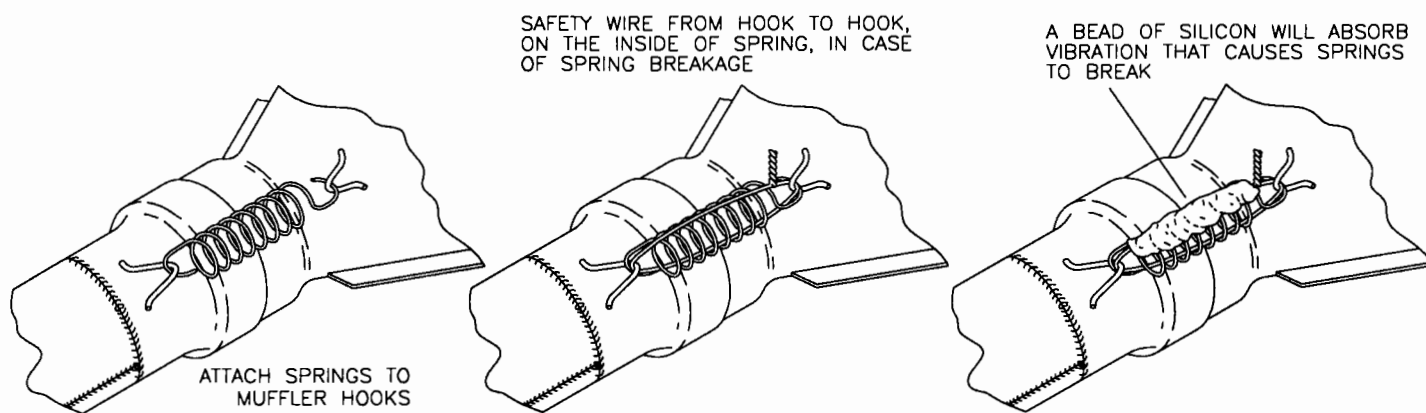
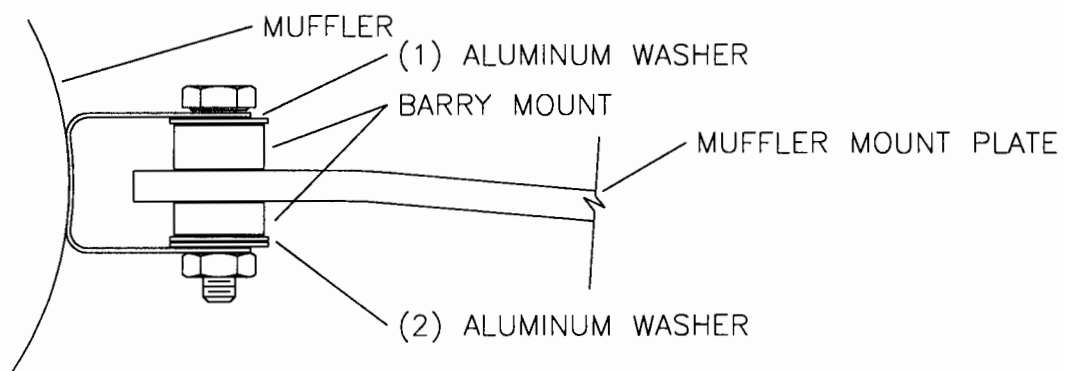
RE-TORQUE BOLTS AFTER 5 HRS. OF FLIGHT

**FIGURE 3-2**  
**S-18 STINGER II**



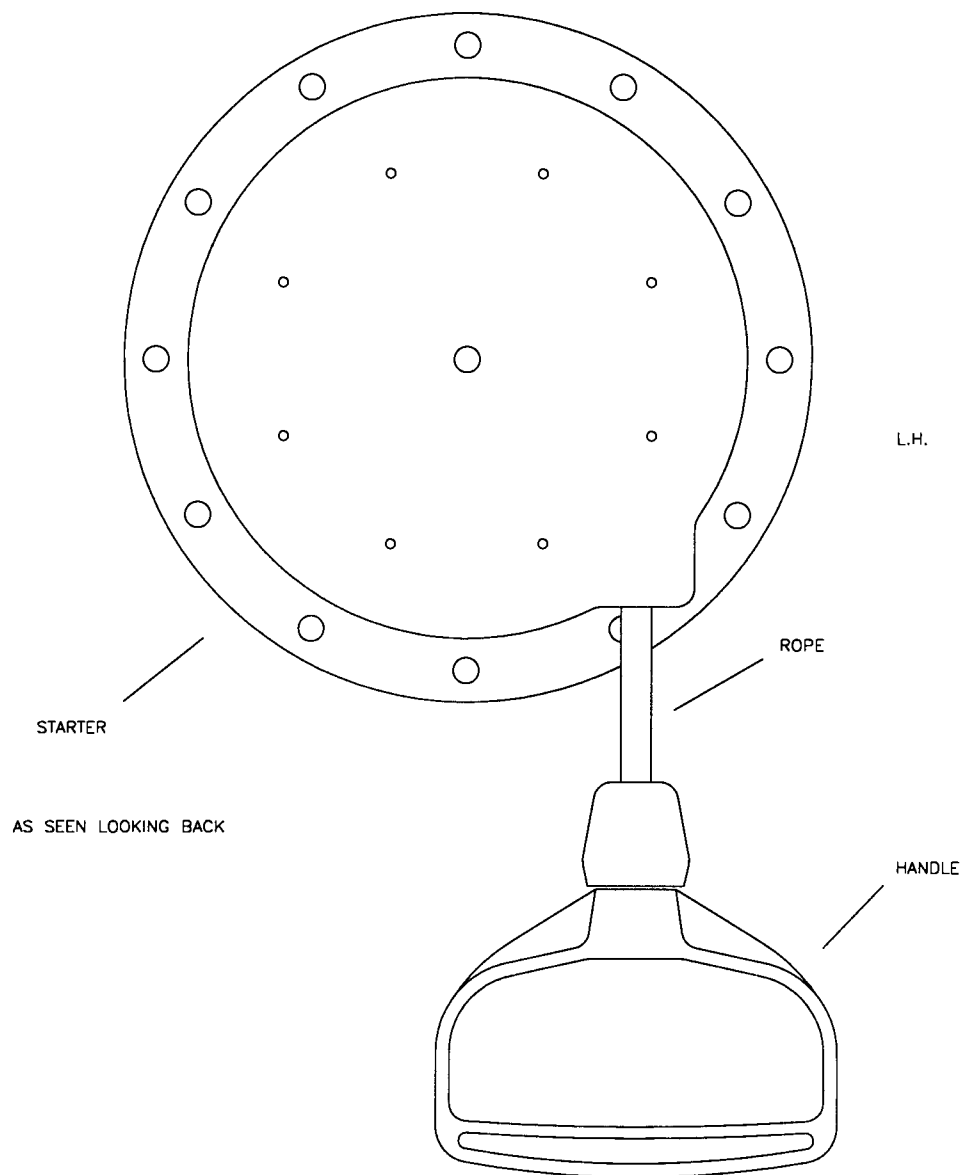
MD4040

**FIGURE 3-3**  
**S-18 STINGER II**



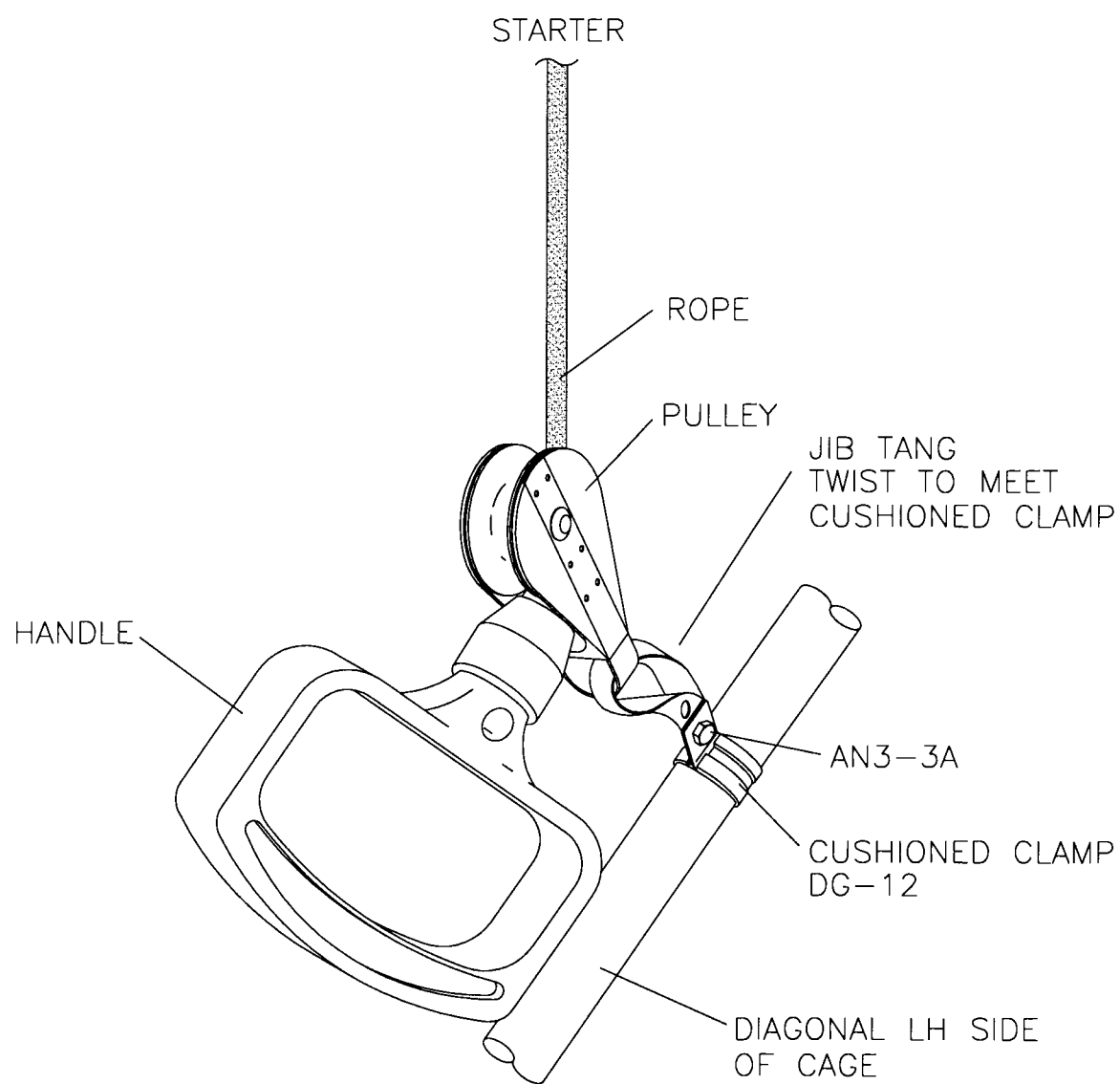
MD4051

**FIGURE 3-4**  
**S-18 STINGER II**



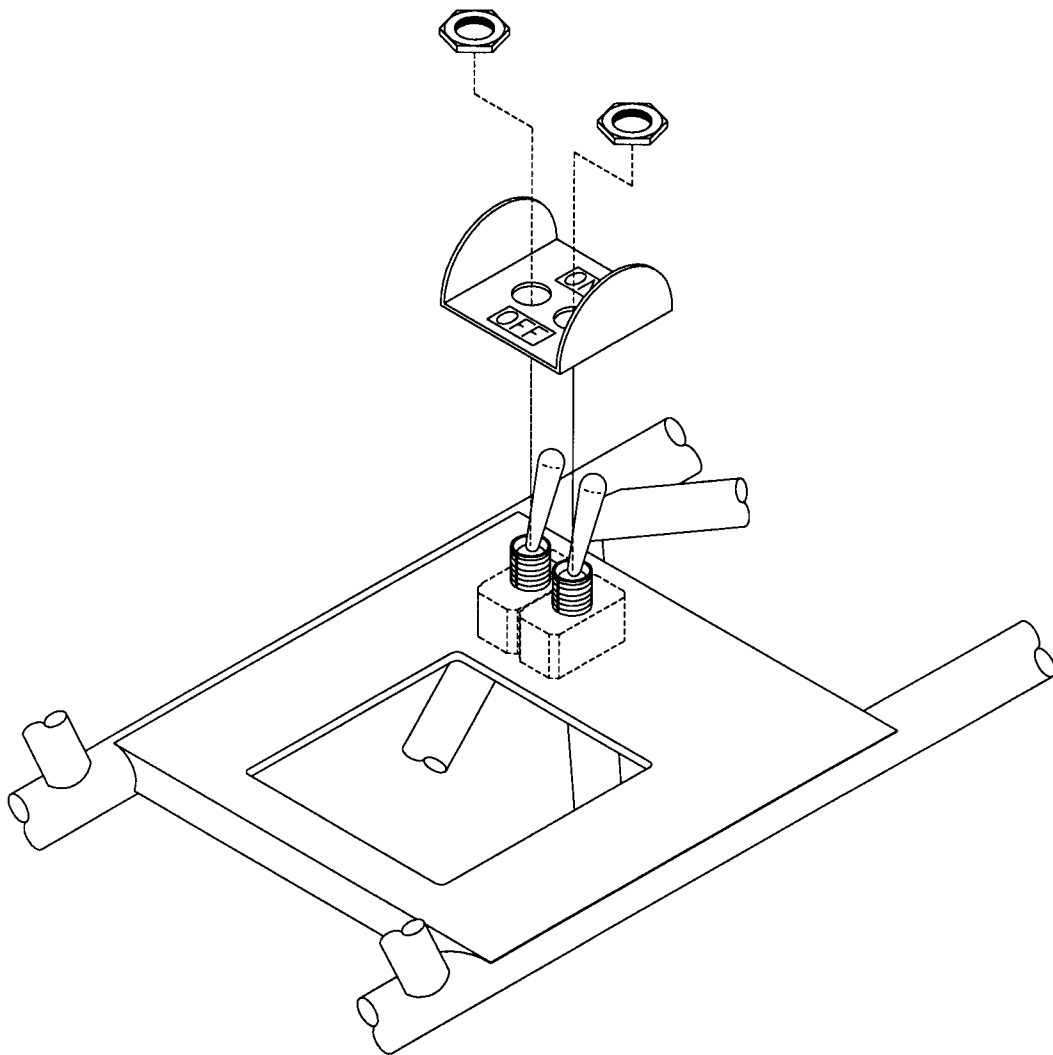
MD4041

**FIGURE 3-5**  
**S-18 STINGER II**



MD4042

**FIGURE 3-6**  
**S-18 STINGER II**



MD4068

**FIGURE 3-7**  
**S-18 STINGER II**

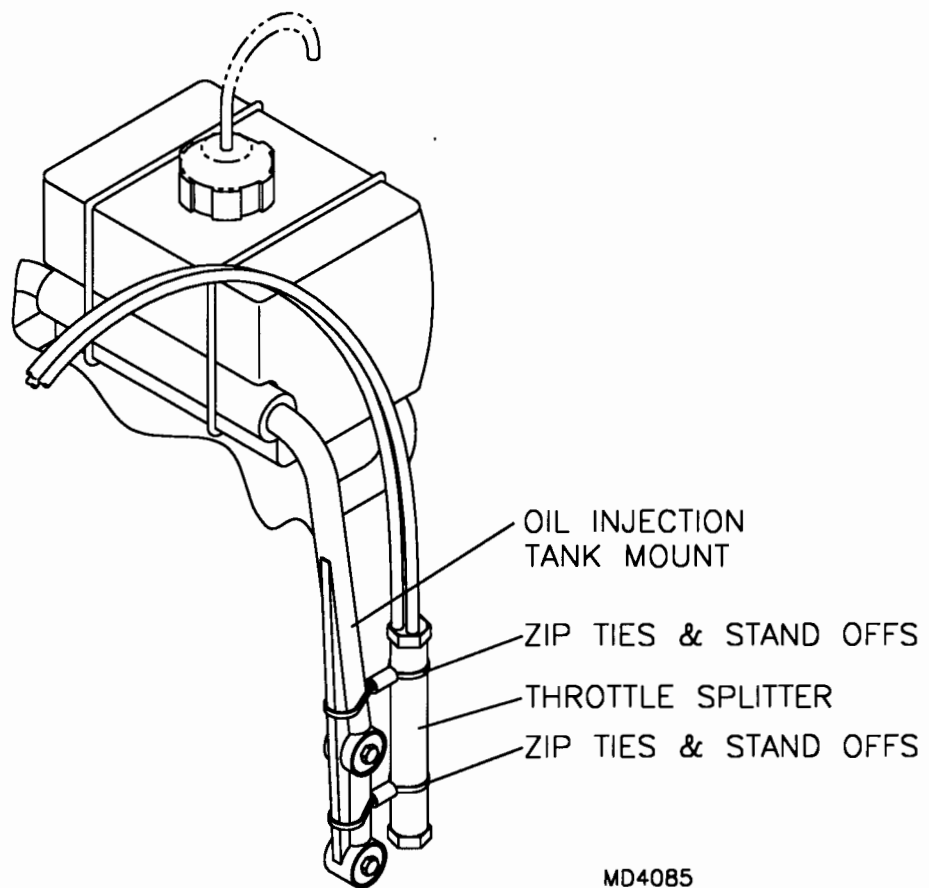
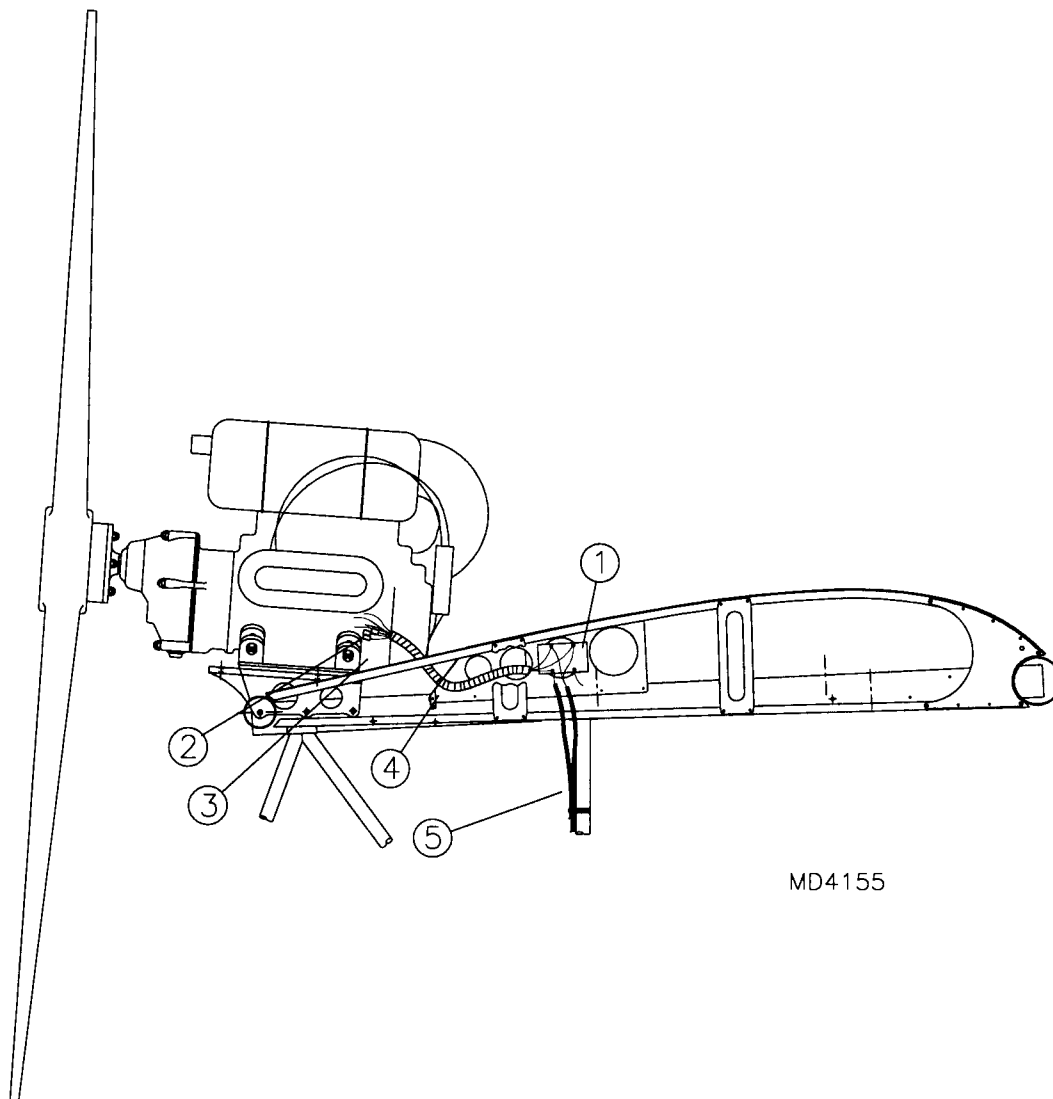


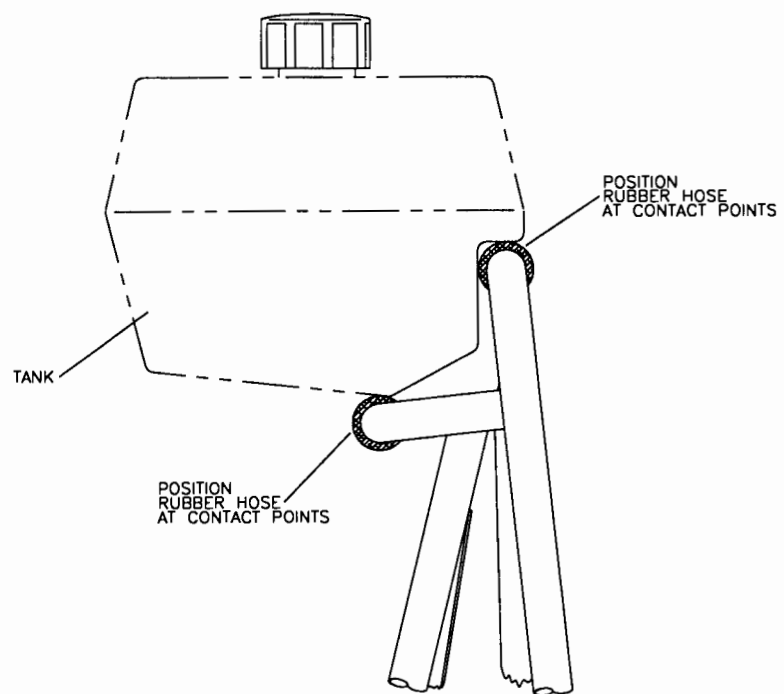
FIGURE 3-9  
S-18 STINGER II



MD4155

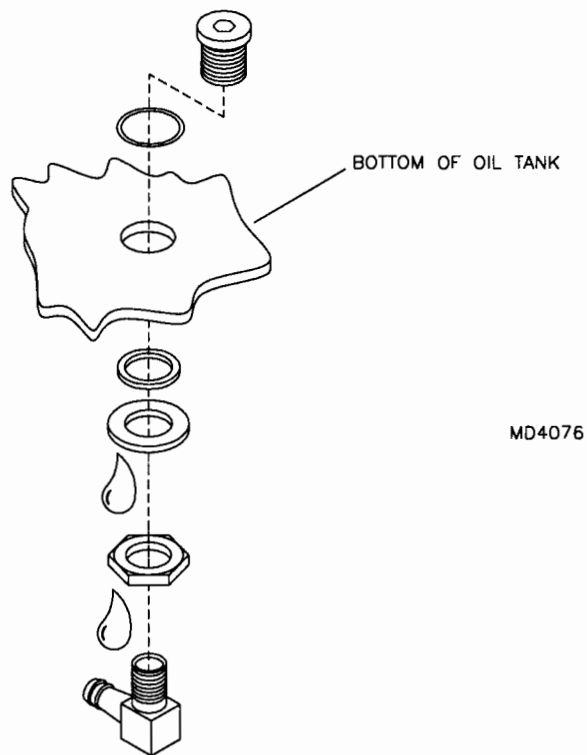
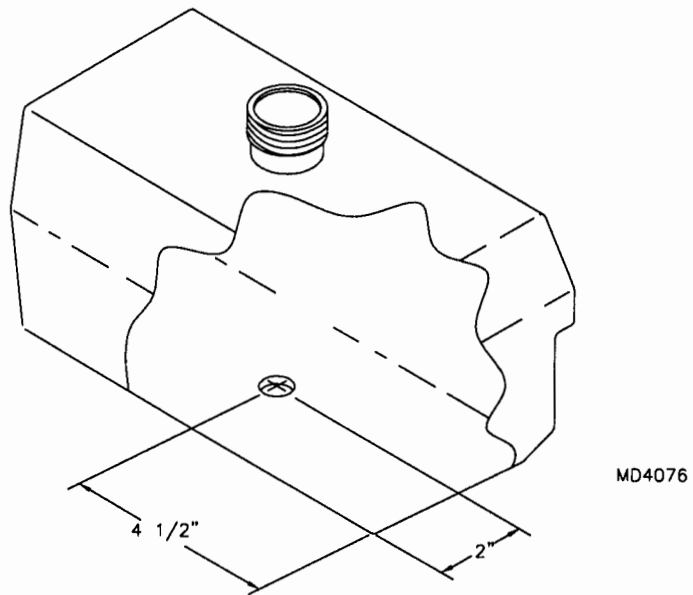
1. REGULATOR BOLTS TO RH SIDE, JUST AFT AND ABOVE THE CENTER CABINE
2. ENGINE WIRES – SEE MANUAL OR SCHEMATIC IN PARTS MANUAL.
3. COIL OF DUAL EGT WIRES – SECURE WITH ZIP TIES TO ENGINE MOUNT USE SHORT STAND OFFS.
4. USE CENTIPEDE STRIP TO COVER THE SLOT IN THE CENTER COVER
5. ROUTE WIRE BUNDLE DOWN CABINE TO INSTRUMENT PANEL

**FIGURE 03-9A**  
**S-18 STINGER II**

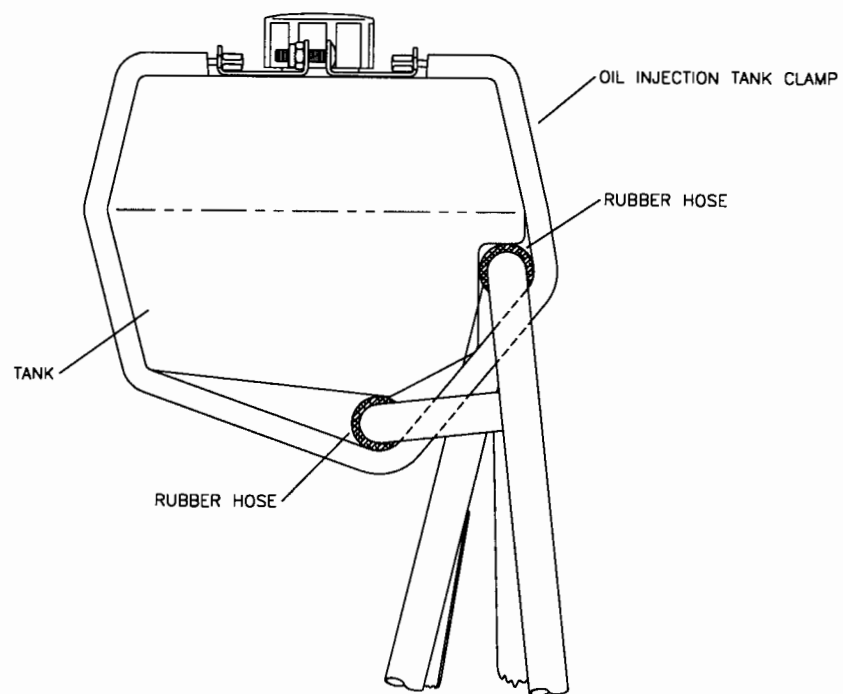


MD4075

**FIGURE 3-10**  
**S-18 STINGER II**

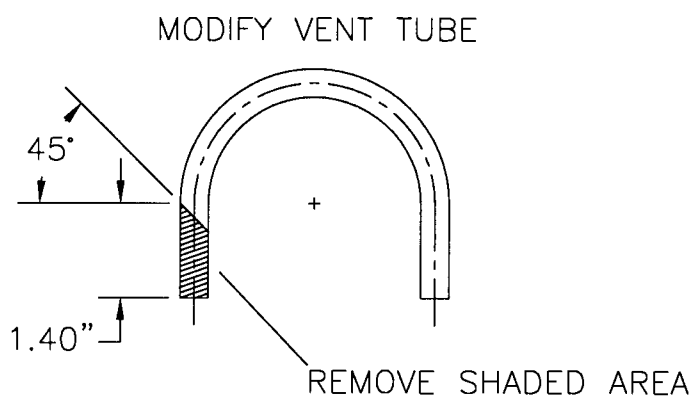
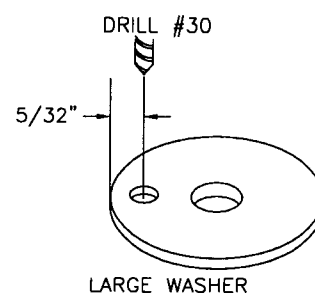
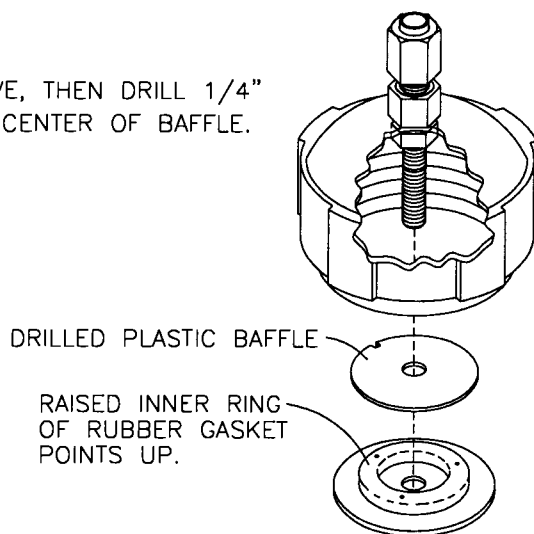
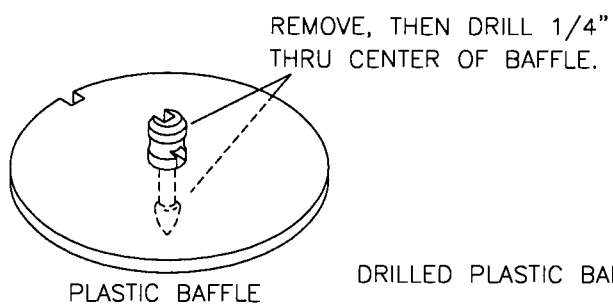
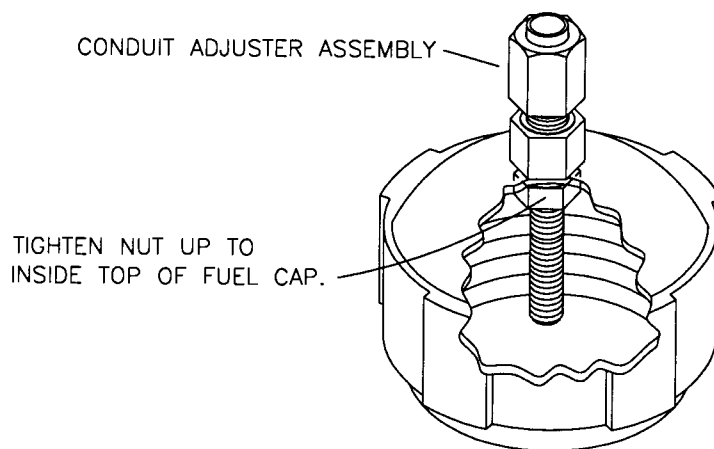
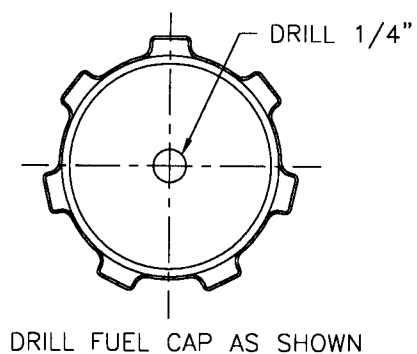


**FIGURE 3-11**  
**S-18 STINGER II**



MD4077

FIGURE 3-12  
S-18 STINGER II



MD4078

**FIGURE 3-13**  
**S-18 STINGER II**

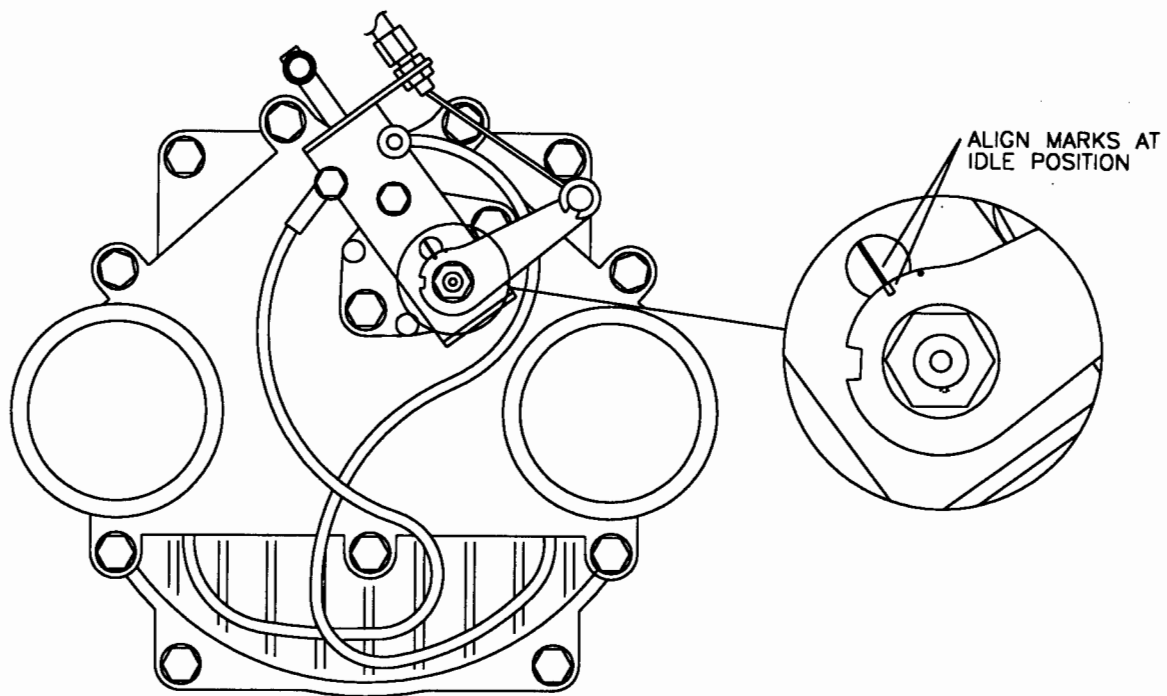
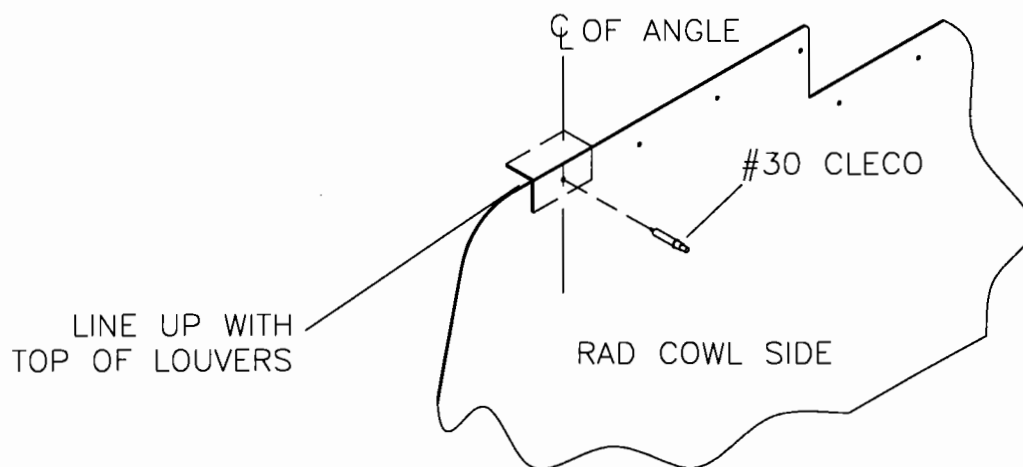
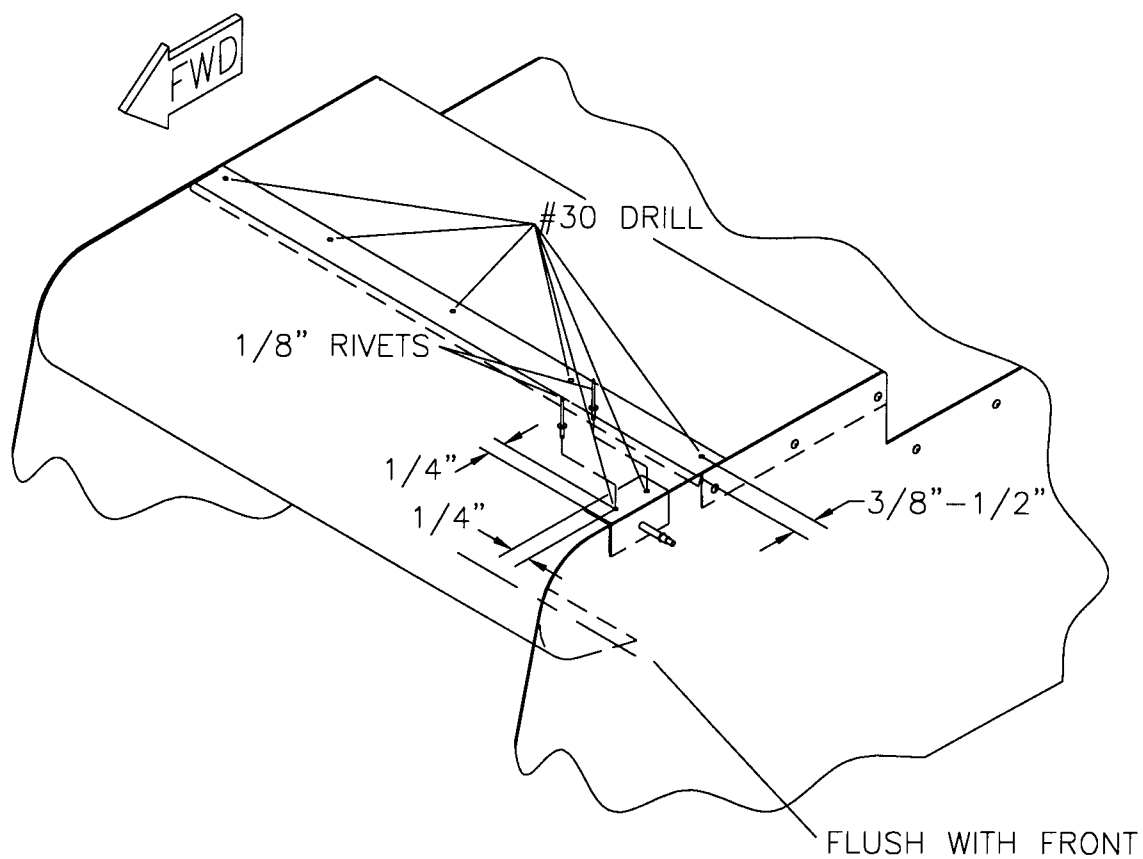


FIGURE 3-14  
S-18 STINGER II



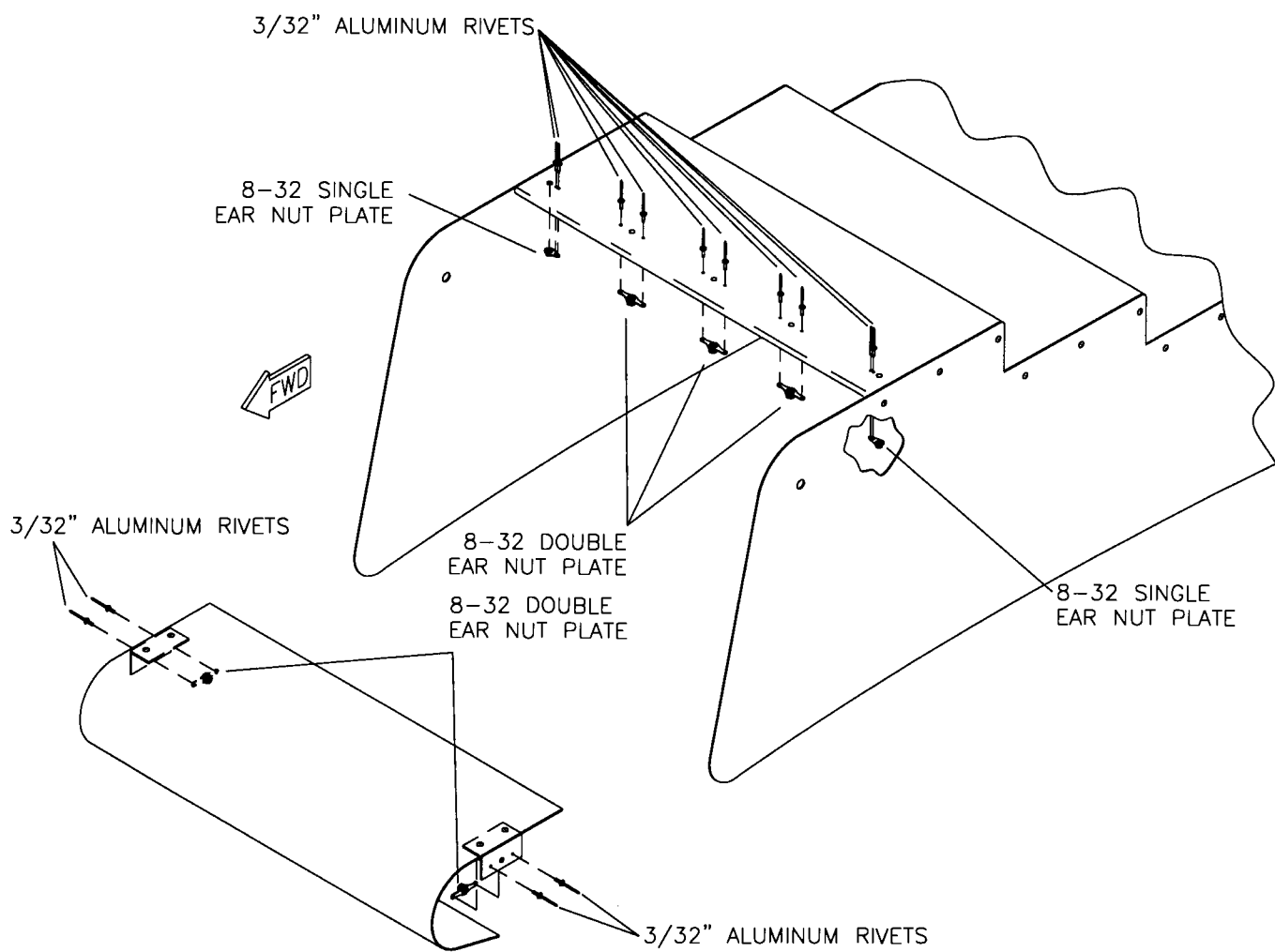
MD4120

**FIGURE 3-14A  
S-18 STINGER II**



MD4121

**FIGURE 3-14B**  
**S-18 STINGER II**



MD4122

**FIGURE 3-14C**  
**S-18 STINGER II**

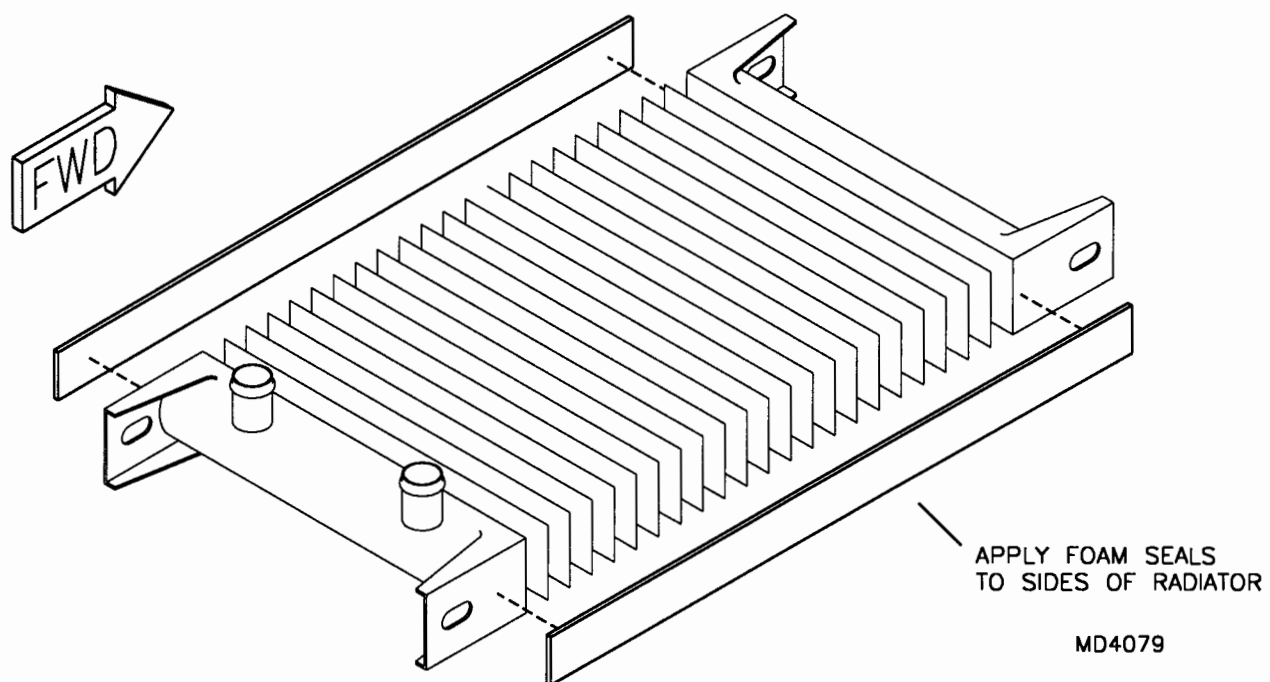
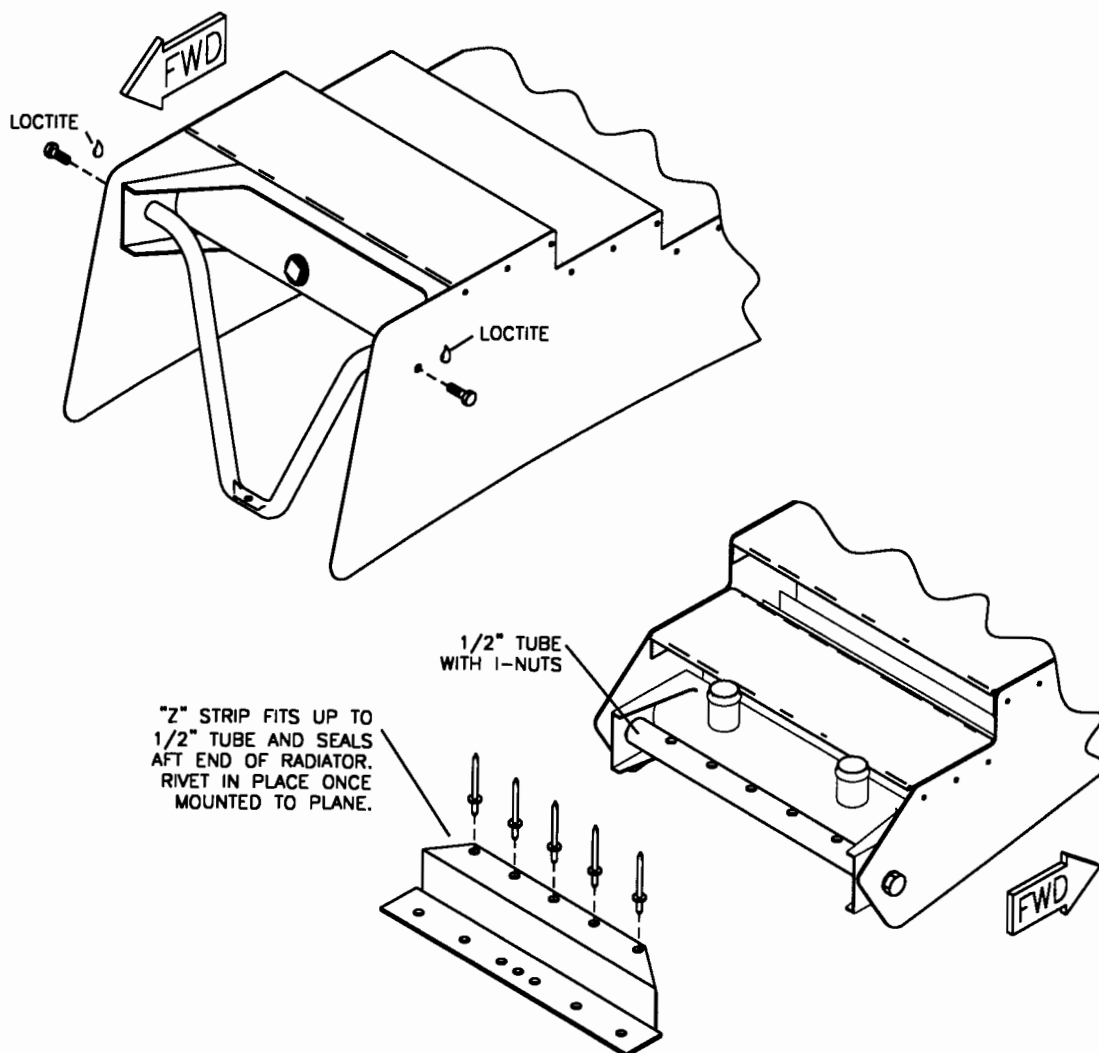
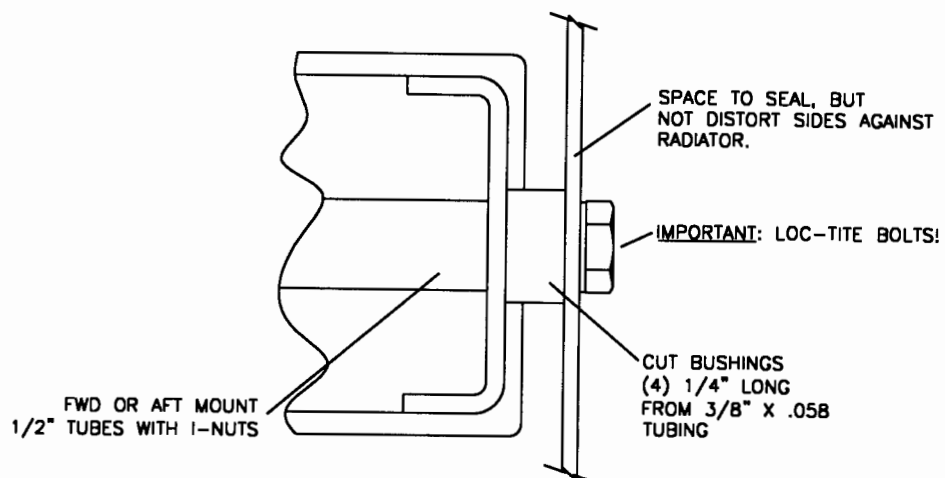
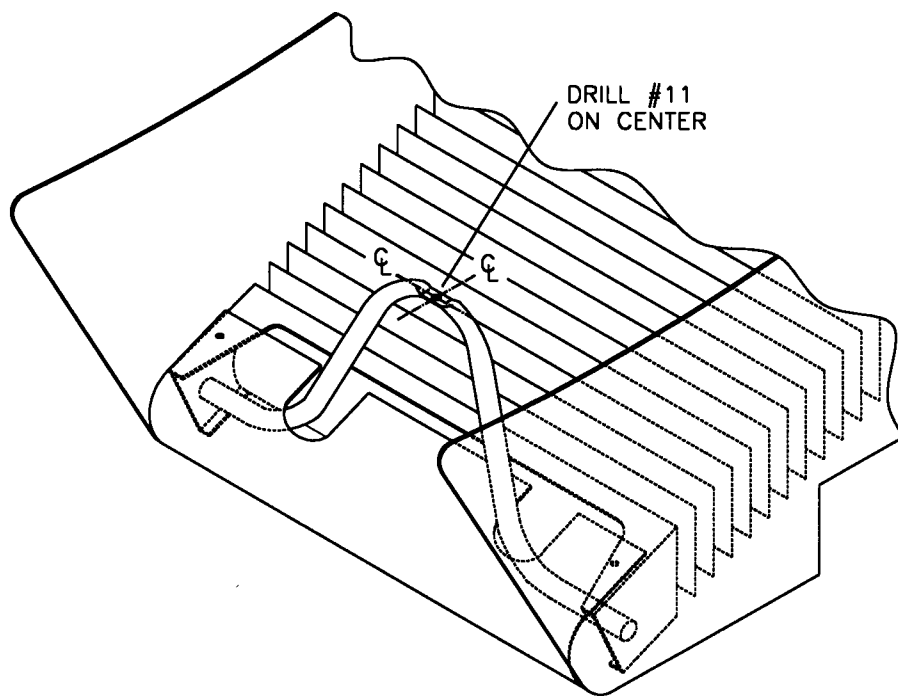


FIGURE 3-15  
S-18 STINGER II



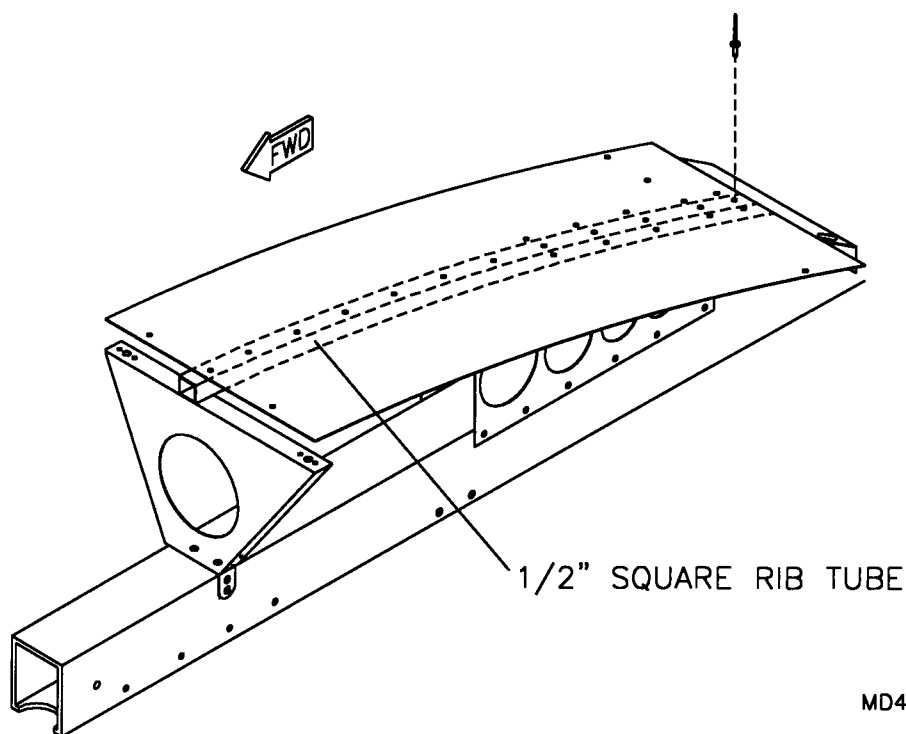
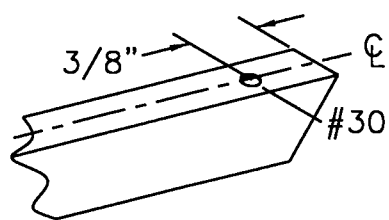
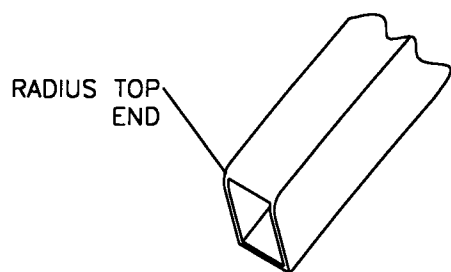
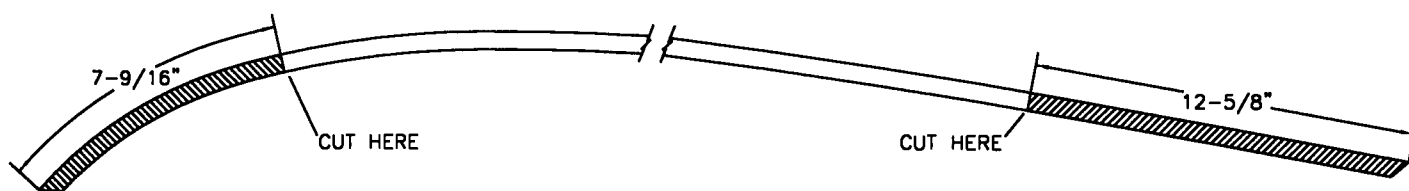
MD4080

FIGURE 3-16  
S-18 STINGER II



MD4081

FIGURE 3-17  
S-18 STINGER II



MD4082

FIGURE 3-18  
S-18 STINGER II

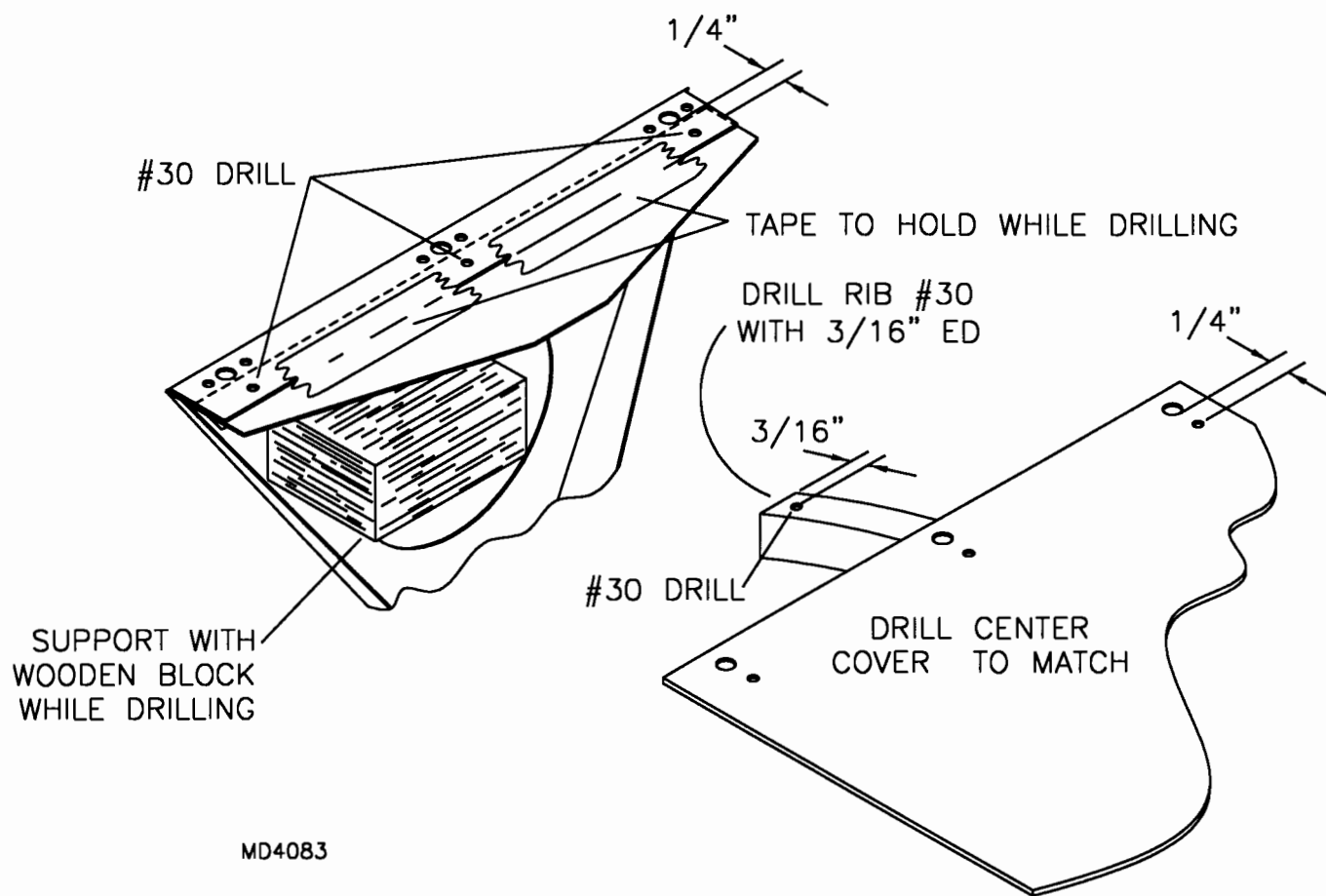


FIGURE 3-19  
S-18 STINGER II

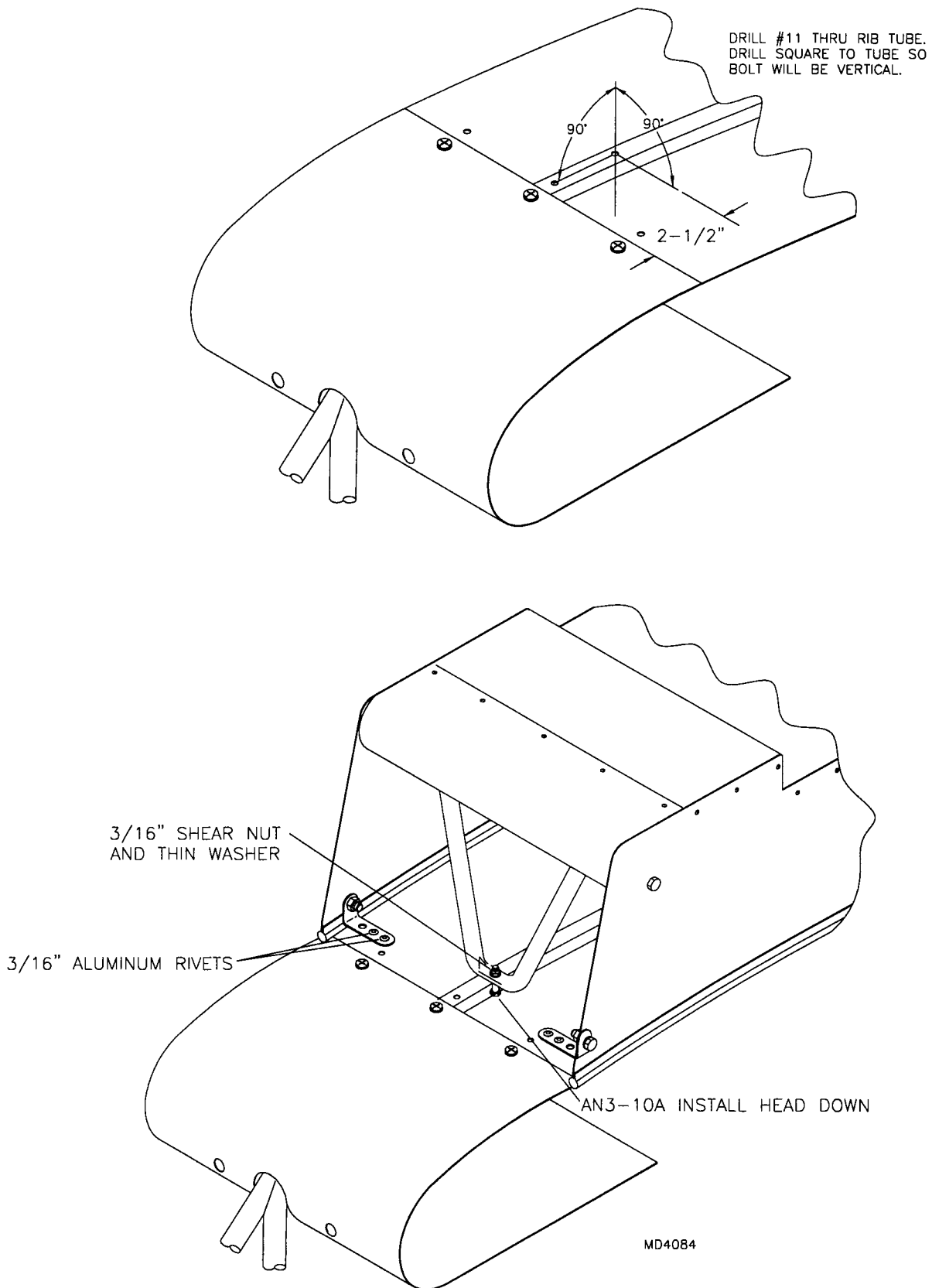


FIGURE 3-20  
S-18 STINGER II

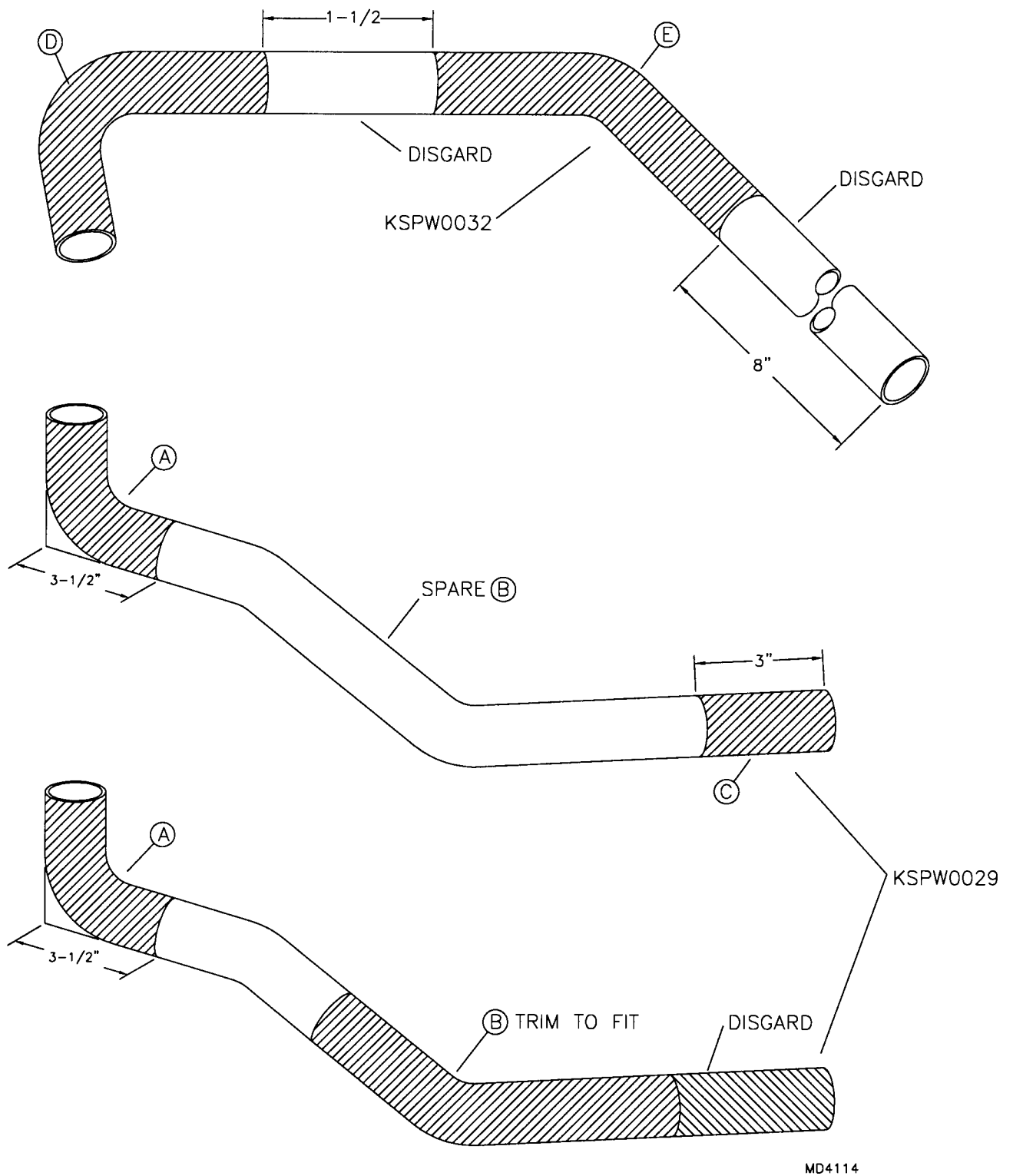
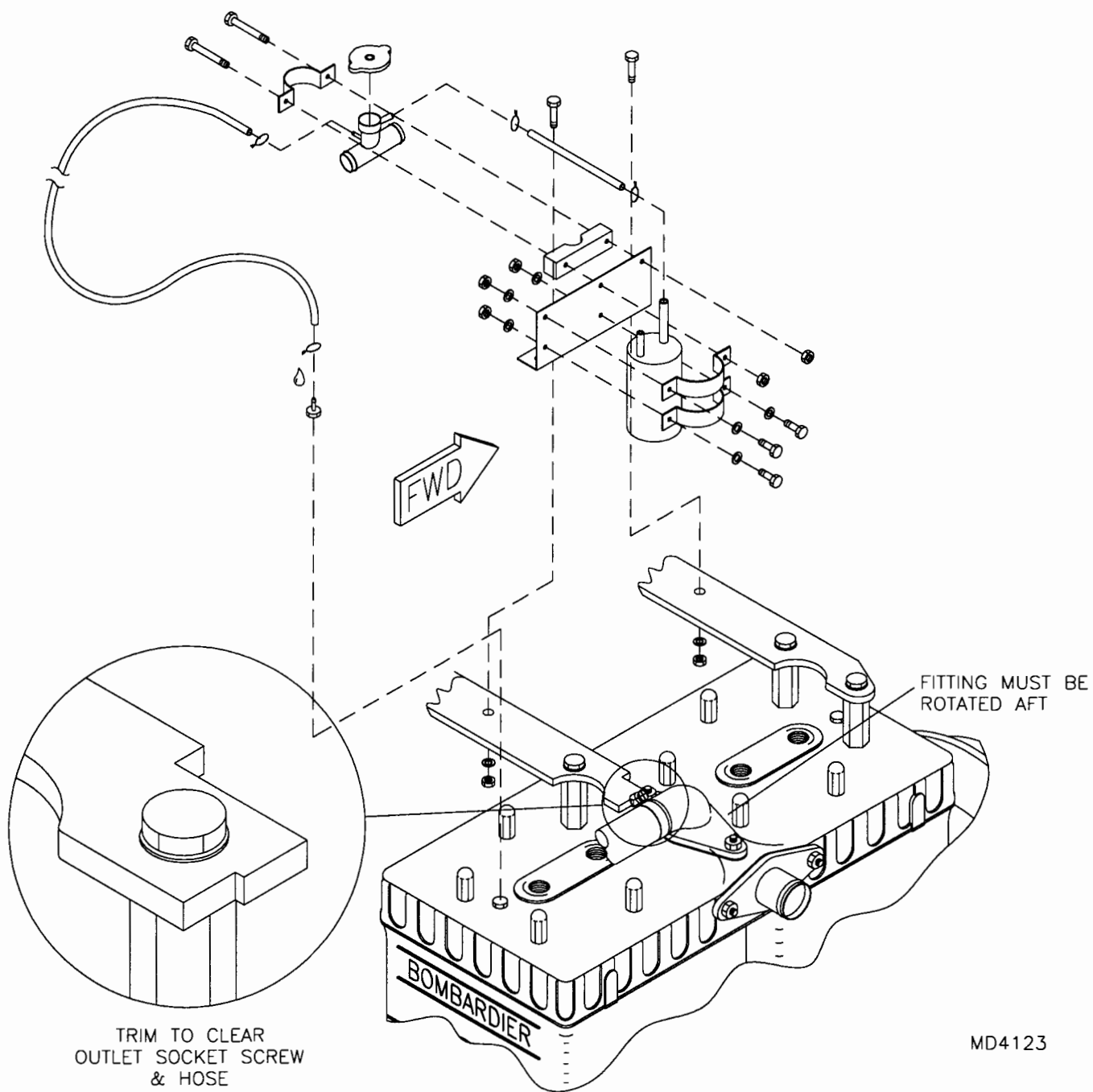
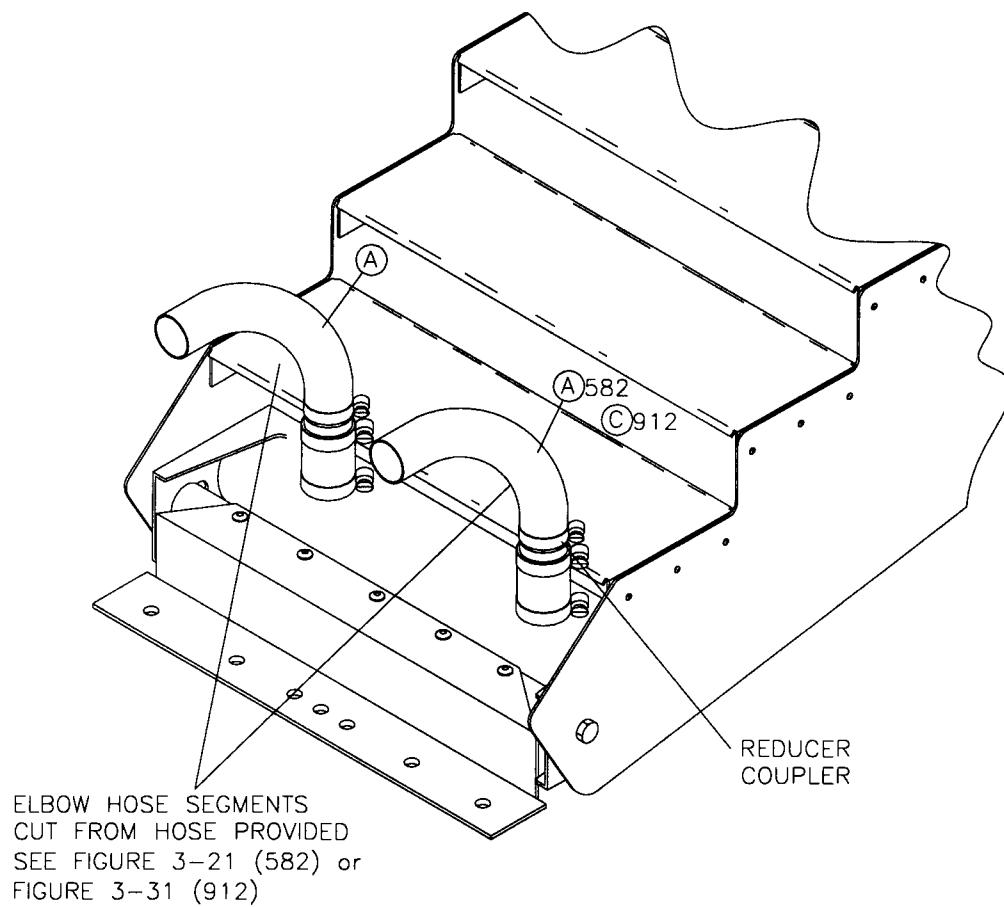


FIGURE 3-21  
S-18 STINGER II



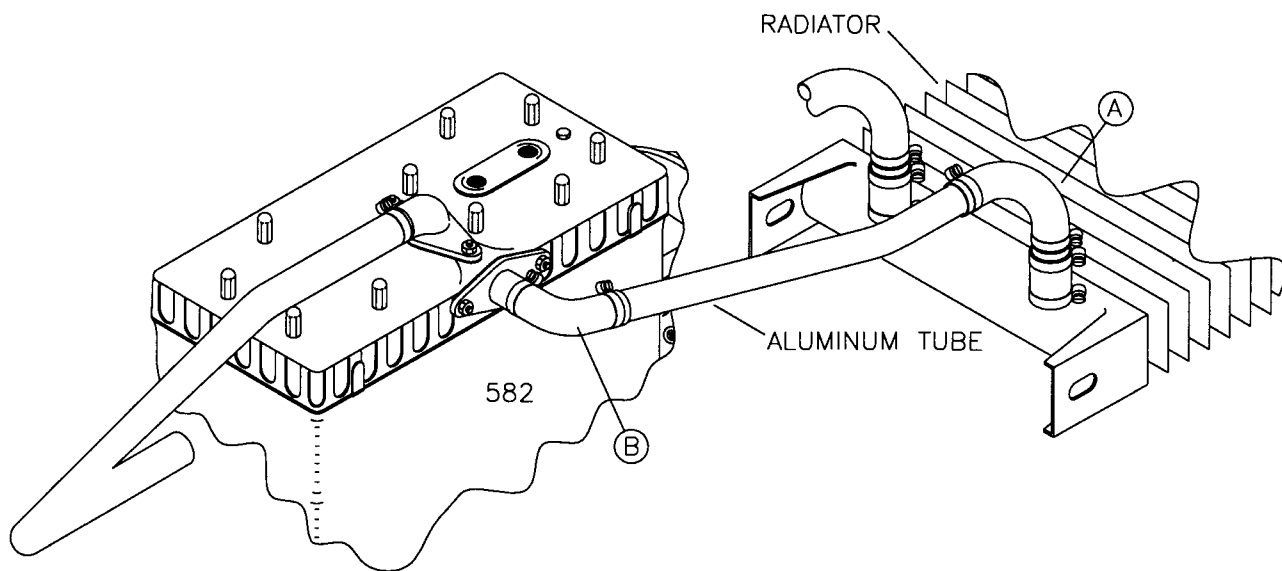
MD4123

**FIGURE 3-22**  
**S-18 STINGER II**



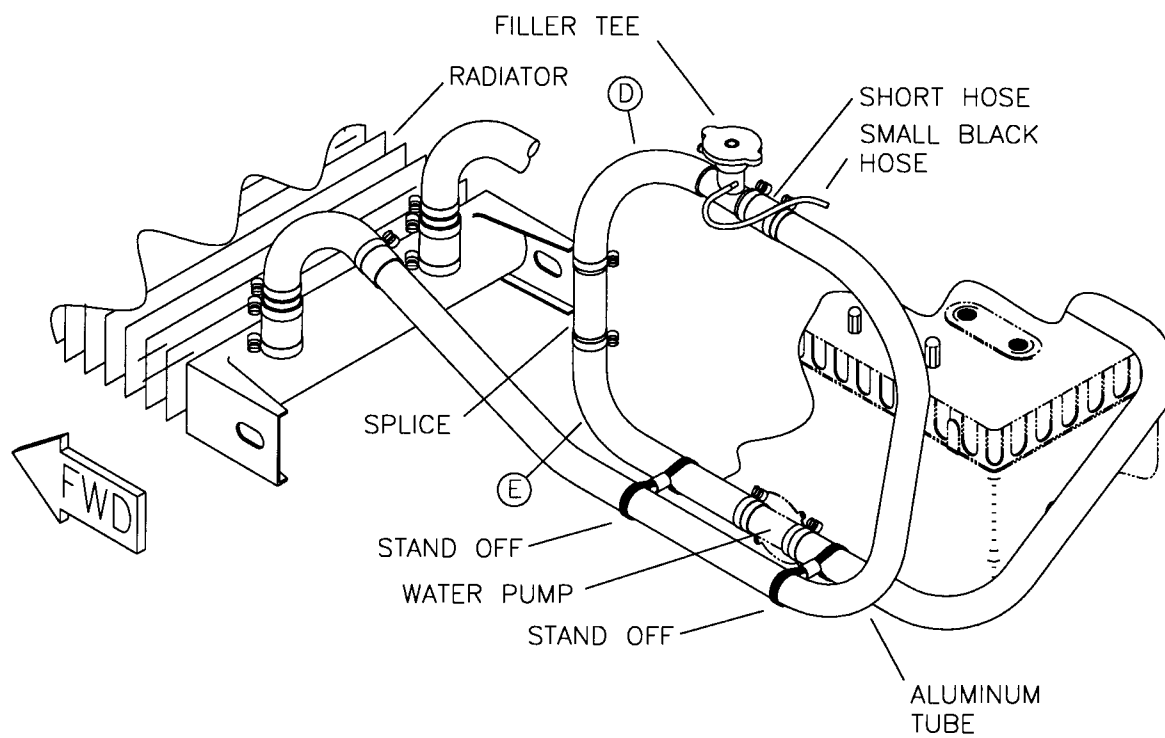
MD4115

**FIGURE 3-23**  
**S-18 STINGER II**



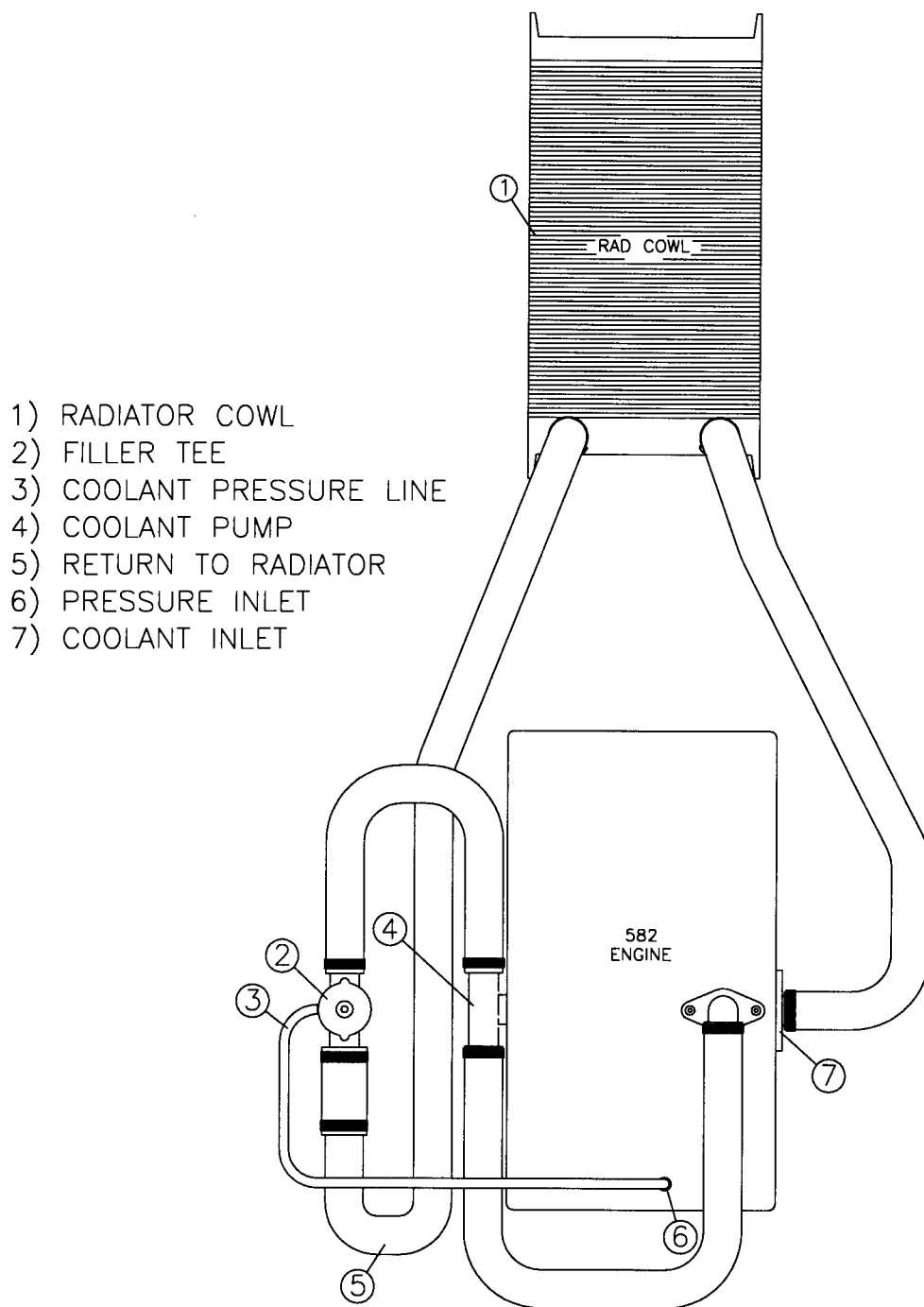
MD4116

**FIGURE 3-24**  
**S-18 STINGER II**



MD4117

**FIGURE 3-25**  
**S-18 STINGER II**



MD4118

**FIGURE 3-26**  
**S-18 STINGER II**

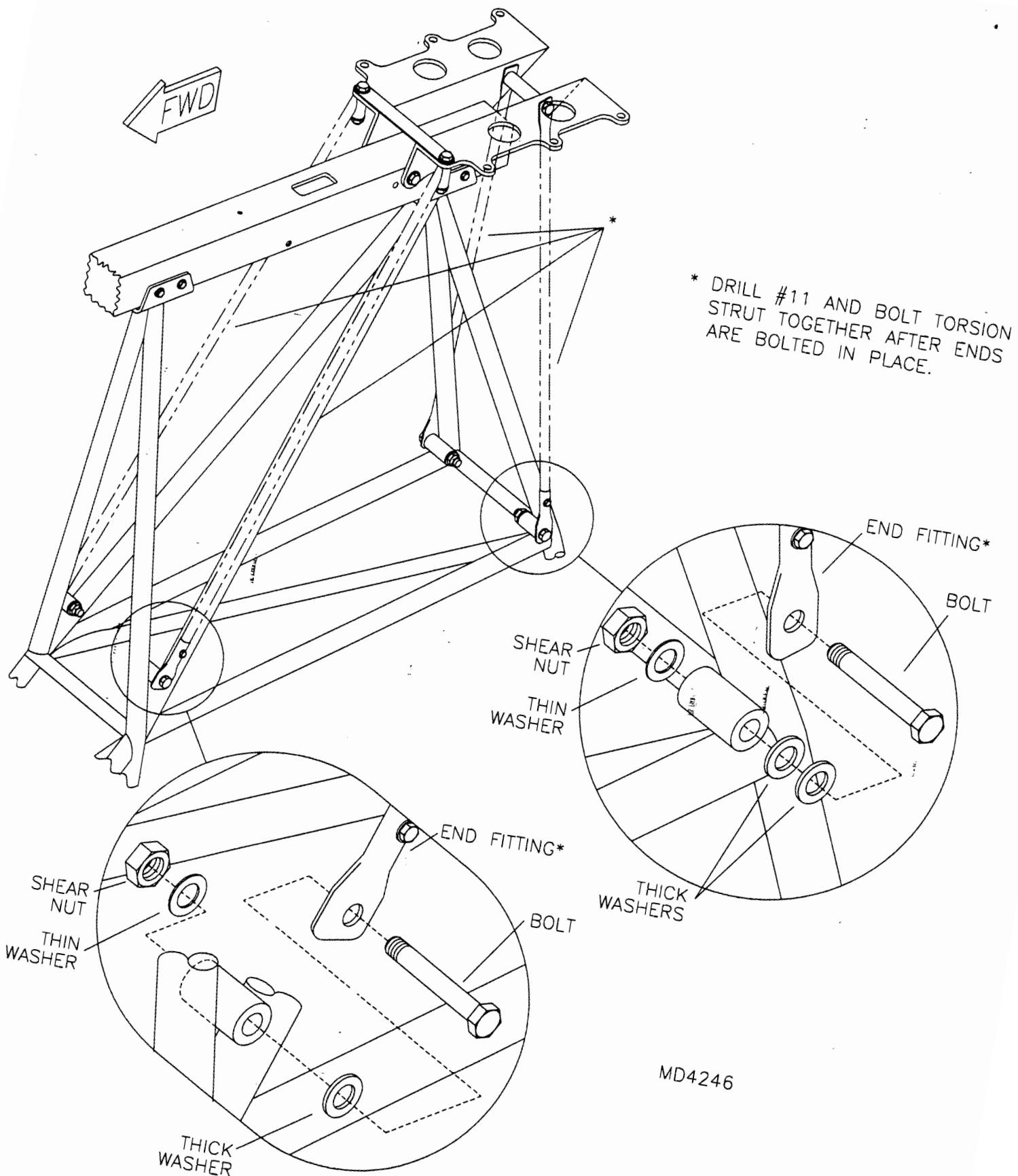
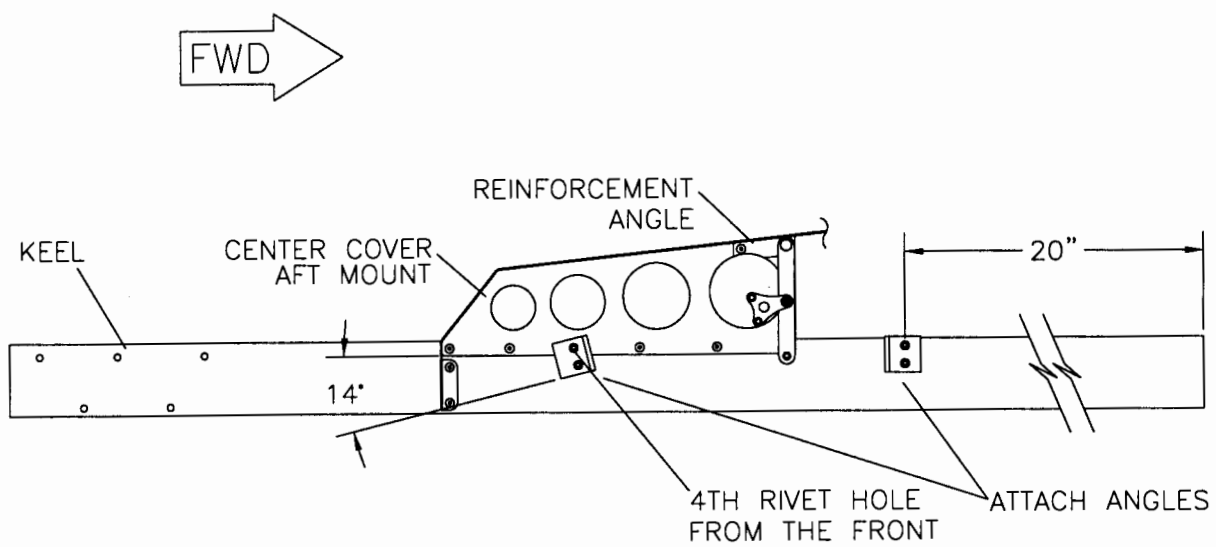


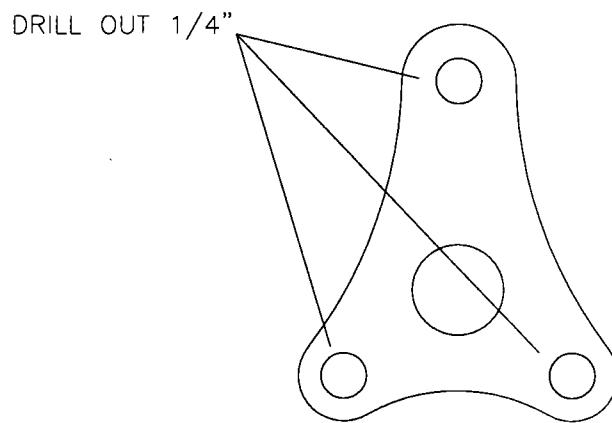
FIGURE 3-27  
S-18 STINGER II

MD4246



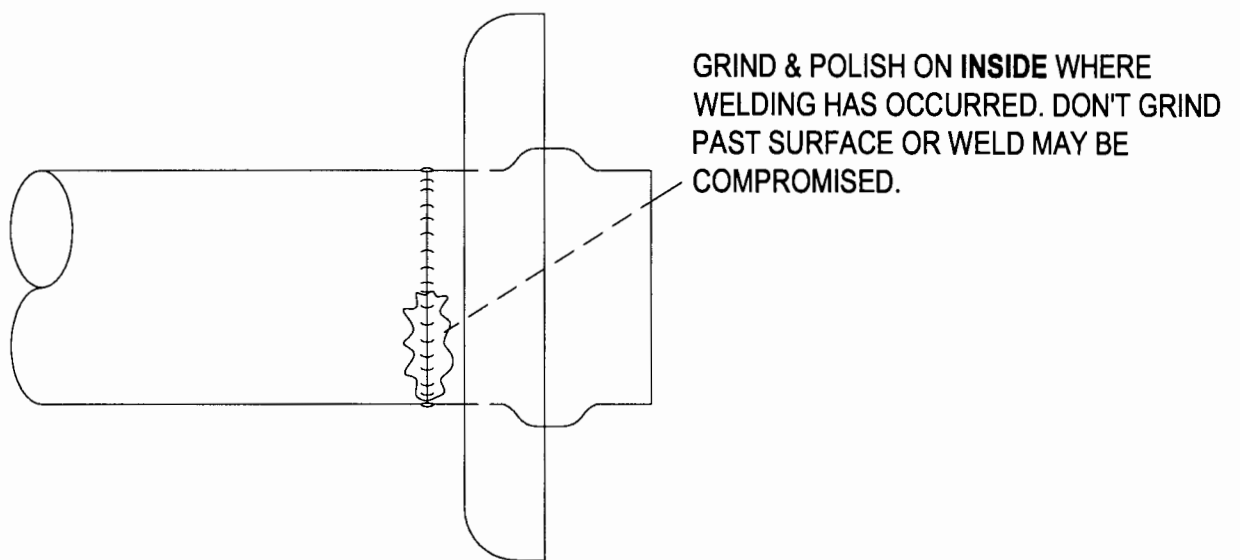
MD4252

**FIGURE 3-28**  
**S-18 STINGER II**



MD4250

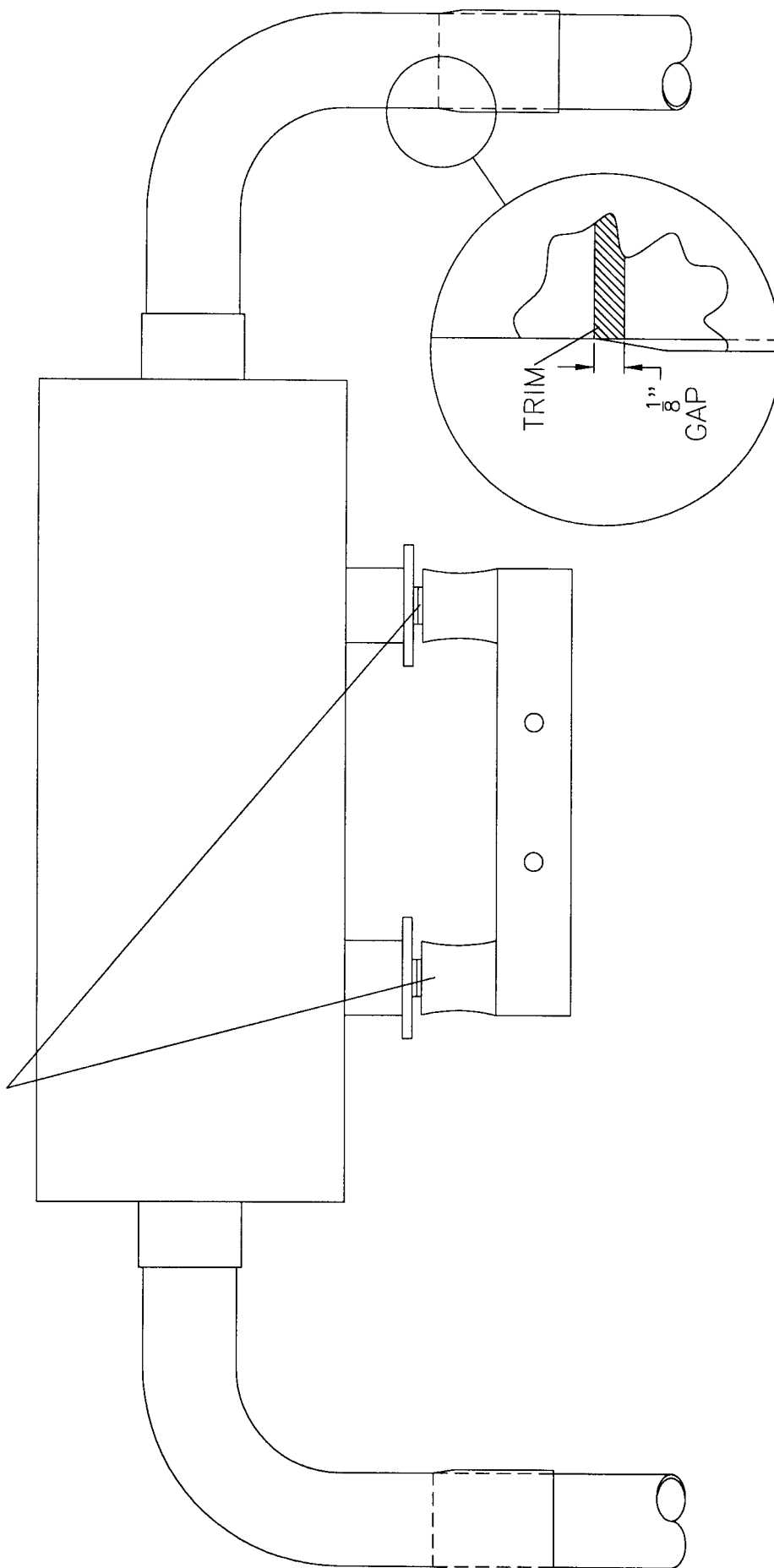
**FIGURE 3-29**  
**S-18 STINGER II**



MD4456

FIGURE 3-29A  
S-18 STINGER II

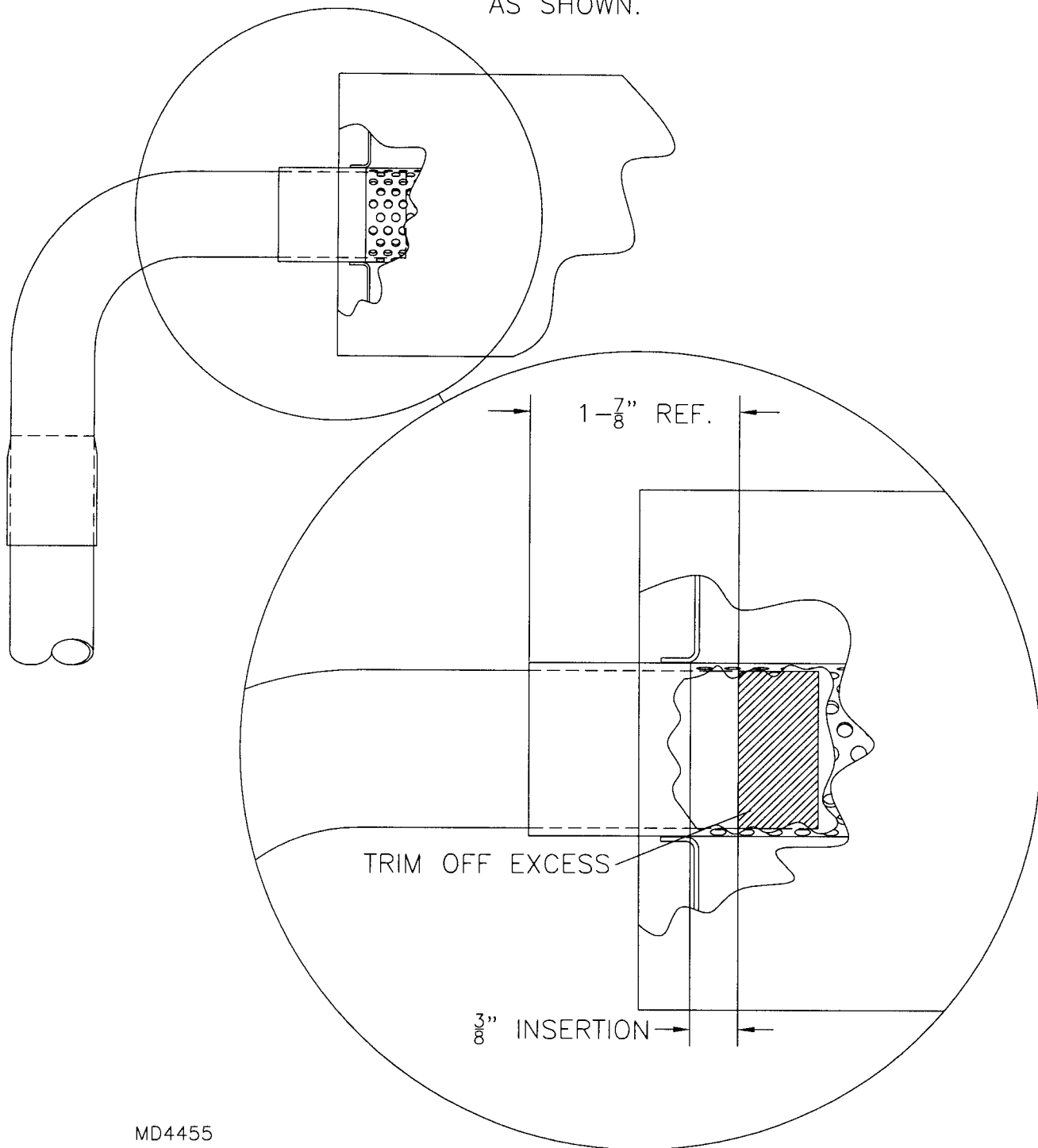
IF THE ISOLATORS ARE BEING  
PULLED UP, TRIM PIPES  
THAT INSERT INTO SWAGGED  
PIPES.



MD4454

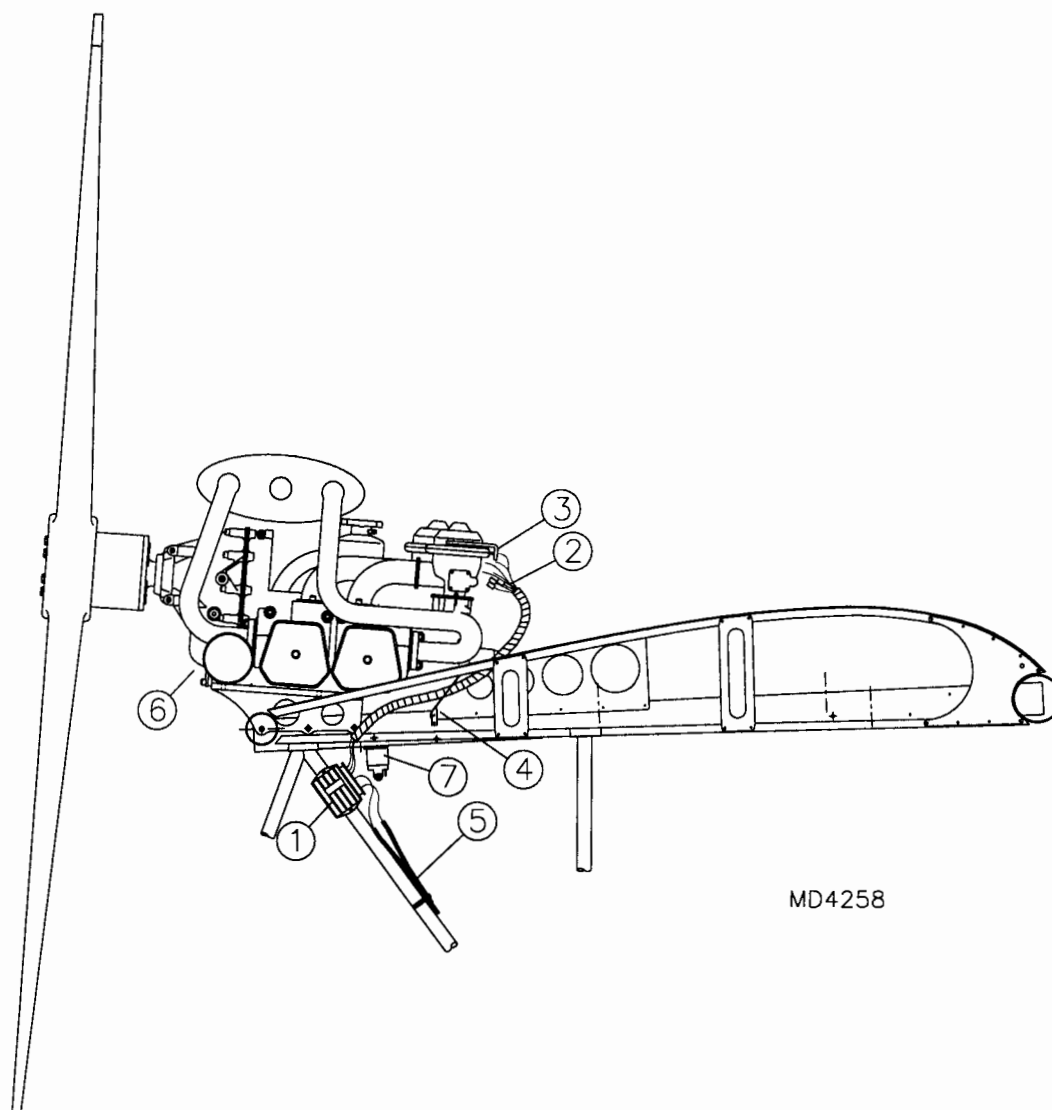
FIGURE 3-29B  
S-18 STINGER II

TRIM OFF EXTRA PIPE  
INSIDE OF MUFFLER  
AS SHOWN.



MD4455

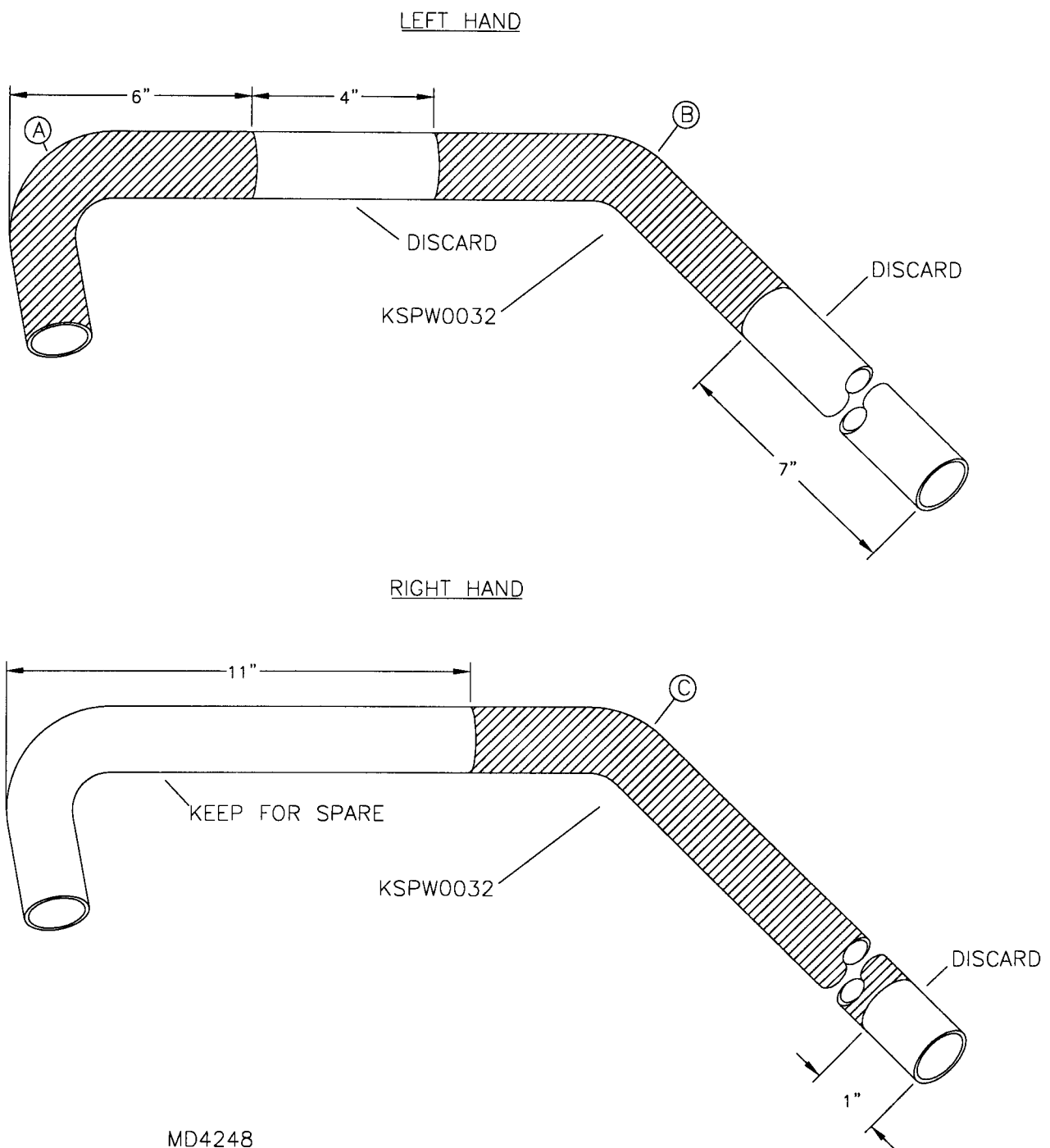
FIGURE 3-29C  
S-18 STINGER II



MD4258

1. REGULATOR BOLTS TO RH SIDE ON REAR DIAGONAL CABINE WITH CUSHION CLAMPS.
2. ENGINE WIRES – SEE MANUAL OR SCHEMATIC IN PARTS MANUAL.
3. ROUTE THROTTLE CABLES FORWARD. THEN THROUGH CENTER COVER SLOTS. SECURE WITH ZIP TIES & SHORT STANDOFFS.
4. USE CENTIPEDE STRIP TO COVER THE SLOT IN THE CENTER COVER
5. ROUTE WIRE BUNDLE DOWN LH CABINE TO INSTRUMENT PANEL
6. ROUTE CHOKE CABLES AFT, THEN BEHIND & UNDER ENGINE. SECURE WITH ZIPTIES & SHORT STANDOFFS
7. STARTER SOLENOID RIVETS TO KEEL BOTTOM. APPROXIMATELY 7-1/2" FROM THE AFT END. PROTECT ELECTRICAL CONTACTS WITH SILICON SEALER TO PREVENT SHORTING.

**FIGURE 03-30**  
**S-18 STINGER II**



MD4248

**FIGURE 3-31**  
**S-18 STINGER II**

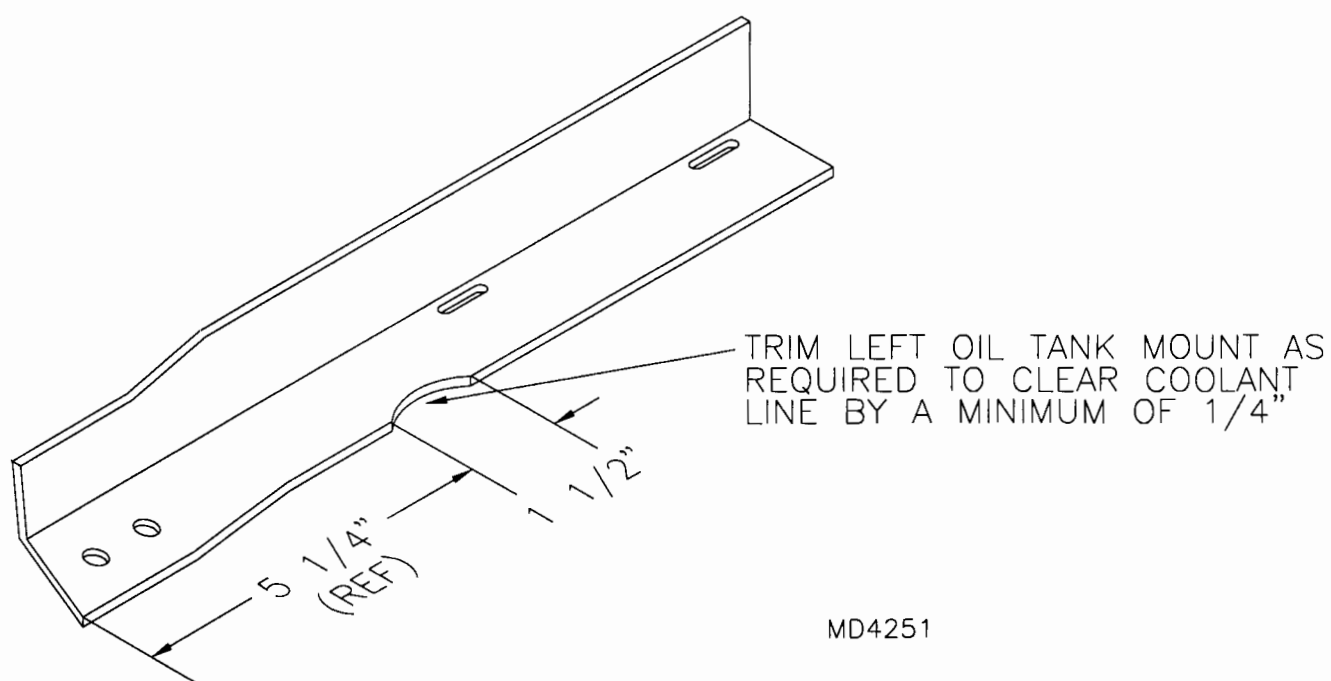
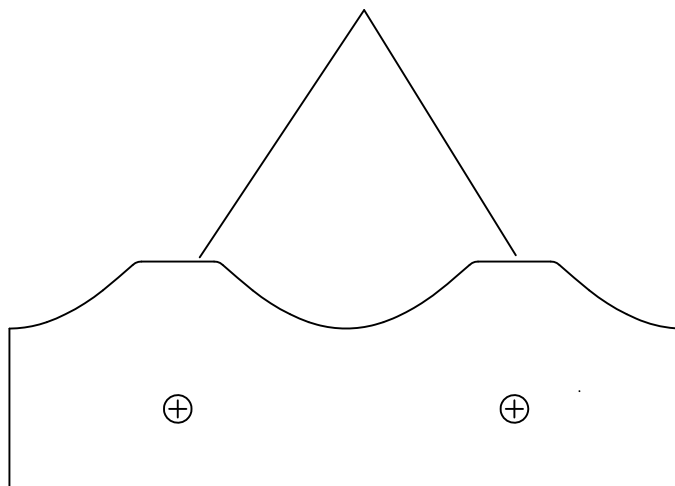


FIGURE 3-32  
S-18 STINGER II

NEED TO BE FLUSH  
WITH END OF TUBE



"FISH MOUTH TEMPLATE"

MD2196

FIGURE 4-1  
S-18 STINGER II

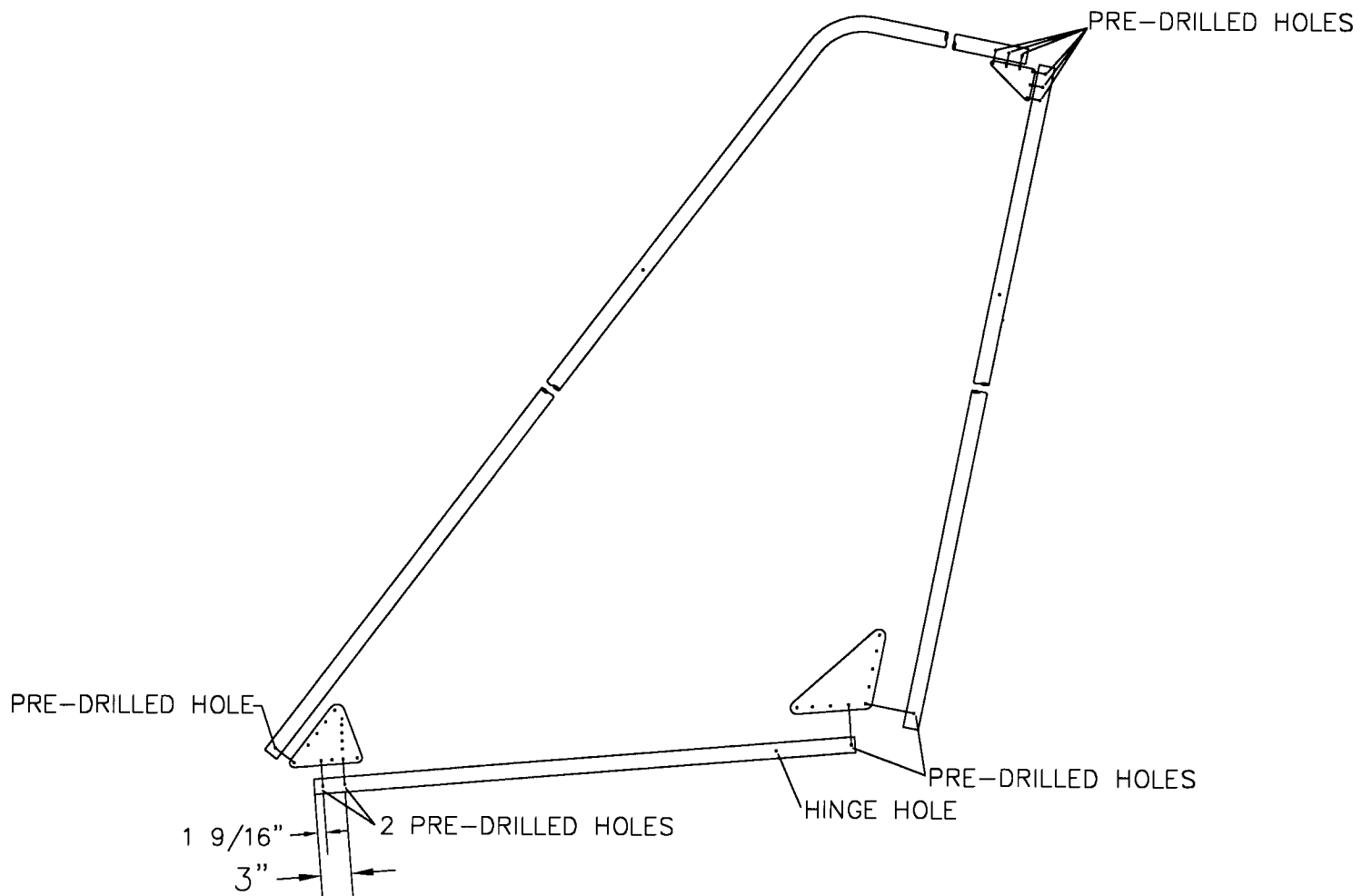
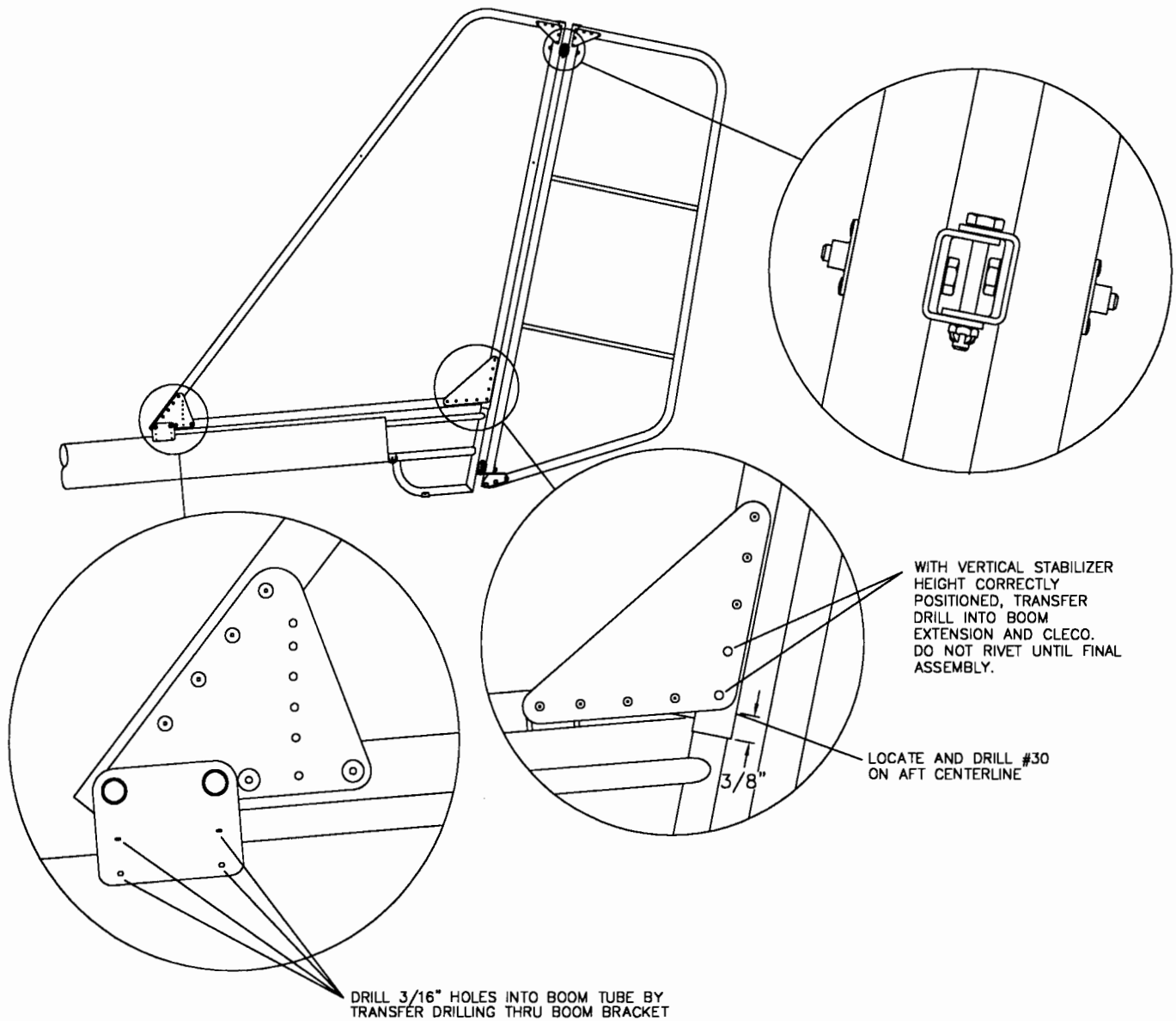


FIGURE 4-2  
S-18 STINGER II

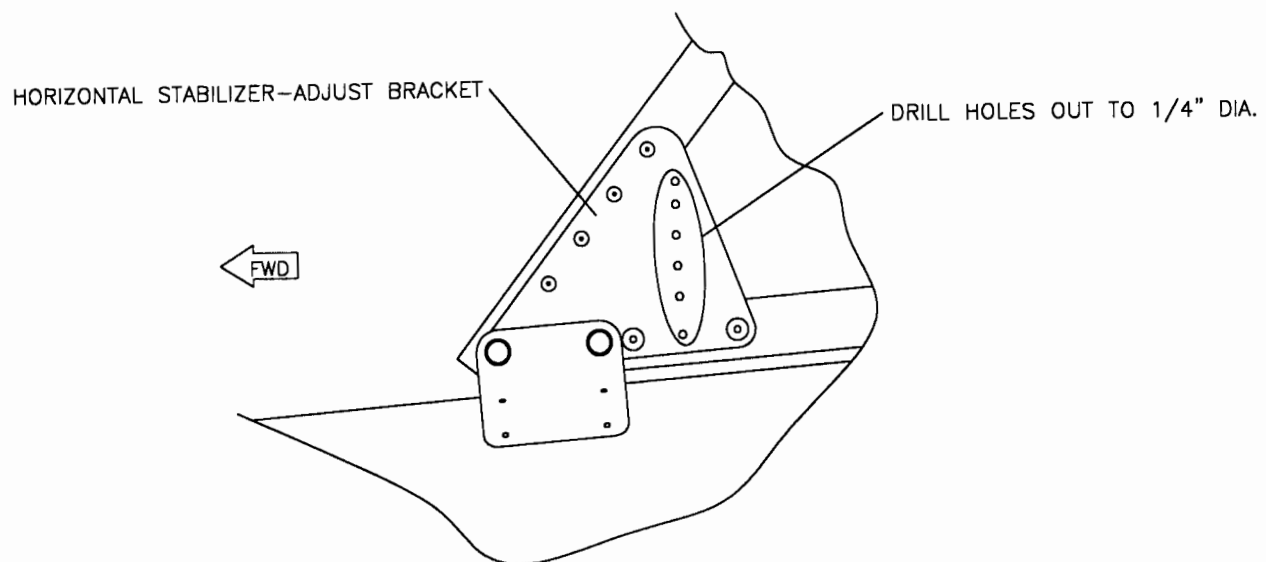
MD4471

6/13/03



**FIGURE 4-3**  
**S-18 STINGER II**

MD3608



MD2197

FIGURE 4-4  
S-18 STINGER II

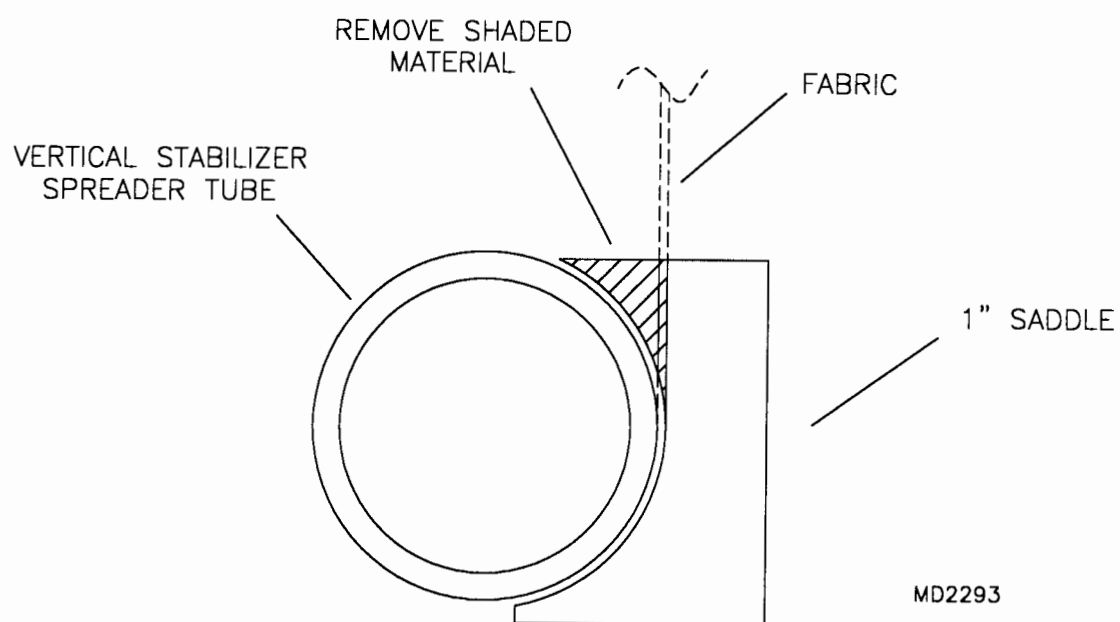


FIGURE 4-5  
S-18 STINGER II

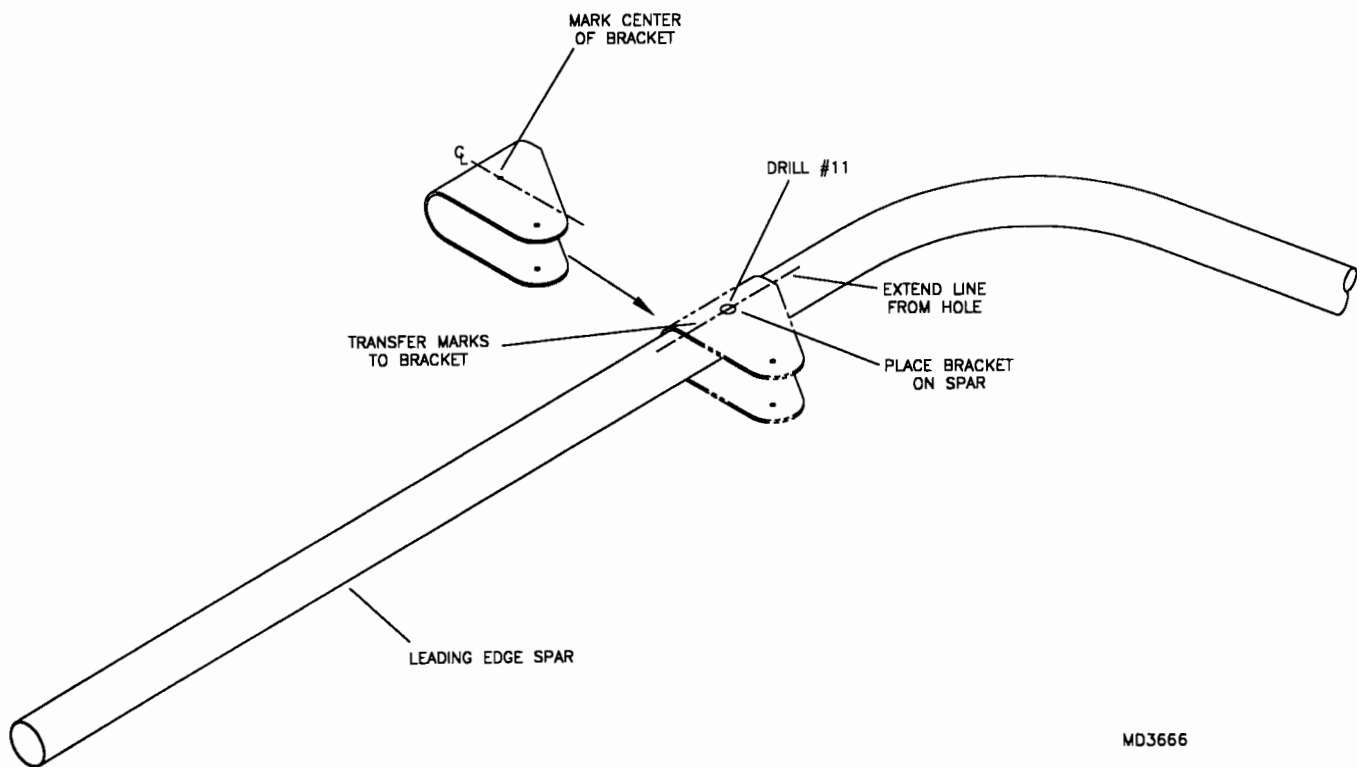
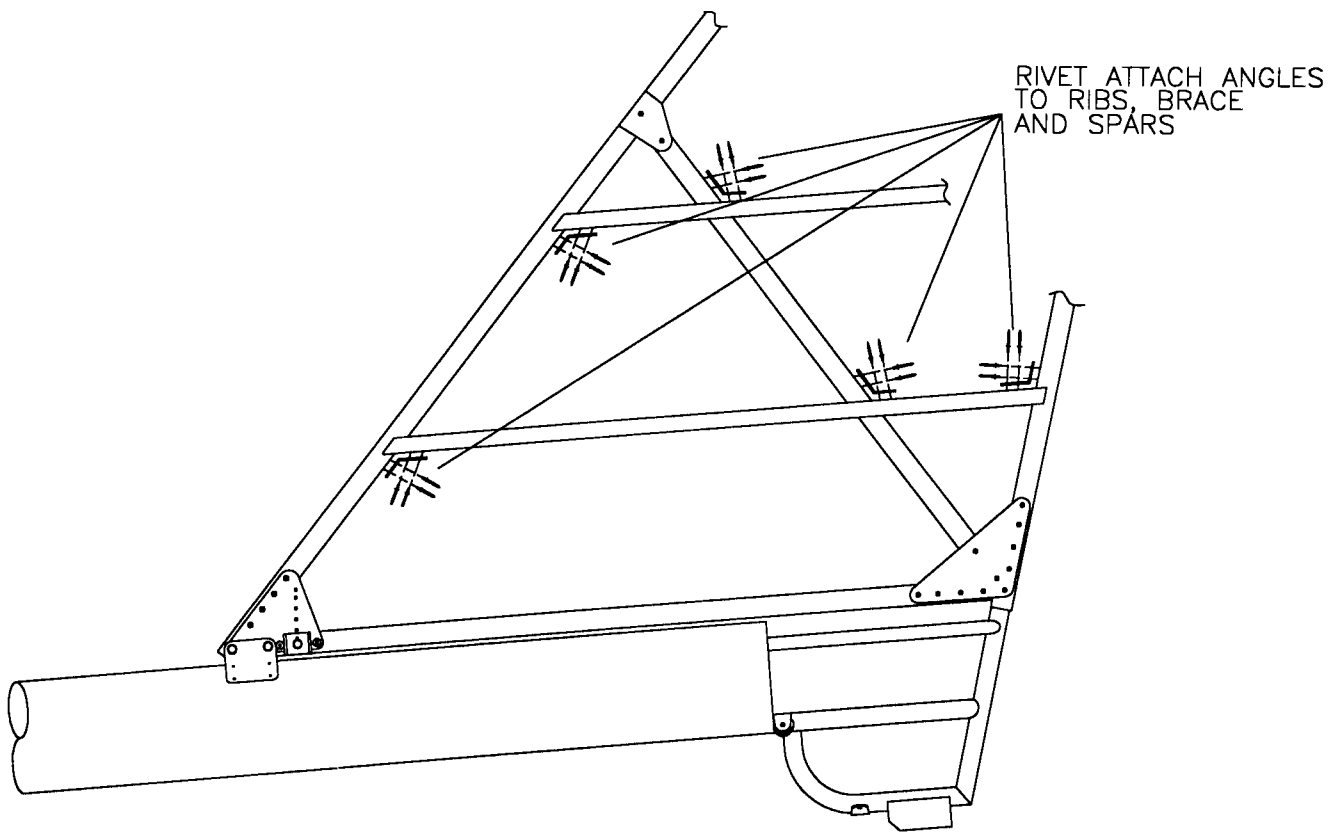
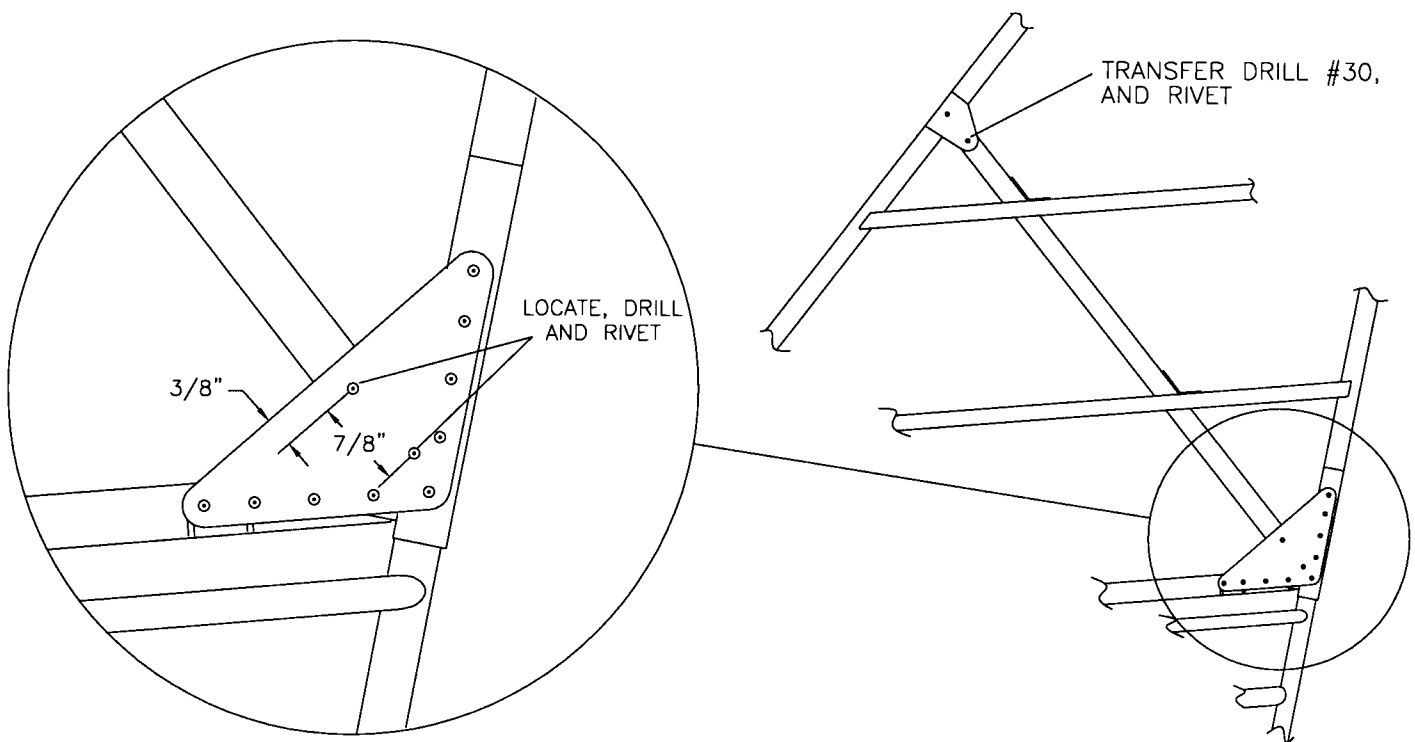


FIGURE 4-6  
S-18 STINGER II



MD3665

FIGURE 4-7  
S-18 STINGER II



MD3667

FIGURE 4-8  
S-18 STINGER II

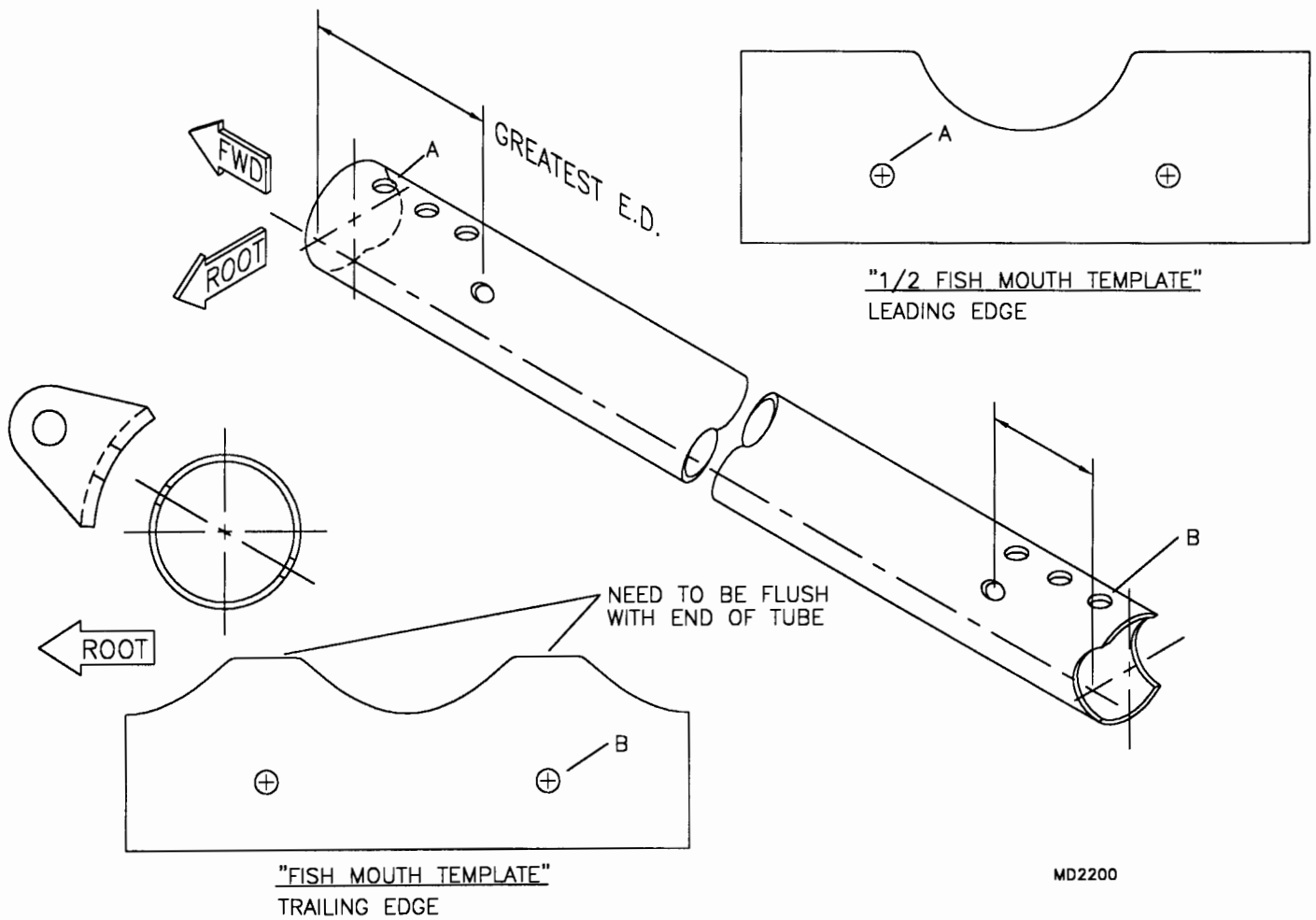
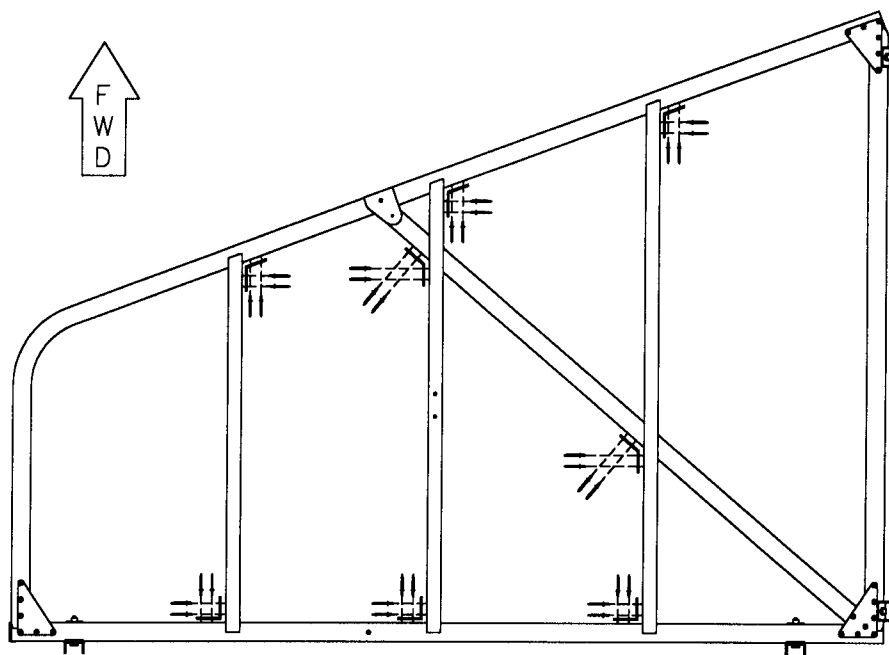


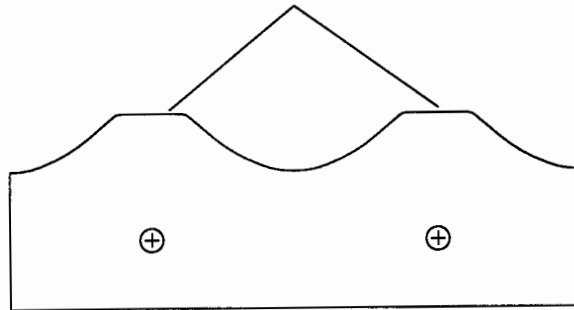
FIGURE 4-9  
S-18 STINGER II



MD3607

FIGURE 4-10  
S-18 STINGER II

NEED TO BE FLUSH  
WITH END OF TUBE



"FISH MOUTH TEMPLATE"

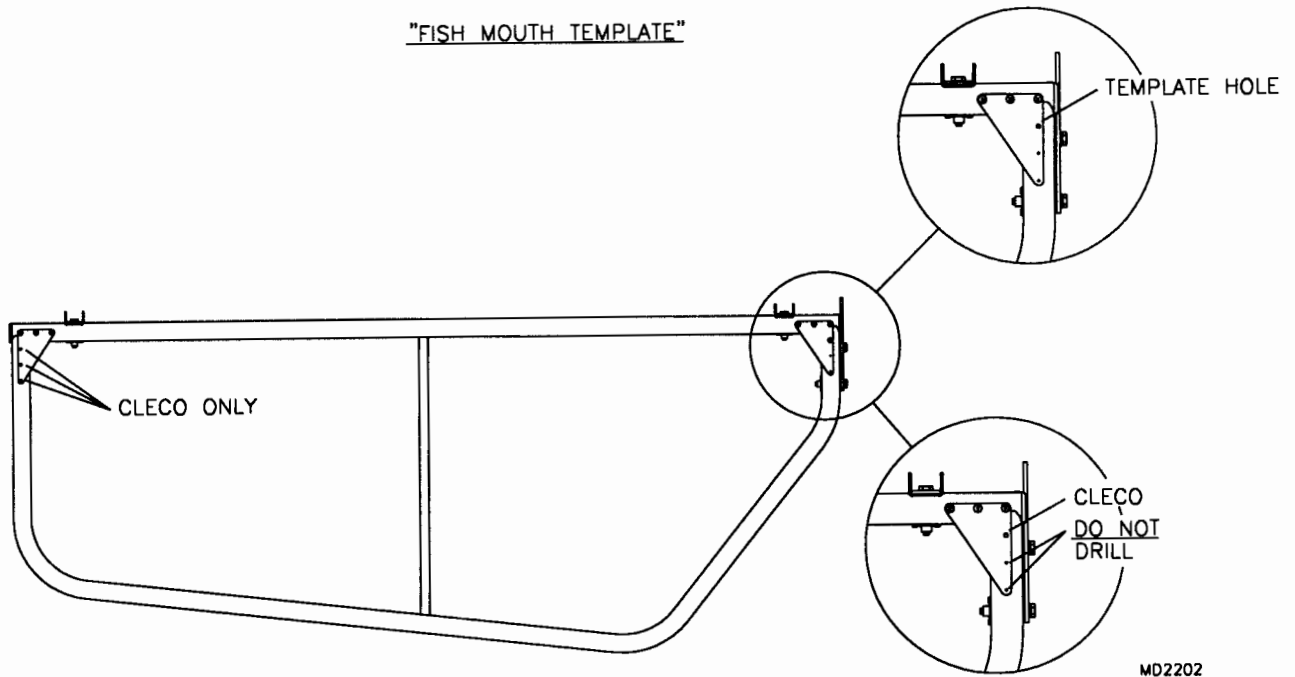
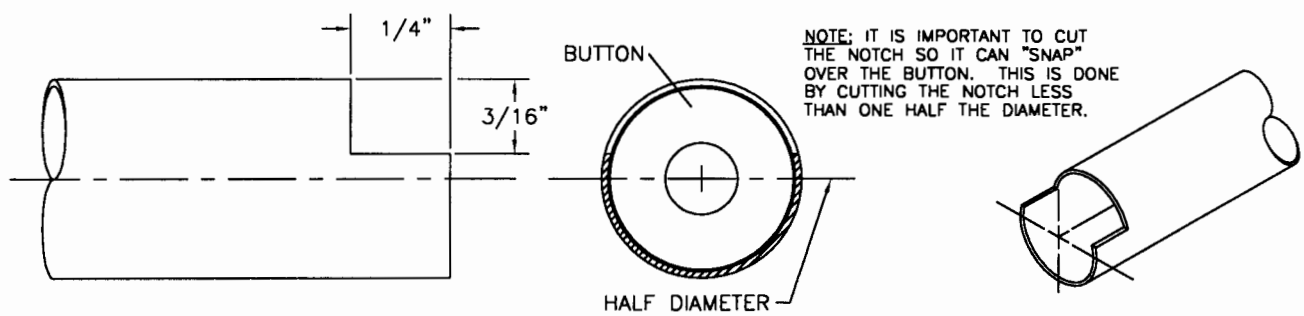
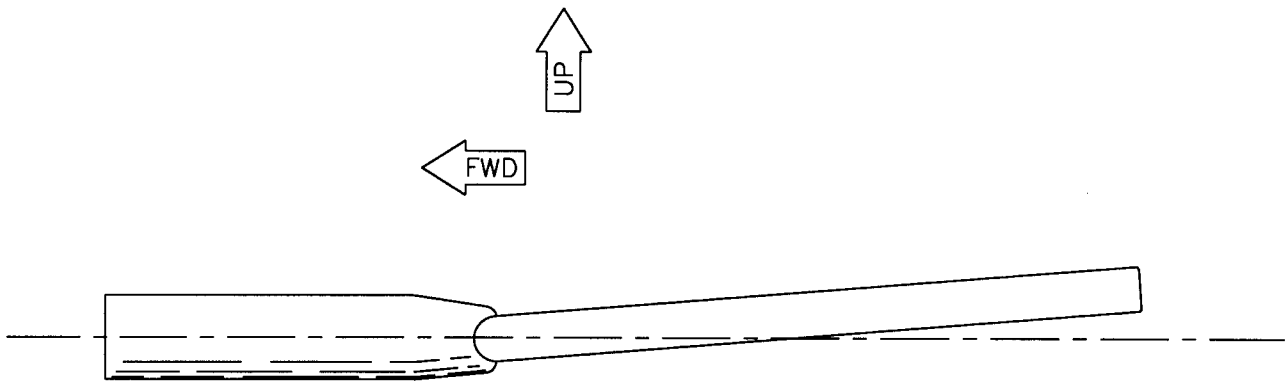


FIGURE 4-11  
S-18 STINGER II



MD2243

FIGURE 4-12  
S-18 STINGER II



MD2239

FIGURE 4-13  
S-18 STINGER II

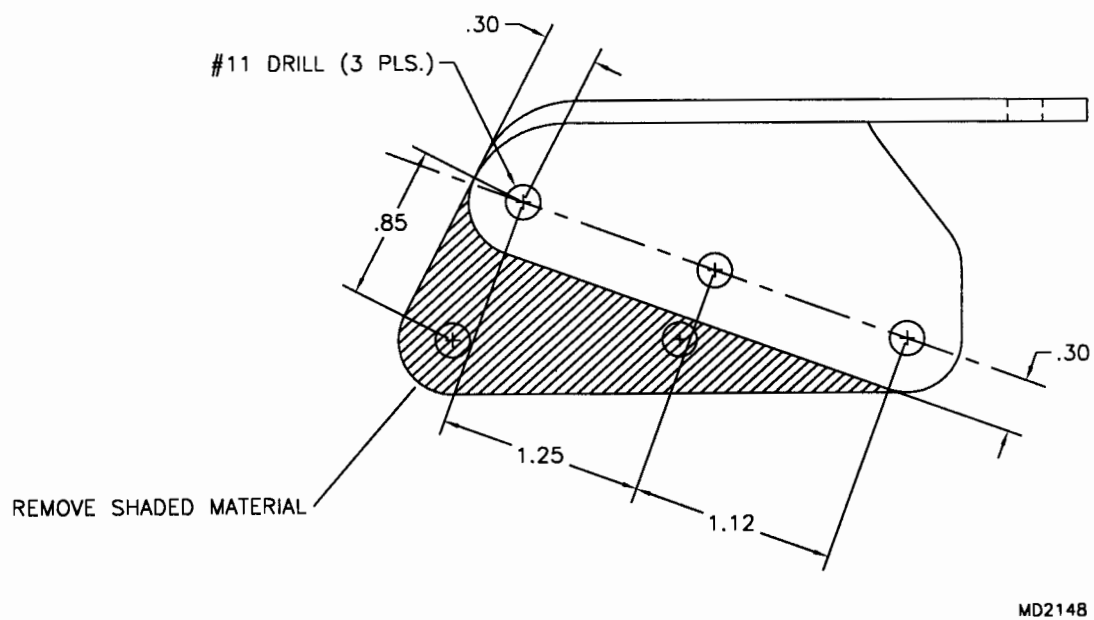


FIGURE 4-14  
S-18 STINGER II

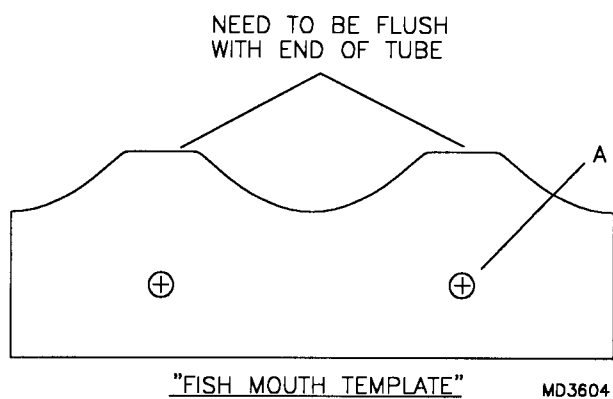
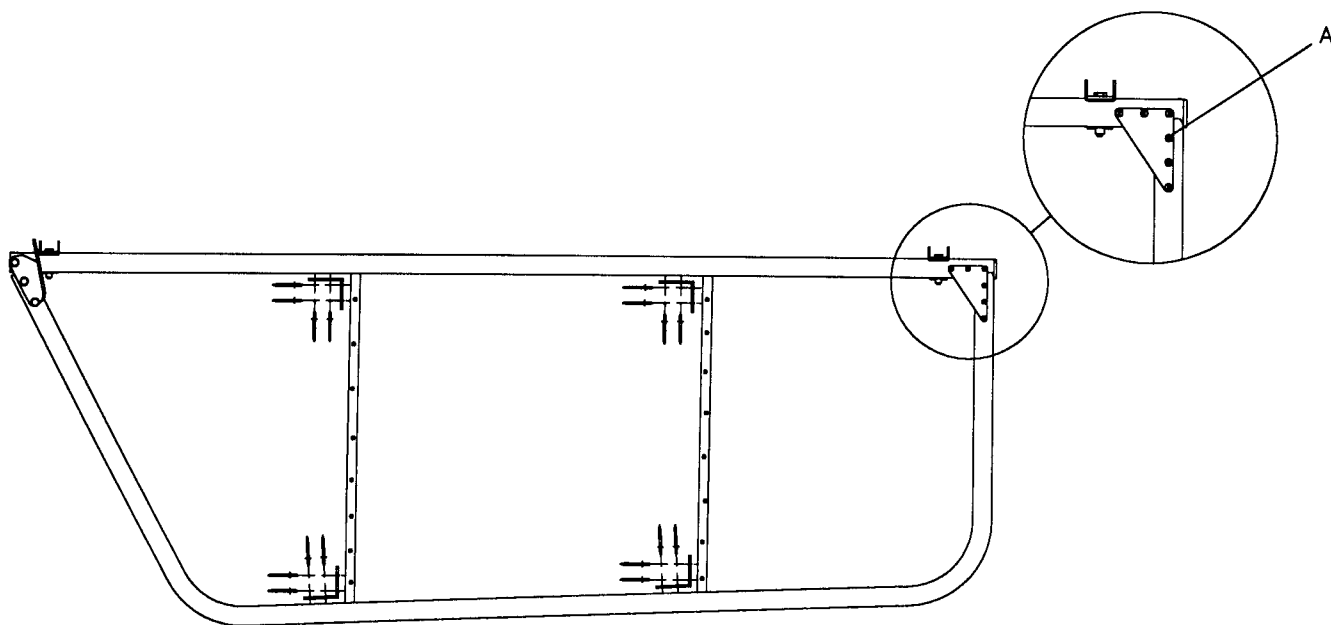
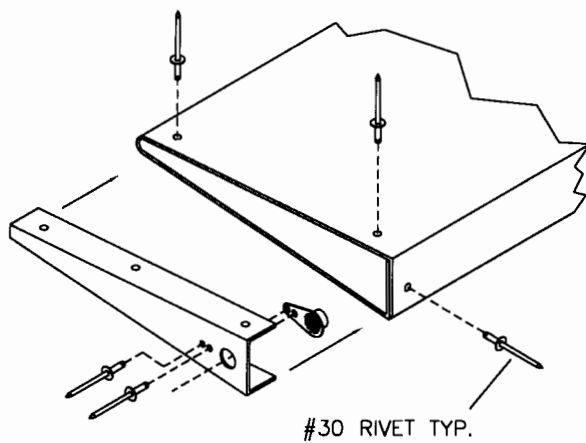


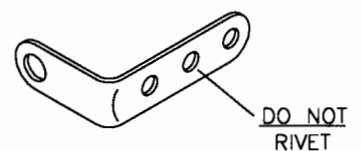
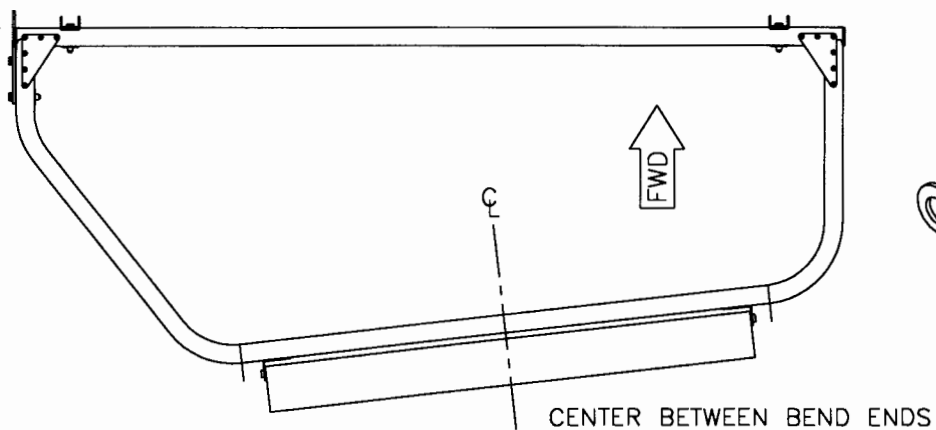
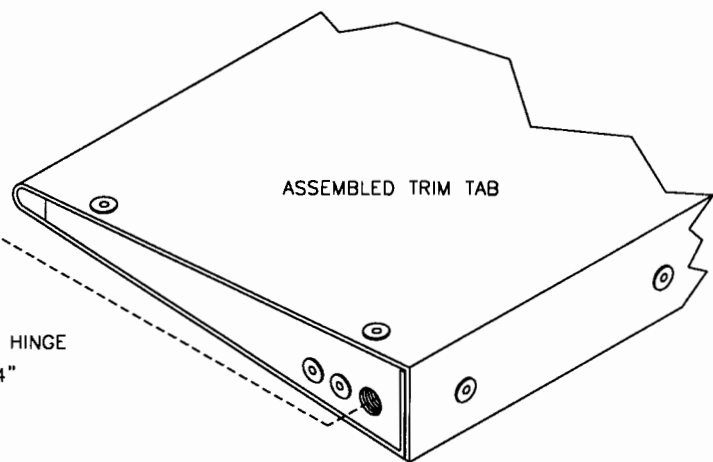
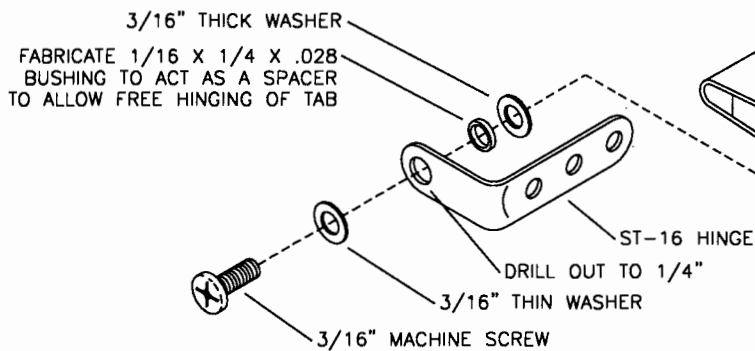
FIGURE 4-15  
S-18 STINGER II



STEP 1: CLECO LEADING EDGE OF TAB WITH #40 CLECOS. PLACE ON FLAT SURFACE AND CHECK FOR STRAIGHTNESS, DRILL TO #30 (LEADING EDGE ONLY). RIVET WITH AAPQ-41 RIVETS. (BE SURE BOTH LAYERS OF METAL ARE DRAWN TOGETHER PRIOR TO RIVETING).

STEP 2: DRILL AND RIVET NUT PLATE TO EACH END RIB.

STEP 3: INSERT NUT PLATED END INTO TAB AND RIVET.



MD2203

FIGURE 4-16  
S-18 STINGER II

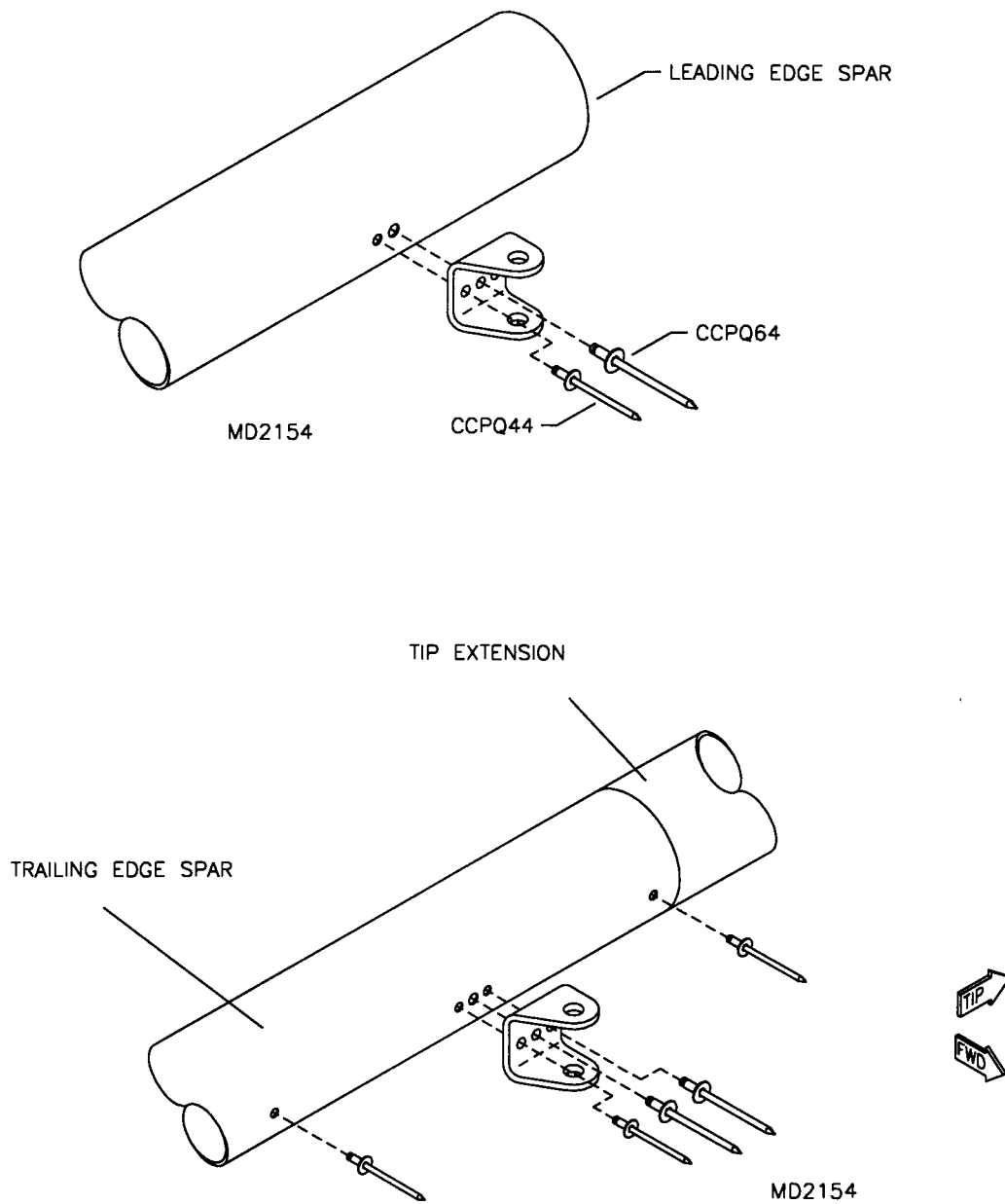
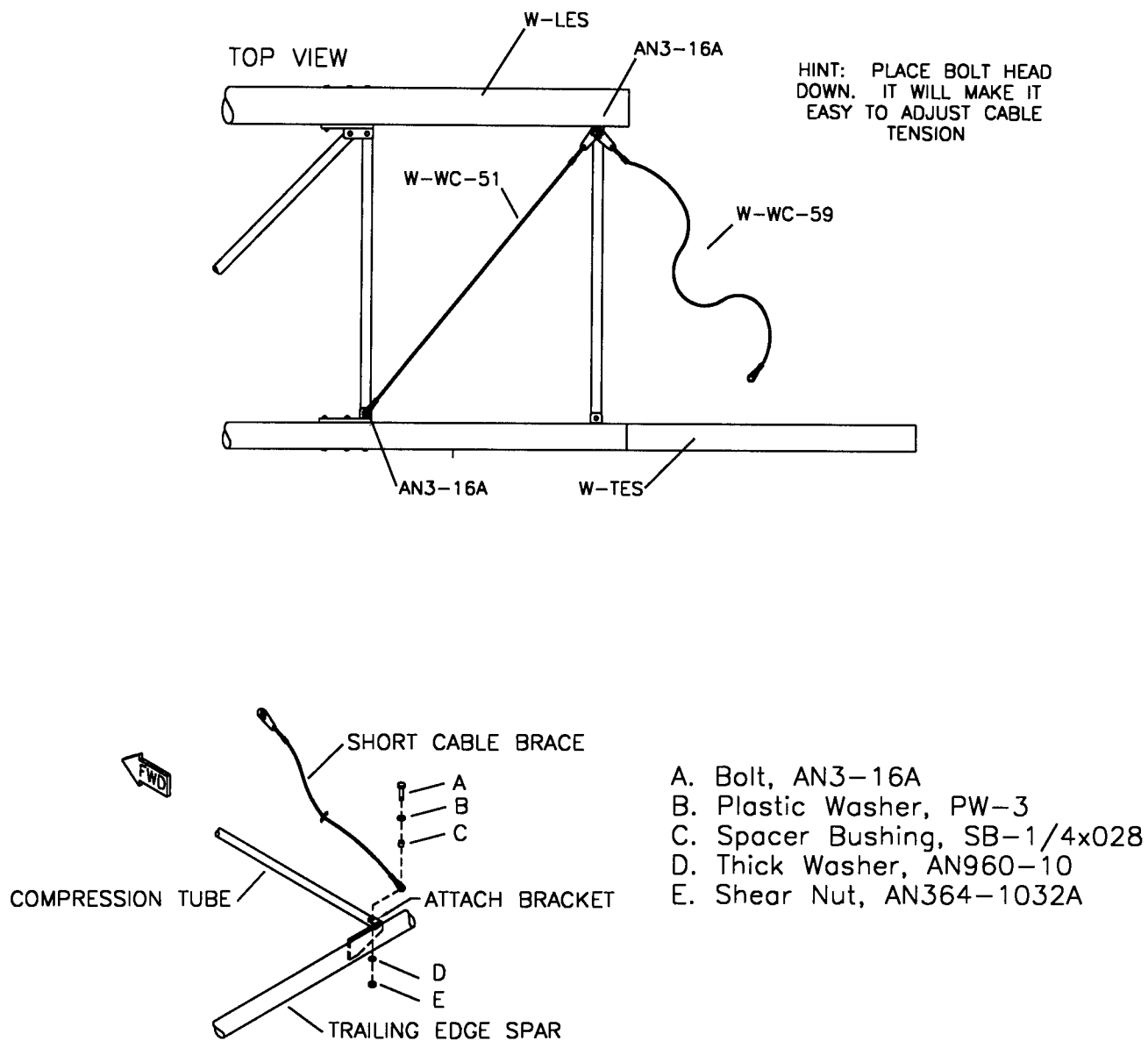
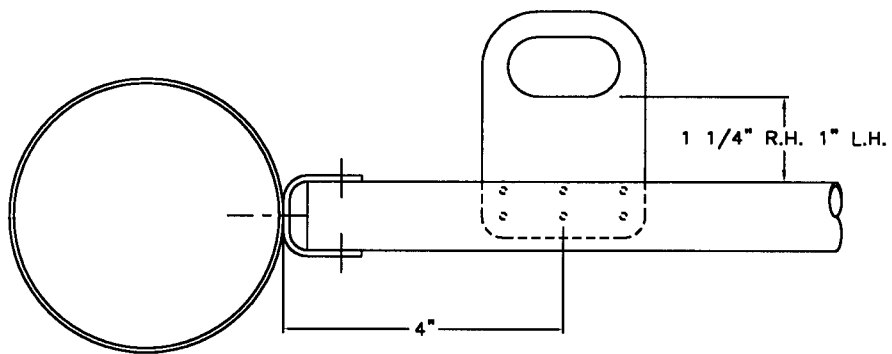
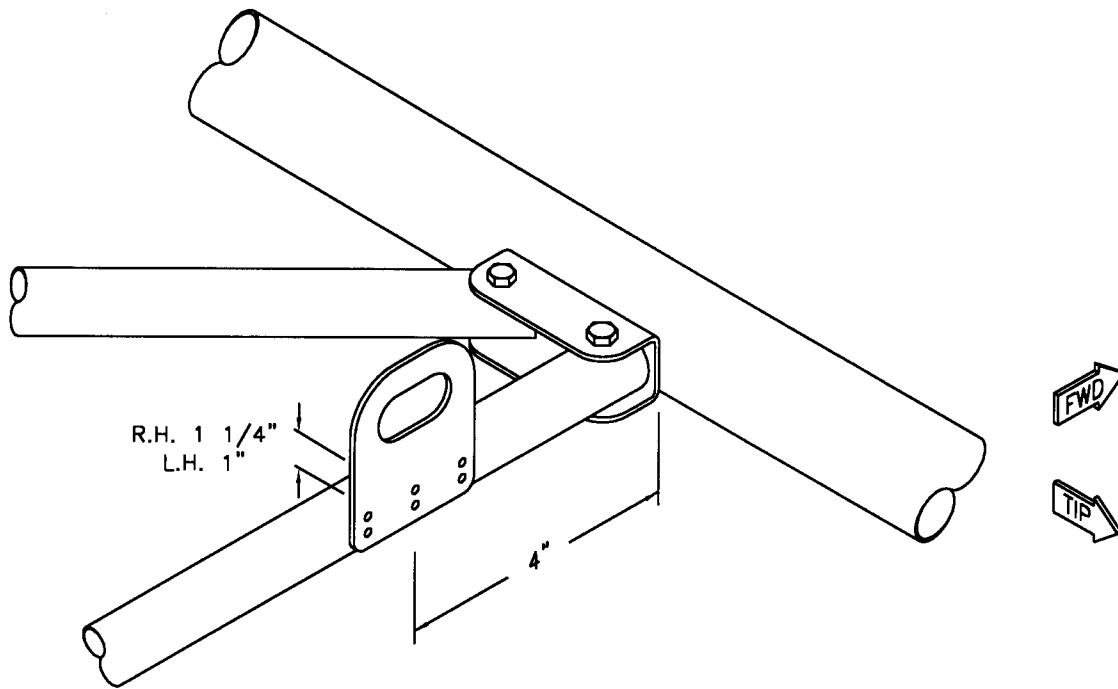


FIGURE 5-1  
S-18 STINGER II



MD2156

FIGURE 5-2  
S-18 STINGER II



W03930

FIGURE 5-3  
S-18 STINGER II

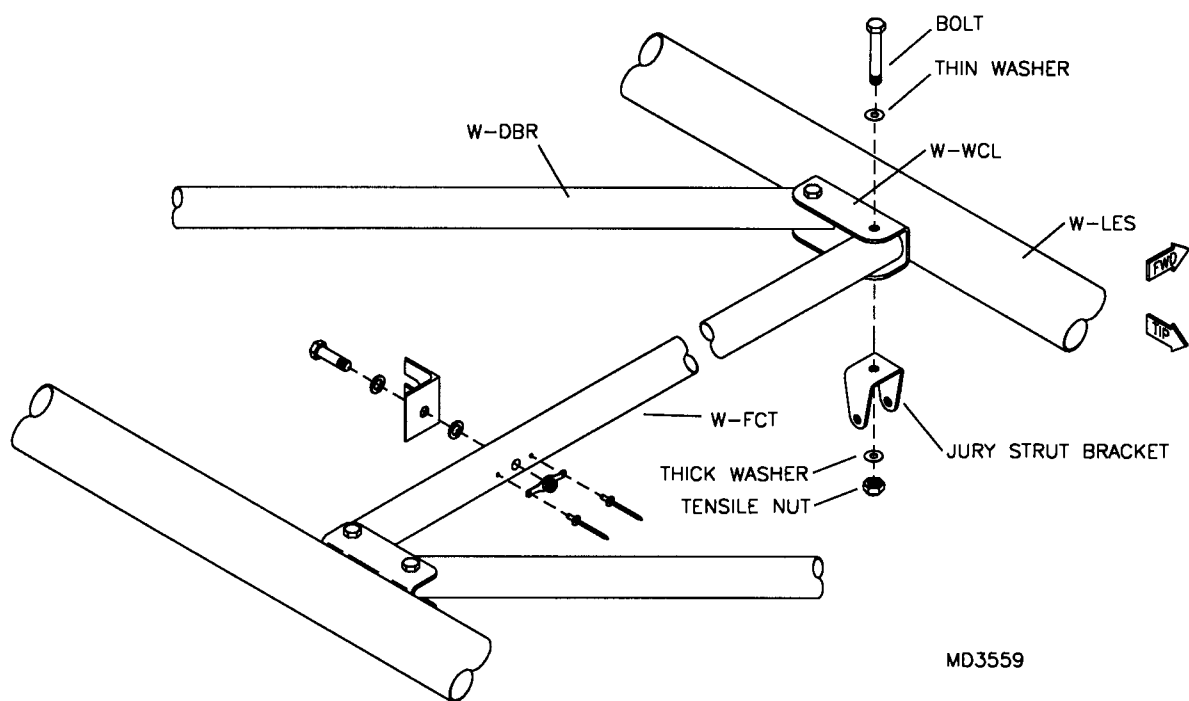
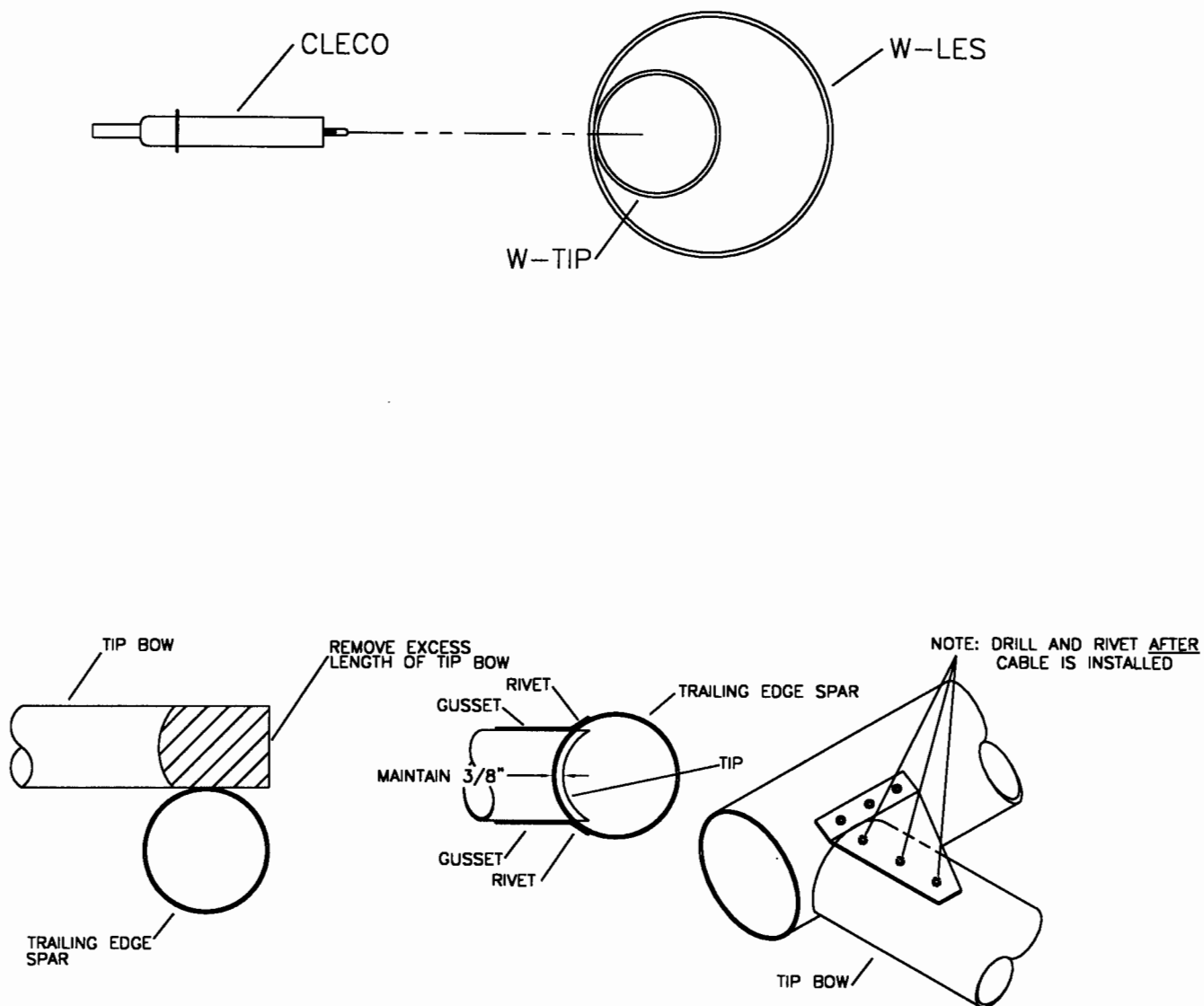
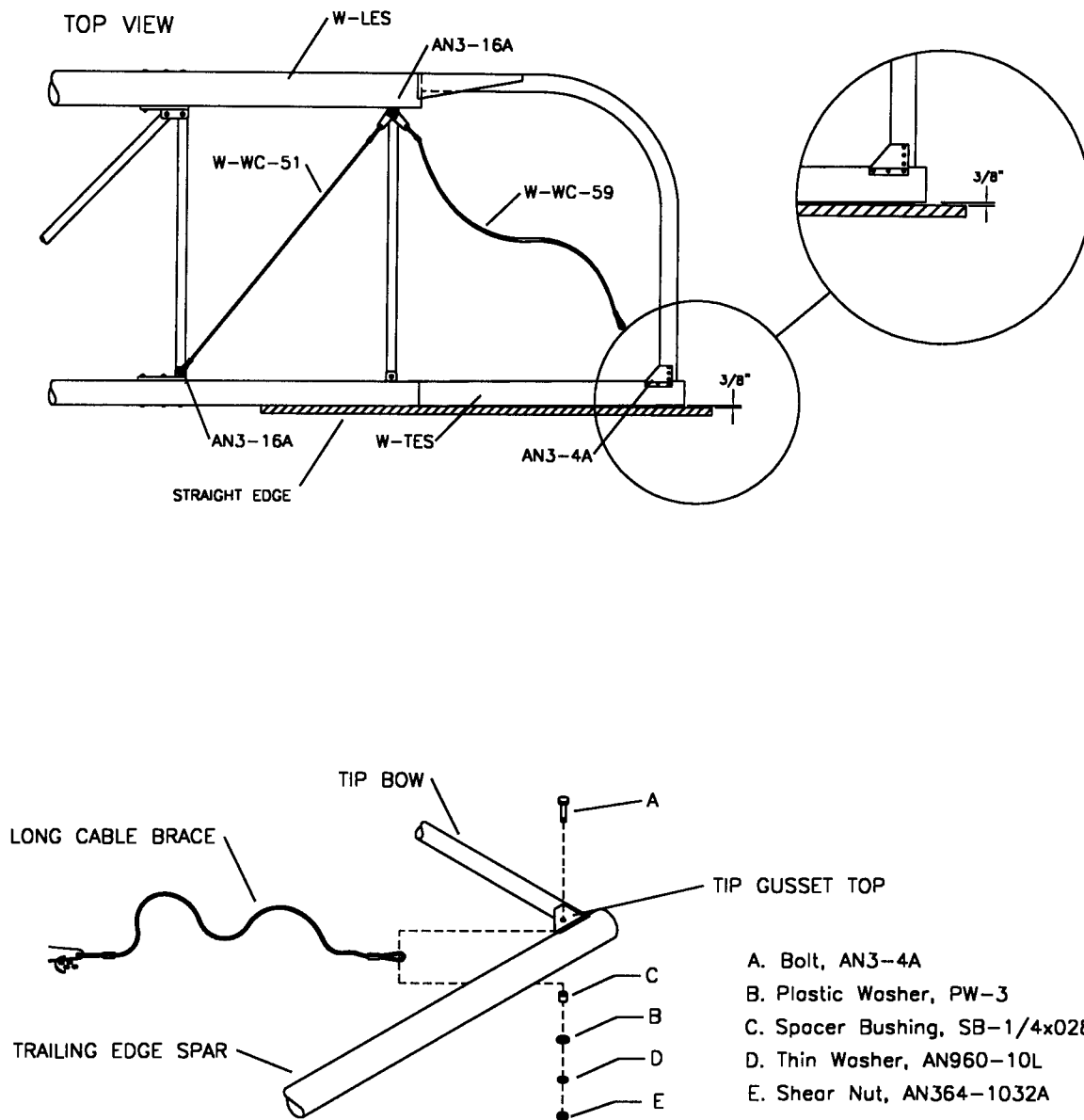


FIGURE 5-4  
S-18 STINGER II



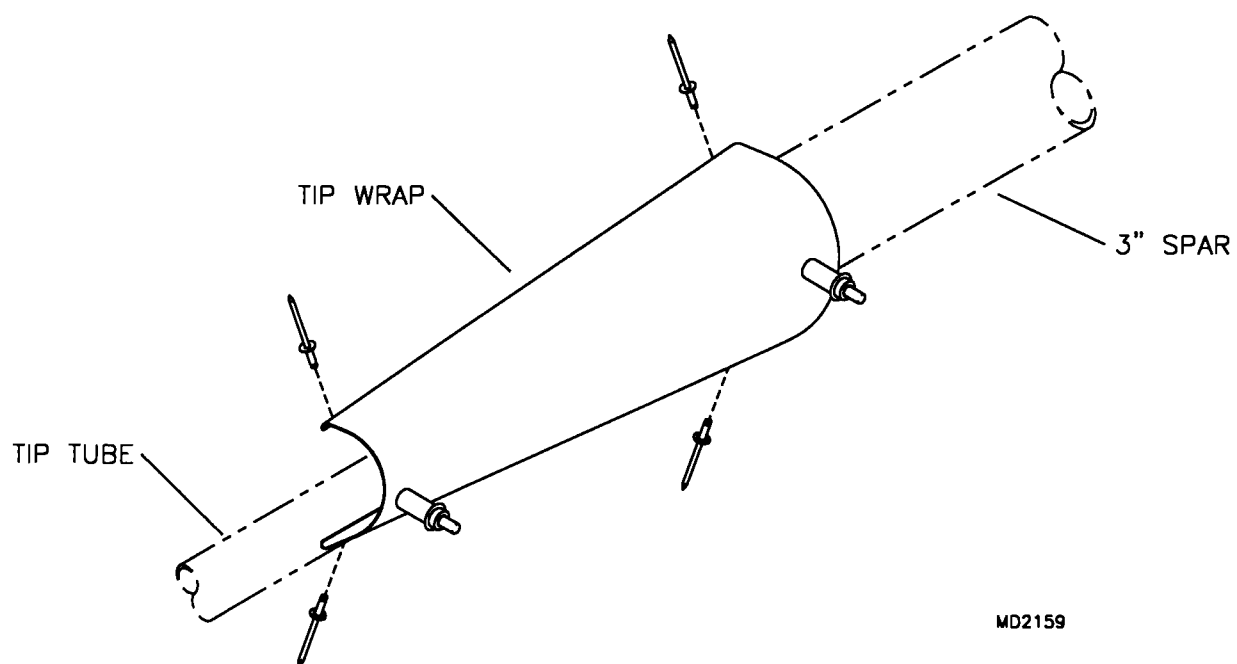
MD2157

FIGURE 5-5  
S-18 STINGER II



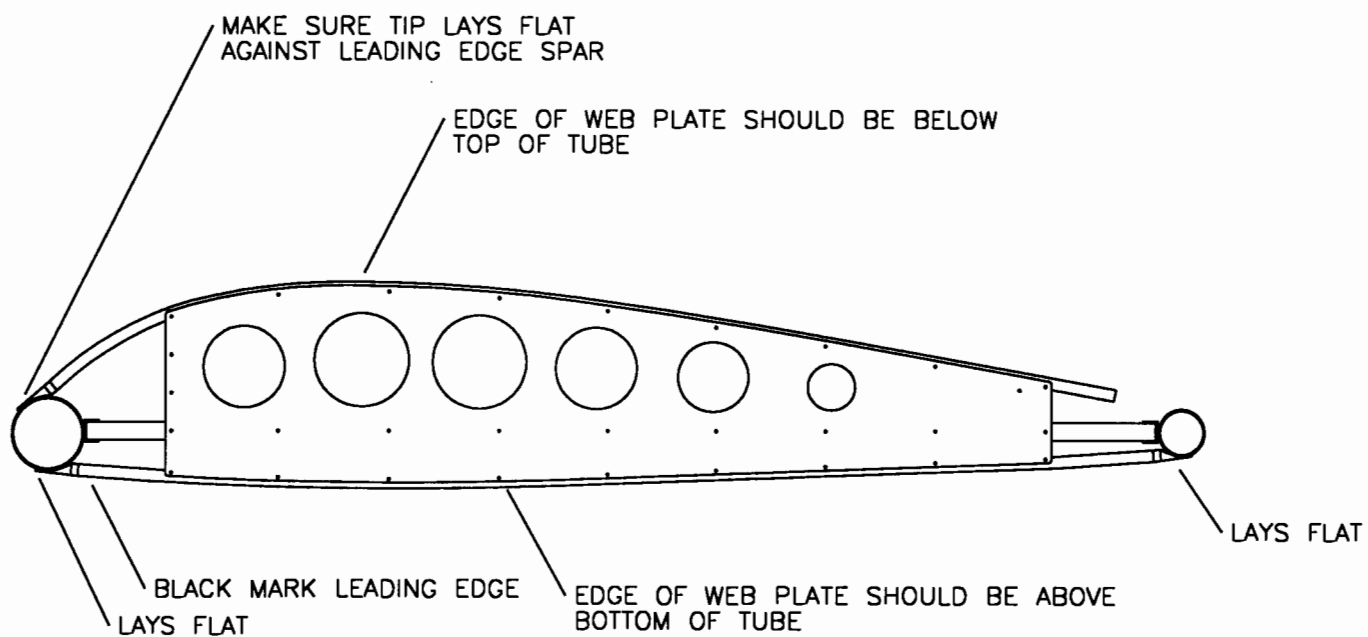
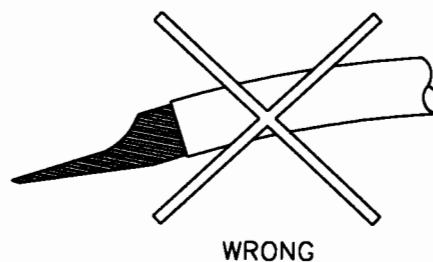
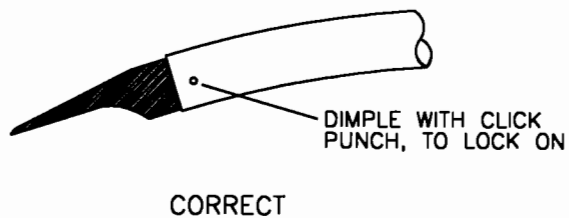
MD2158

FIGURE 5-6  
S-18 STINGER II



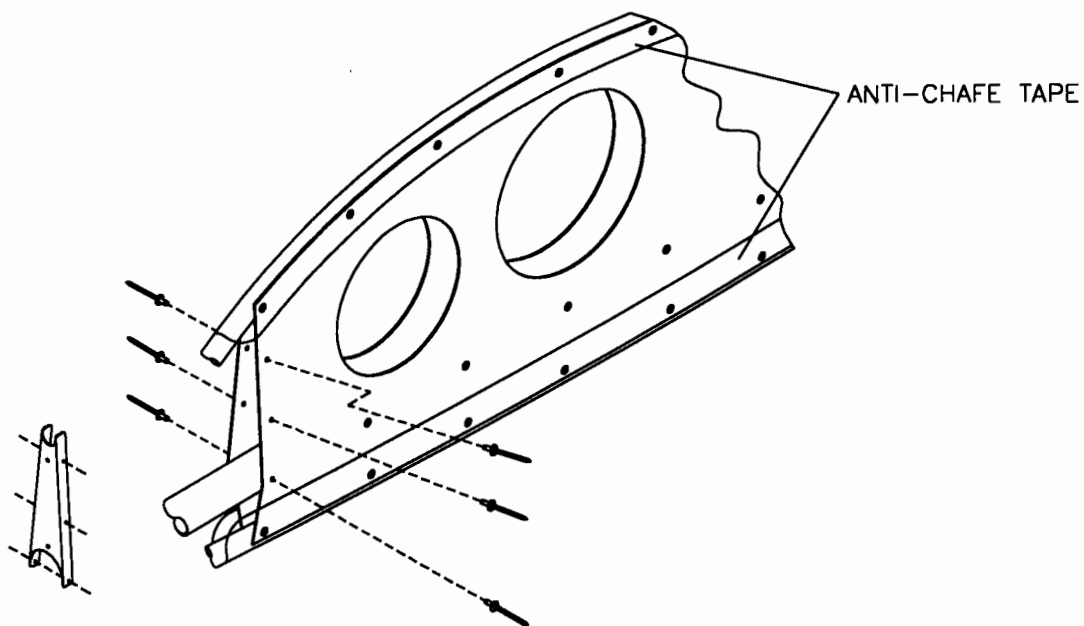
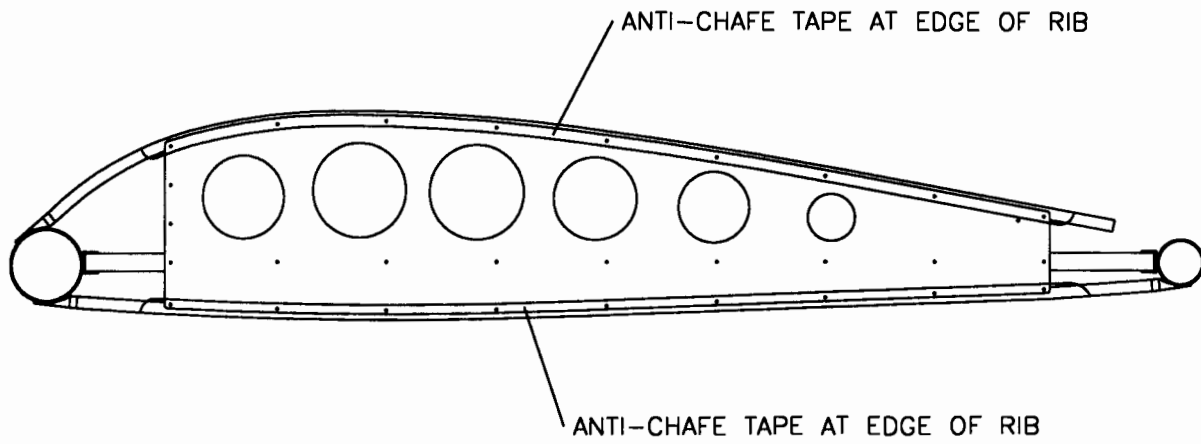
MD2159

FIGURE 5-7  
S-18 STINGER II



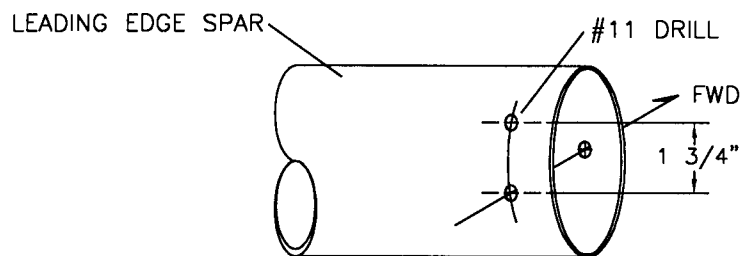
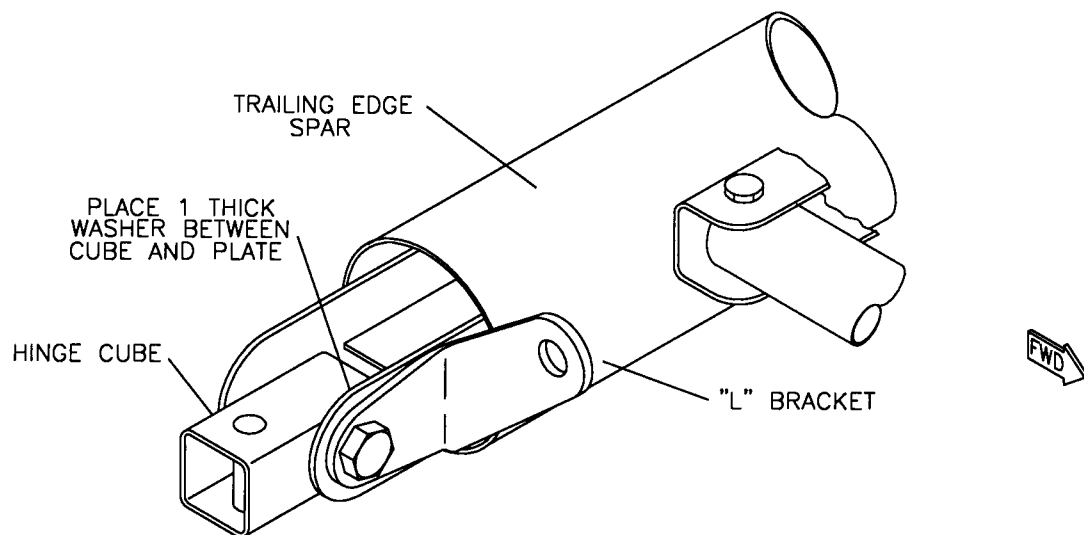
MD2160

FIGURE 5-8  
S-18 STINGER II



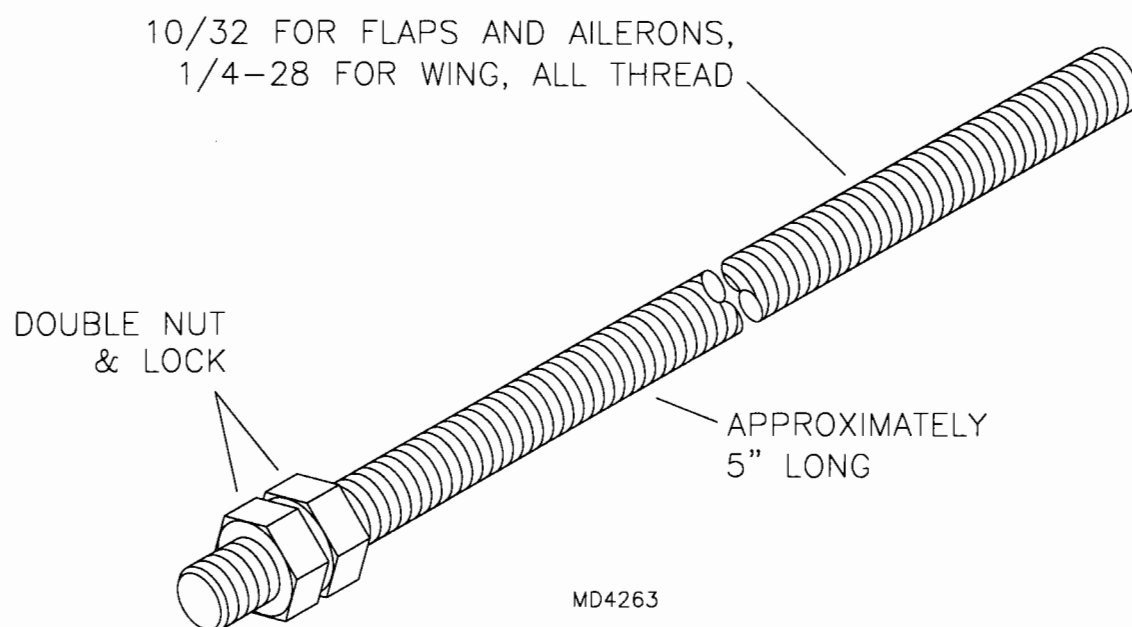
MD2189

FIGURE 5-9  
S-18 STINGER II

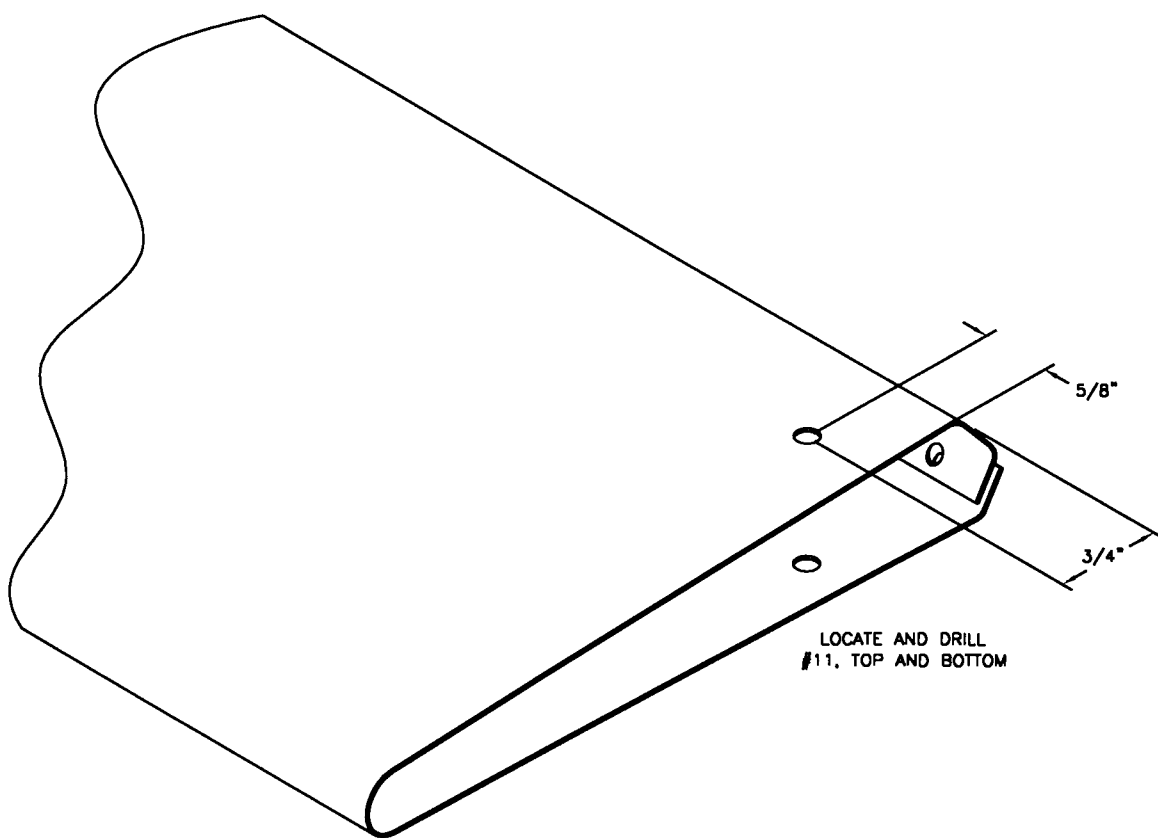


MD2568

FIGURE 5-10  
S-18 STINGER II

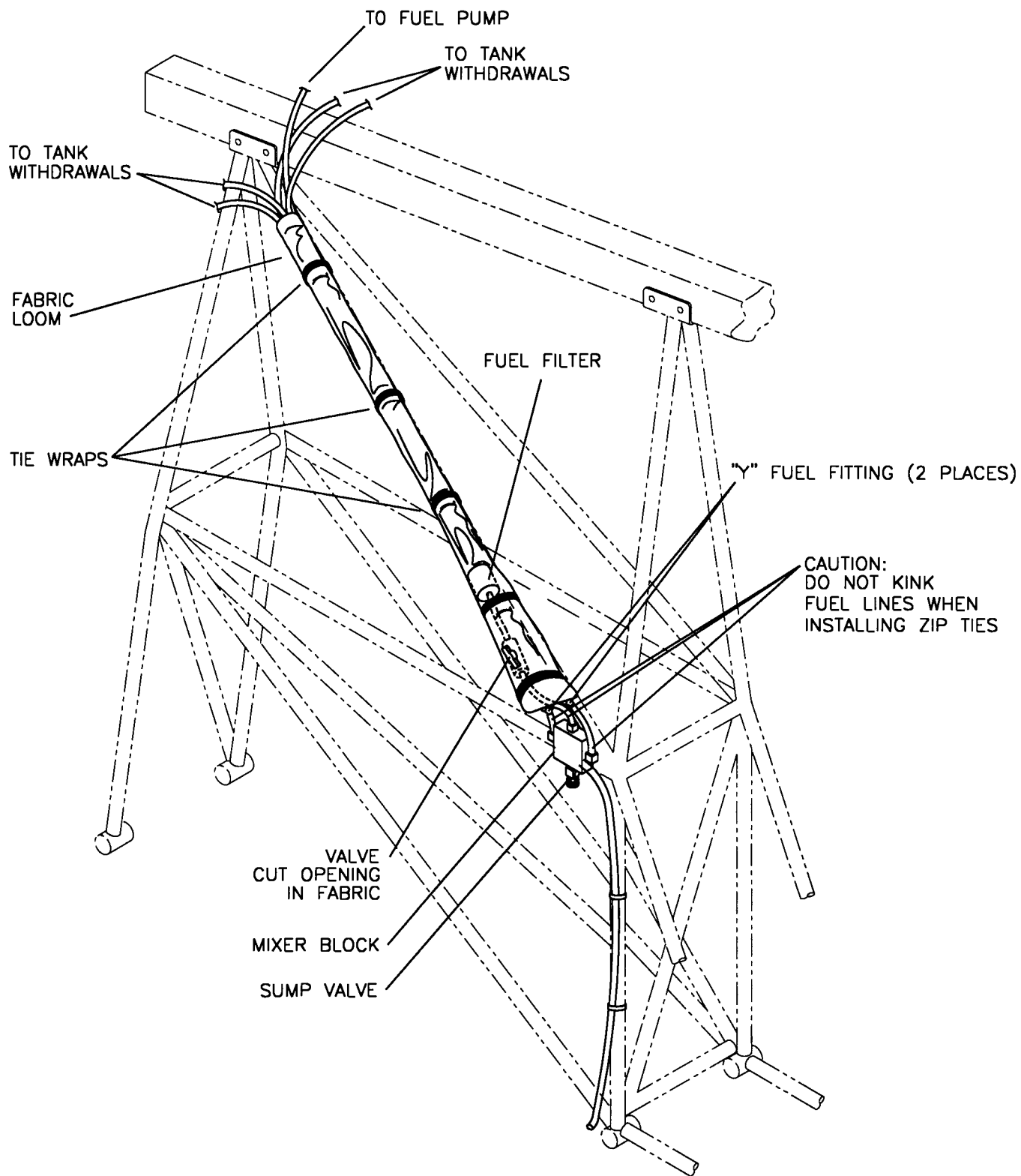


**FIGURE 5-10A**  
**S-18 STINGER II**



MD4067

FIGURE 5-11  
S-18 STINGER II



MD3972

FIGURE 6-1  
S-18 STINGER II

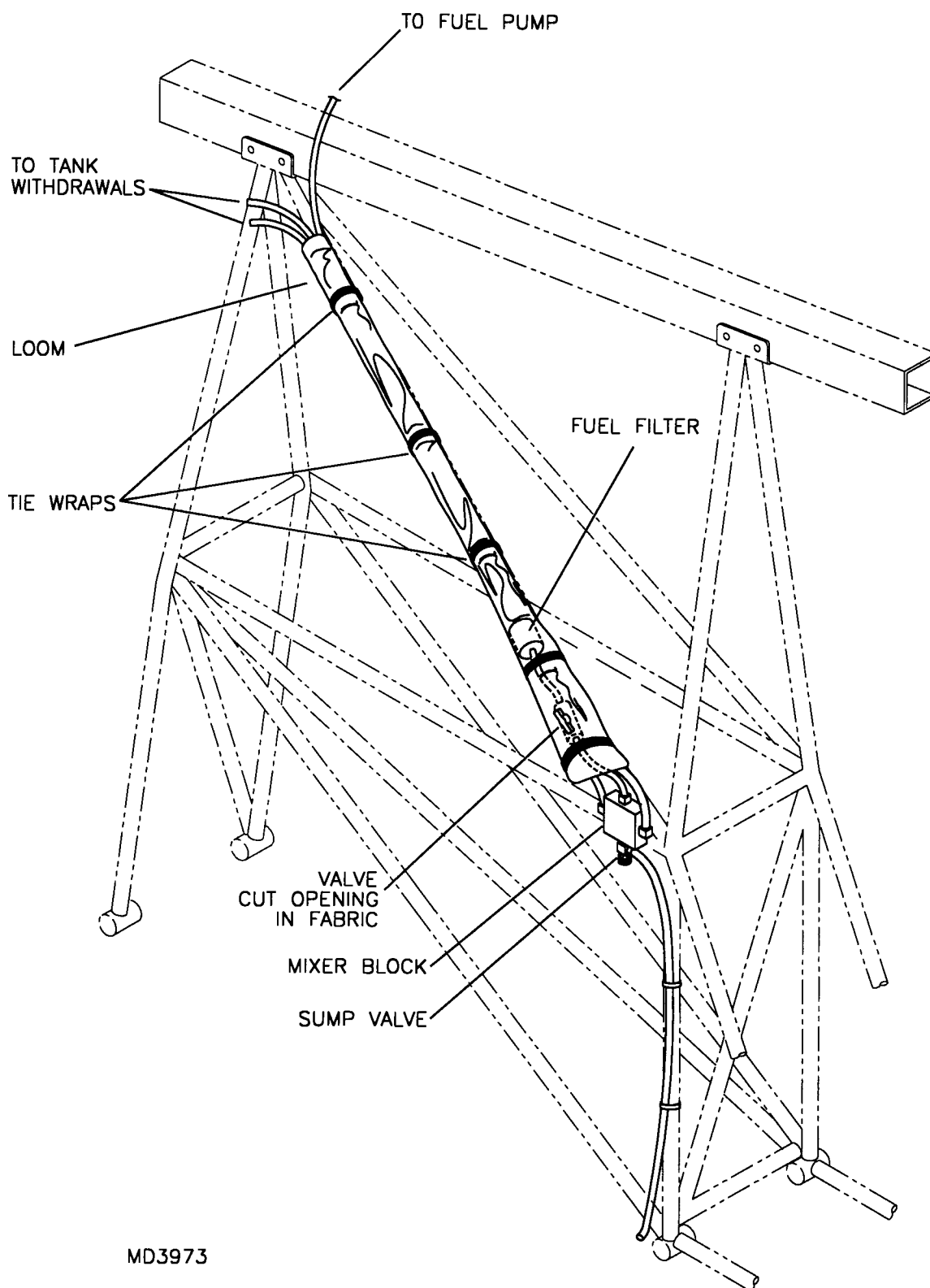
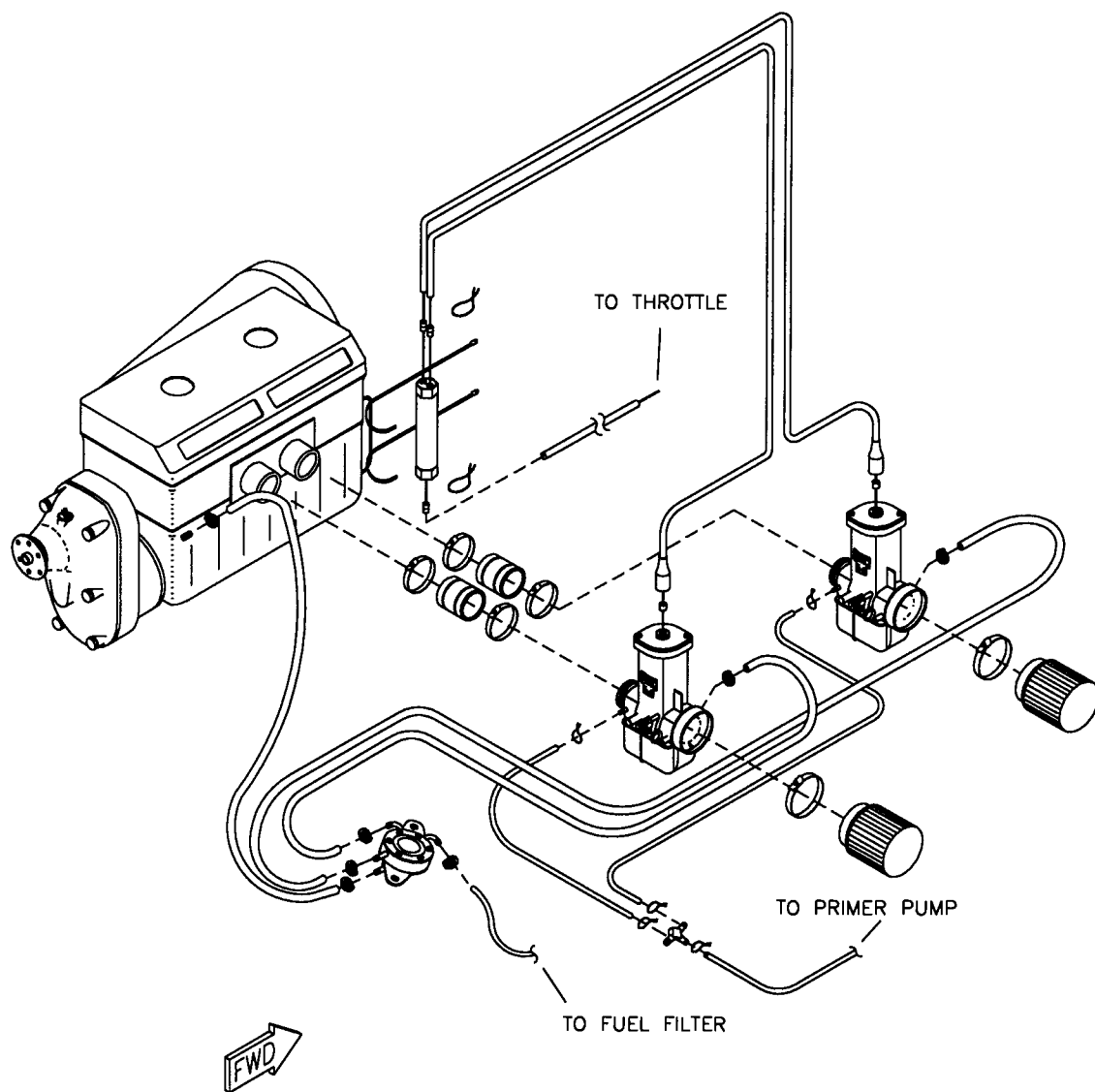


FIGURE 6-2  
S-18 STINGER II

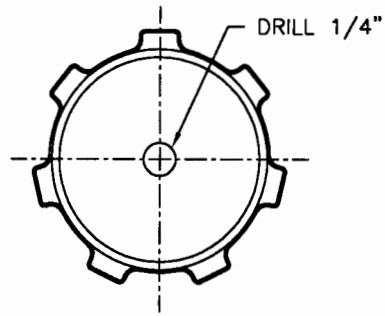
3/01/01



MD3974

FIGURE 6-3  
S-18 STINGER II

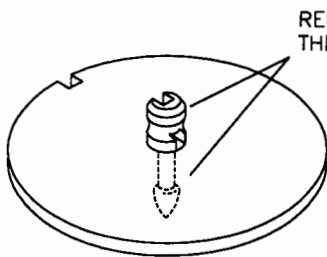
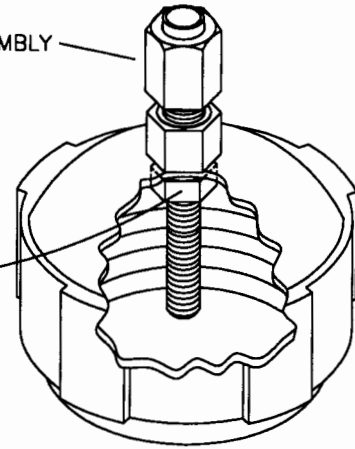




DRILL FUEL CAP AS SHOWN

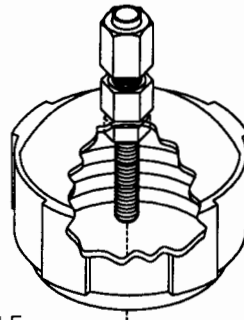
CONDUIT ADJUSTER ASSEMBLY

TIGHTEN NUT UP TO  
INSIDE TOP OF FUEL CAP.



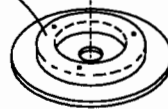
PLASTIC BAFFLE

REMOVE, THEN DRILL 1/4"  
THRU CENTER OF BAFFLE.



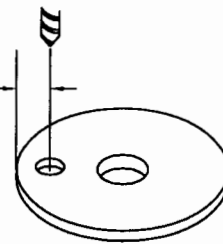
DRILLED PLASTIC BAFFLE

RAISED INNER RING  
OF RUBBER GASKET  
POINTS UP.



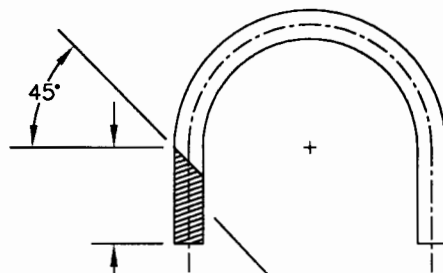
DRILL #30

5/32"



LARGE WASHER

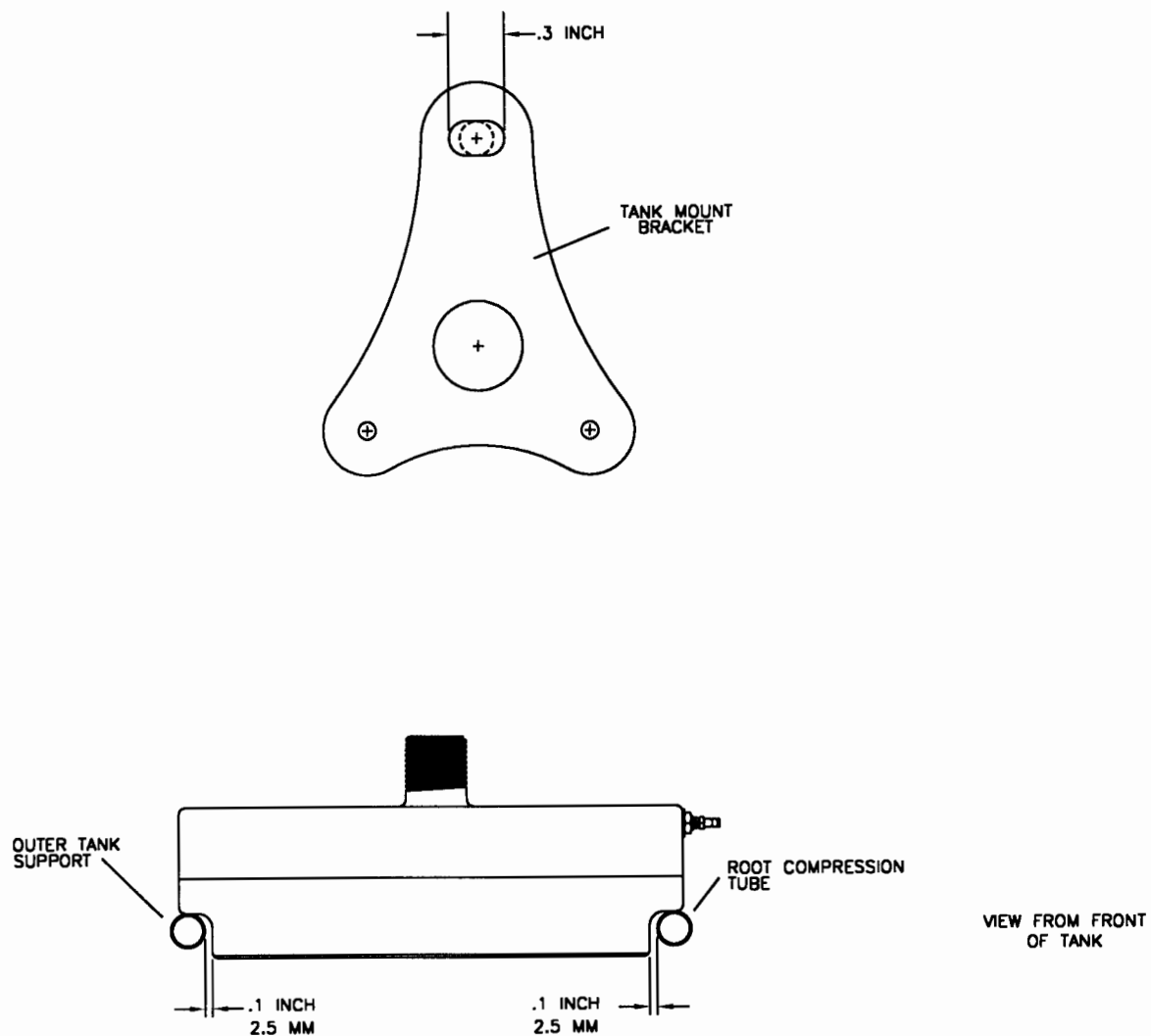
MODIFY VENT TUBE



REMOVE SHADED AREA

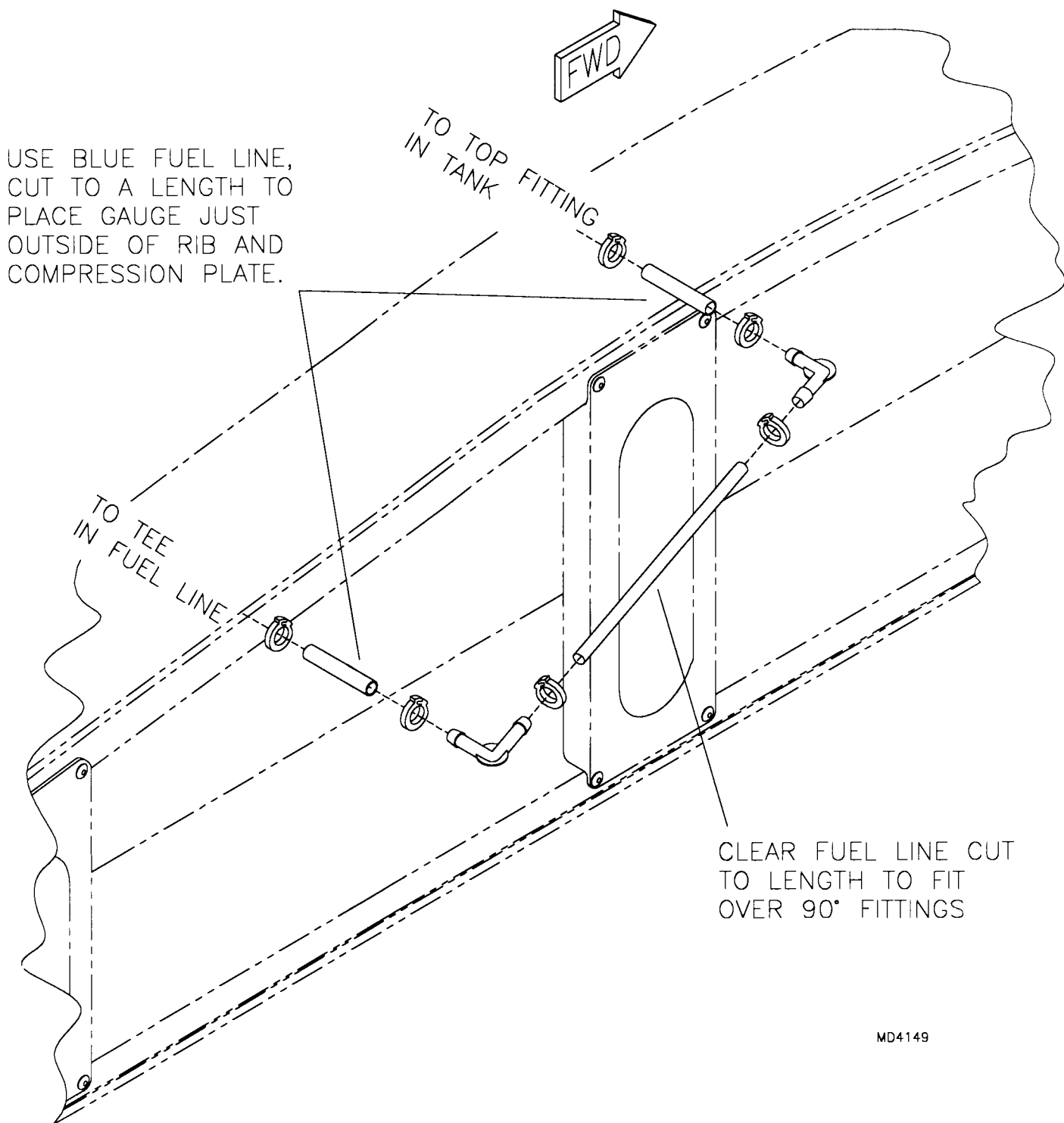
MD3976

FIGURE 6-5  
S-18 STINGER II



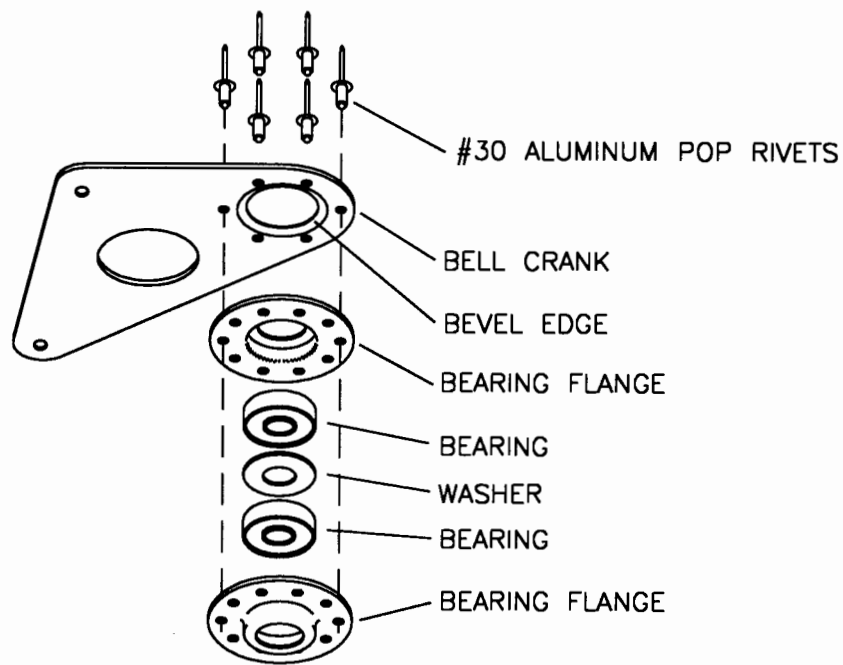
MD3978

FIGURE 6-6  
S-18 STINGER II



MD4149

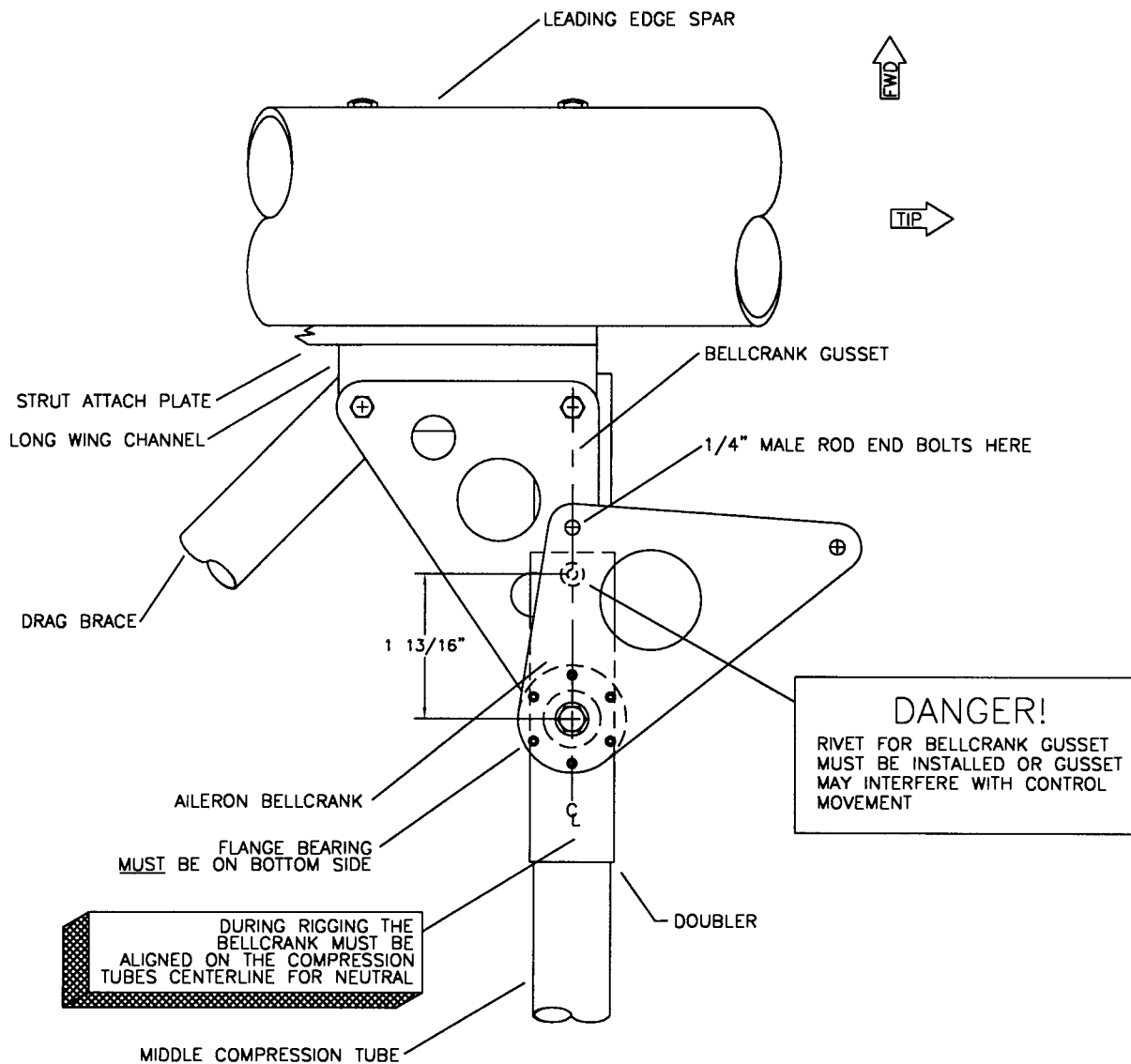
FIGURE 6-7  
S-18 STINGER II



ATTACH FLANGE BEARING WITH  
(6) #30 ALUMINUM POP RIVETS.  
MAKE A LEFT AND RIGHT BELLCRANK.

MD2163

FIGURE 7-1  
S-18 STINGER II

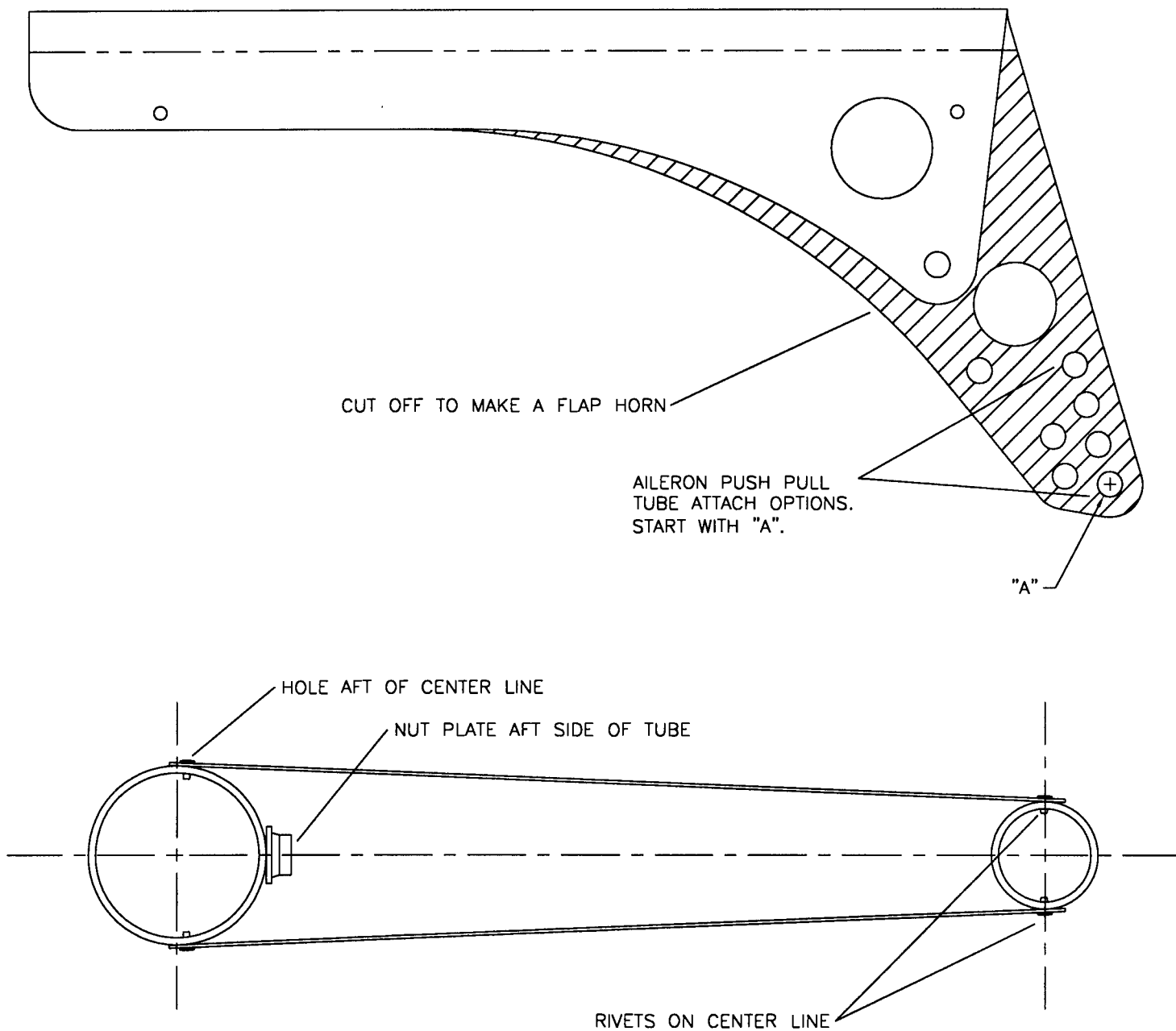


**IMPORTANT:** SMALL FLANGE ON GUSSET  
MUST POINT DOWN

**NOTE:** DO NOT STOP NUT. THE  
ROD END IS LEFT ATTACHED  
TO THE BELLCRANK AFTER  
COVERING THE WING THE  
AILERON PUSH PULL TUBE  
IS INSERTED THROUGH  
THE EXIT HOLE IN THE  
WING AND SCREWED INTO  
THE ROD END.

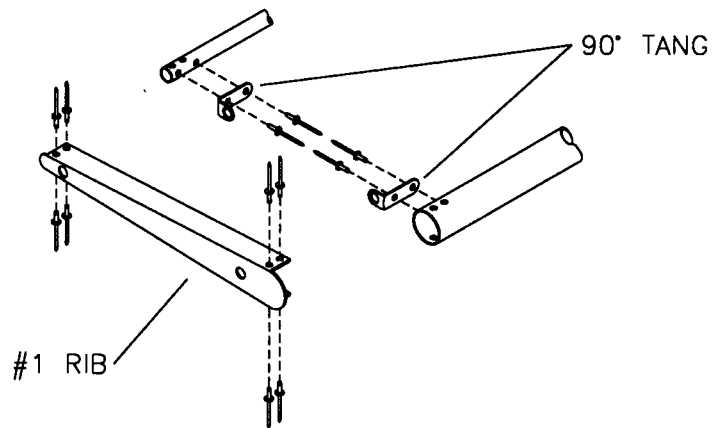
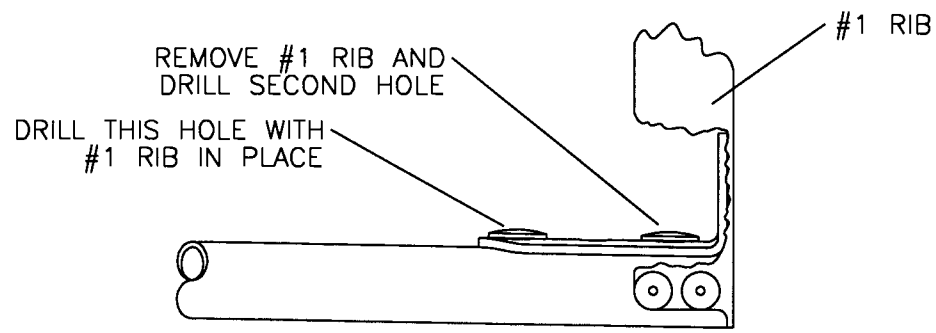
MD2184

**FIGURE 7-2**  
**S-18 STINGER II**



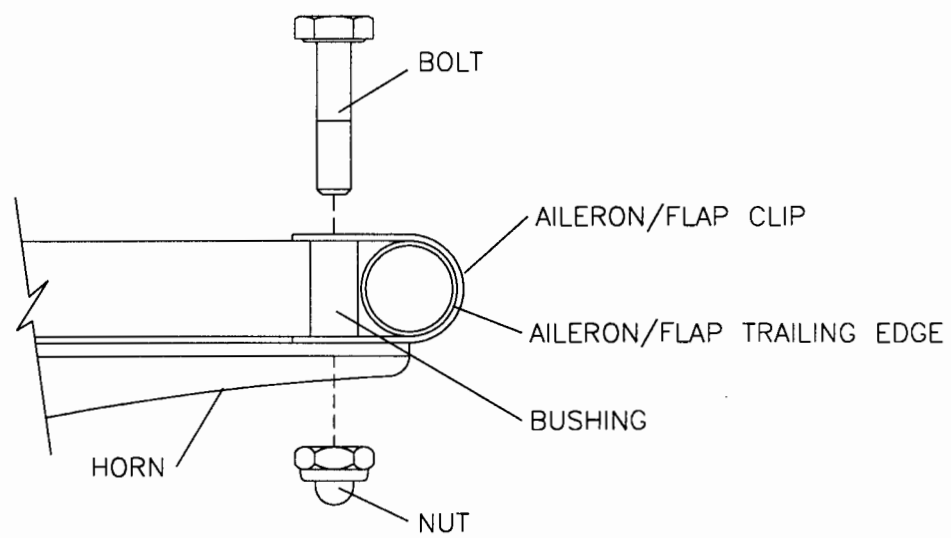
MD2165

FIGURE 7-3  
S-18 STINGER II



MD2191

FIGURE 7-4  
S-18 STINGER II



MD4052

**FIGURE 7-5**  
**S-18 STINGER II**

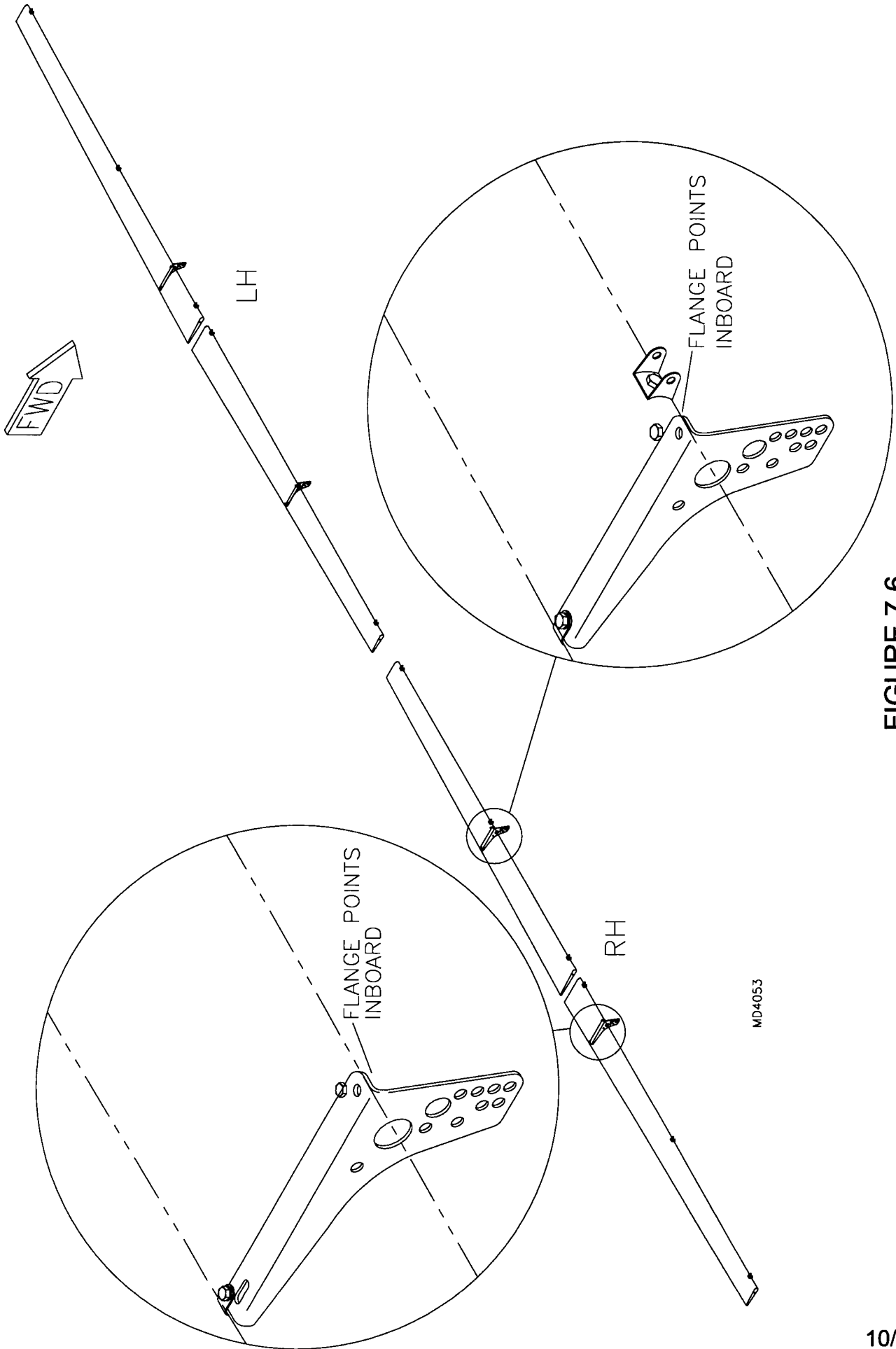
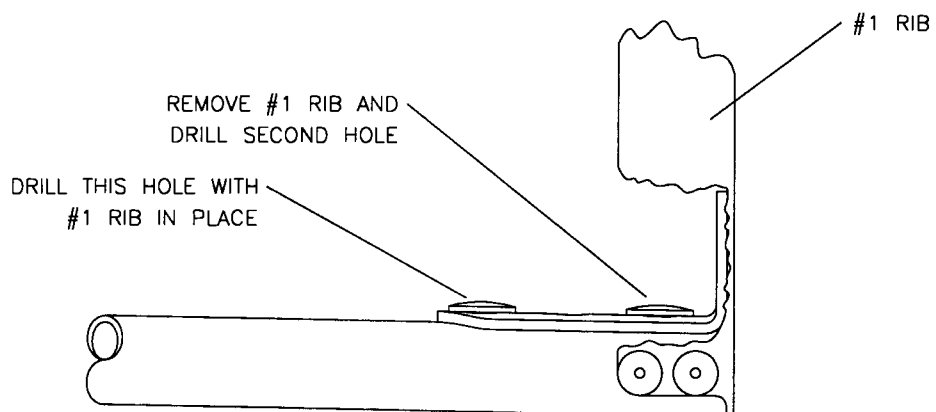
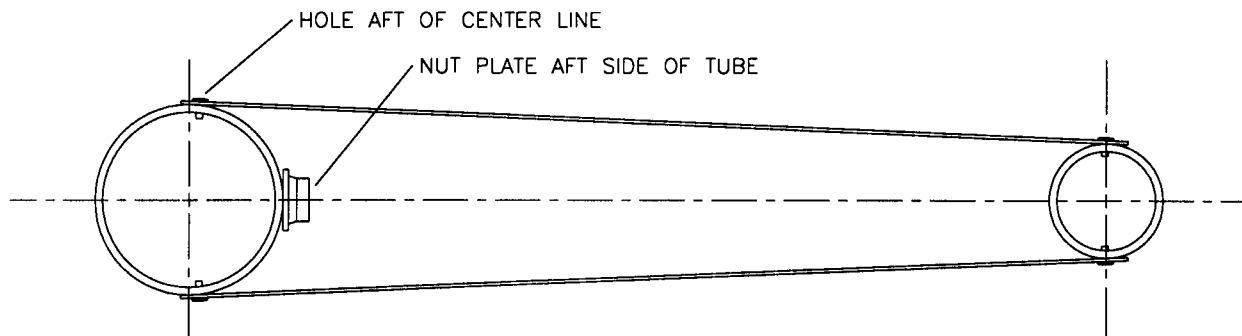


FIGURE 7-6  
S-18 STINGER II



MD2166

**FIGURE 7-7**  
**S-18 STINGER II**

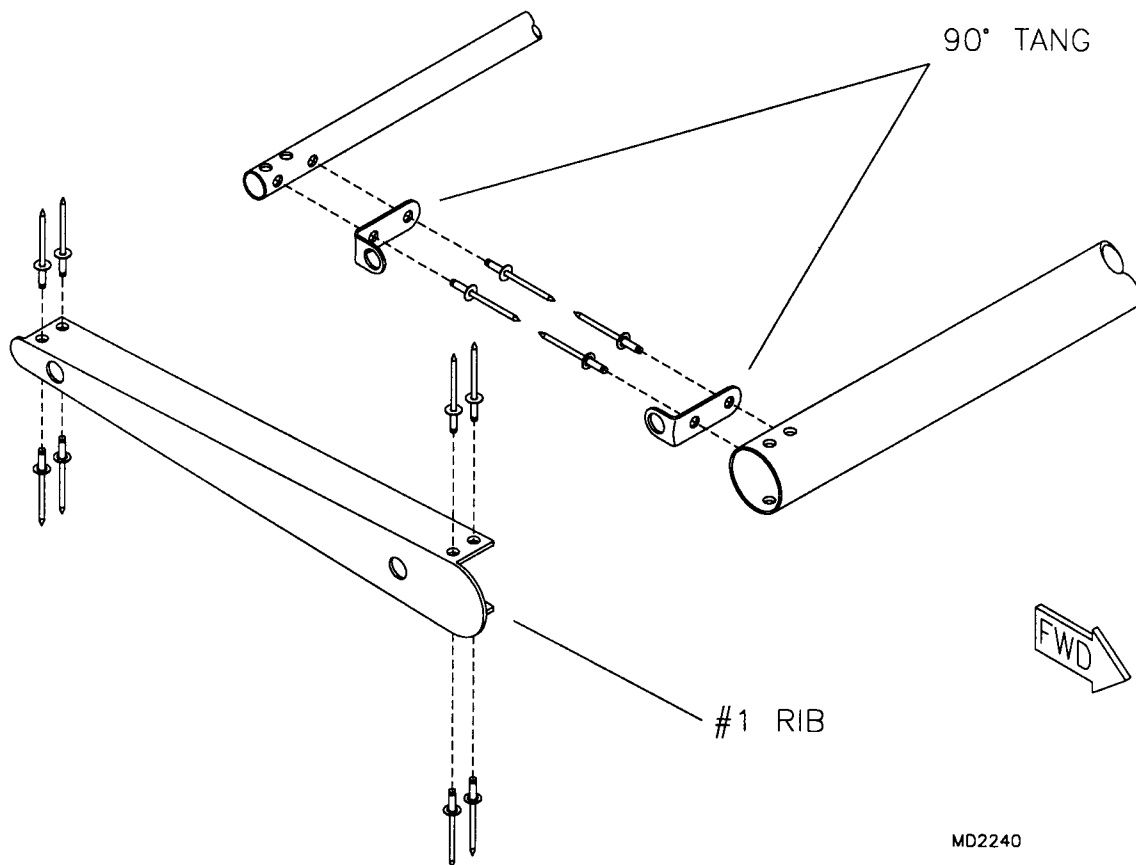
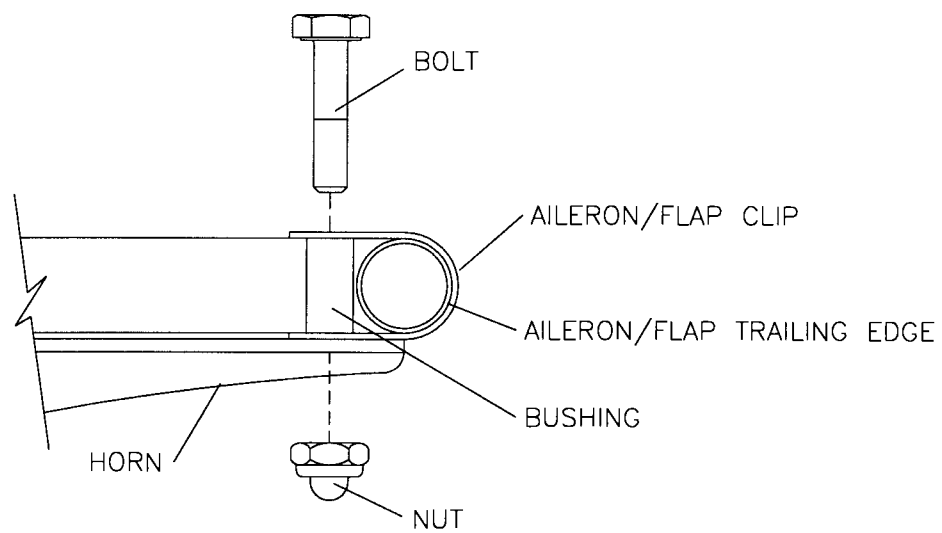
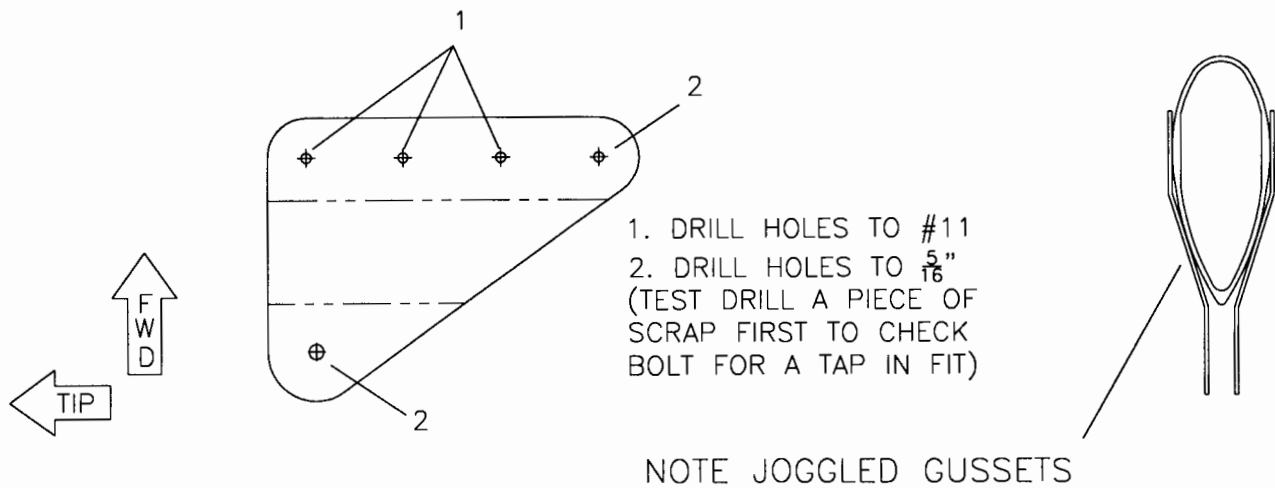


FIGURE 7-8  
S-18 STINGER II

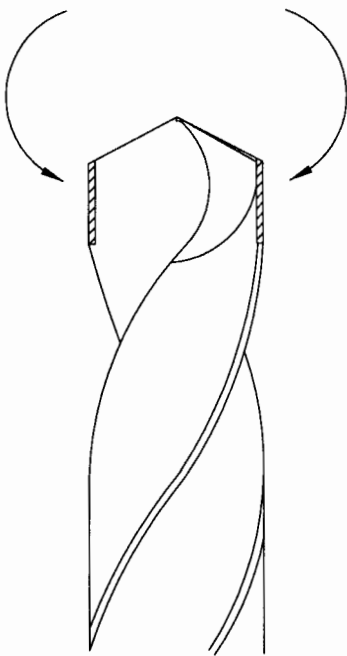


MD4052

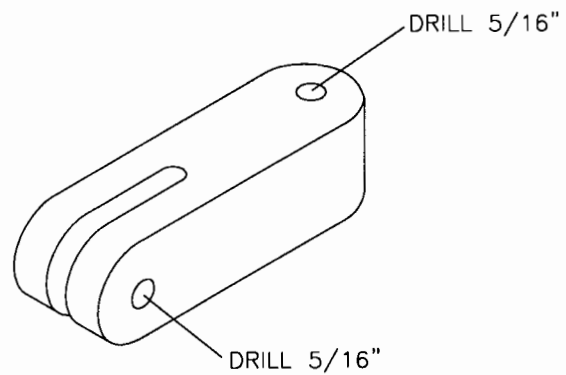
**FIGURE 7-9**  
**S-18 STINGER II**



REMOVE UNTIL DESIRED  
 HOLE IS ACHIEVED

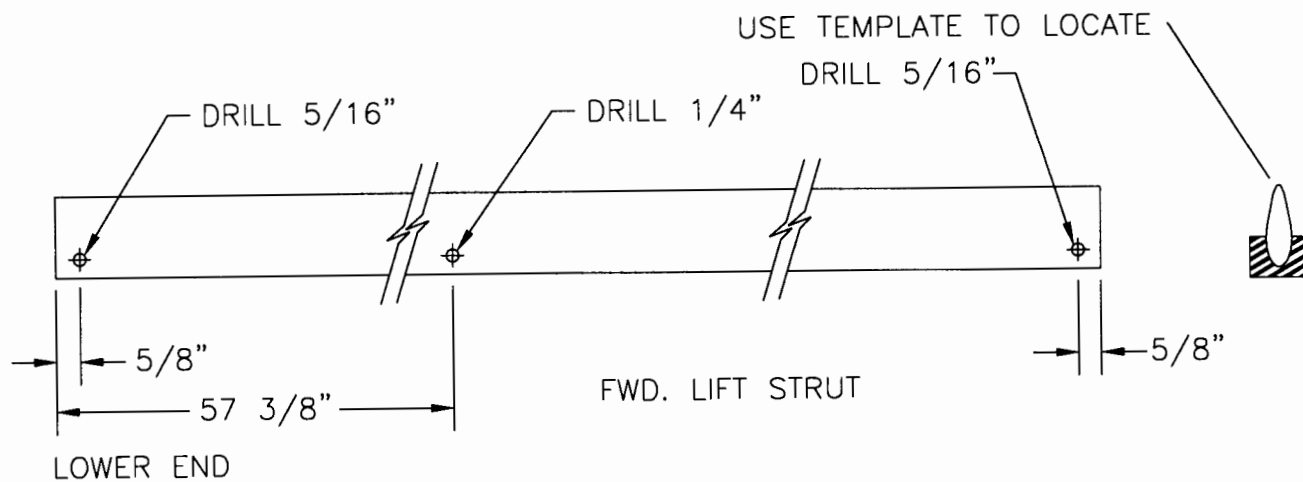


MAY NEED TO GRIND BIT  
 TO ACHIEVE TAP IN FIT



MD3980

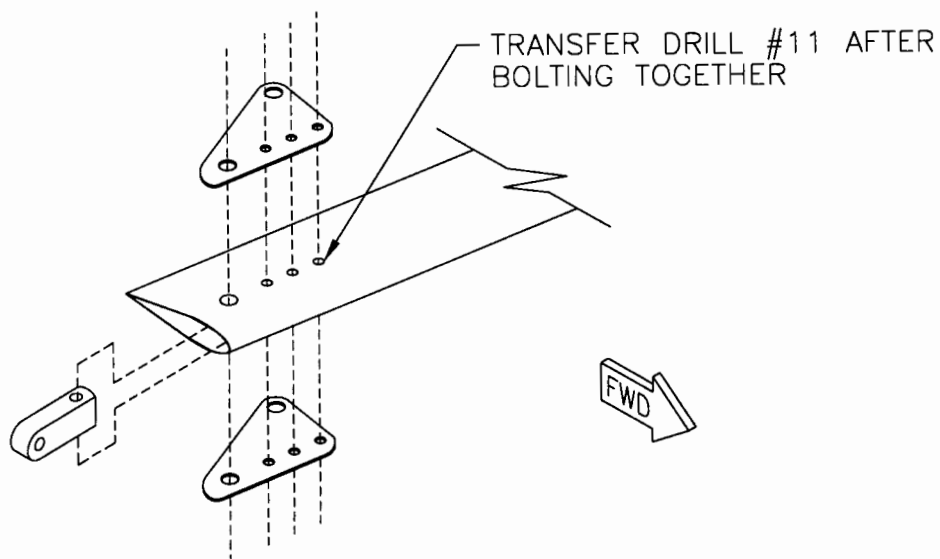
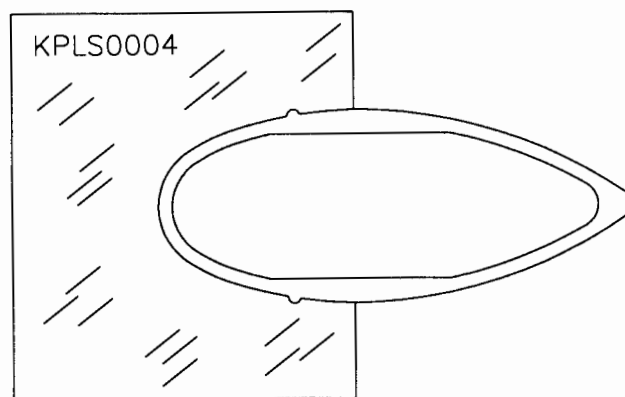
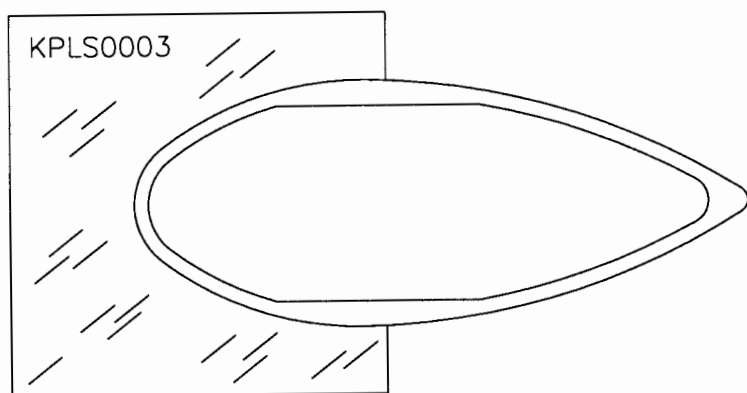
**FIGURE 8-1**  
**S-18 STINGER II**



STRUT CHORDWISE  
HOLE LOCATION  
C-747 LIFT STRUT

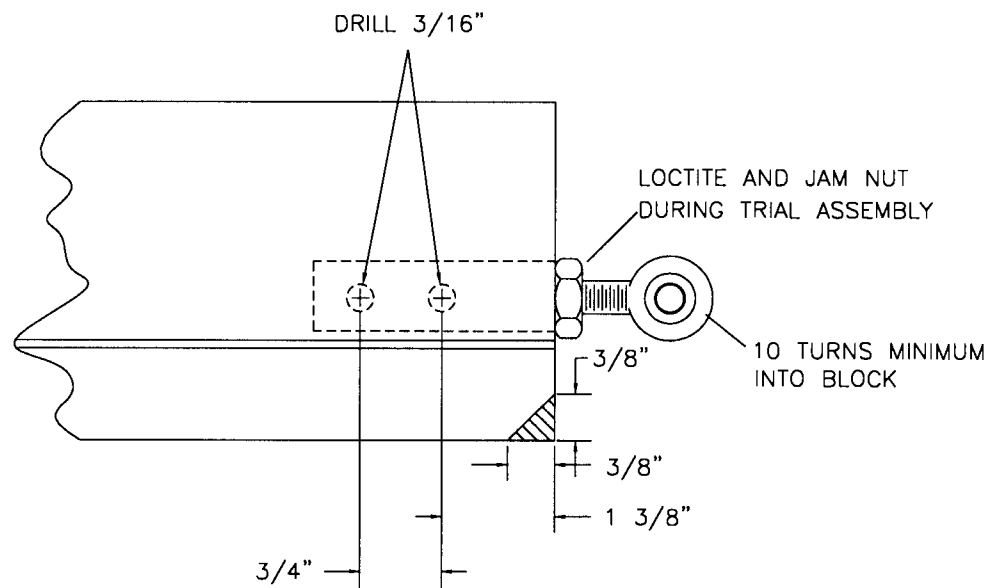
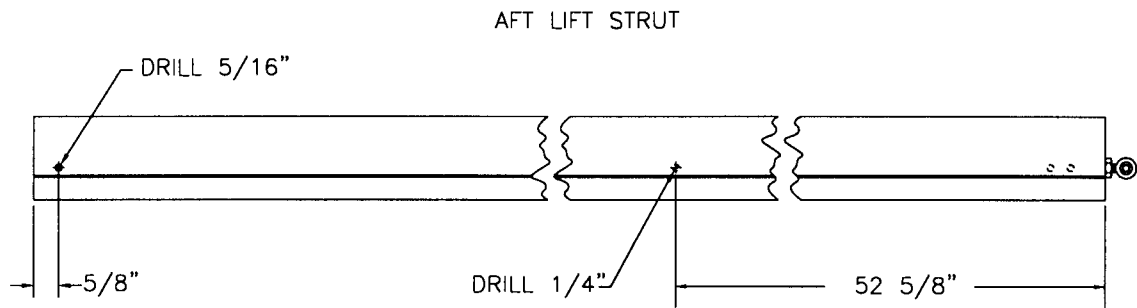
PLACE OVER STRUT AND  
MARK WHERE TEMPLATE ENDS.

STRUT CHORDWISE  
HOLE LOCATION  
C-748 LIFT STRUT



MD3981

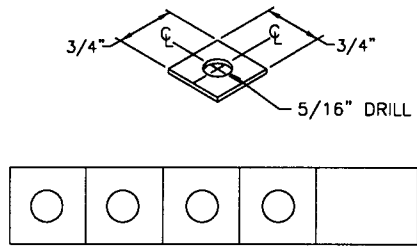
**FIGURE 8-2**  
**S-18 STINGER II**



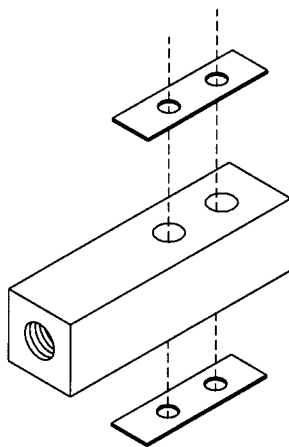
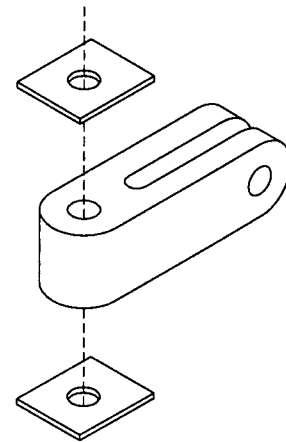
MD3982

**FIGURE 8-3**  
**S-18 STINGER II**

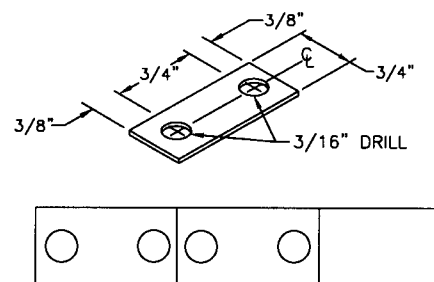
# UPPER AFT & FORWARD STRUT SHIM



HINT: DRILL HOLES IN SHIM STRAP THEN CUT TO LENGTH. MAKE AS REQUIRED.

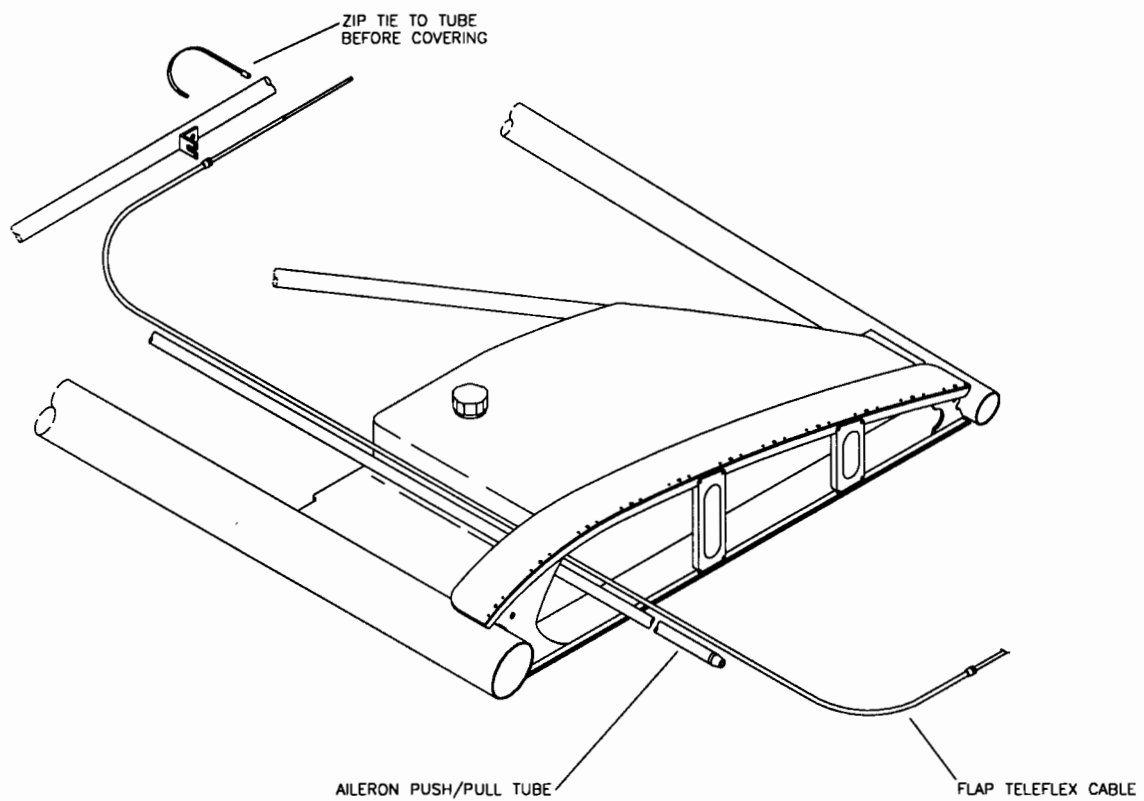


## ADJUSTABLE STRUT SHIM



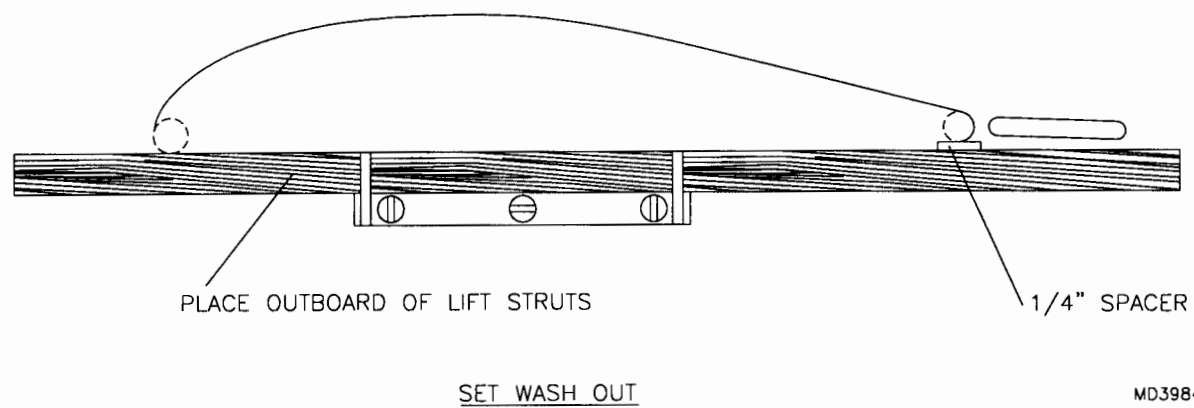
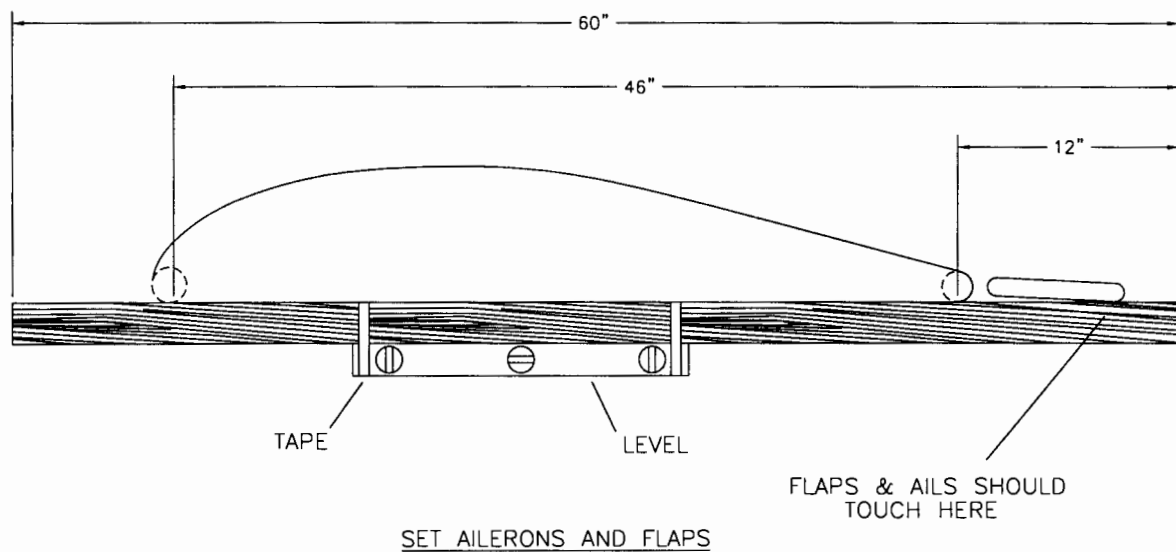
MD3983

FIGURE 8-4  
S-18 STINGER II



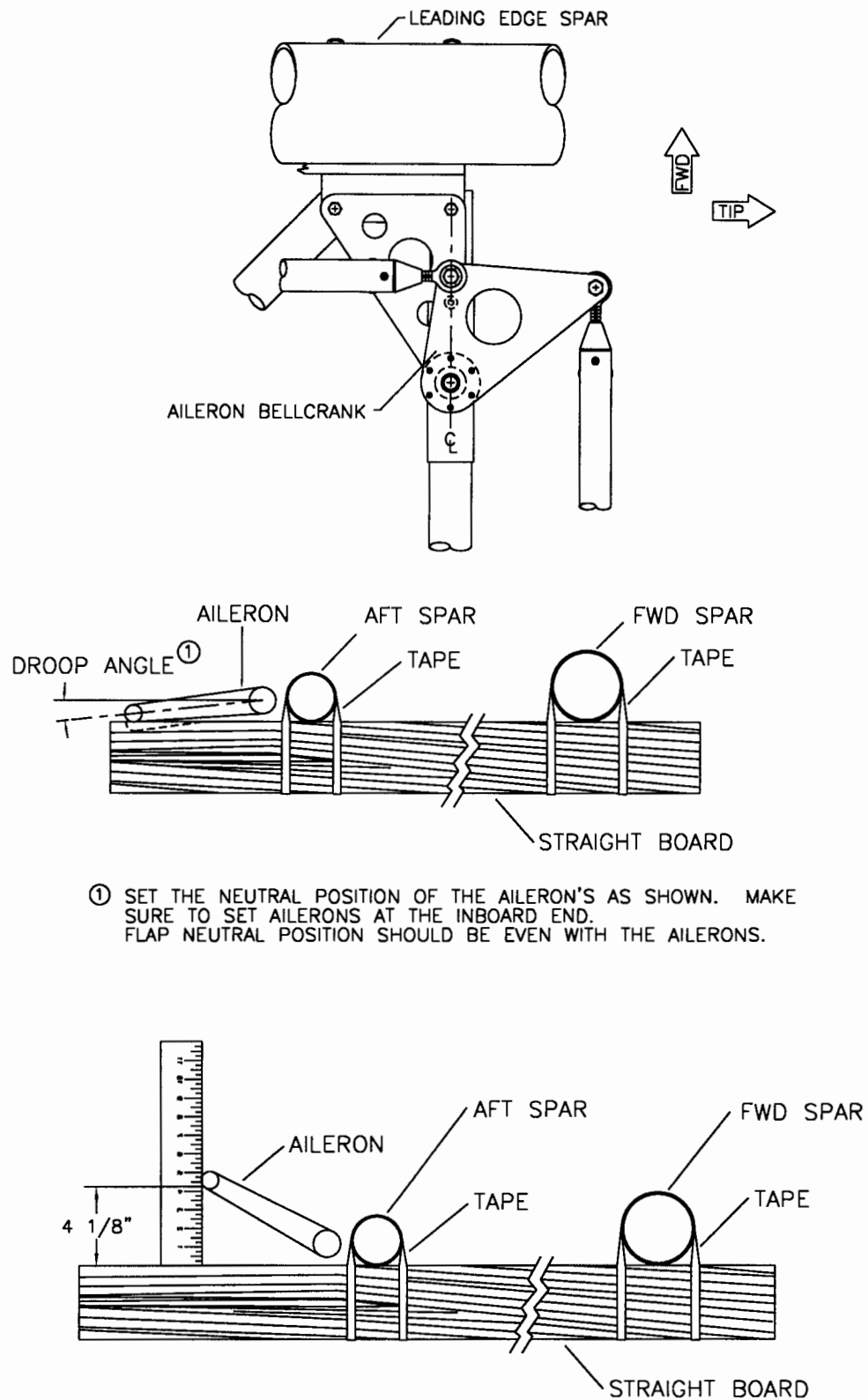
MD4049

FIGURE 8-5  
S-18 STINGER II



MD3984

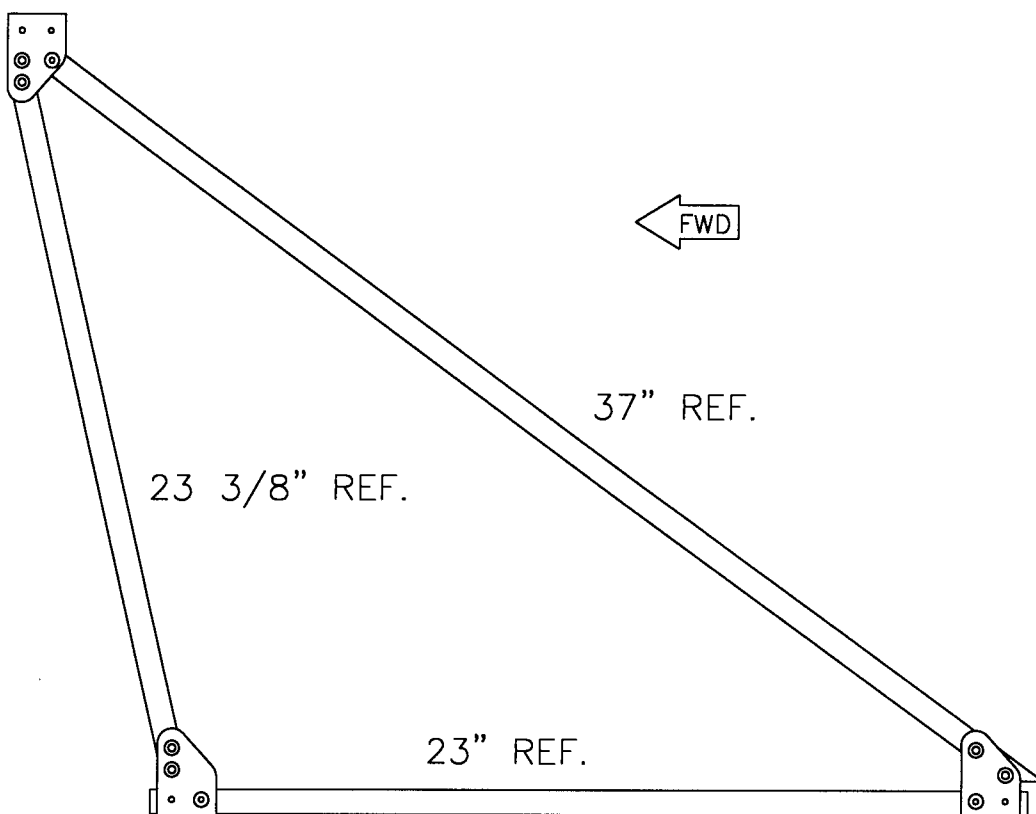
**FIGURE 8-6**  
**S-18 STINGER II**



MEASURE 4 1/8" FROM STRAIGHT EDGE TO LOWER SIDE OF TRAILING EDGE. MEASURE AT INBOARD END OF AILERON.

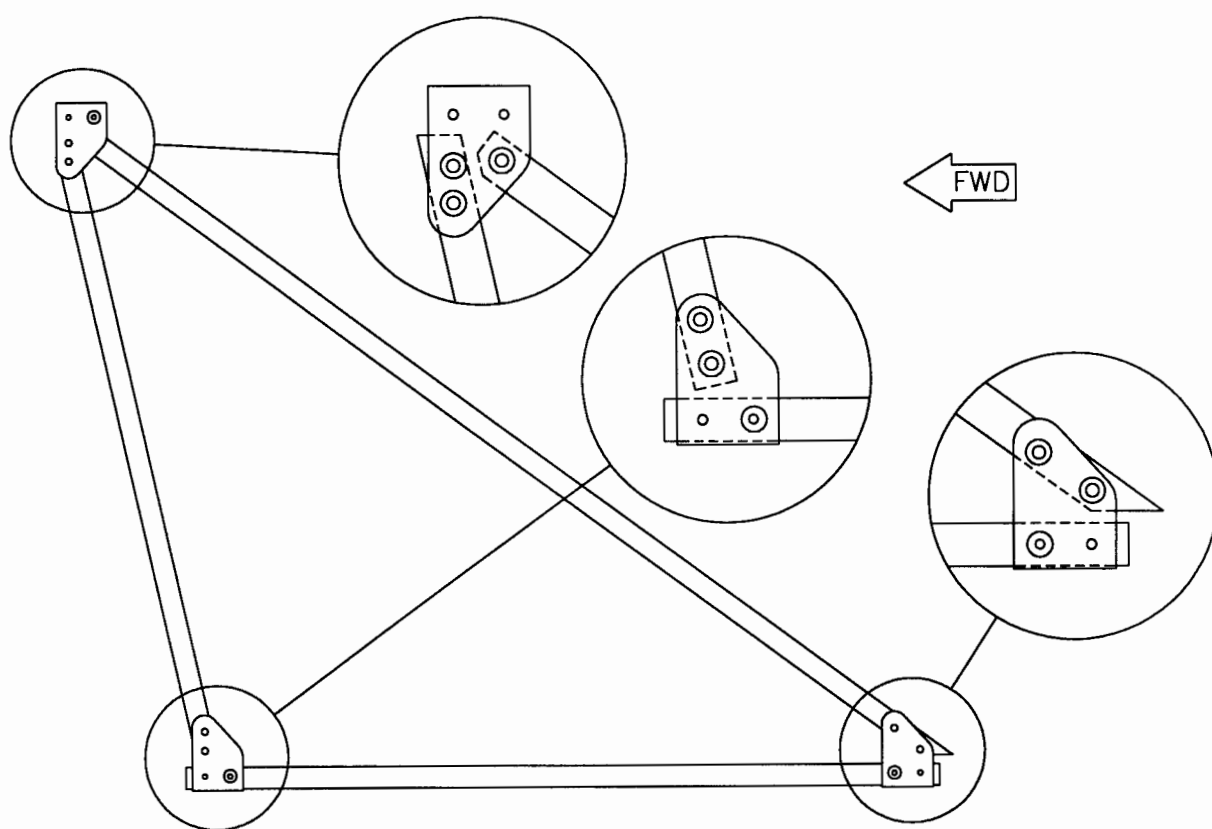
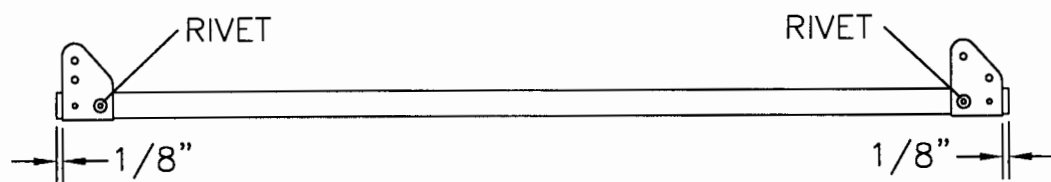
**FIGURE 8-7**  
**S-18 STINGER II**

MD4050



MD3985

FIGURE 8-8  
S-18 STINGER II

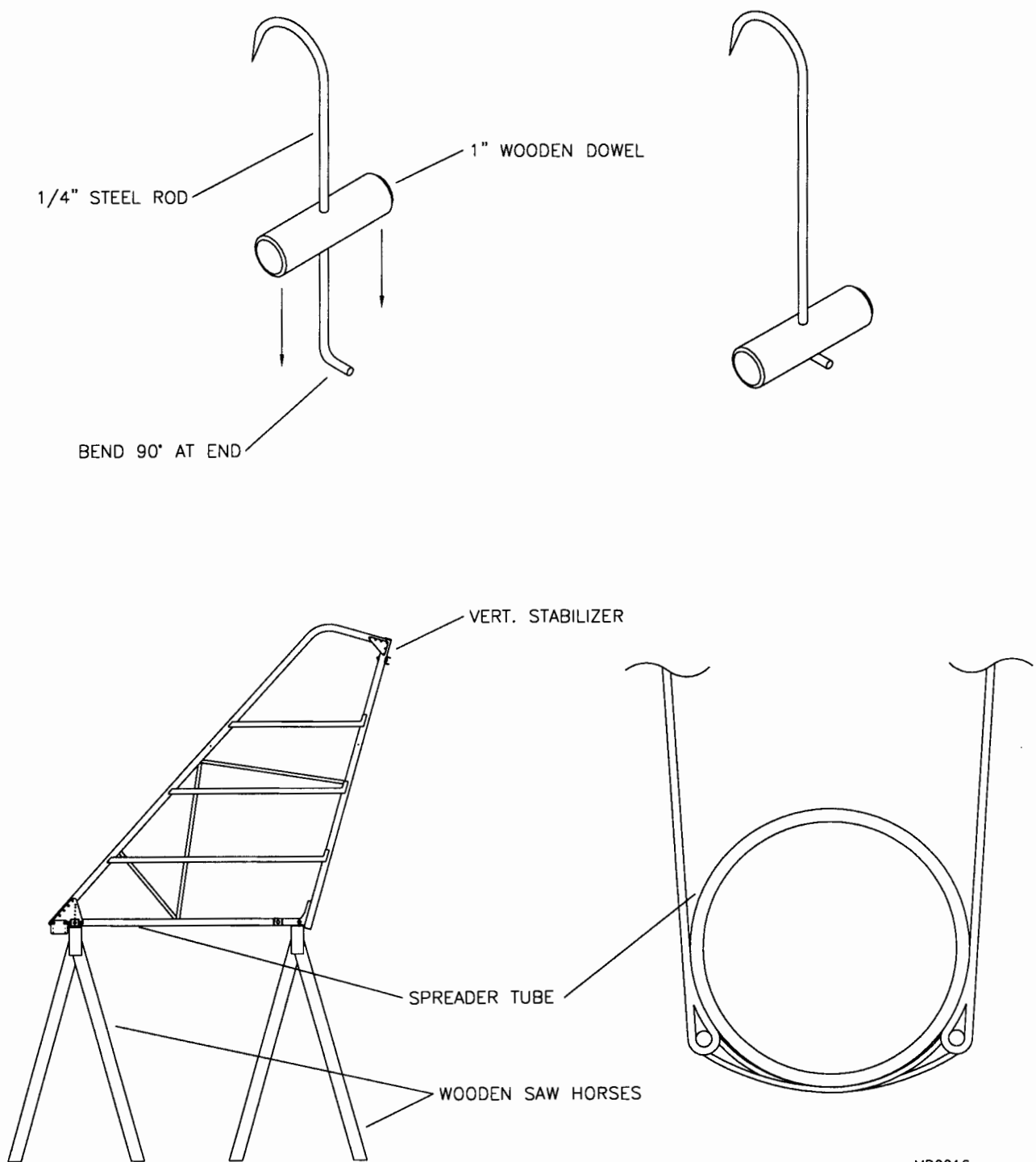


MD3986

FIGURE 8-9  
S-18 STINGER II

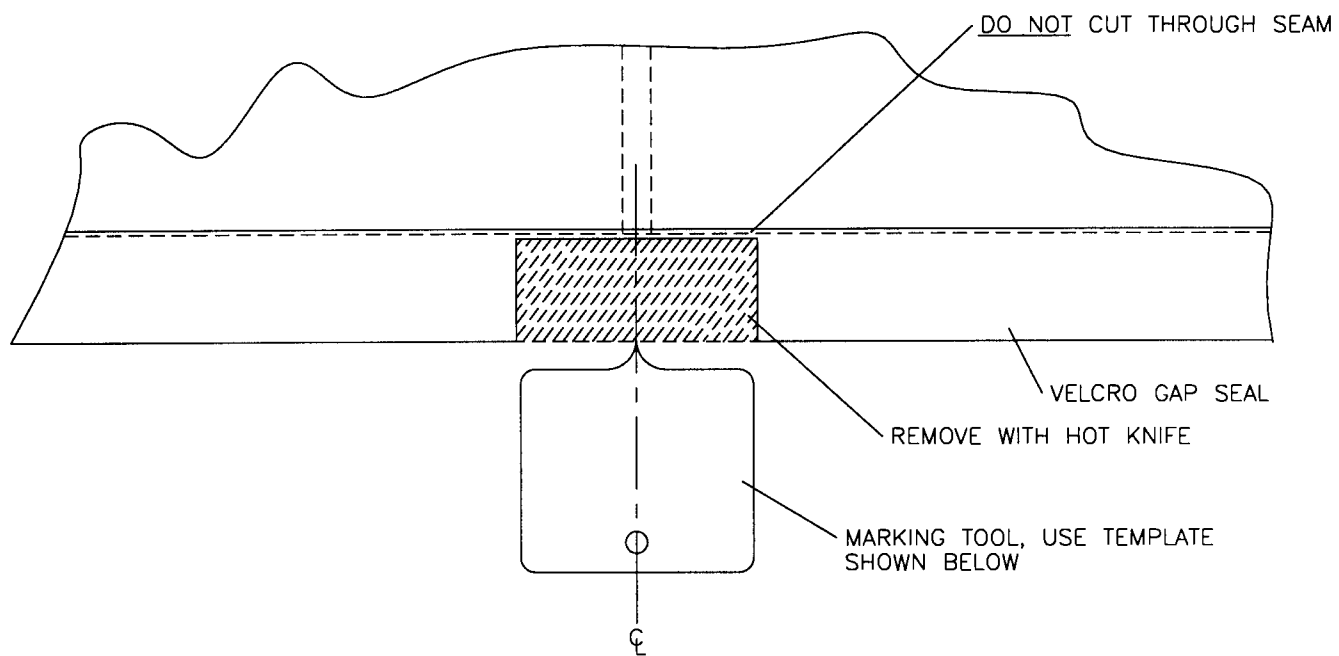


3/01/01

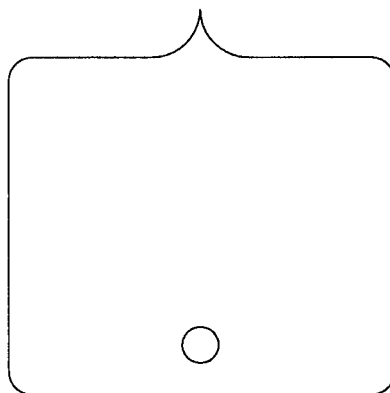


MD2216

**FIGURE 9-2**  
**S-18 STINGER II**



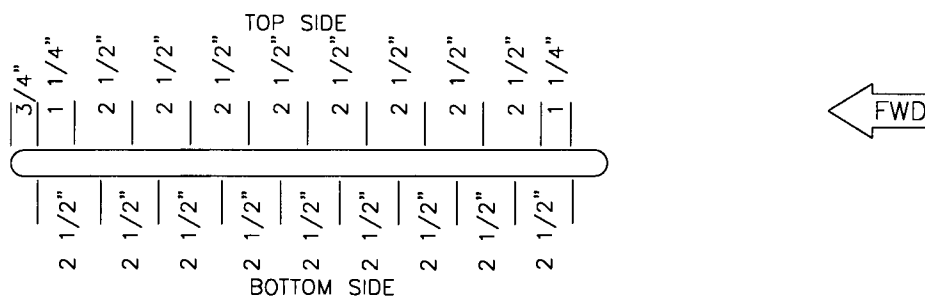
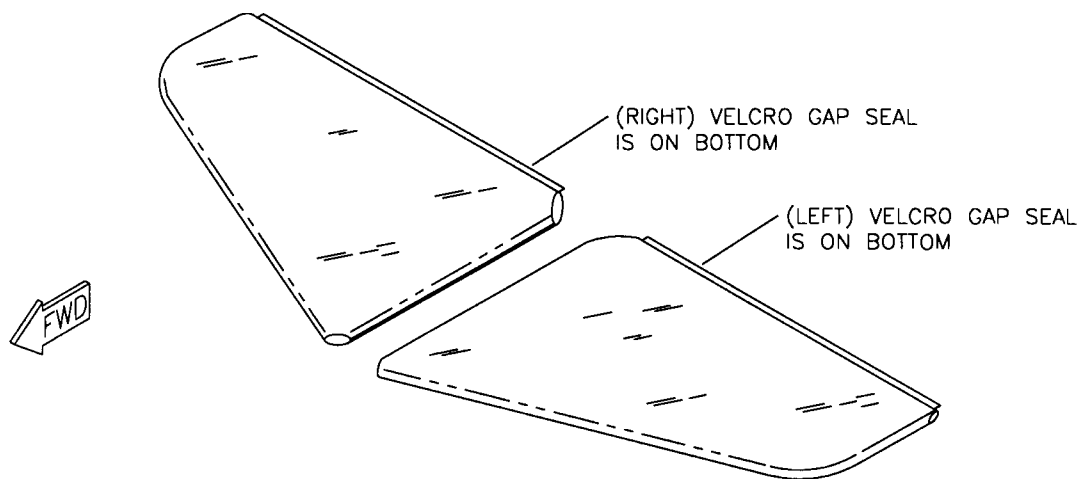
POINT OF TEMPLATE  
INSERTS INTO HINGE  
BOLT HOLE.



TEMPLATE

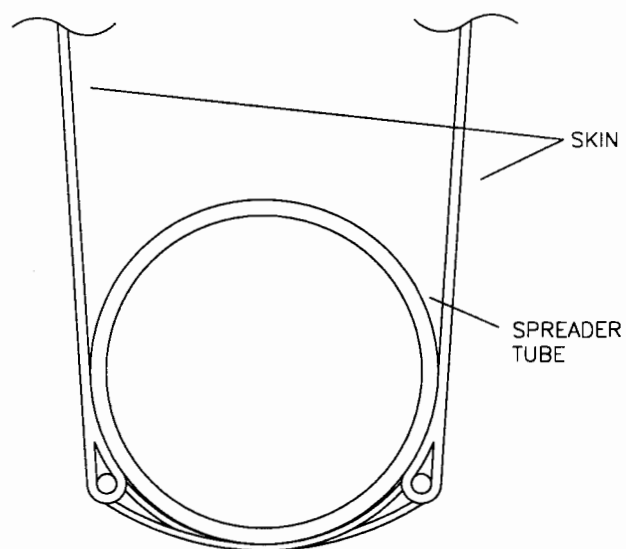
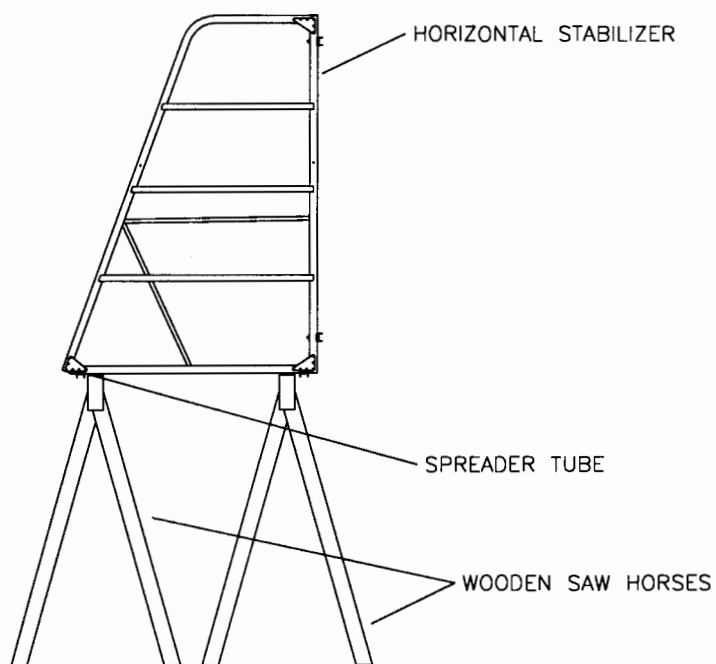
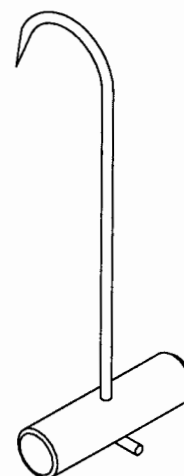
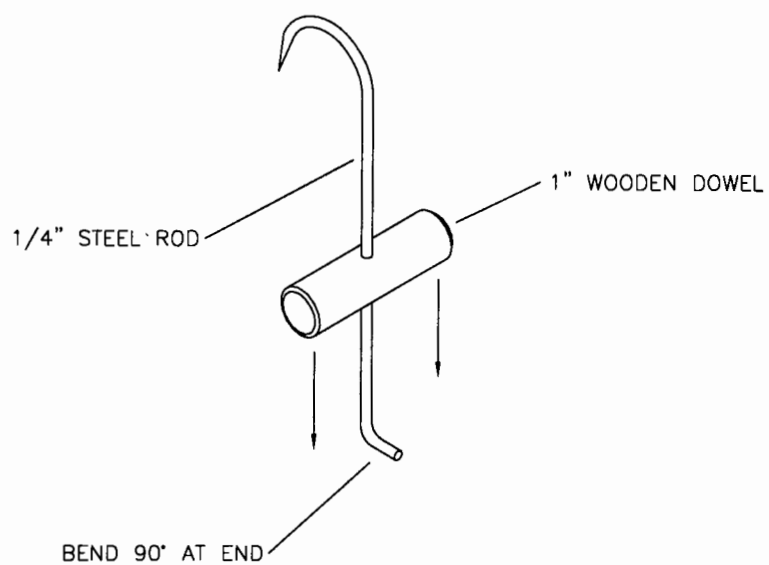
MD2210

**FIGURE 9-3**  
**S-18 STINGER II**



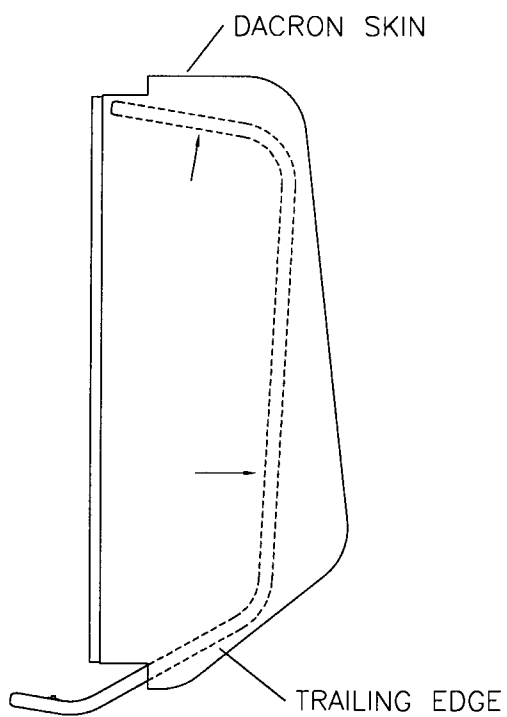
MD2214

FIGURE 9-4  
S-18 STINGER II

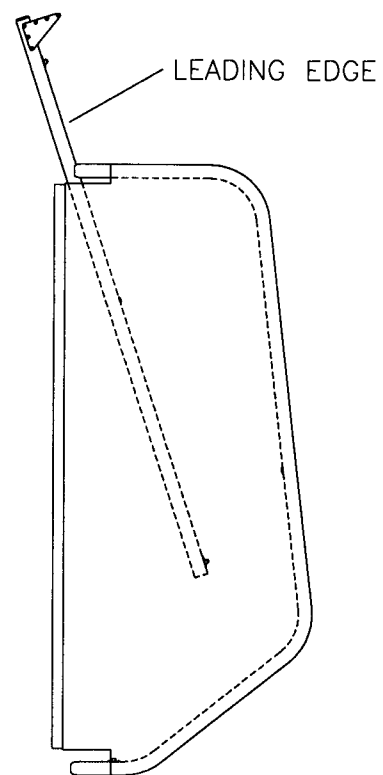


MD2217

**FIGURE 9-5**  
**S-18 STINGER II**



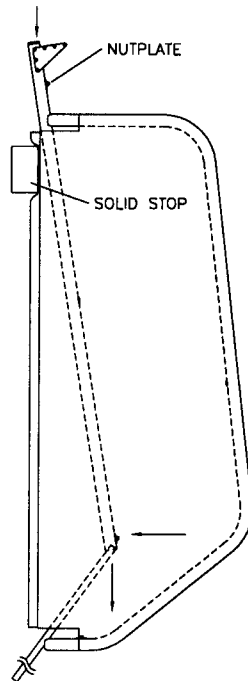
- ① SLIDE ELEVATOR TRAILING EDGE INTO DACRON COVER.



- ② WITH OUTBOARD GUSSETS RIVETED ON LEADING EDGE. SLIDE ELEVATOR LEADING EDGE INTO FABRIC. ROTATE SPAR TO CLEAR OUTBOARD NUT PLATE.

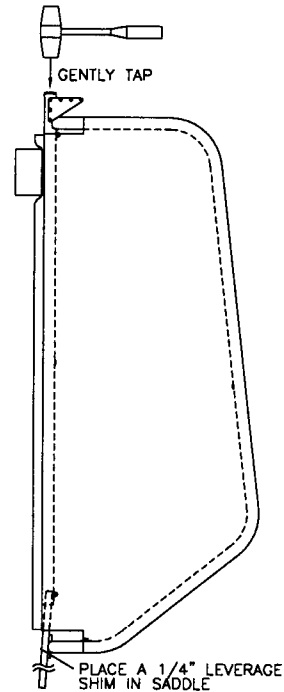
MD2194

**FIGURE 9-6  
S-18 STINGER II**



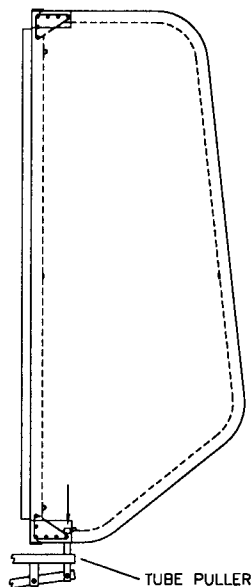
- ③ SECURE A 3/4" LEVERAGE TUBE (NOT SUPPLIED). THIS CAN BE A HEAVY WALL STEEL OR ALUMINUM TUBE. INSERT INTO LEADING EDGE TO PULL LEADING EDGE INTO POSITION.

ONCE IT IS PULLED TIGHTLY AGAINST FRONT EDGE OF FABRIC, LIGHTLY TAP ON OUTBOARD END OF LEADING EDGE UNTIL IT BOTTOMS OUT ON TRAILING EDGE OF THE ROOT.

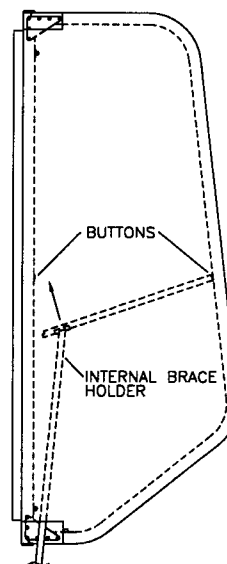


- ④ LEVERAGE TOOL INSERTED INTO LEADING EDGE APPROX. 1 1/2". PULL ON LEVERAGE TUBE WHILE A HELPER TAPS LEADING EDGE INTO POSITION.

CLECO OUTBOARD GUSSETS INTO POSITION ON TRAILING EDGE.



- ⑤ WHILE HOLDING OUTBOARD OF ELEVATOR, USE TUBE PULLER TO PULL TRAILING EDGE INTO POSITION AND CLECO, PRE-DRILL HOLES IN TRAILING EDGE. DRILL AND CLECO AFT TWO HOLES IN TRAILING EDGE USING GUSSET AS A GUIDE.



- ⑥ PUSH THE INTERNAL BRACE INTO POSITION BRACE WITH THE NOTCHED END OPEN TO THE BOTTOM, USE THE TOOL DETAILED ON THE NEXT PAGE OR ATTACH TO STEEL STRAP IN A SIMILAR FASHION. MAKE SURE BRACE IS SNAPPED IN POSITION SECURELY.

MD2211

FIGURE 9-7  
S-18 STINGER II

# RANS INSTALLATION TOOL

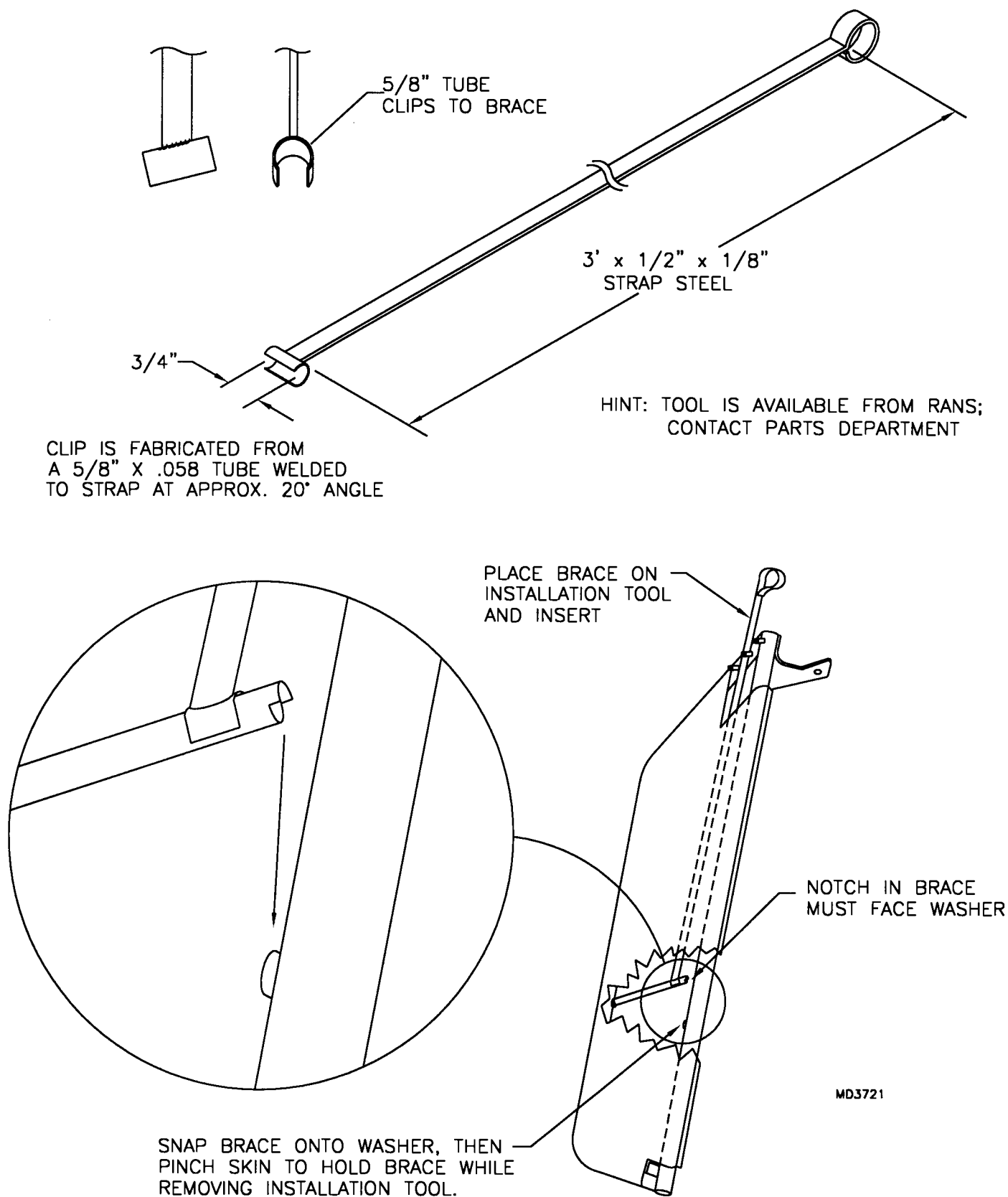
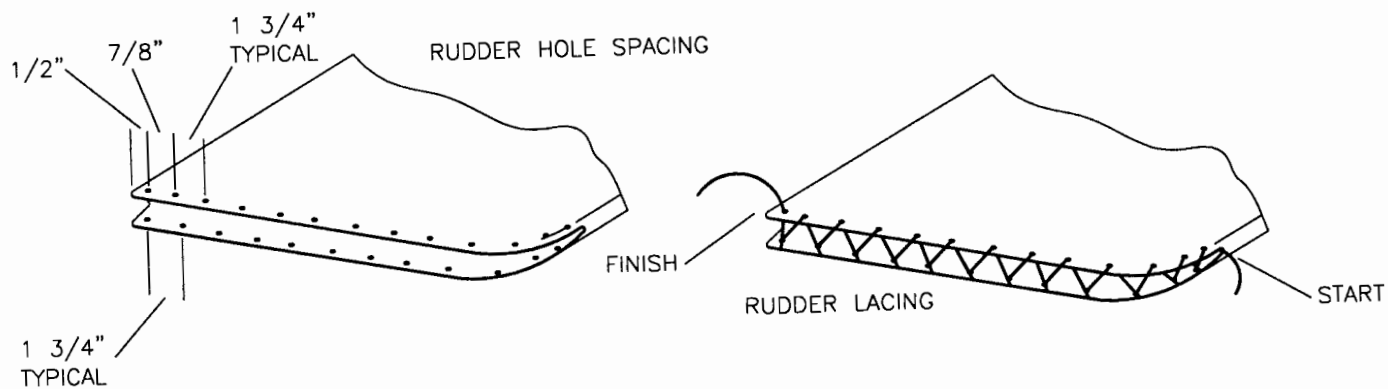
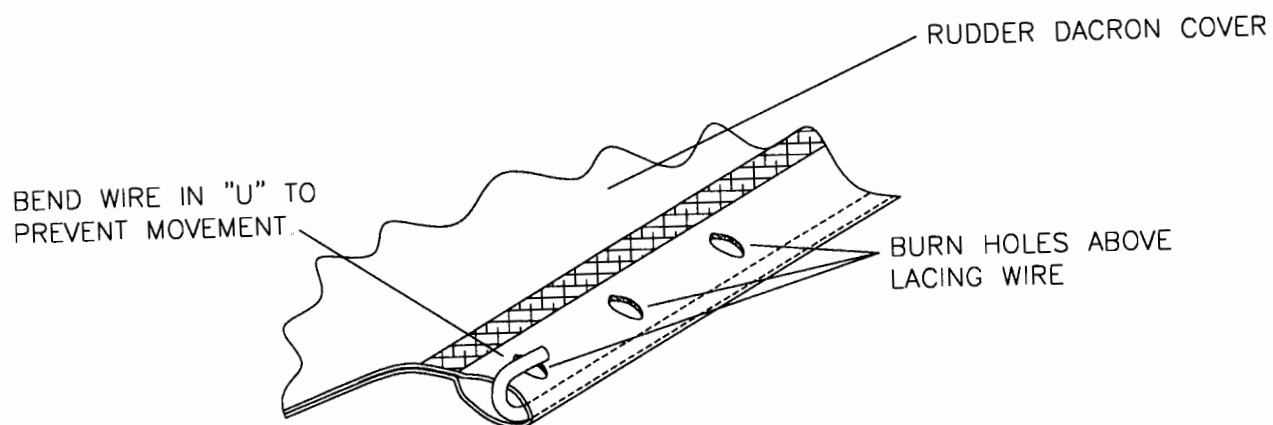


FIGURE 9-8  
S-18 STINGER II



MD2235

FIGURE 9-9  
S-18 STINGER II

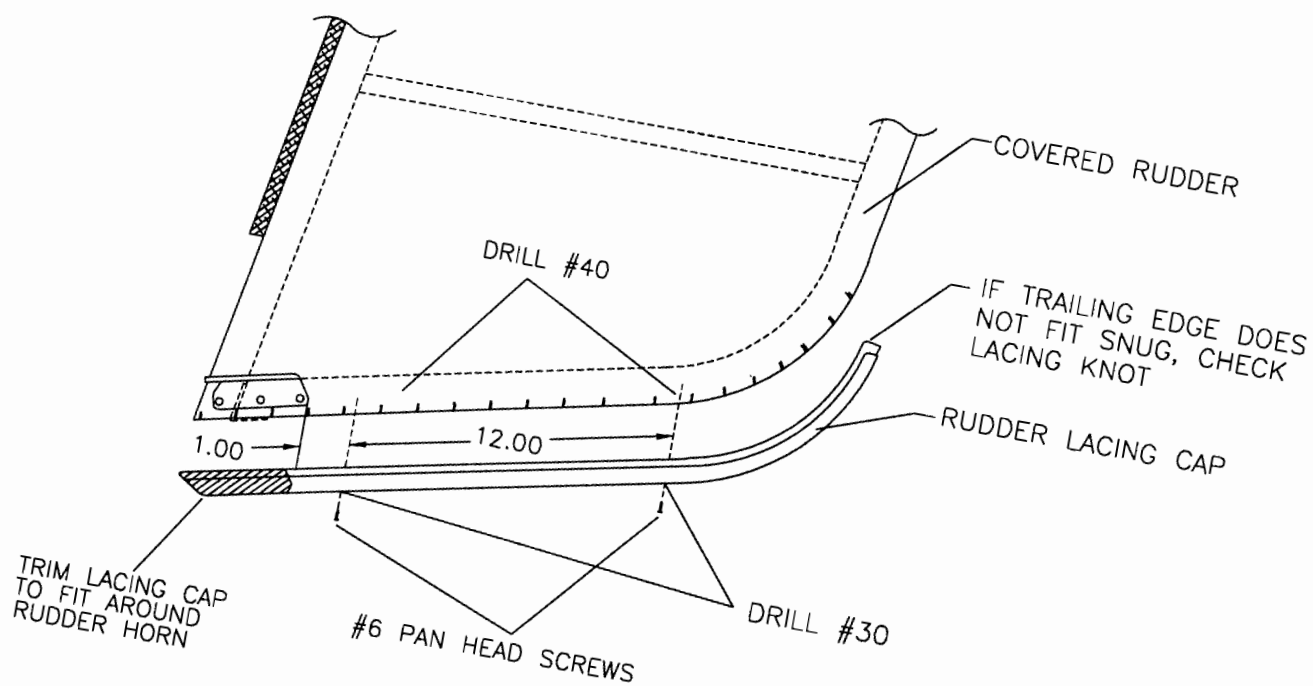
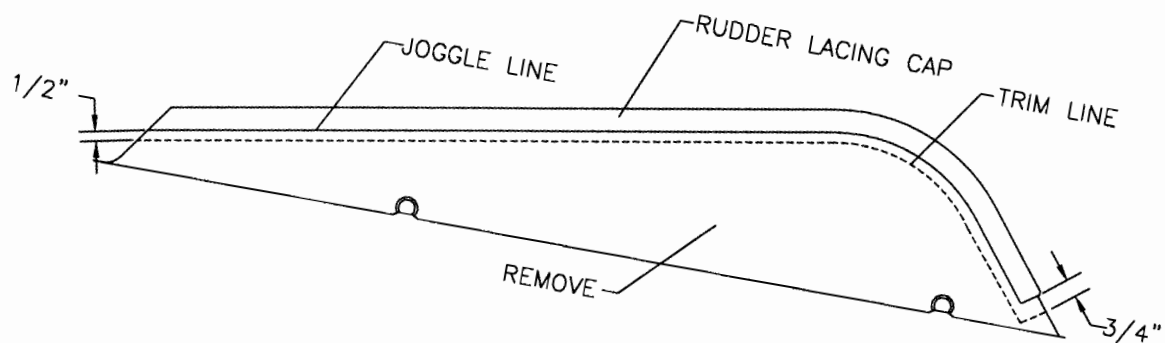
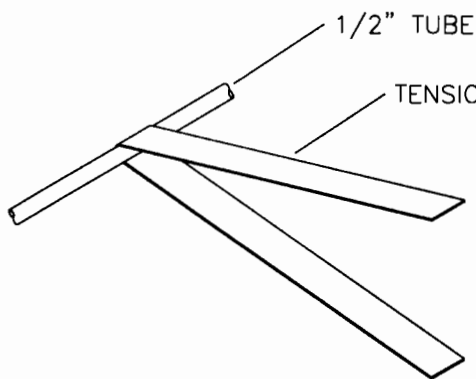
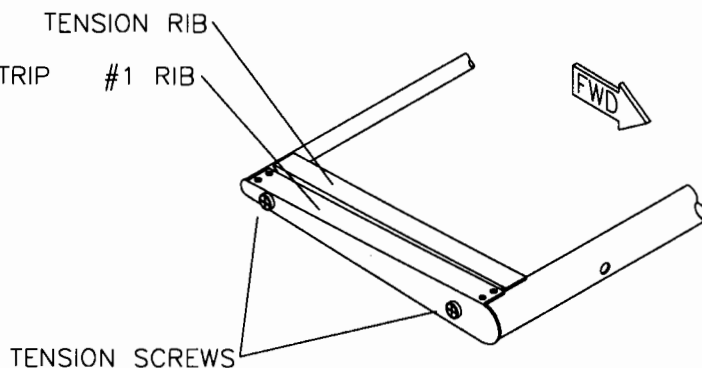


FIGURE 9-10  
S-18 STINGER II

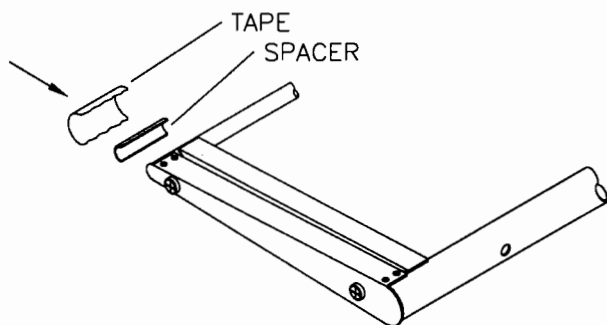
MD2964



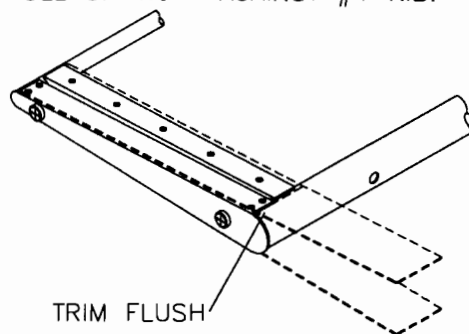
- ① FORM STRIP APPROXIMATELY MID. POINT AROUND 1/2" TUBE.



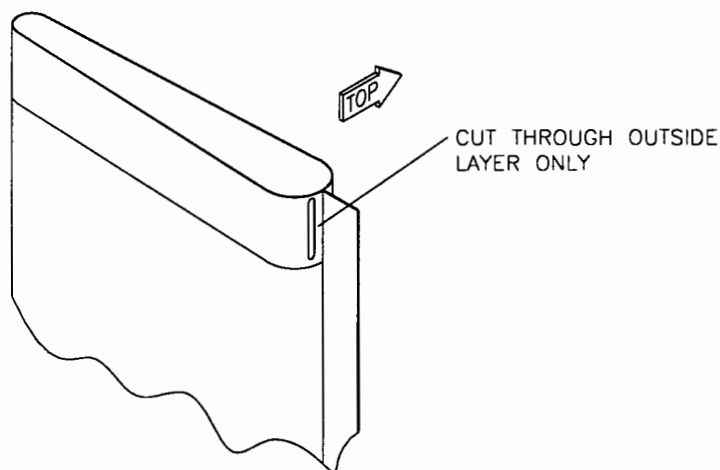
- ② INSTALL TENSION RIB AND SCREWS. PULL UP TIGHT AGAINST #1 RIB.



- ③ SPLIT 2" PIECE OF 1/2" x .035 AND TAPE TO TRAILING EDGE, THIS WILL ACT AS A SPACER FOR FABRIC THICKNESS AND ALLOW THE TENSION STRIP LATITUDE TO JUMP OVER RIVETS ON #1 RIB.

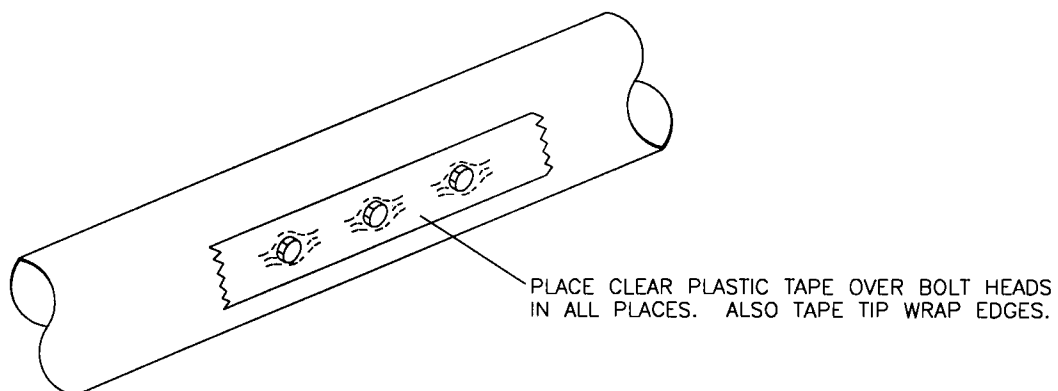
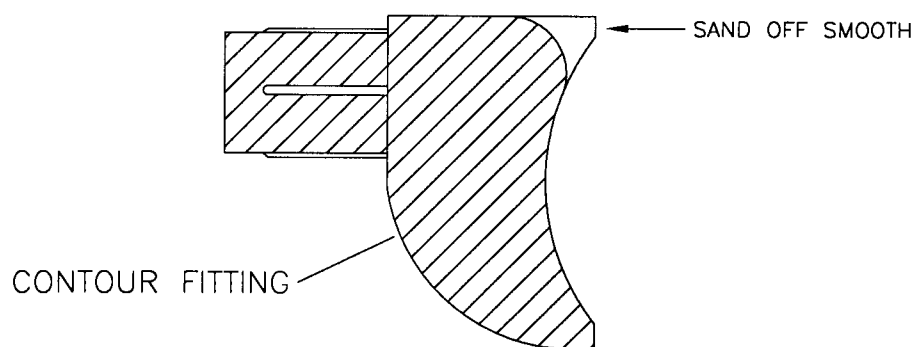
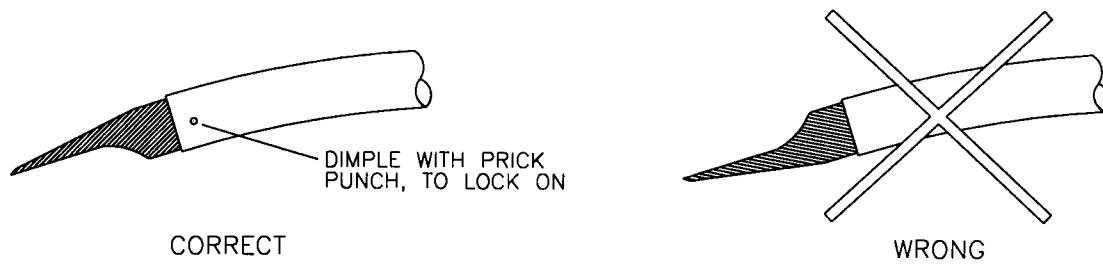


- ④ PULL TENSION STRIP TIGHT AROUND #1 RIB, TENSION RIB AND SPACER KEEPING IT FLUSH WITH THE OUTSIDE OF #1 RIB DRILL (5) EQUALLY SPACED #30 HOLES WITH 1/2" E.D. OFF INSIDE OF TENSION STRIP INTO TENSION RIB, CLECO AS YOU GO, TRIM TENSION STRIP AS SHOWN, RADIUS ALL CORNERS.



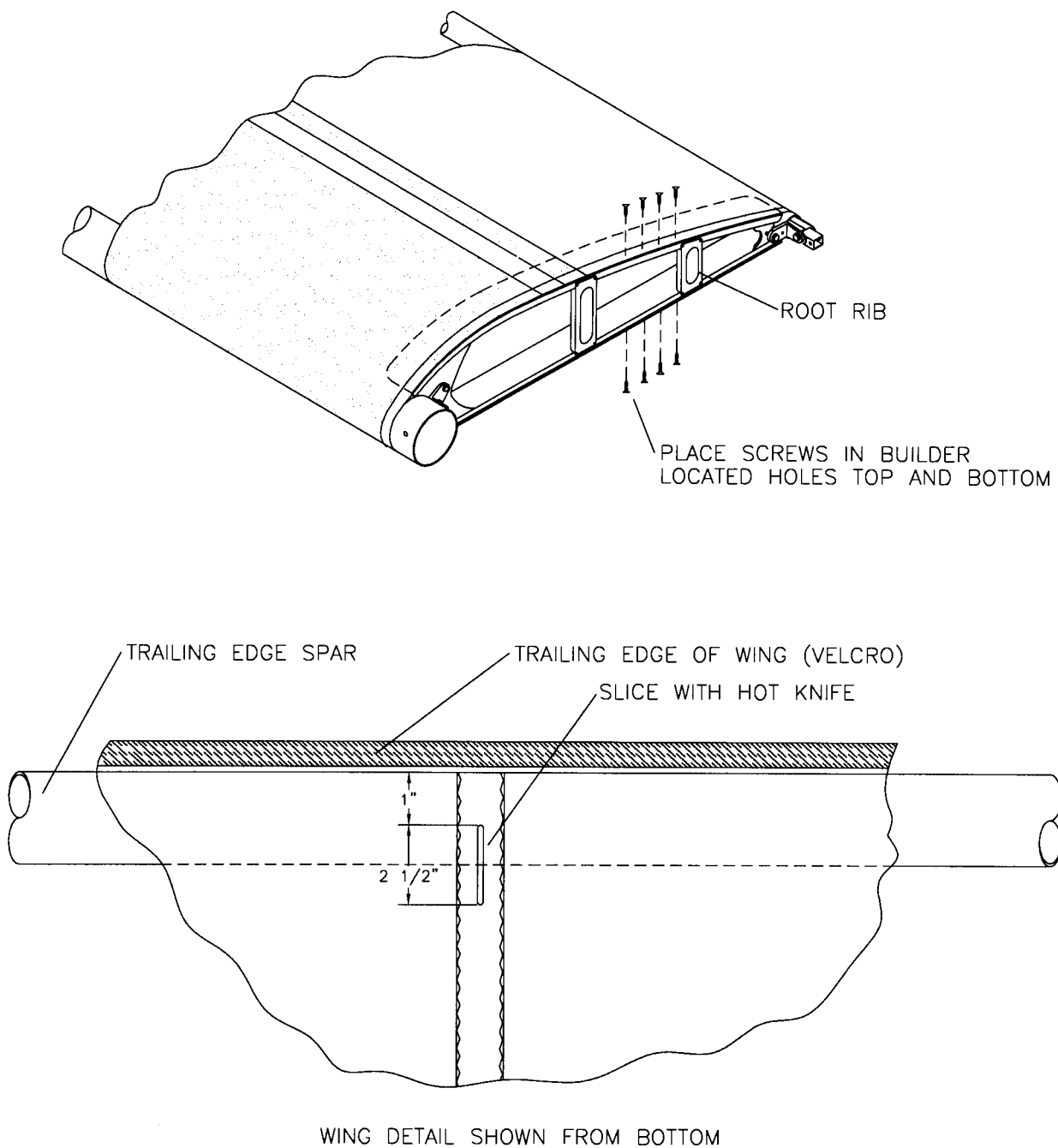
MD2187

FIGURE 9-11  
S-18 STINGER II



MD2212

**FIGURE 9-12**  
**S-18 STINGER II**



MD2213

**FIGURE 9-13**  
**S-18 STINGER II**

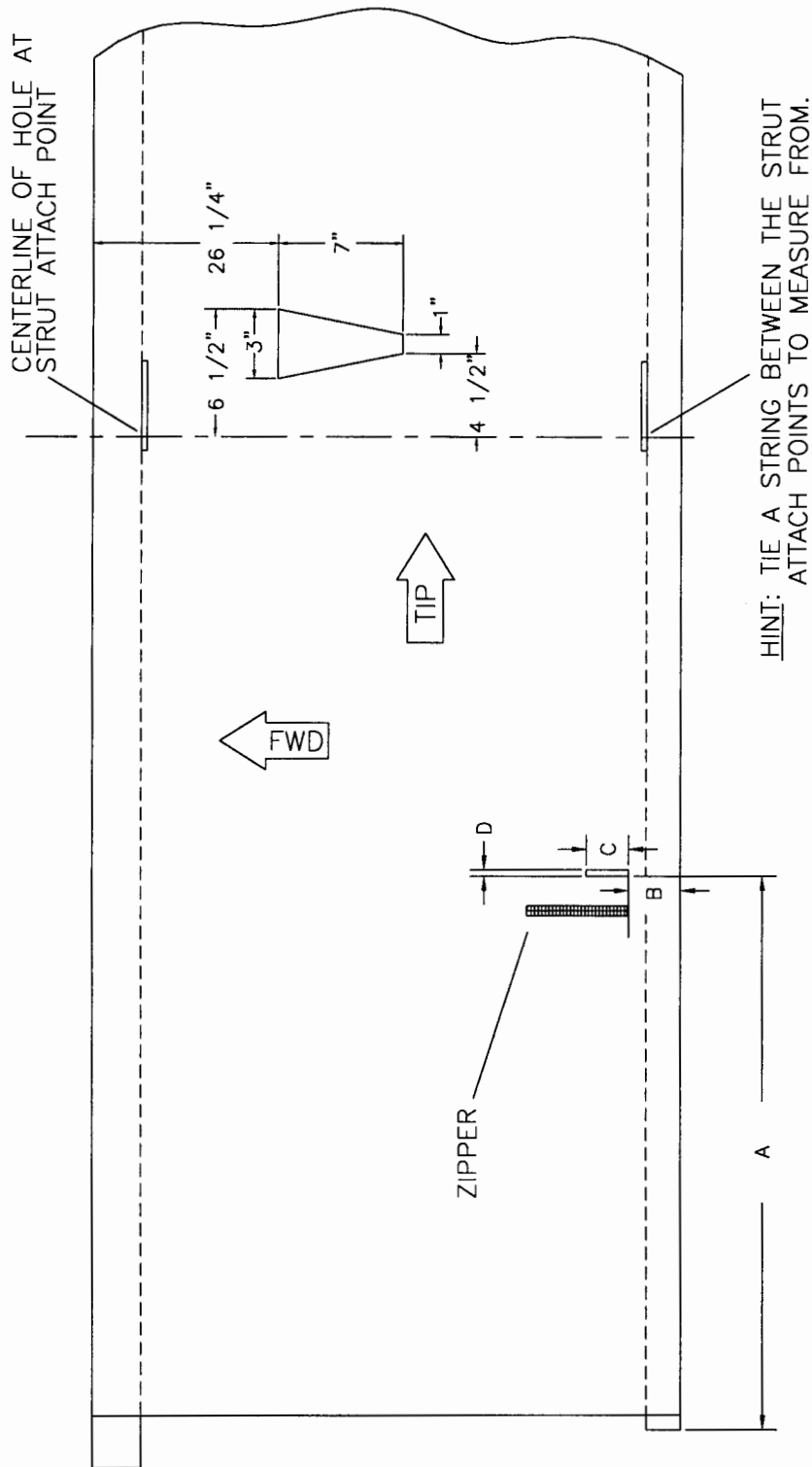


FIGURE 9-14  
S-18 STINGER II

IN-FLIGHT ADJUSTABLE FLAP  
EXIT LOCATIONS

A - 51 7/8"  
B - 2 1/2"  
C - 1 1/2"  
D - 1 1/2"

GROUND ADJUSTABLE FLAP  
EXIT LOCATIONS

A - 52 1/2"  
B - 1 3/4"  
C - 3"  
D - 1/8"

MD2218

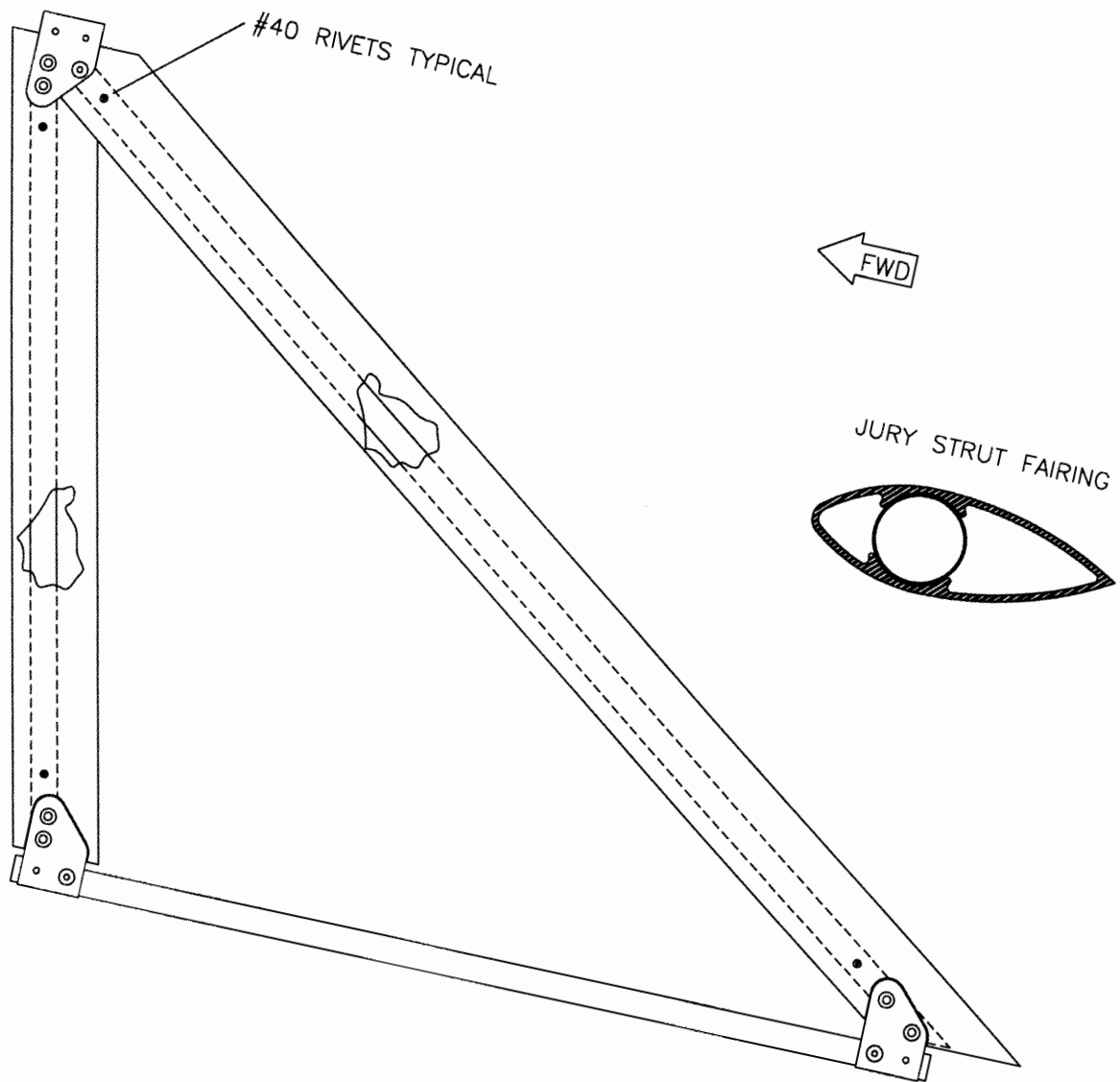
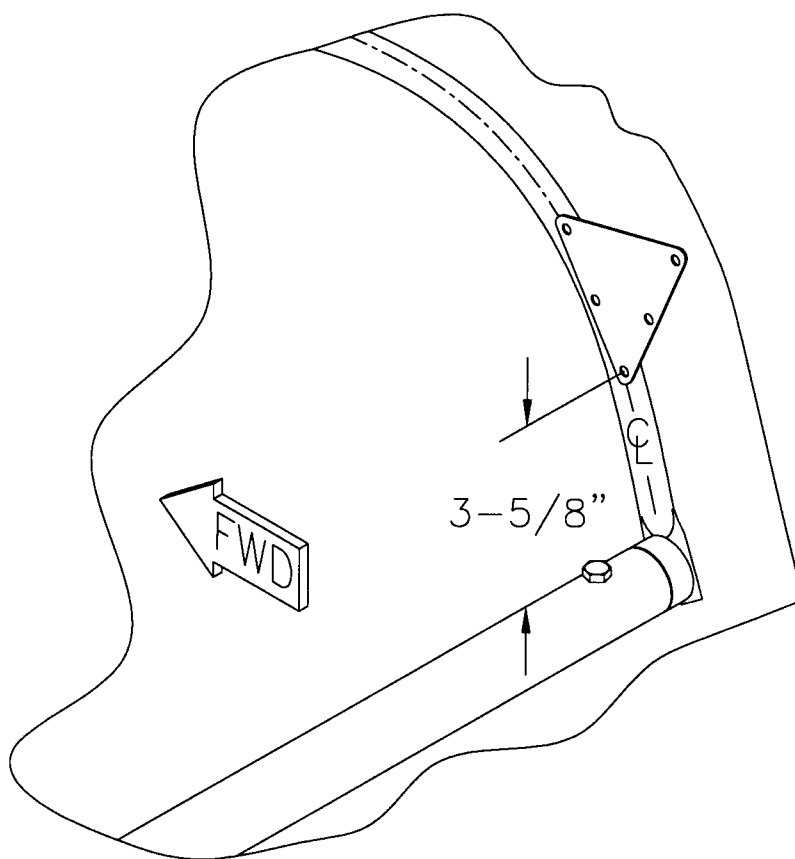


FIGURE 10-1  
S-18 STINGER II

MD3987

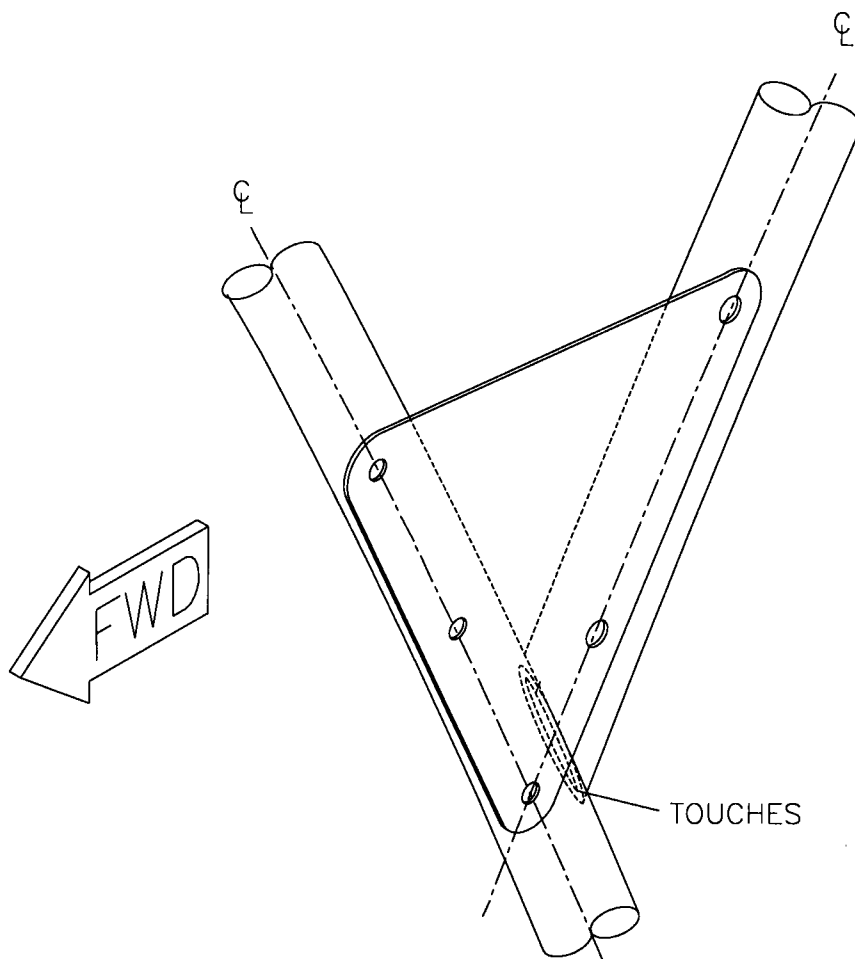
3/01/01



MD4129

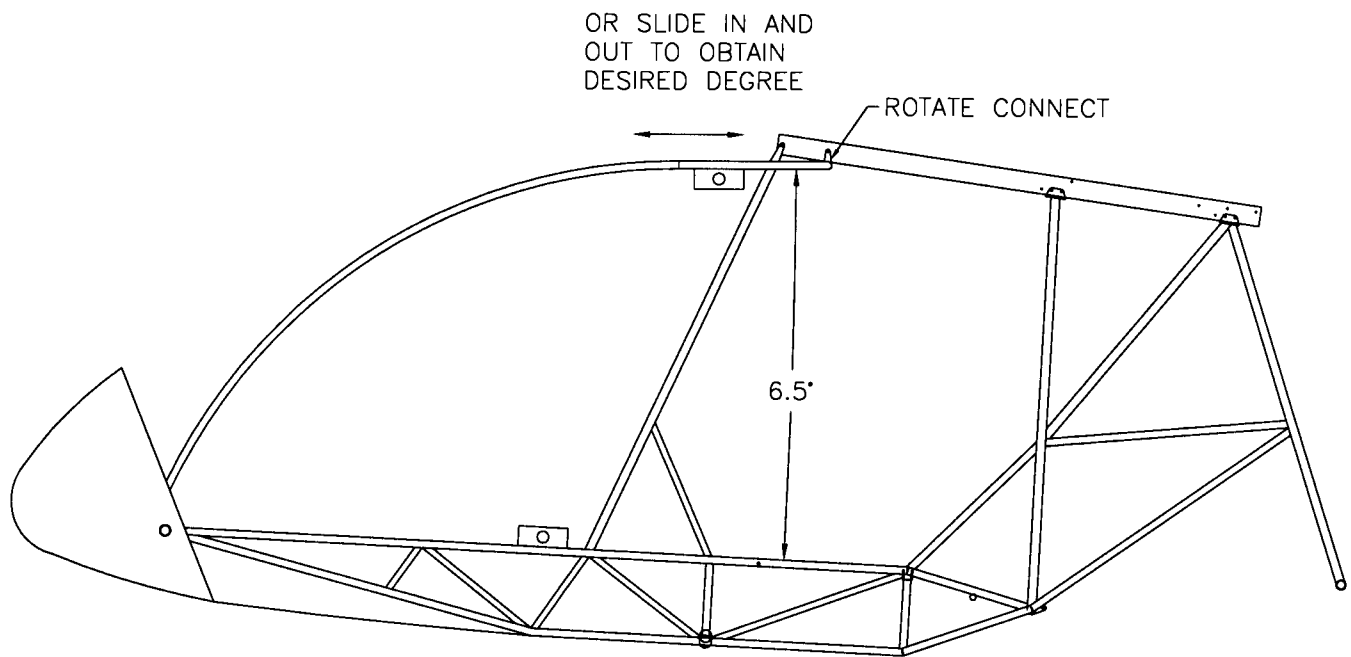
FIGURE 10A-1  
S-18 STINGER II

07/02/01



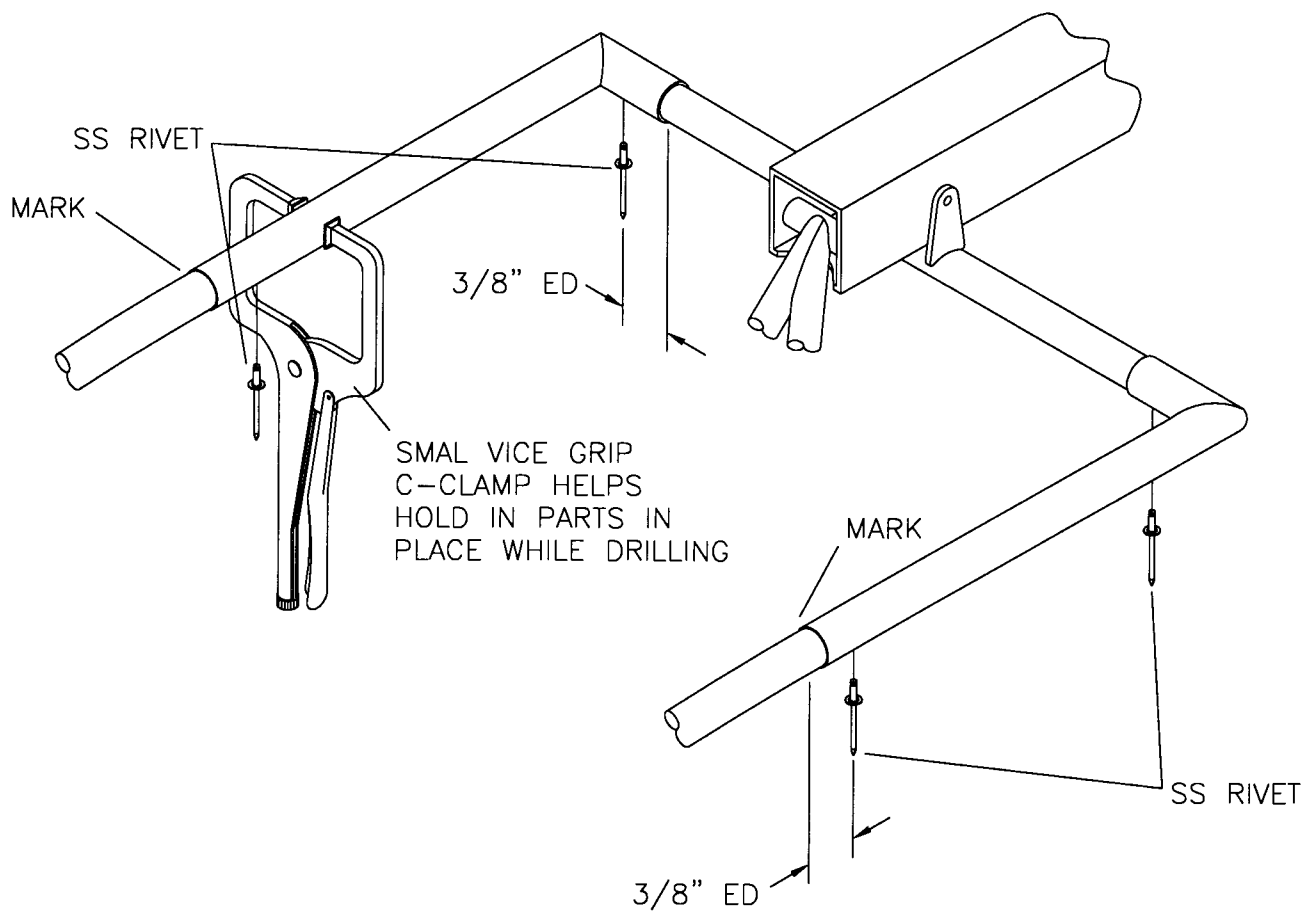
MD4128

**FIGURE 10A-2**  
**S-18 STINGER II**



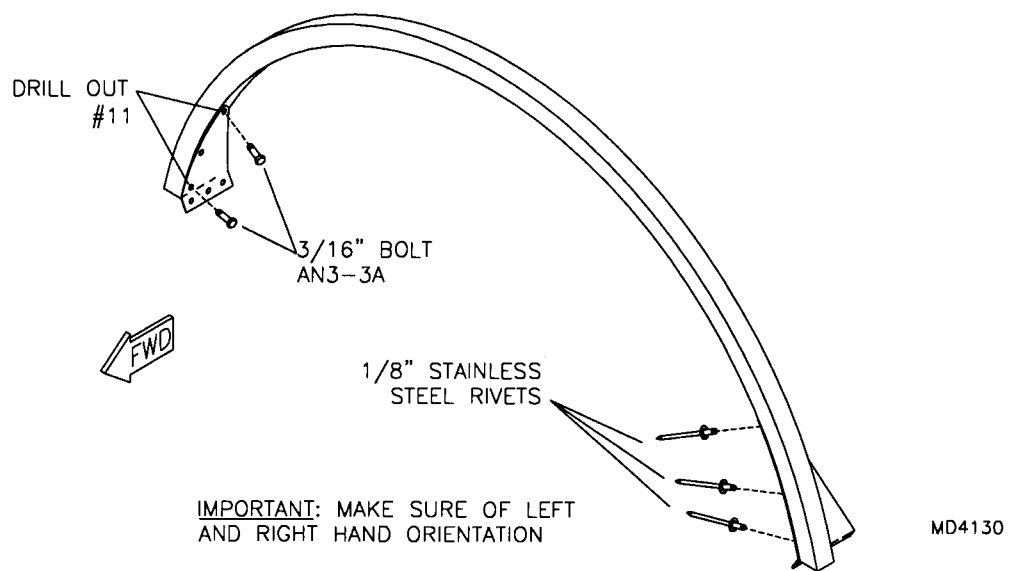
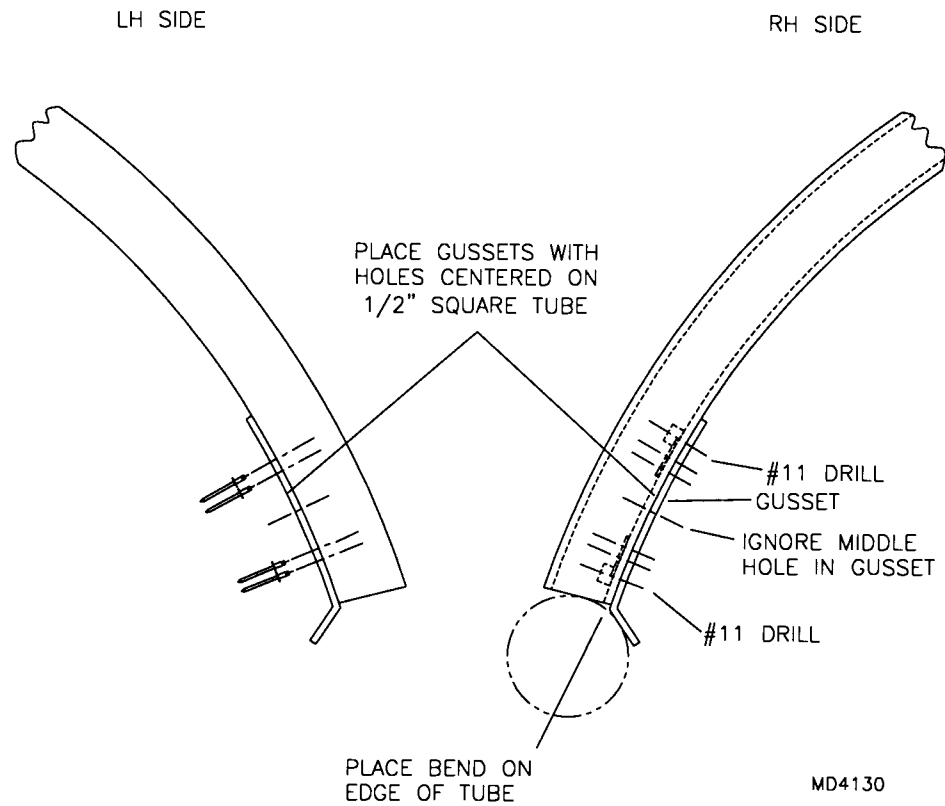
MD4137

**FIGURE 10A-3**  
**S-18 STINGER II**

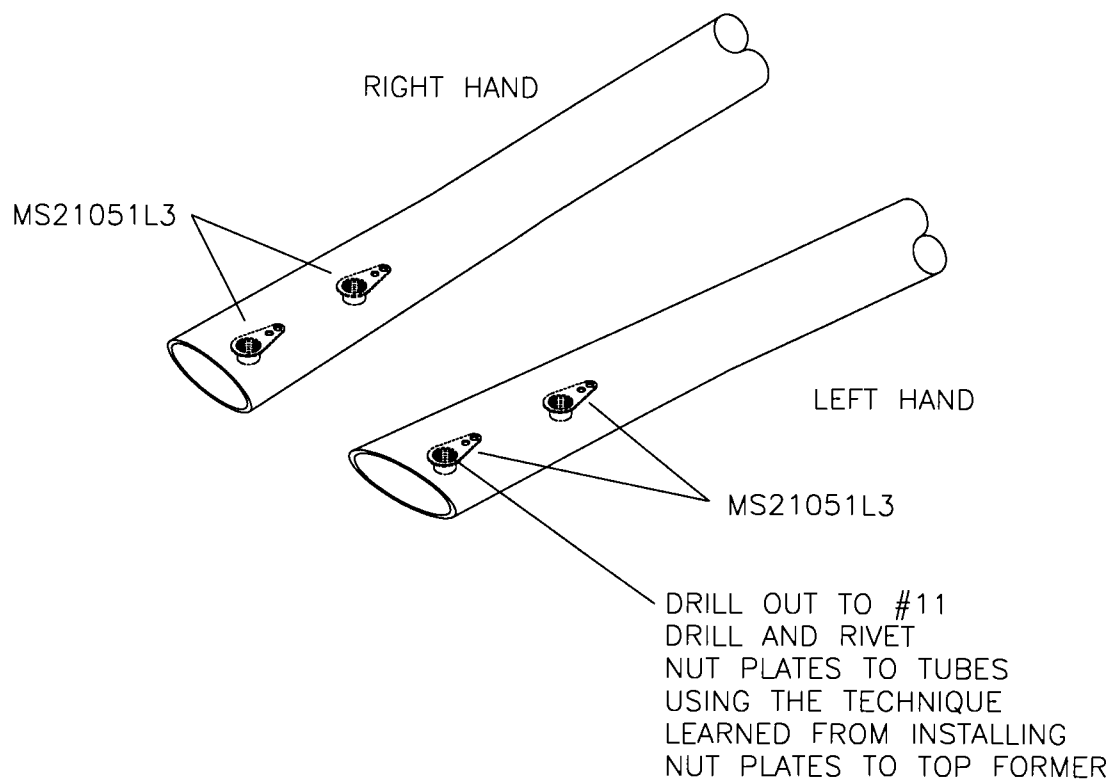


MD4136

**FIGURE 10A-4**  
**S-18 STINGER II**



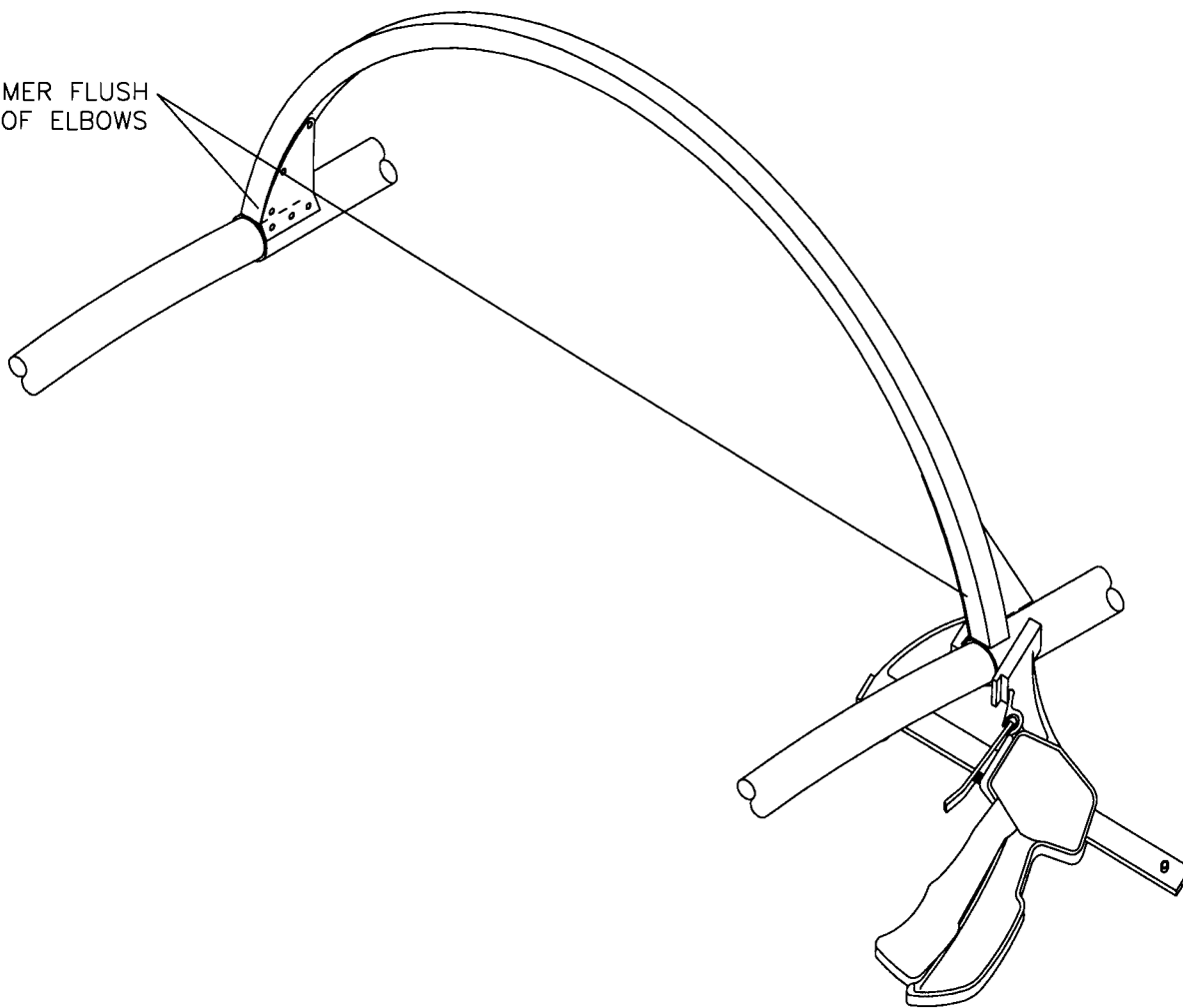
**FIGURE 10A-5**  
**S-18 STINGER II**



MD4132

**FIGURE 10A-6**  
**S-18 STINGER II**

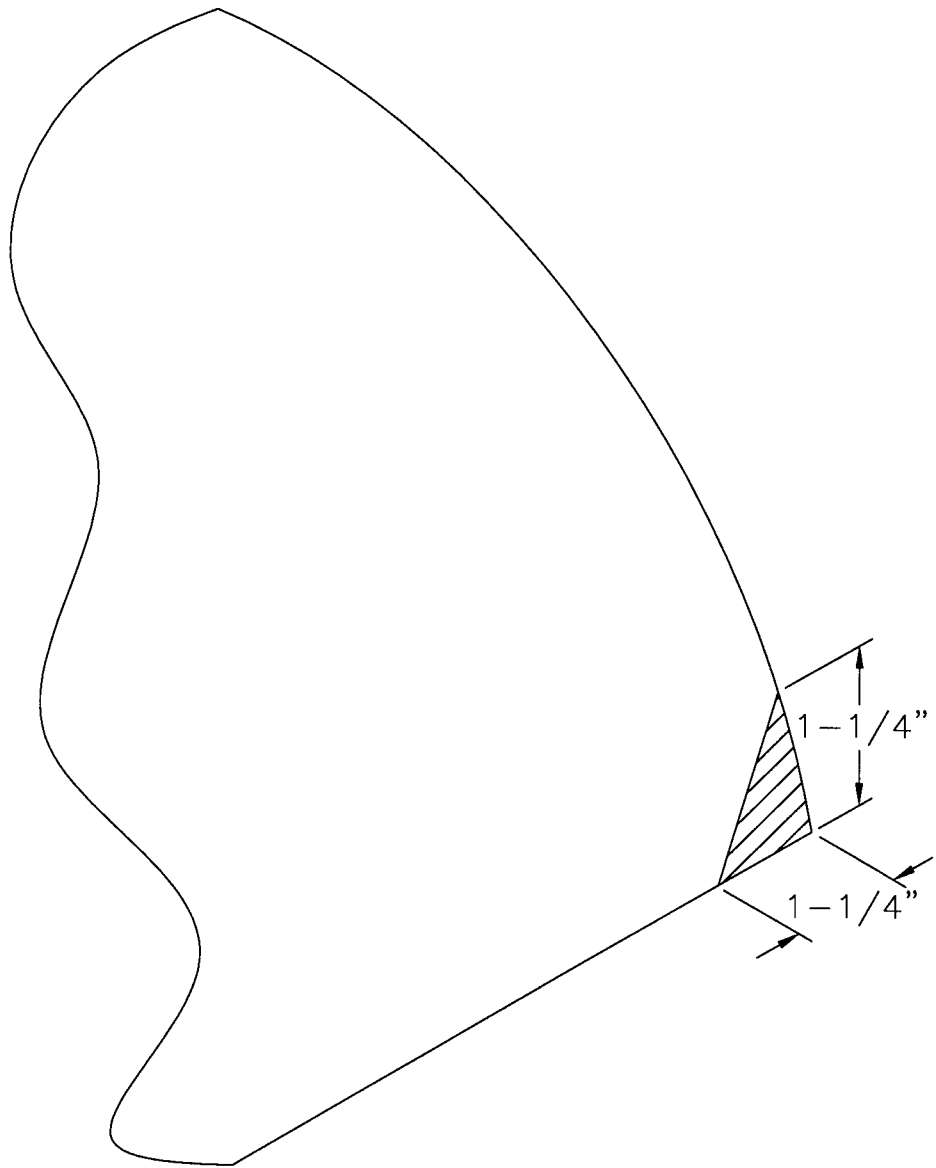
PLACE FORMER FLUSH  
WITH ENDS OF ELBOWS



MD4134

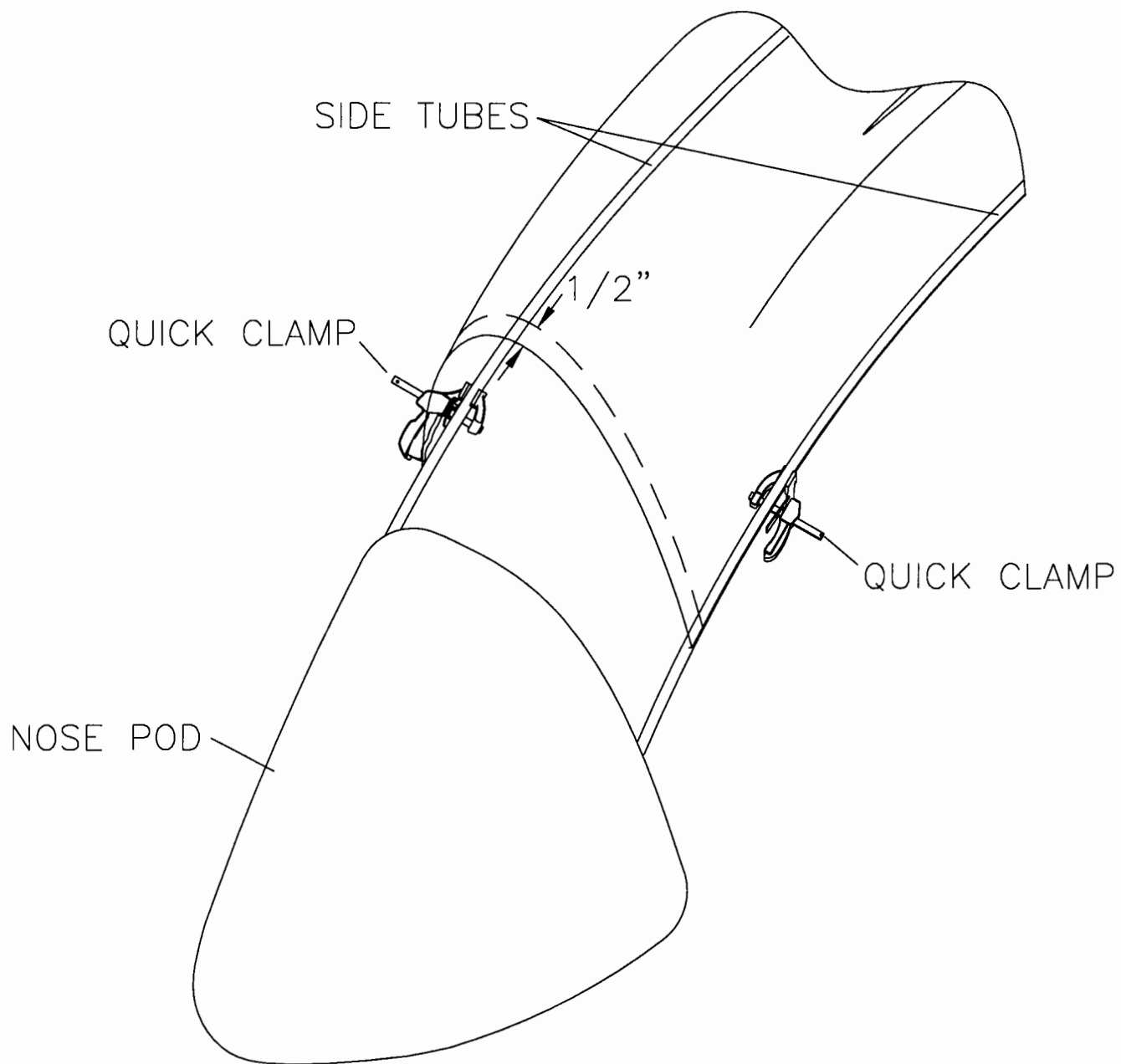
**FIGURE 10A-7**  
**S-18 STINGER II**

07/02/01



MD4135

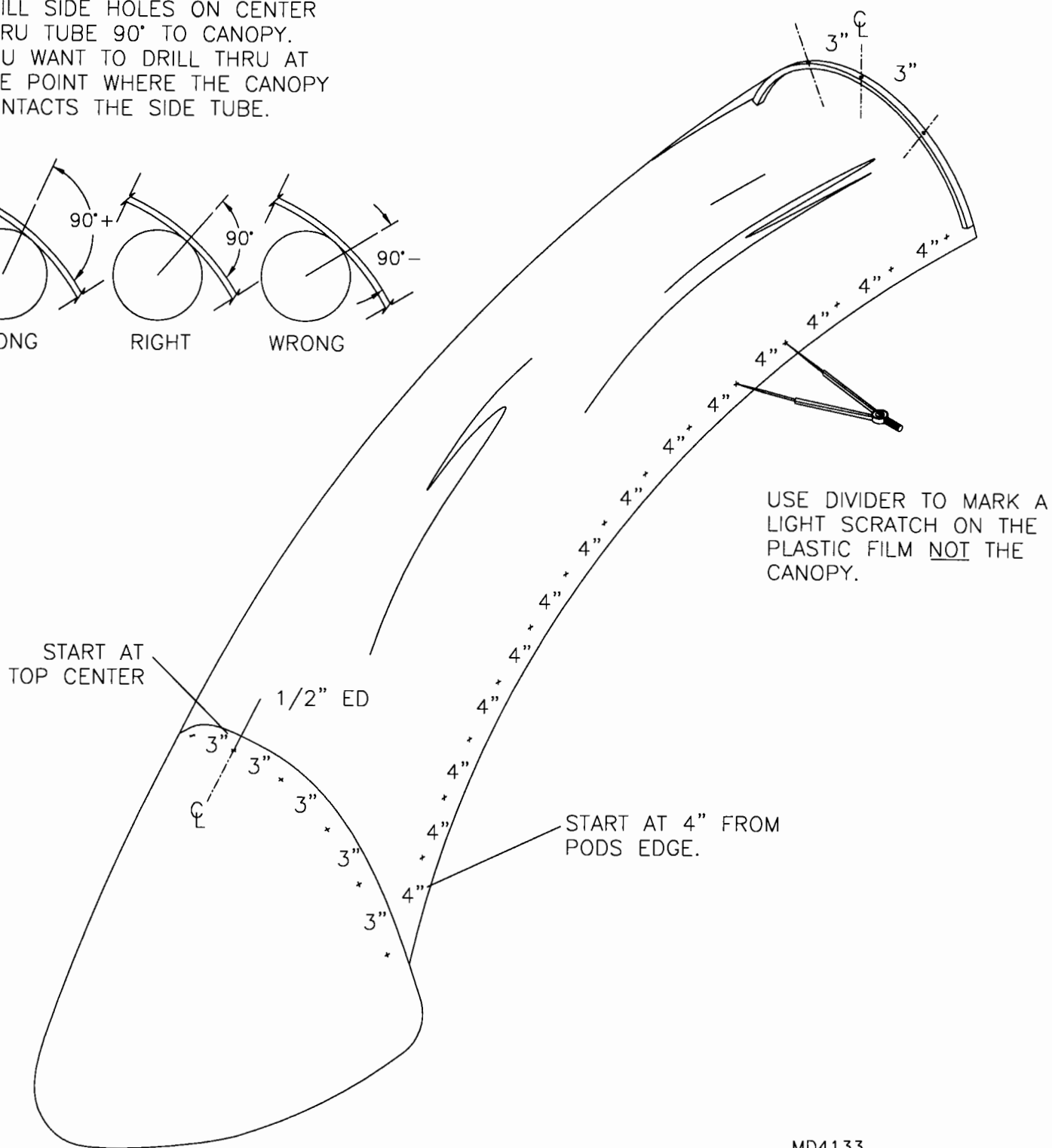
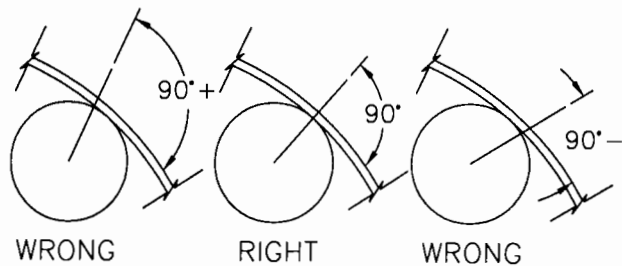
**FIGURE 10A-8  
S-18 STINGER II**



MD4141

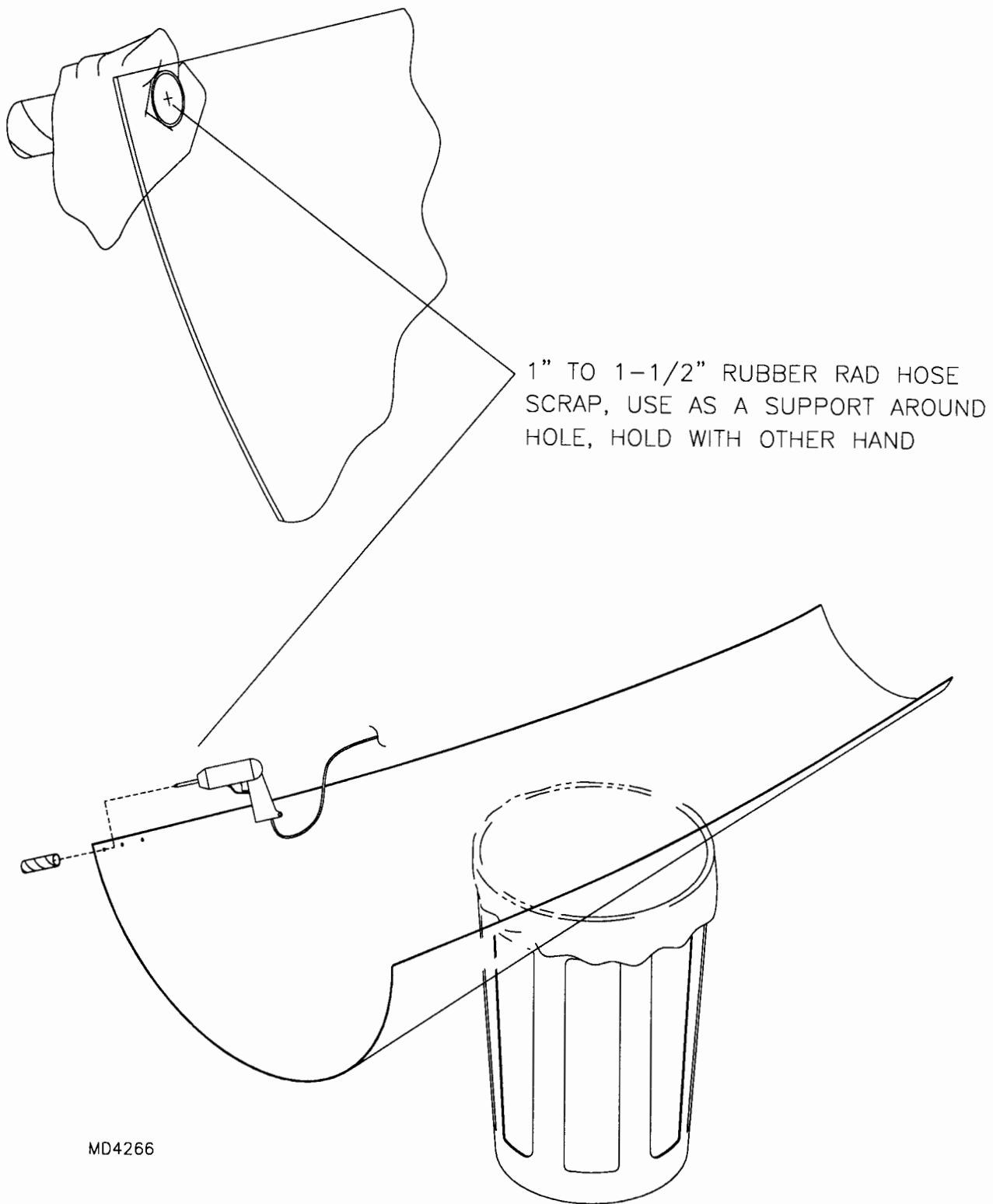
**FIGURE 10A-9  
S-18 STINGER II**

NOTE: ANGLE VARIES AS  
CANOPY CURVES, ALWAYS  
DRILL SIDE HOLES ON CENTER  
THRU TUBE 90° TO CANOPY.  
YOU WANT TO DRILL THRU AT  
THE POINT WHERE THE CANOPY  
CONTACTS THE SIDE TUBE.



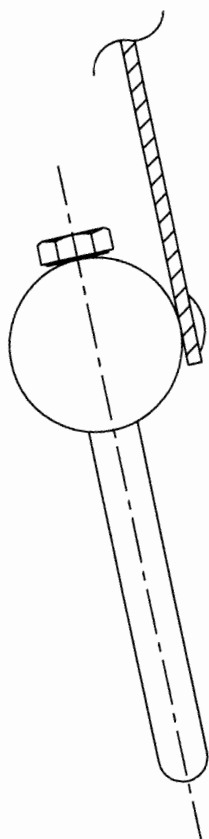
MD4133

FIGURE 10A-10  
S-18 STINGER II

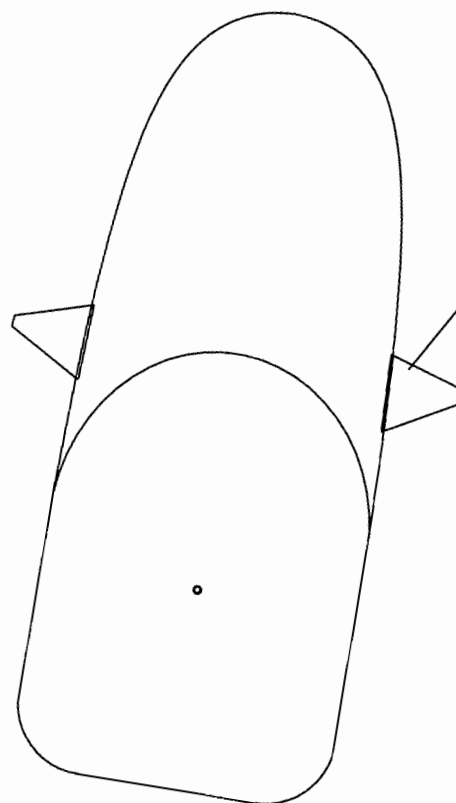


**FIGURE 10A-10A  
S-18 STINGER II**

FRONT VIEW



FRONT VIEW



VORTEX GENERATORS  
POINT DOWN.

LOCATE HANDHOLD BETWEEN  
6TH FASTENER ON R.H. SIDE

TRANSFER DRILL 5/16"  
HOLES INTO VORTEX  
GENERATOR USING  
FASTENERS 4 AND 5  
ON EACH SIDE, AS SHOWN

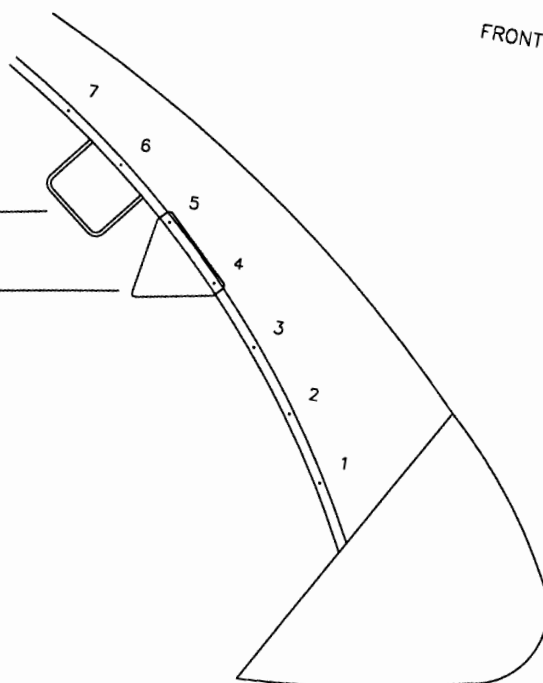
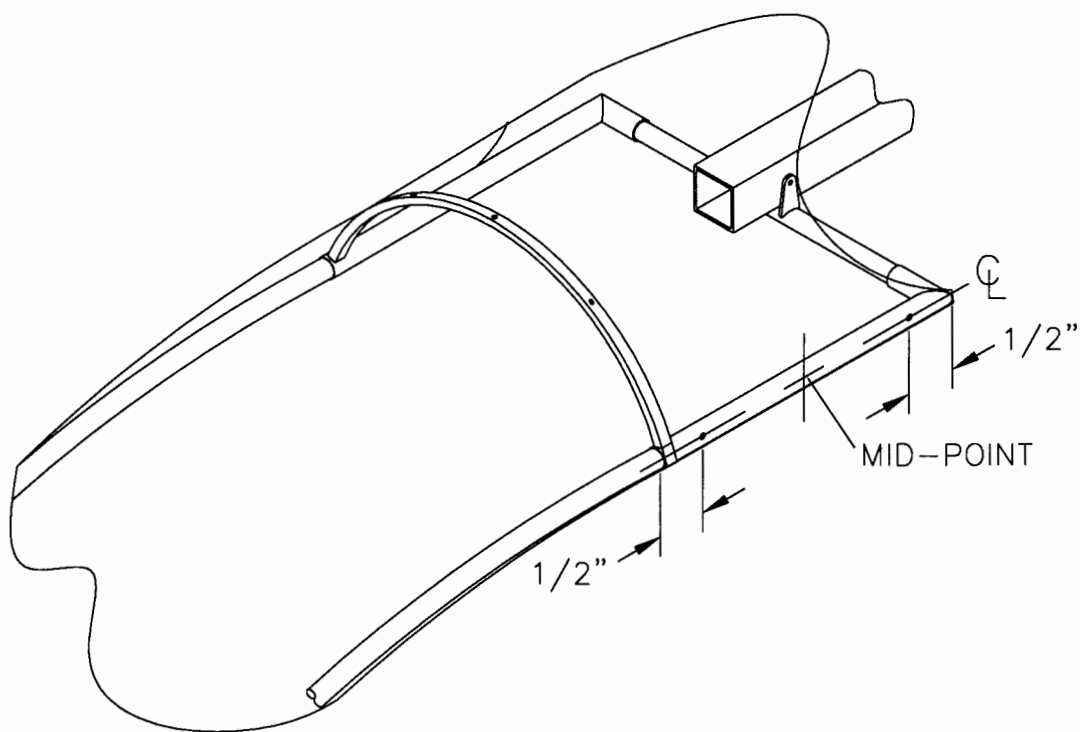


FIGURE 10A-11  
S-18 STINGER II

MD4142

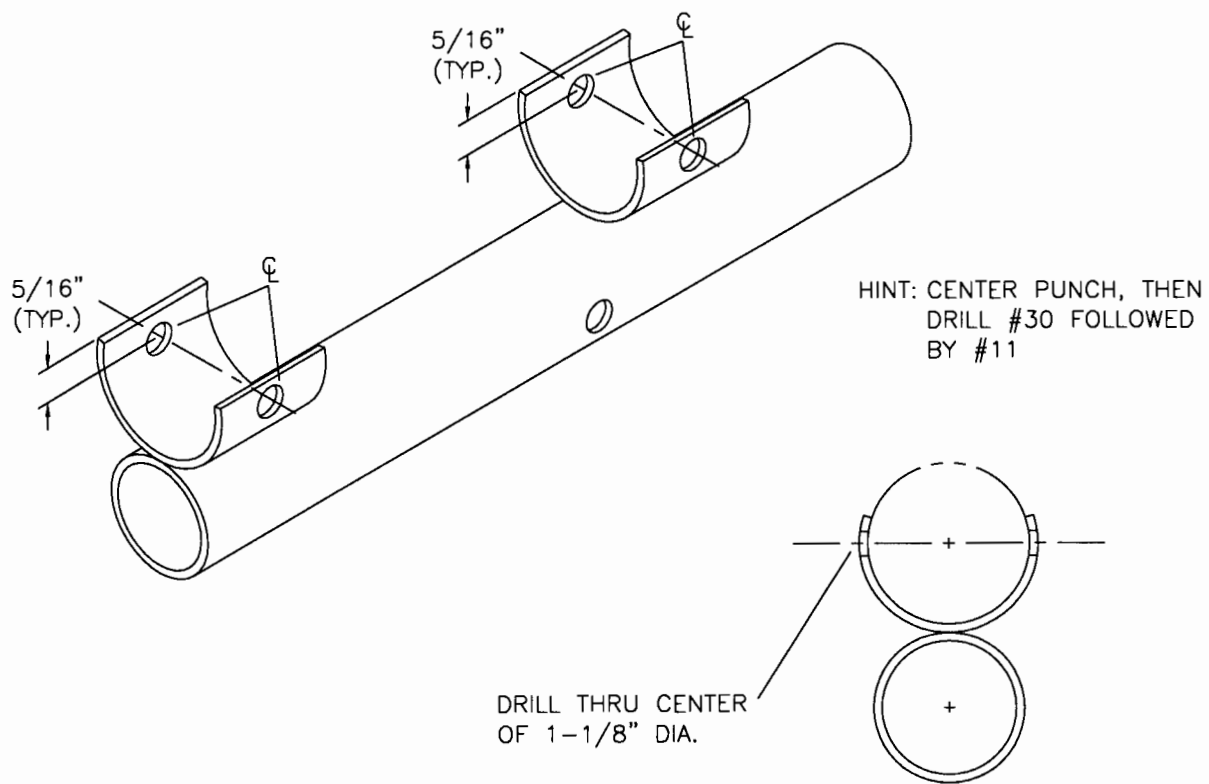
7/02/01

- 1) DRILL 1/8" AND CLECO
- 2) DRILL OUT TO 1/4"
- 3) DRILL UPPER CANOPY ONLY
- 4) DEBURR AND INSTALL USING  
SAME FASTENERS USED ON THE  
LOWER CANOPY



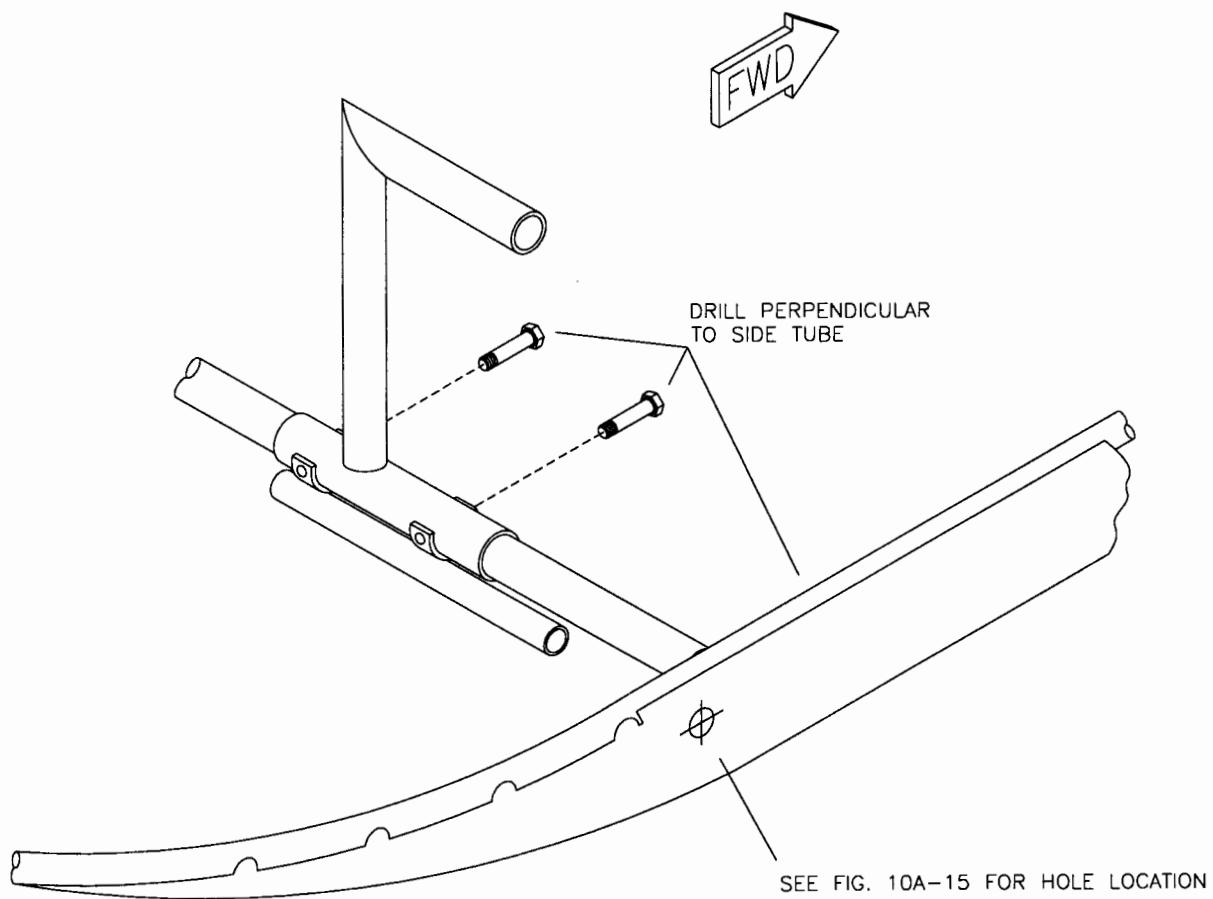
MD4144

**FIGURE 10A-12**  
**S-18 STINGER II**



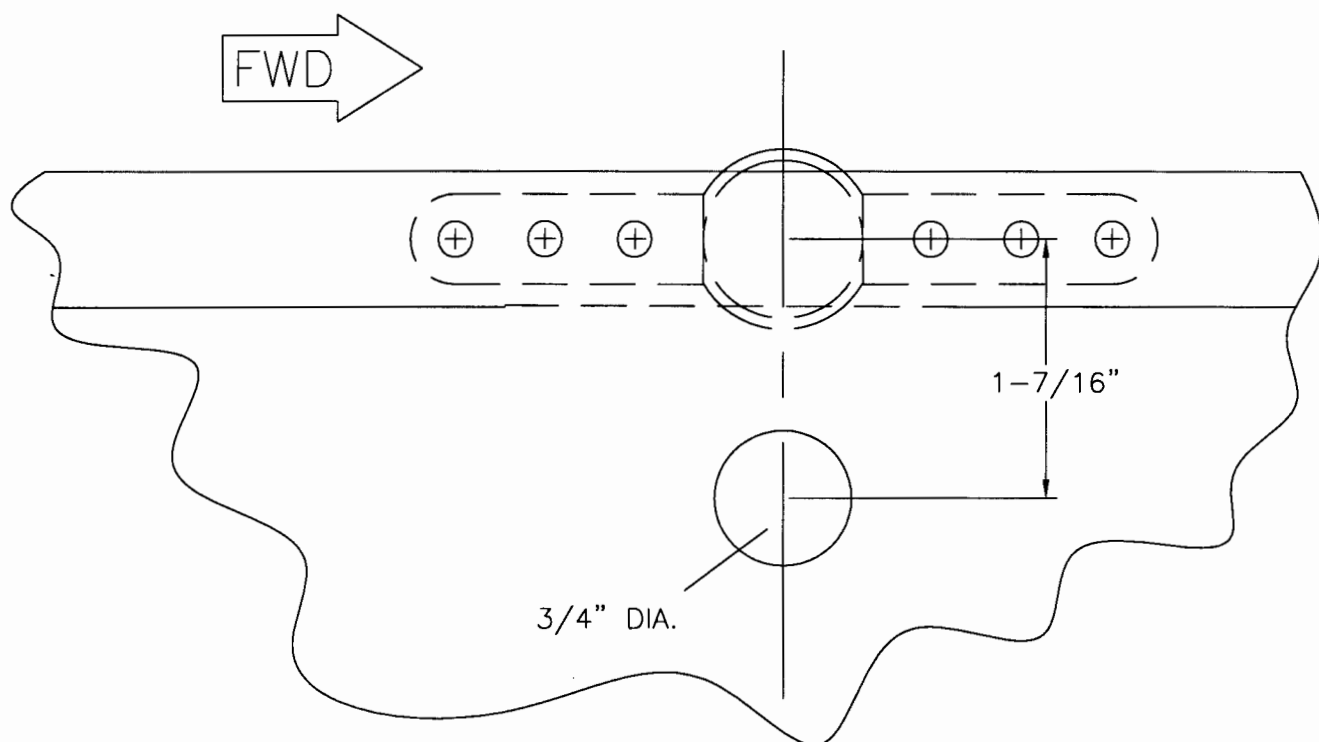
MD4127

**FIGURE 10A-13**  
**S-18 STINGER II**



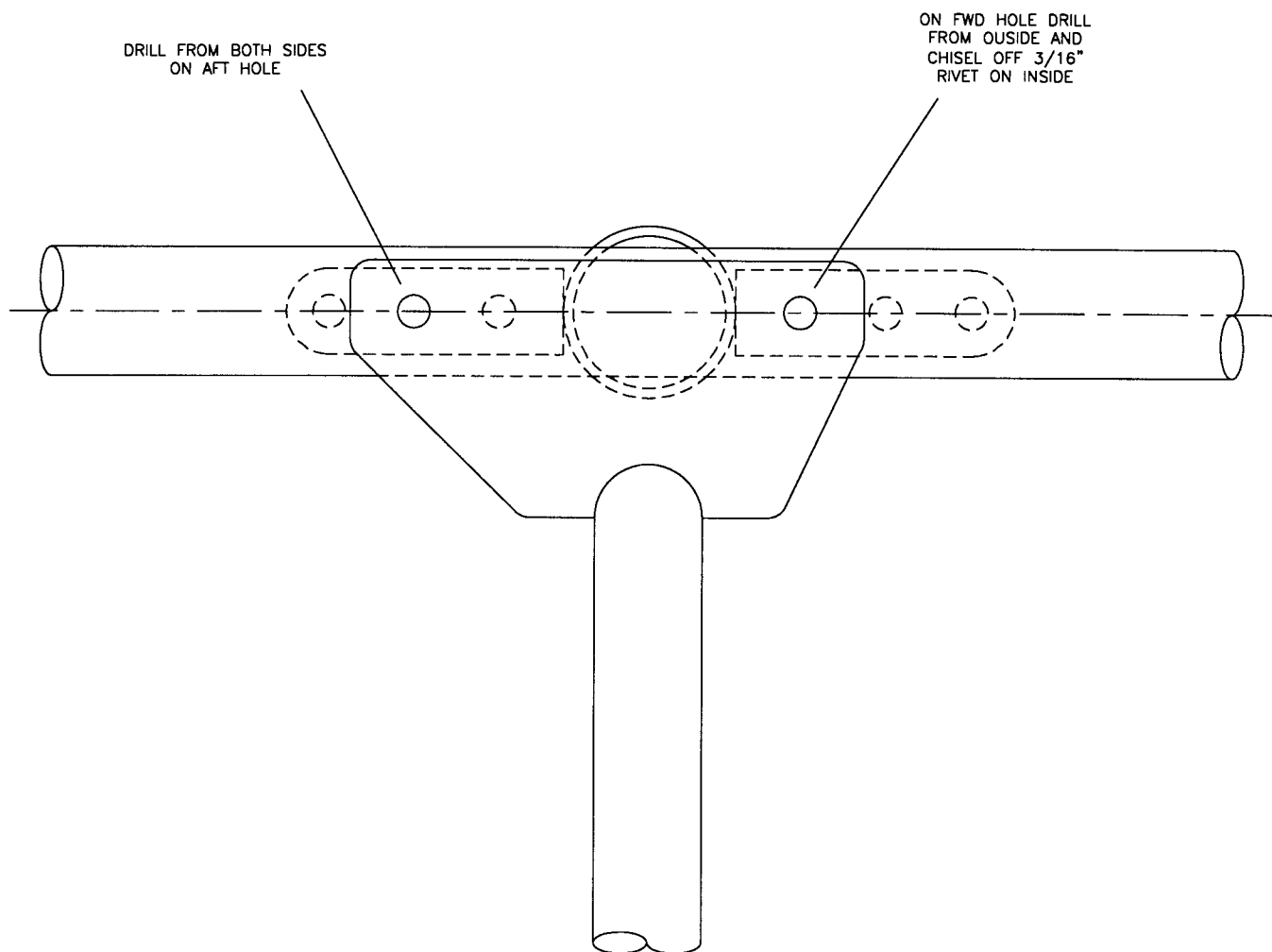
MD4138

FIGURE 10A-14  
S-18 STINGER II



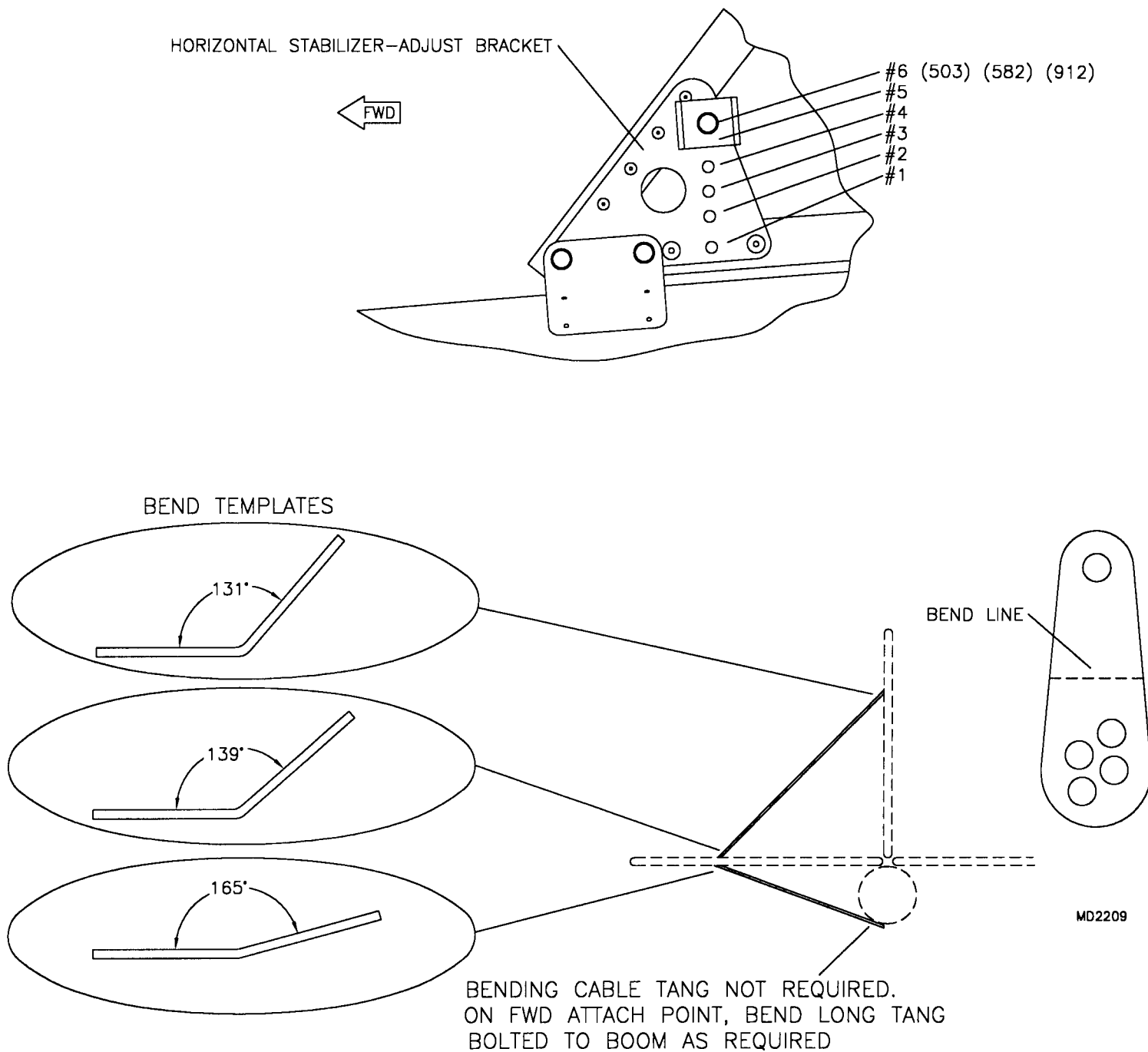
MD4139

**FIGURE 10A-15**  
**S-18 STINGER II**

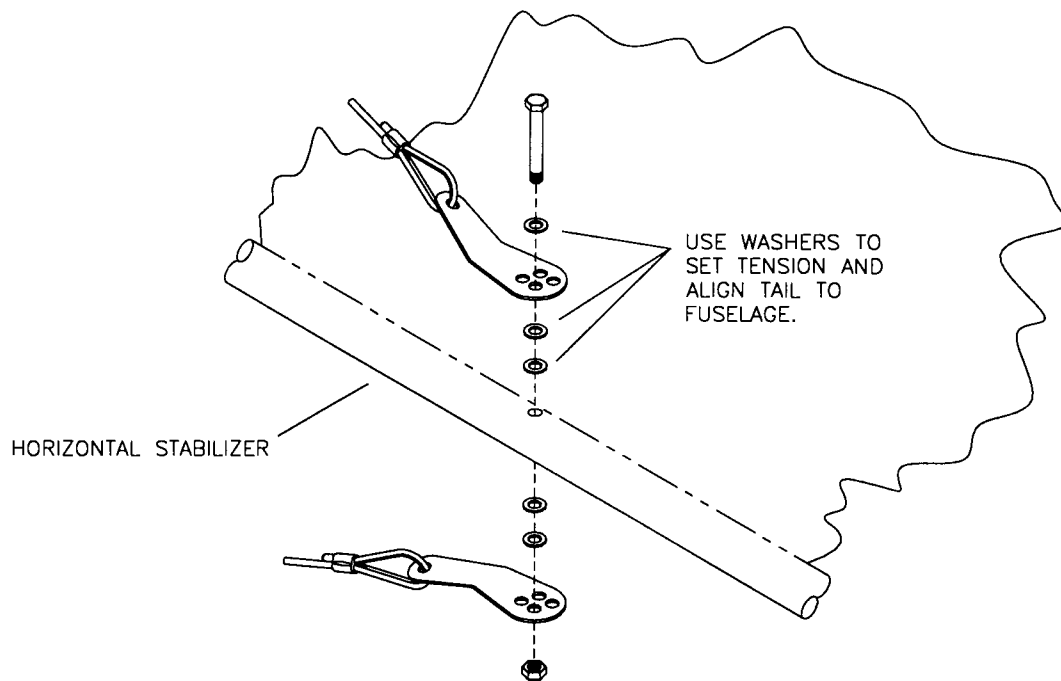
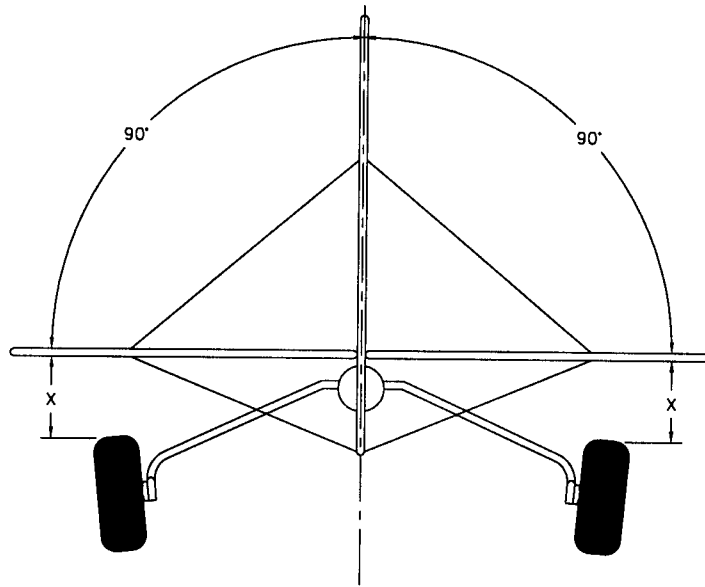


MD4140

FIGURE 10A-16  
S-18 STINGER II

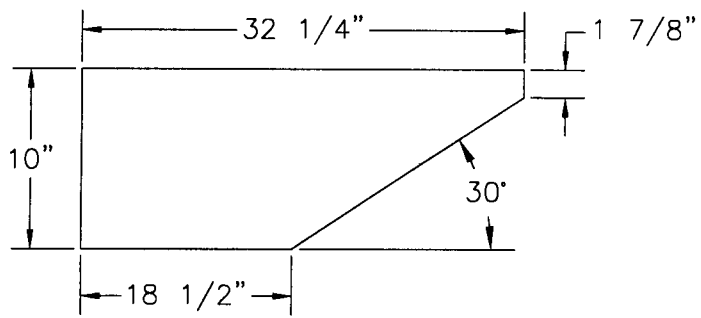


**FIGURE 11-1**  
**S-18 STINGER II**

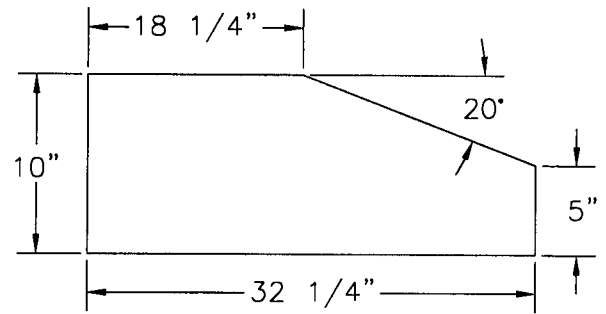


MD4045

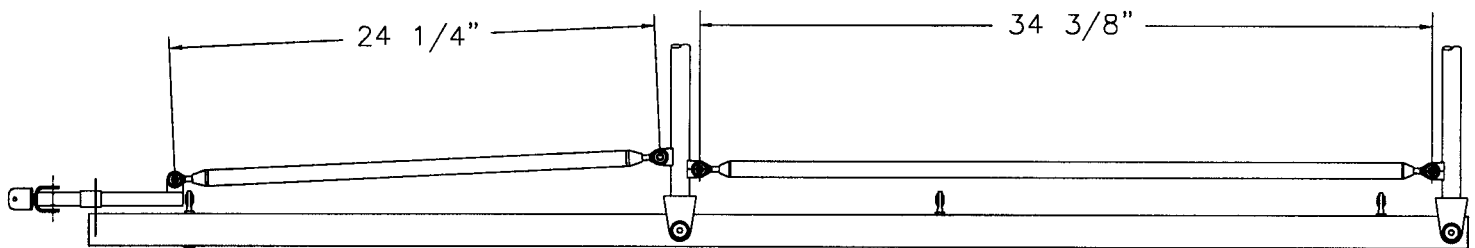
**FIGURE 11-2**  
**S-18 STINGER II**



UP DEFLECTION TEMPLATE



DOWN DEFLECTION TEMPLATE



MD4044

FIGURE 11-3  
S-18 STINGER II

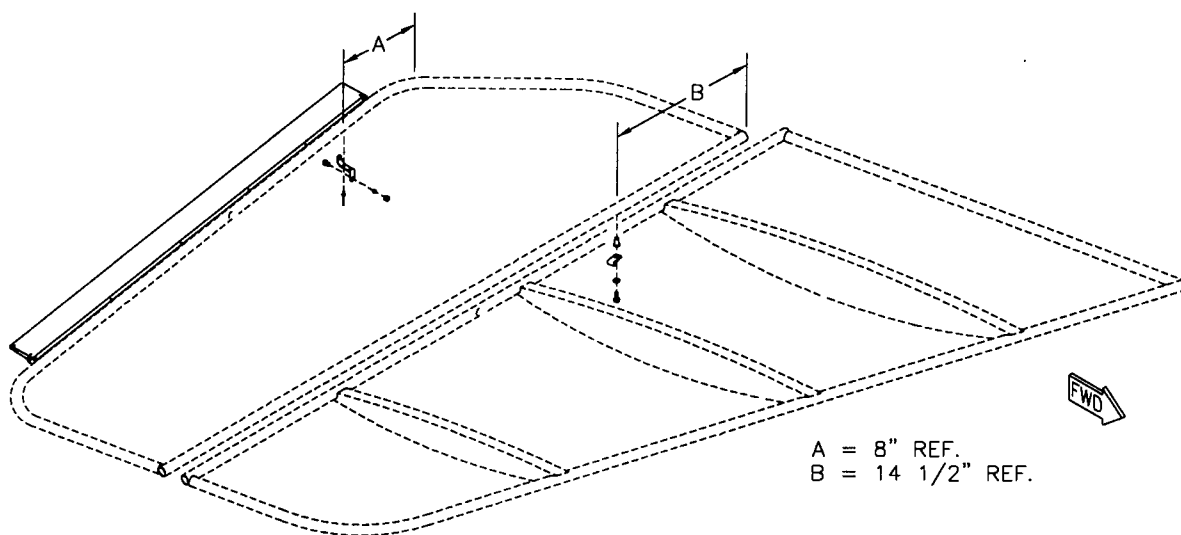
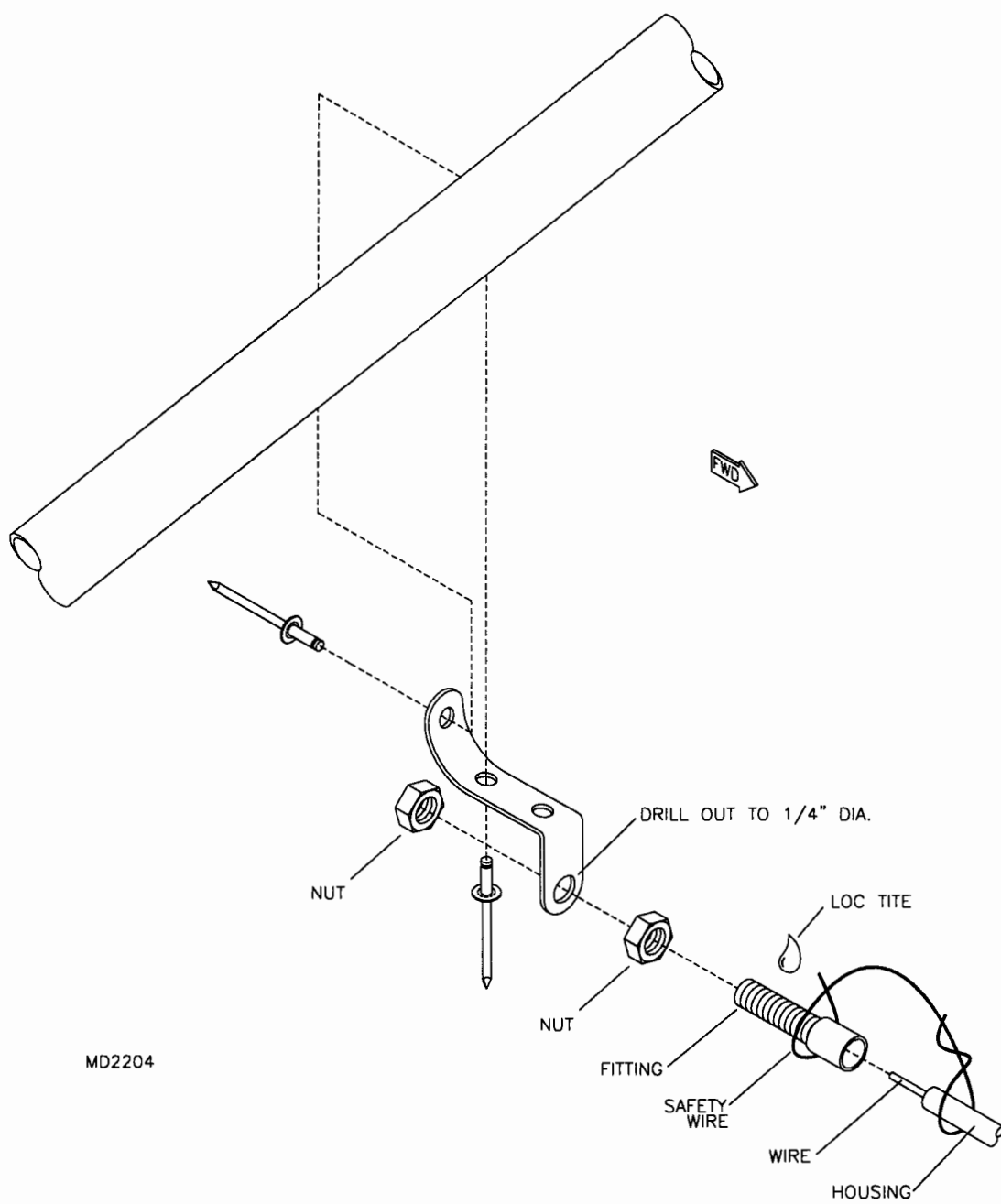
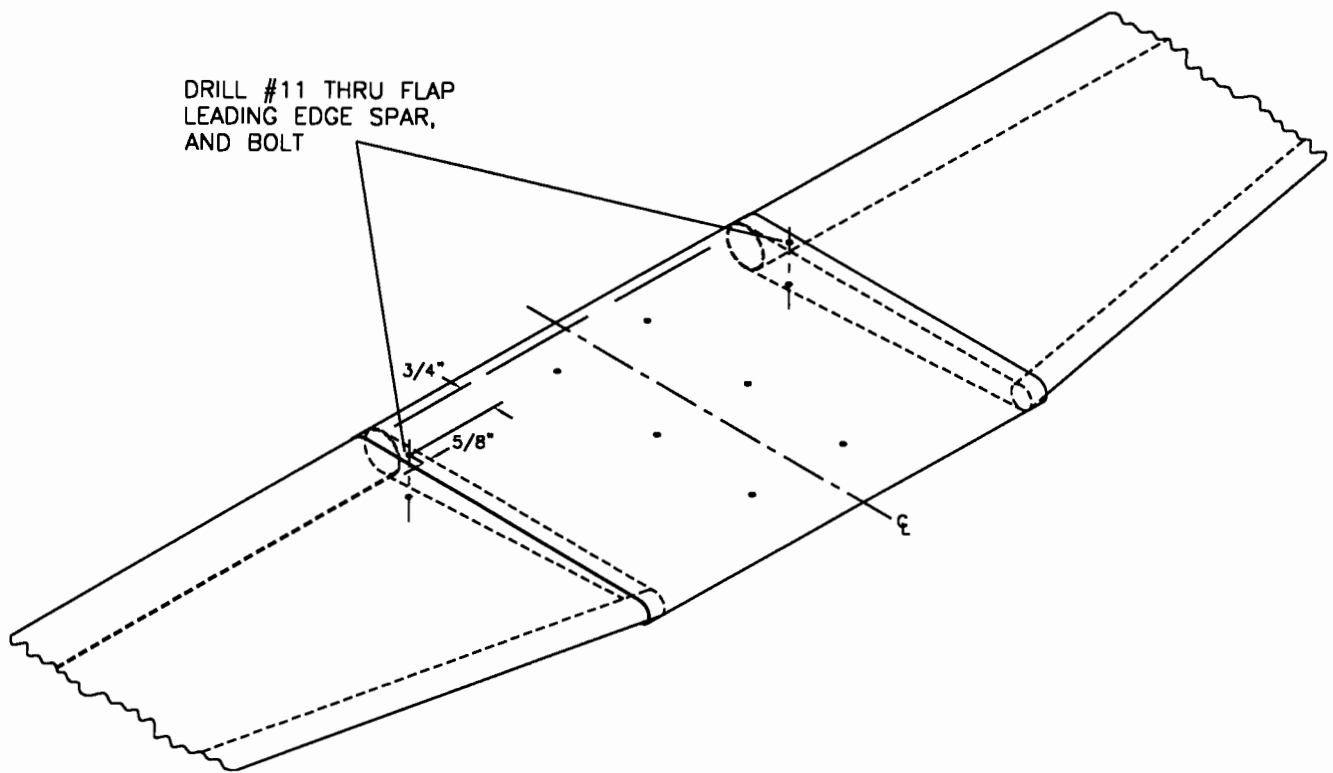
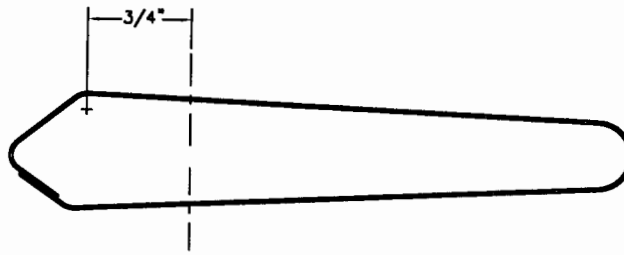


FIGURE 11-4  
S-18 STINGER II

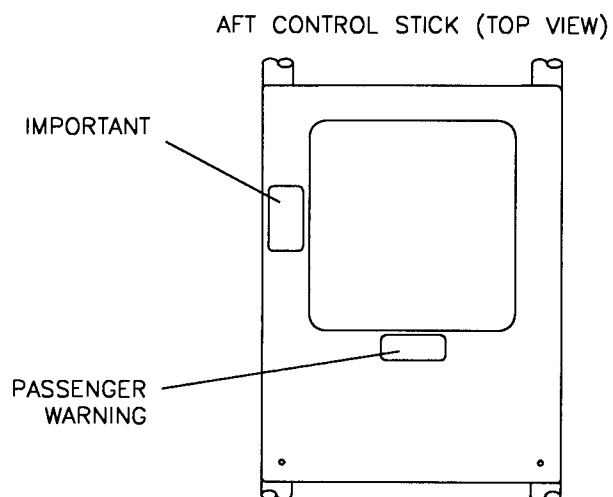
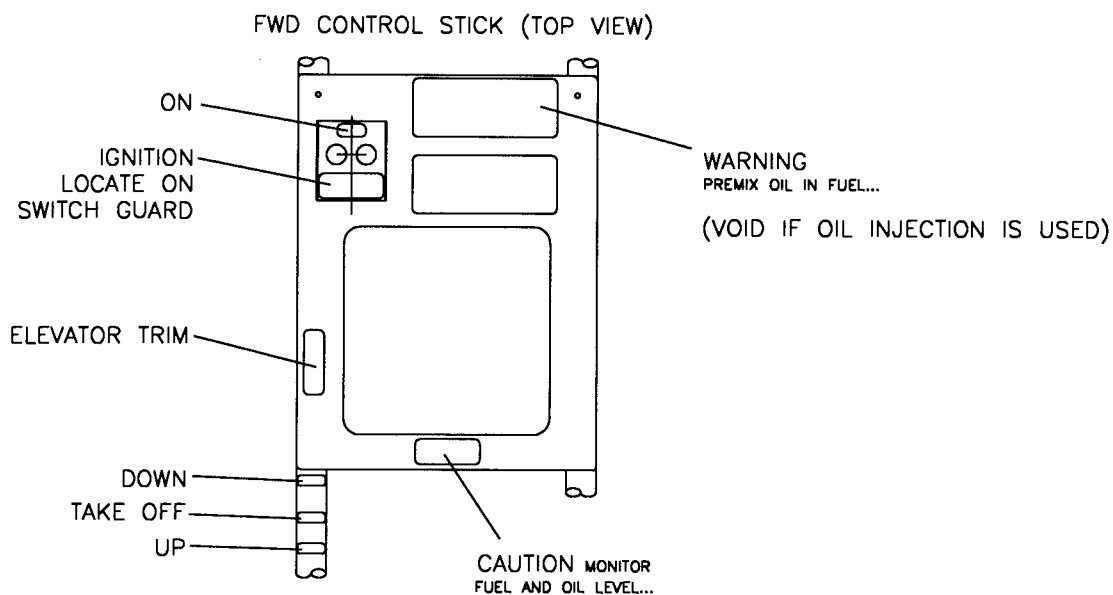
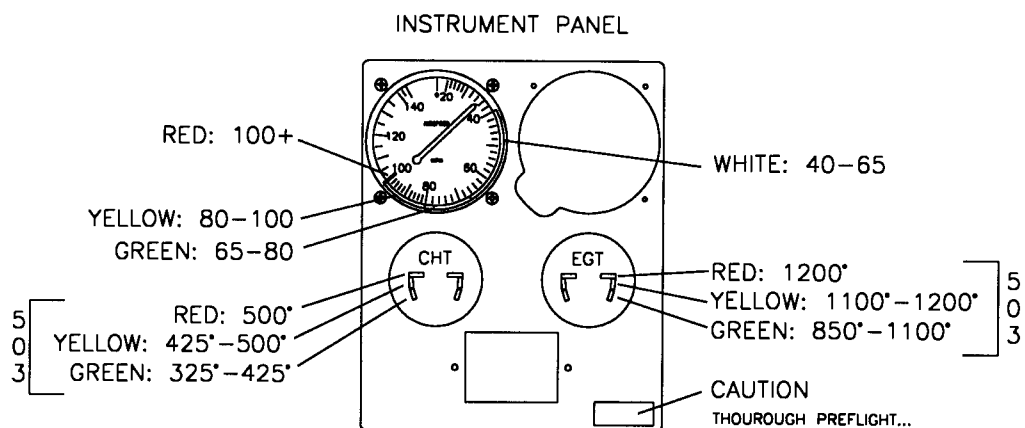


**FIGURE 11-5**  
**S-18 STINGER II**



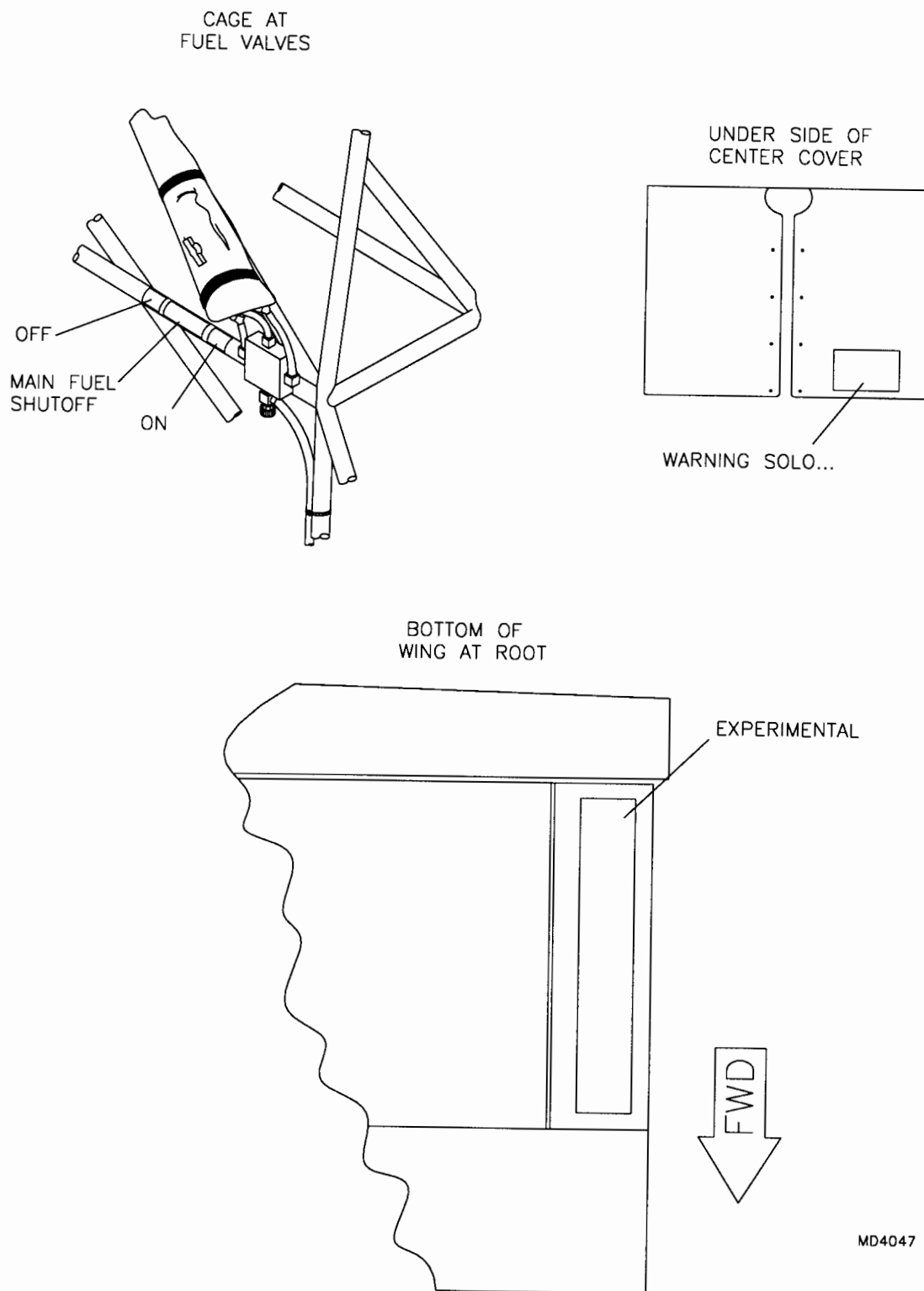
MD4055

FIGURE 11-5A  
S-18 STINGER II



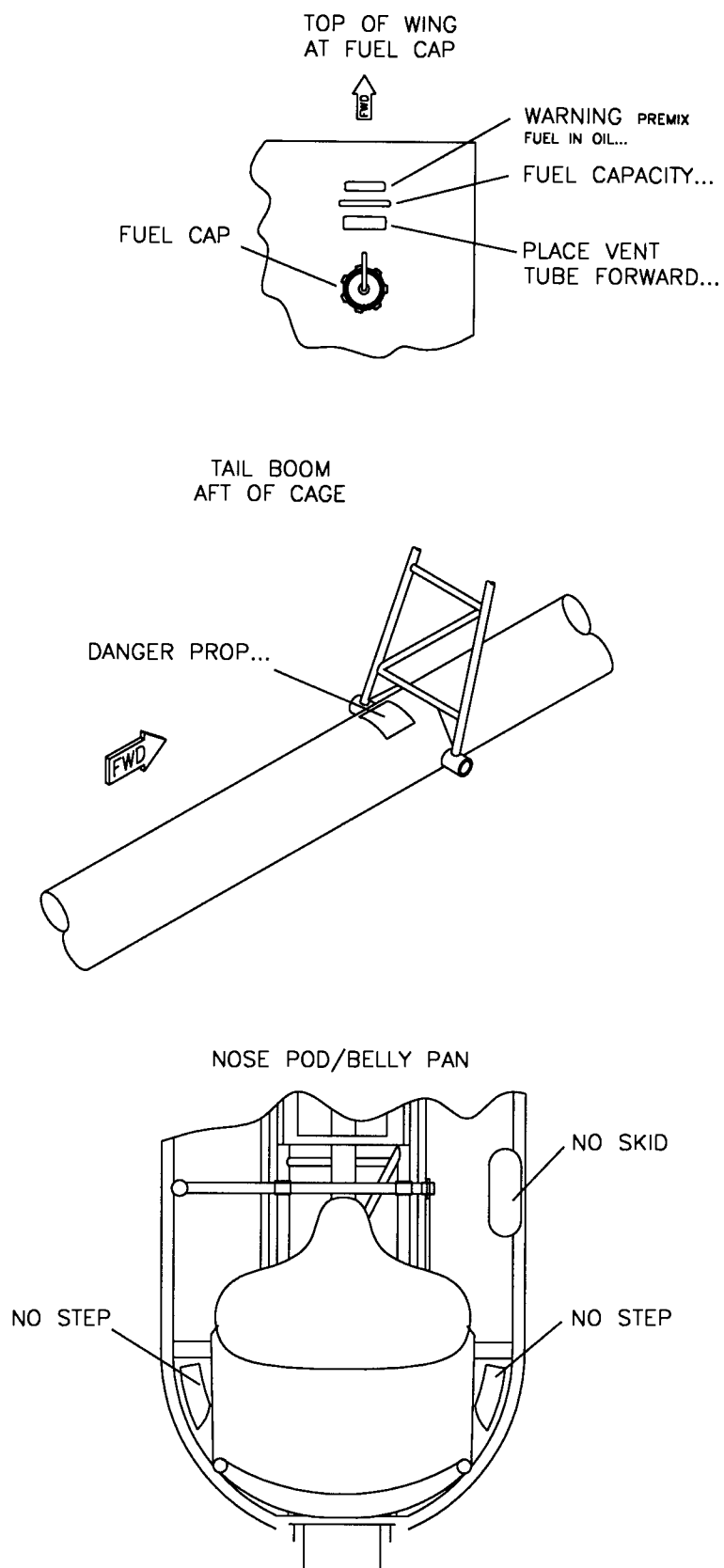
MD4047

FIGURE 11-6  
S-18 STINGER II



MD4047

**FIGURE 11-7**  
**S-18 STINGER II**



MD4047

FIGURE 11-8  
S-18 STINGER II

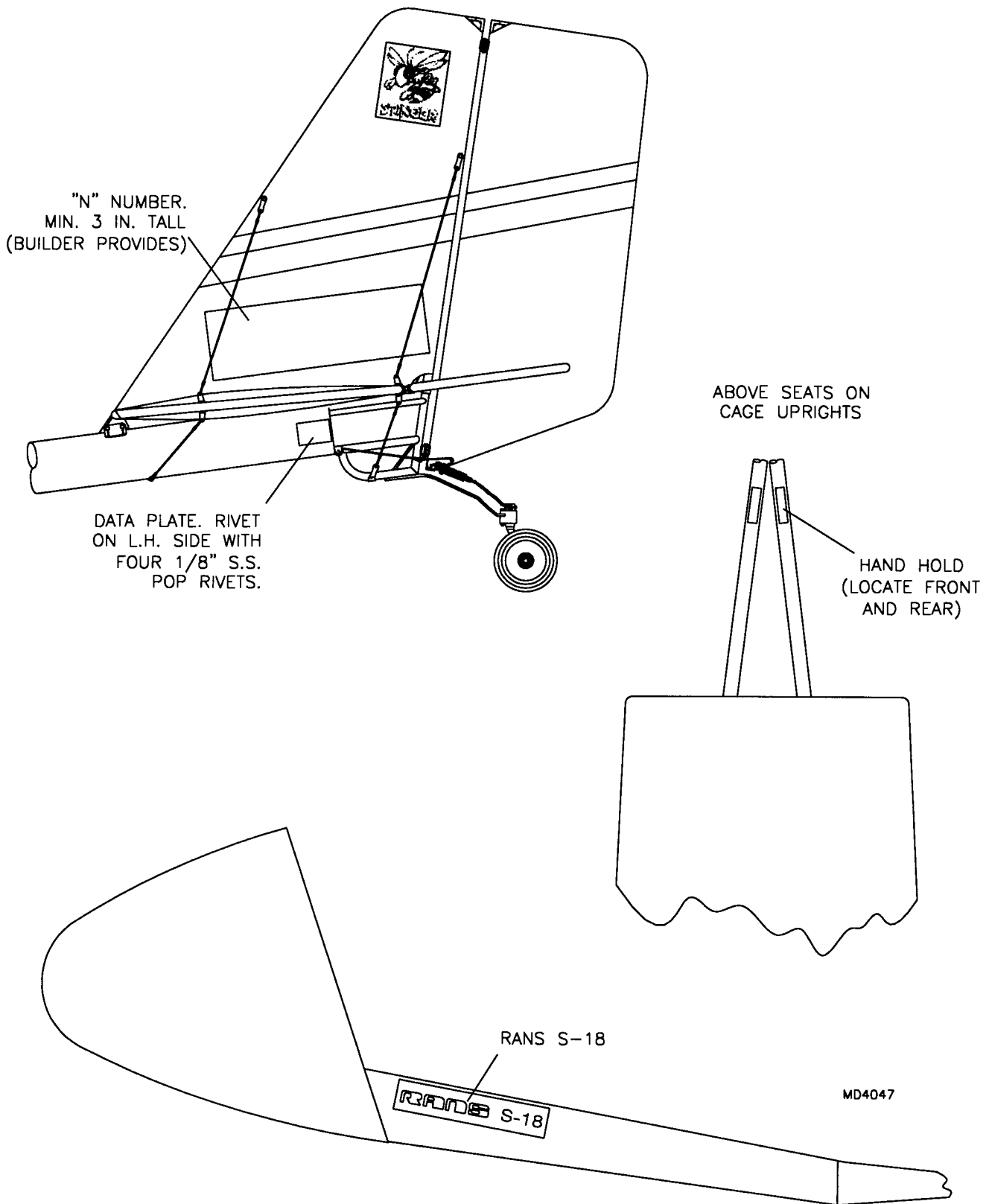
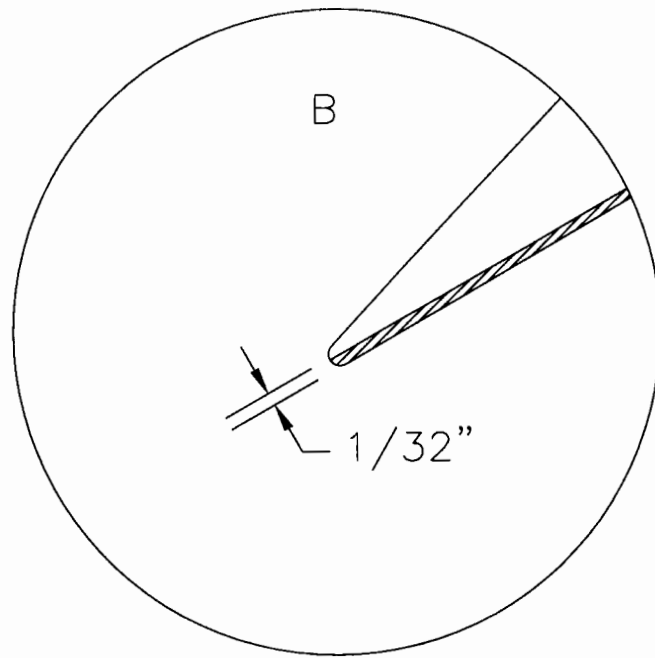
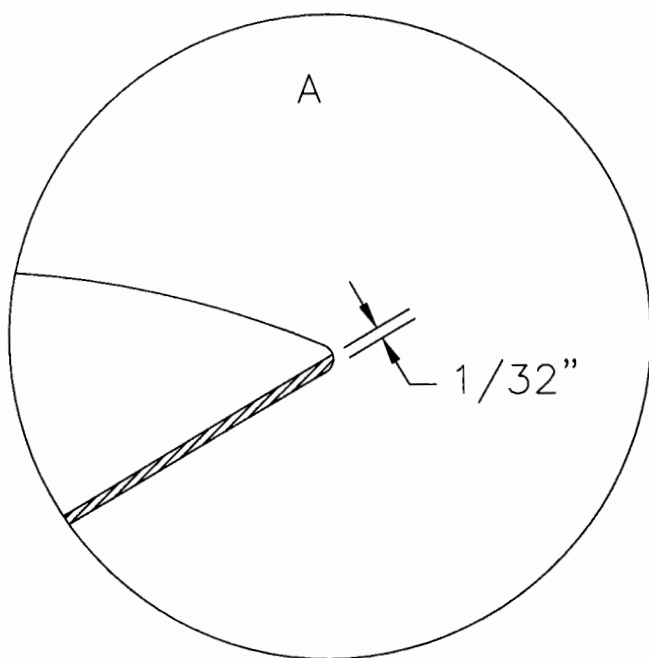
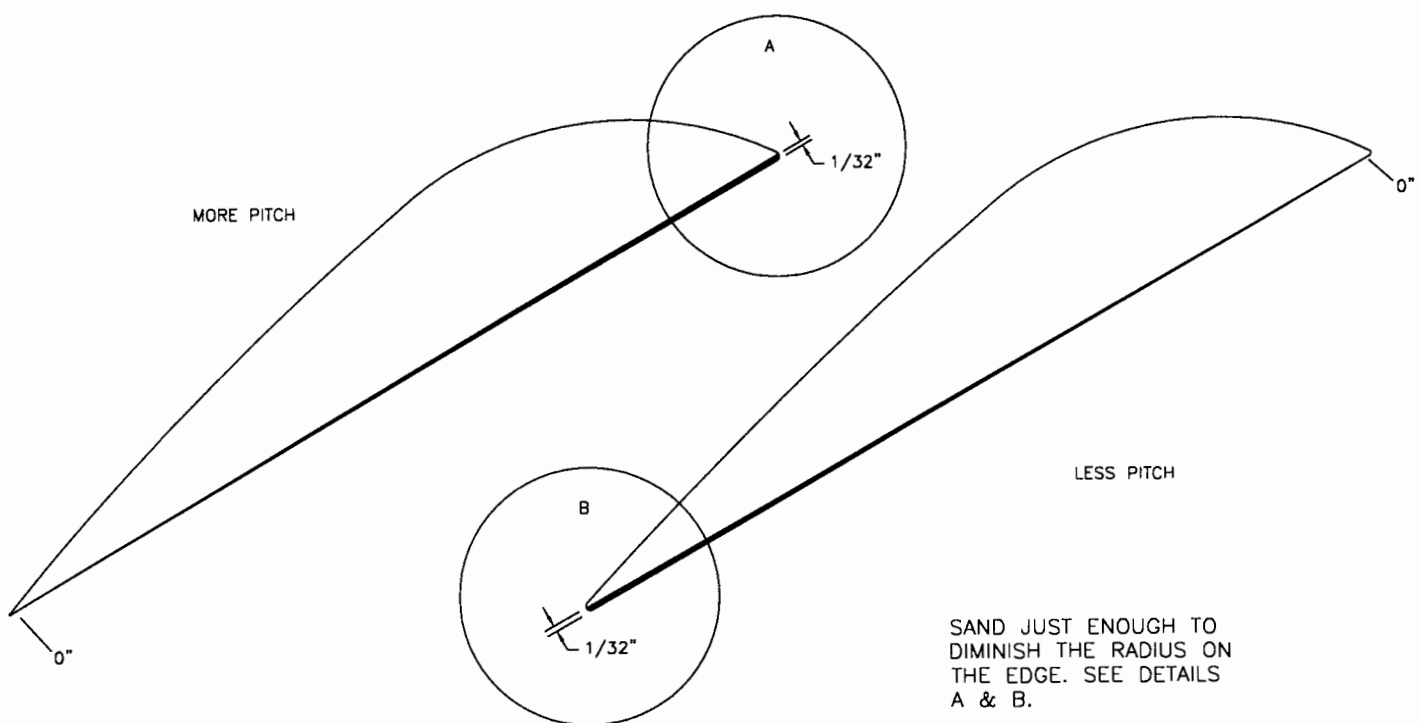
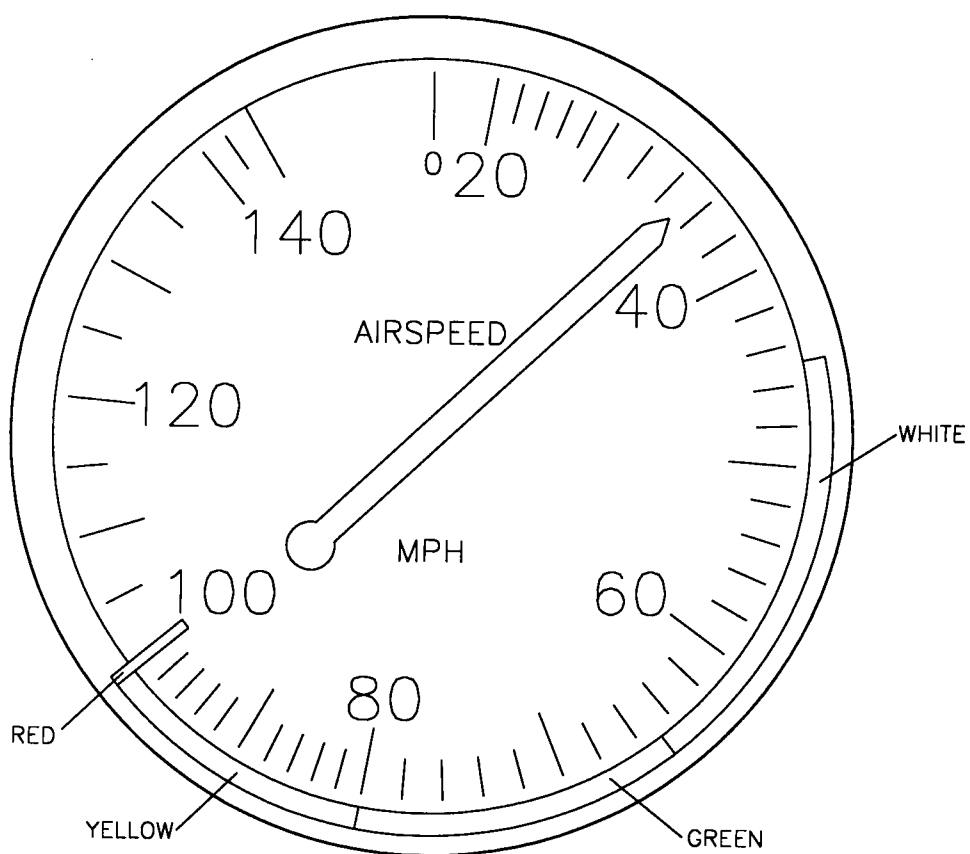


FIGURE 11-9  
S-18 STINGER II



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FIGURE 12-1  
S-18 STINGER II



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FIGURE 12-2  
S-18 STINGER II