

Step 1: Final-Drill #30 the holes in the VA-195A Mount Plate and VA-195B Keeper Plate that are used to mount the ES E22-50K Micro Switch. Machine countersink both holes of the mount plates inboard side for the flush head of a #4 screw. See Figure 1.

Step 2: Final-Drill #19 the hole in the VA-195A Mount Plate and VA-195B Keeper Plate that holds the #8 screw on which the VA-196 Stall Warning Vane pivots. Machine countersink this hole in the mount plate on the inboard side for the flush head of a #8 screw. See Figure 1.

Step 3: Deburr all holes and edges.

Step 4: Assemble the Stall Warning Subassembly as shown in Figure 1. Do not over-torque the nut on the screw about which the VA-196 Stall Warning Vane pivots. Insure that the stall warning vane can rotate freely.

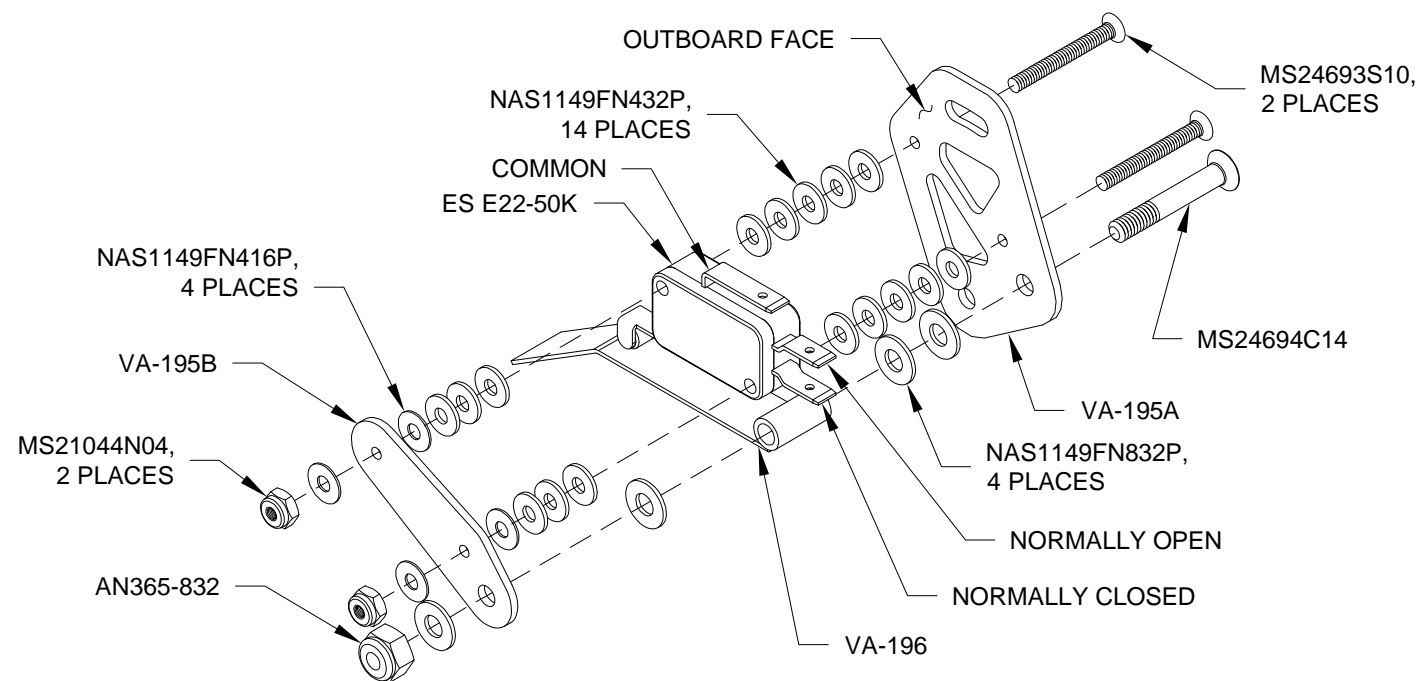


FIGURE 1: STALL WARNING SUBASSEMBLY

Step 5: Take the W-1205-L and W-1205-R Terminal Brackets and remove the bending tabs as shown in figure 2. Deburr all holes and edges.

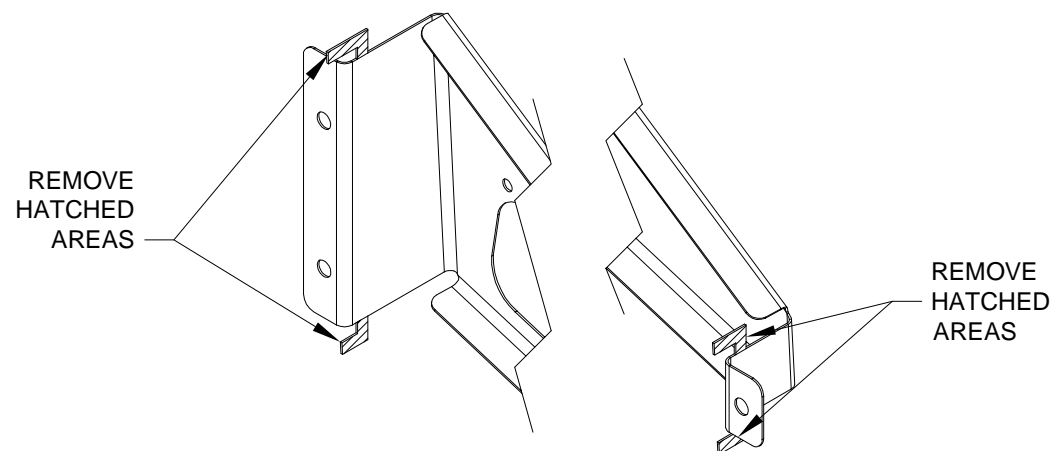


FIGURE 2: MODIFYING THE TERMINAL BRACKET

Step 6: Clamp the PS UHMW .125X2X2 1/4 to the W-1205B/F-1270C Guide UHMW Drill Template, match-drill #40 all holes, clecoes may be added to keep part from turning. Final-Drill to create the W-1205B Terminal Block as shown in Figure 3. Repeat for second terminal block. Save the UHMW drill template for use in creating the F-1270C Terminal Blocks as shown in Section 31 of the builder's manual.

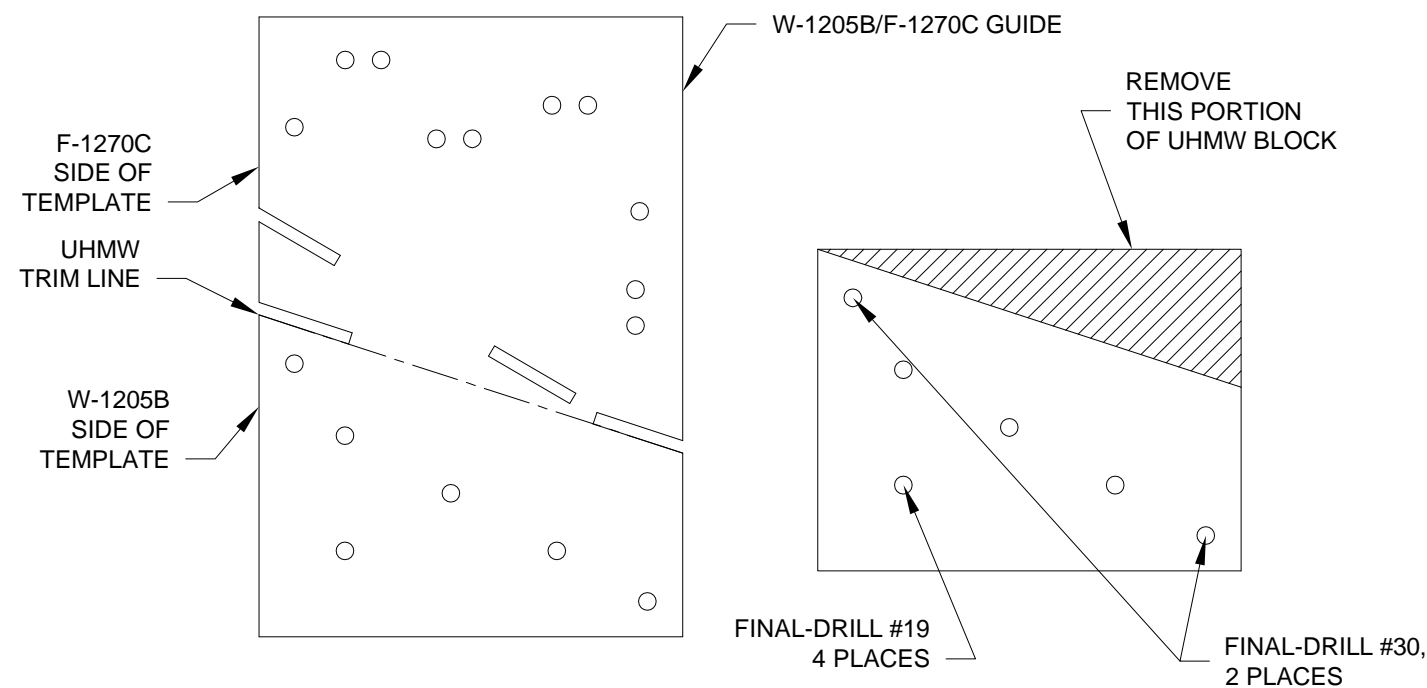


FIGURE 3: DRILLING THE TERMINAL BLOCK

Step 7: Place the W-1205B Terminal Block on the outboard side of the W-1205-L Terminal Bracket and rivet as shown in Figure 4. Repeat process for W-1205-R Terminal bracket.

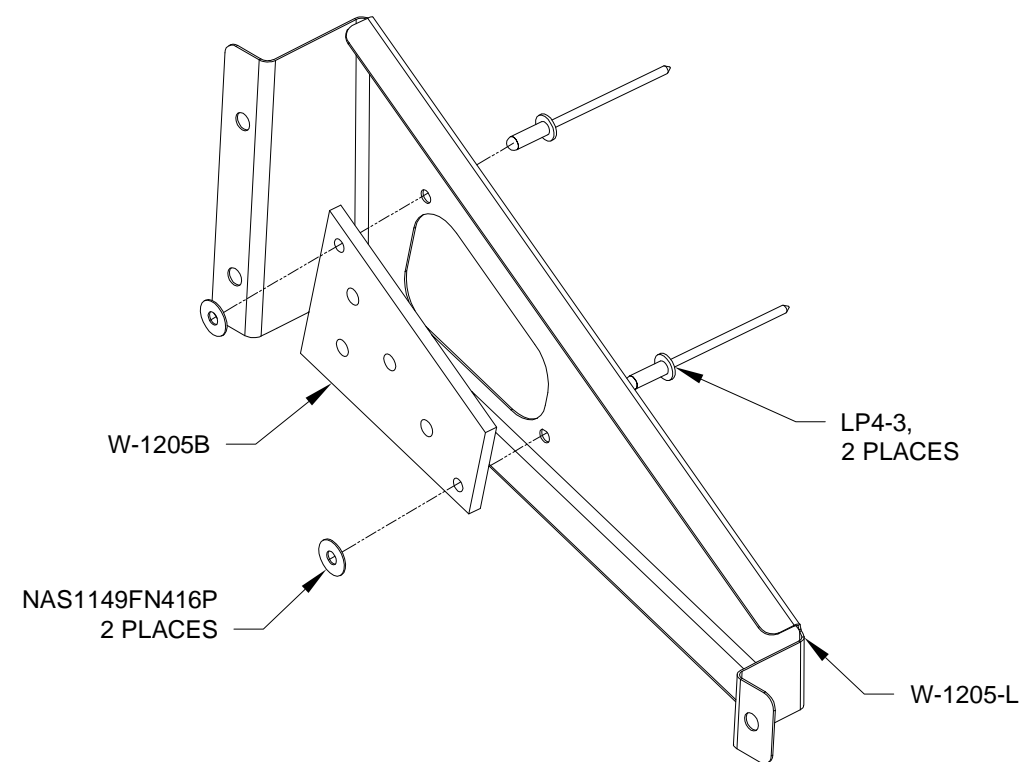


FIGURE 4: TERMINAL BRACKET ASSEMBLY