

MODELS

EFFECTIVITY

KIT NO.

PA-23-235	27-505 THRU 27-622	652-579
PA-23-250	27-1 THRU 27-504	652-579
PA-23-250 (6)	27-2000 THRU 27-8154030	652-579
PA-E23-250	27-2505 THRU 27-4916 & 27-7304917 THRU 27-7554168	652-579
PA-24-180	24-1 THRU 24-3641, 24-3643 THRU 24-3687	652-580
PA-24-250	24-103 THRU 24-3641, 24-3643 THRU 24-3687	652-580
PA-24-260	24-3642, 24-4000 THRU 24-5034	652-580
PA-24-400	26-2 THRU 26-148	652-581
PA-30	30-2 THRU 30-2000	652-582
PA-39	39-1 THRU 39-162	652-583

←				DRAFTSMAN	T.CHYTIL	03-11-05
	A	REV		DESIGN ENGINEER	T.CHYTIL	03-11-05
	BJ	BY		CHECKER		
	4-12-06	DATE		PROGRAM MANAGER	K.FRALEY	03-11-05
		APPD		METHODS		
	B	REV		SCALE	NONE	LAST SECTION OR C LAST VIEW
	AEC	BY		CAL. WT.	ARM	ACT. WT. WT MOM
	2-18-10	DATE				
		APPD				

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THE NEW PIPER AIRCRAFT INC.
VERO BEACH, FLORIDA

DOA	
MANUFACTURING	
MATERIALS	

TITLE

KIT - TORQUE TUBE
REPLACEMENT

KIT NO: 652-579, 652-580, 652-581,
652-582, 652-583.

SHT. 1	DWG NO.	88372	B
OF 10			

652-582 KIT PARTS LIST:			
REF	DINITROL AV8 OR CRC PROTECTOR 100 RUST INHIBITOR - LOCAL PURCHASE		
1	25034-002	PIN (TOOL)	
1	25034-000	PIN (TOOL)	
1	22655-007	TORQUE TUBE ASSY	
<input checked="" type="checkbox"/>	-005	KIT (652-582)	
-005 QTY	PART NO.	PART NAME	DESCRIPTION
652-581 KIT PARTS LIST:			
REF	DINITROL AV8 OR CRC PROTECTOR 100 RUST INHIBITOR - LOCAL PURCHASE		
1	25034-002	PIN (TOOL)	
1	25034-000	PIN (TOOL)	
1	22655-012	TORQUE TUBE ASSY	
<input checked="" type="checkbox"/>	-004	KIT (652-581)	
-004 QTY	PART NO.	PART NAME	DESCRIPTION
652-580 KIT PARTS LIST:			
REF	DINITROL AV8 OR CRC PROTECTOR 100 RUST INHIBITOR - LOCAL PURCHASE		
1	25034-002	PIN (TOOL)	
1	25034-000	PIN (TOOL)	
1	20203-006	TORQUE TUBE ASSY	
<input checked="" type="checkbox"/>	-003	KIT (652-580)	
-003 QTY	PART NO.	PART NAME	DESCRIPTION
652-579 KIT PARTS LIST:			
REF	DINITROL AV8 OR CRC PROTECTOR 100 RUST INHIBITOR - LOCAL PURCHASE		
1	25034-002	PIN (TOOL)	
1	25034-000	PIN (TOOL)	
1	16067-003	TORQUE TUBE ASSY	
<input checked="" type="checkbox"/>	-002	KIT (652-579)	
-002 QTY	PART NO.	PART NAME	DESCRIPTION
THE NEW PIPER AIRCRAFT INC. VERO BEACH, FLORIDA		TITLE KIT - TORQUE TUBE REPLACEMENT	
KIT NO:	652-579, 652-580, 652-581, 652-582, 652-583	SHT. 2	DWG NO. 88372
			B

652-583 KIT PARTS LIST:			
REF	DINITROL AV8 OR CRC PROTECTOR 100 RUST INHIBITOR - LOCAL PURCHASE		
1	25034-002	PIN (TOOL)	
1	25034-000	PIN (TOOL)	
1	27183-003	TORQUE TUBE ASSY	
<input checked="" type="checkbox"/>	-006	KIT (652-583)	
-006 QTY	PART NO.	PART NAME	DESCRIPTION

NOTES:

1. THIS KIT PROVIDES PARTS AND INFORMATION FOR FIELD REPLACEMENT OF THE STABILATOR TORQUE TUBE ON THE MODELS LISTED ON SHEET 1 OF THIS KIT.

IT IS RECOMMENDED THAT THE AIRCRAFT SERVICE MANUAL BE REVIEWED FOR INSTRUCTIONS ON REMOVAL AND REINSTALLATION OF CONTROL CABLES, STABILATOR, AND STABILATOR TORQUE TUBE. SPECIAL CONDITIONS MAY APPLY.

WHERE INSTRUCTIONS CONTAINED IN THE AIRCRAFT SERVICE MANUAL DIFFER FROM THE FOLLOWING NOTES AND SKETCHES, THE INFORMATION CONTAINED IN THE AIRCRAFT SERVICE MANUAL SHOULD BE USED.

REFER TO THE AIRCRAFT ILLUSTRATED PARTS CATALOG FOR REPLACEMENT HARDWARE, IF REQUIRED, OR FOR IDENTIFICATION OF EXISTING HARDWARE.

..... END OF NOTES

THE NEW PIPER AIRCRAFT INC. VERO BEACH, FLORIDA		TITLE KIT - TORQUE TUBE REPLACEMENT	
KIT NO:	652-579, 652-580, 652-581, 652-582, 652-583	SHT. 3	DWG NO. 88372
			B

INSTRUCTIONS:

1. REMOVE THE AFT FUSELAGE ACCESS PANEL FWD OF THE RIGHT STABILATOR.
2. REMOVE THE FUSELAGE TAIL FAIRINGS.
3. DISCONNECT THE STABILATOR CONTROL CABLES FROM THE STABILATOR HORN ASSEMBLY (SEE SKETCH "B", ITEM A, SHEET 10). THEN REMOVE THE BALANCE WEIGHT FROM THE ARM (SEE SKETCH "B", ITEM Q, SHEET 10).
4. REMOVE THE BOLT FROM THE STABILATOR TRIM TAB HORN (SEE SKETCH "A", ITEM B, SHEET 9).
5. REMOVE THE BOLT FROM THE STABILATOR REAR SPAR (SEE SKETCH "A", ITEM C, SHEET 9).
6. REMOVE THE FOUR BOLTS ATTACHING THE STABILATORS TO THE STABILATOR TORQUE TUBE ASSEMBLY AND REMOVE THE STABILATORS.

CAUTION: ONLY LIGHT FORCE SHOULD BE USED TO REMOVE THE STABILATOR HALVES. A BUILD-UP OF RUST AND CORROSION ON THE STABILATOR TORQUE TUBE BETWEEN THE INBOARD AND OUTBOARD STABILATOR ATTACH FITTINGS CAN PREVENT STABILATOR REMOVAL. IF THE STABILATOR WILL ROTATE ON THE TORQUE TUBE ASSEMBLY AFTER BOLT REMOVAL BUT WILL NOT DETACH, UNBOLT THE INBOARD ATTACHMENT FITTING FROM THE STABILATOR ON THE AIRPLANE. REMOVE THE STABILATOR LEAVING THE INBOARD ATTACHMENT FITTING ON THE TORQUE TUBE ASSEMBLY (SEE SKETCH "A", ITEM D, SHEET 9).

7. REMOVE THE STABILATOR BEARING BLOCK REINFORCEMENT CHANNELS (PA24-400, PA30, PA39, PA23-235/250/250(6)). (SEE SKETCH "A", ITEM E, SHEET 9)
8. REMOVE THE TWO BOLTS HOLDING THE STABILATOR TAB CONTROL BELLCRANK ASSEMBLY TO THE STABILATOR BEARING BLOCKS (IT IS NOT NECESSARY TO FURTHER DISASSEMBLE THIS UNIT). (SEE SKETCH "A", ITEM F, SHEET 9)
9. REMOVE THE FOUR BOLTS FROM THE STABILATOR BEARING BLOCKS (SEE SKETCH "A", ITEM G, SHEET 9).

CAUTION: MARK THE TOP OF EACH BEARING BLOCK FOR PROPER REASSEMBLY.

10. BY PULLING AFT AND ROTATING THE TORQUE TUBE ASSEMBLY DOWNWARD TO PASS UNDER THE RUDDER ARM, THE ENTIRE TORQUE TUBE ASSEMBLY AND STABILATOR HORN ASSEMBLY CAN BE REMOVED FROM THE AIRCRAFT.
11. REMOVE ALL PAINT AND RUST FROM THE OUTER SURFACE OF THE TORQUE TUBE ASSEMBLY. COAT THE TORQUE TUBE ASSEMBLY WITH LIGHT OIL TO FACILITATE THE REMOVAL OF COMPONENTS FROM THE TORQUE TUBE ASSEMBLY. DURING THE REMOVAL OF THE TORQUE TUBE ASSEMBLY COMPONENTS, NOTE THE POSITION OF THE PARTS SO THAT THEY CAN BE PROPERLY REINSTALLED.

THE NEW PIPER AIRCRAFT INC. VERO BEACH, FLORIDA		TITLE KIT - TORQUE TUBE REPLACEMENT	
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12. REMOVE THE LEFT BEARING BLOCK BY TAPPING WITH A SOFT MALLET. (SEE SKETCH "C", ITEM H, SHEET 10). NOTE THE PRESENCE OF ANY SHIMS AND RECORD THEIR LOCATION FOR PROPER REINSTALLMENT.

13. REMOVE THE COLLAR ASSEMBLY (SEE SKETCH "C", ITEM J, SHEET 10).

NOTE: SEVERELY CORRODED TORQUE TUBE ASSEMBLY COMPONENTS MAY REQUIRE A HYDRAULIC PRESS FOR DISASSEMBLY.

INSPECT THE EXPOSED STABILATOR HORN ASSEMBLY AND COLLAR ASSEMBLY BOLTS INSIDE THE TORQUE TUBE ASSEMBLY VISUALLY WITH A FLASHLIGHT FOR RUST AND CORROSION. ABRASIVE BLAST REMOVAL OF RUST AND CORROSION MAY BE REQUIRED TO PREVENT JAMMING DURING BOLT REMOVAL. DISCARD ALL TORQUE TUBE ASSEMBLY HARDWARE.

14. REMOVE THE STABILATOR HORN ASSEMBLY (SEE SKETCH "C", ITEM K, SHEET 10).

15. REMOVE THE RIGHT BEARING BLOCK ASSEMBLY (SEE SKETCH "C", ITEM L, SHEET 10). NOTE THE PRESENCE OF ANY SHIMS AND RECORD THEIR LOCATION FOR PROPER REINSTALLMENT.

NOTE (FOR STEPS 16 & 17): HOLES DRILLED IN THE TORQUE TUBE ASSEMBLY ARE UNDERSIZED AND WILL BE LINE REAMED DURING ASSEMBLY OF MATING PARTS. SINCE THE HOLES IN THE STABILATOR HORN ASSEMBLY AND COLLAR ASSEMBLY ARE ALREADY REAMED TO FULL SIZE, SPECIAL LOCATING PINS, 25034-000 AND 25034-002, ARE INCLUDED IN THE KIT TO ENSURE PROPER FIT OF THESE ASSEMBLIES.

NOTE THAT PIN 25034-000 IS LARGER IN DIAMETER THAN PIN 25034-002.

16. INSTALLATION OF STABILATOR HORN ASSEMBLY.

NOTE: THE STABILATOR HORN ASSEMBLY MAY BE SUBJECT TO SPECIAL RECURRING INSPECTION REQUIREMENTS AND/OR A LIFE LIMIT. CONSULT THE LATEST PIPER SERVICE BULLETINS AND APPLICABLE MAINTENANCE MANUAL FOR GUIDANCE BEFORE PROCEEDING. THE INSTRUCTIONS IN THIS KIT ARE ALSO APPLICABLE FOR THE INSTALLATION OF A NEW REPLACEMENT STABILATOR HORN ASSEMBLY.

ENSURE THAT THE INSIDE DIAMETER OF THE STABILATOR HORN ASSEMBLY IS LUBRICATED AND FREE OF CORROSION. INSTALL THE STABILATOR HORN ASSEMBLY ON THE NEW STABILATOR TORQUE TUBE ASSEMBLY (SEE SKETCH "C", ITEMS K AND M, SHEET 10).

LOCATE THE STABILATOR HORN ASSEMBLY IN POSITION ON THE TORQUE TUBE ASSEMBLY. INSERT THE LOCATING PIN, 25034-000, ITEM N, INTO ONE HOLE UNTIL THE SHOULDER BOTTOMS OUT ON THE TORQUE TUBE.

REAM THE OTHER HOLE IN THE TORQUE TUBE TO $\phi .3120/.3130$. INSERT THE NEW BOLT INTO THE REAMED HOLE BEFORE REMOVING THE LOCATING PIN TO REAM THE SECOND HOLE. REAM THE SECOND HOLE TO $\phi .3120/.3130$. INSTALL THE SECOND NEW BOLT TO SECURE THE STABILATOR HORN ASSEMBLY.

THE NEW PIPER AIRCRAFT INC.

VERO BEACH, FLORIDA

TITLE

KIT - TORQUE TUBE REPLACEMENT

KIT NO:

652-579, 652-580,
652-581, 652-582,
652-583

SHT.

5

DWG NO.

88372

B

INSTALL THESE TWO NEW BOLTS WITH THE BOLT HEAD ON THE FORWARD SIDE OF THE STABILATOR HORN ASSEMBLY. TORQUE NUTS TO 120-145 IN-LBS.

NOTE: THE STATED TORQUE VALUE OF 120-145 IN-LBS INCLUDES FRICTION DRAG FROM THE NUT'S LOCKING ELEMENT, WHICH IS ASSUMED TO BE 60 IN-LBS. AT THE MECHANIC'S DISCRETION, THE INSTALLATION TORQUE CAN BE ADJUSTED ACCORDING TO THE ACTUAL, MEASURED FRICTION DRAG. FOR EXAMPLE, IF THE FRICTION DRAG TORQUE IS MEASURED TO BE 40 IN-LBS (WHICH IS 20 IN-LBS LESS THAN THE ASSUMED VALUE OF 60 IN-LBS), THEN THE INSTALLATION TORQUE WILL BE ADJUSTED TO BE 100-125 IN-LBS OF TORQUE.

17. INSTALLATION OF COLLAR ASSEMBLY.

ENSURE THAT THE INSIDE DIAMETER OF THE COLLAR ASSEMBLY IS LUBRICATED AND FREE OF CORROSION.

SLIDE THE COLLAR ASSEMBLY ONTO THE TORQUE TUBE ASSEMBLY (SEE SKETCH "C" ITEM J, SHEET 10).

- A) FOR KITS 652-580, 652-581, 652-582, AND 652-583, LOCATE THE COLLAR ASSEMBLY IN POSITION ON THE TORQUE TUBE ASSEMBLY. INSERT THE LOCATING PIN, 25034-002, ITEM P, INTO ONE HOLE UNTIL THE SHOULDER BOTTOMS OUT ON THE TORQUE TUBE.

REAM THE OTHER HOLE IN THE TORQUE TUBE TO $\phi .2465/.2475$. INSERT THE NEW BOLT INTO THE REAMED HOLE BEFORE REMOVING THE LOCATING PIN TO REAM THE SECOND HOLE. REAM THE SECOND HOLE TO $\phi .2465/.2475$. INSTALL THE SECOND NEW BOLT TO SECURE THE COLLAR ASSEMBLY. INSTALL THE NEW INBOARD BOLT WITH THE BOLT HEAD ON THE FORWARD SIDE OF THE COLLAR ASSEMBLY, AND INSTALL THE NEW OUTBOARD BOLT WITH THE BOLT HEAD ON THE AFT SIDE OF THE COLLAR ASSEMBLY.

TORQUE BOLTS PER THE FINE THREAD SERIES TORQUE TABLES IN THE "HANDLING AND SERVICING" SECTION OF THE SERVICE MANUAL.

- B) FOR KIT 652-579, LOCATE THE COLLAR ASSEMBLY IN POSITION ON THE TORQUE TUBE ASSEMBLY. INSERT THE LOCATING PIN, 25034-000, ITEM P, INTO ONE HOLE UNTIL THE SHOULDER BOTTOMS OUT ON THE TORQUE TUBE.

REAM THE OTHER HOLE IN THE TORQUE TUBE TO $\phi .3120/.3130$. INSERT THE NEW BOLT INTO THE REAMED HOLE BEFORE REMOVING THE LOCATING PIN TO REAM THE SECOND HOLE. REAM THE SECOND HOLE TO $\phi .3120/.3130$. INSTALL THE SECOND NEW BOLT TO SECURE THE COLLAR ASSEMBLY. INSTALL THE NEW INBOARD BOLT WITH THE BOLT HEAD ON THE FORWARD SIDE OF THE COLLAR ASSEMBLY, AND INSTALL THE NEW OUTBOARD BOLT WITH THE BOLT HEAD ON THE AFT SIDE OF THE COLLAR ASSEMBLY.

TORQUE BOLTS PER THE FINE THREAD SERIES TORQUE TABLES IN THE "HANDLING SERVICING" SECTION OF THE SERVICE MANUAL.

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PROTECT THE AREA AROUND THE COLLAR ASSEMBLY AND AROUND THE STABILATOR HORN ASSEMBLY USING DINITROL AVS OR CRC PROTECTOR 100 RUST INHIBITOR PER THE MANUFACTURER'S INSTRUCTIONS ON THE CONTAINER. ENSURE THAT THE AREA OF THE TORQUE TUBE ASSEMBLY IMMEDIATELY OUTBOARD OF COLLAR ASSEMBLY, WHERE THE BEARING BLOCK WILL BE POSITIONED, IS FREE OF RUST INHIBITOR.

18. REMOVE THE BEARINGS FROM BOTH BEARING BLOCKS. REMOVE THE RETAINER RINGS AND DUST SEALS. CLEAN AND INSPECT BEARINGS. REPACK BEARINGS WITH GREASE CONFORMING TO MIL-PRF-81322 OR EQUIVALENT AND REASSEMBLE OR REPLACE AS NECESSARY. PLACE BEARINGS IN BEARING BLOCK. INSTALL THE LEFT BEARING BLOCK ON THE TORQUE TUBE ASSEMBLY. (SEE SKETCH "C", ITEM H, SHEET 10). INSTALL THE RIGHT BEARING BLOCK ON THE TORQUE TUBE ASSEMBLY (SEE SKETCH "C", ITEM L, SHEET 10).

SHIMS (IF ORIGINALLY INSTALLED) SHOULD BE INSTALLED WITH THE BEARING BLOCKS IN THE SAME POSITION AS WHEN REMOVED. MAINTAIN A DIMENSION OF 8.620 INCHES BETWEEN THE CENTER OF THE AFT FACING HOLES ON THE BEARING BLOCKS AS SHOWN IN SKETCH "C".

19. REINSTALL THE TORQUE TUBE ASSEMBLY ON THE AIRCRAFT IN THE REVERSE ORDER OF DISASSEMBLY. TORQUE BEARING BLOCK BOLTS PER THE FINE THREAD SERIES TORQUE TABLES IN THE "HANDLING AND SERVICING" SECTION OF THE SERVICE MANUAL.

20. INSTALLATION OF STABILATORS.

NOTE: STABILATOR ATTACHMENT BOLTS REQUIRE ONE THIN WASHER UNDER EACH BOLT HEAD, ONE THICK WASHER UNDER THE INBOARD ATTACH FITTING NUT, AND TWO THICK WASHERS UNDER THE OUTBOARD ATTACH FITTING NUT.

ENSURE THAT THE ATTACH FITTINGS IN THE STABILATOR HALVES ARE LUBRICATED AND FREE OF CORROSION. IF NECESSARY, LUBRICATE THE TORQUE TUBE TO FACILITATE INSTALLATION OF THE STABILATOR HALVES.

SLIDE THE LEFT HAND STABILATOR HALF ONTO THE TORQUE TUBE ASSEMBLY. POSITION THE STABILATOR ATTACHMENT FITTING HOLES SO THAT THEY ARE IN LINE WITH THE TORQUE TUBE HOLES.

- A) FOR MODELS PA-24-180/250/260, INSERT THE LOCATING PIN, 25034-002, INTO ONE HOLE UNTIL THE SHOULDER BOTTOMS OUT ON THE STABILATOR ATTACHMENT FITTING (SEE SKETCH "A", ITEM O, SHEET 9).

REAM THE OTHER HOLE IN THE TORQUE TUBE TO $\varnothing .2465/.2475$. INSERT THE NEW BOLT INTO THE REAMED HOLE BEFORE REMOVING THE LOCATING PIN TO REAM THE SECOND HOLE. REAM THE SECOND HOLE TO $\varnothing .2465/.2475$. INSTALL THE SECOND NEW BOLT TO SECURE THE LEFT HAND STABILATOR HALF.

REPEAT THE PROCEDURE FOR THE RIGHT HAND STABILATOR HALF.

THE NEW PIPER AIRCRAFT INC. VERD BEACH, FLORIDA		TITLE KIT - TORQUE TUBE REPLACEMENT	
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TORQUE BOLTS PER THE FINE THREAD SERIES TORQUE TABLES IN THE "HANDLING AND SERVICING" SECTION OF THE SERVICE MANUAL.

- B) FOR MODELS PA-23-235/250/250(6), PA-E23-250, PA-24-400, AND PA-30/39, INSERT THE LOCATING PIN, 25034-000, INTO ONE HOLE UNTIL THE SHOULDER BOTTOMS OUT ON THE STABILATOR ATTACHMENT FITTING (SEE SKETCH "A", ITEM O, SHEET 9).

REAM THE OTHER HOLE IN THE TORQUE TUBE TO $\phi .3120/.3130$. INSERT THE NEW BOLT INTO THE REAMED HOLE BEFORE REMOVING THE LOCATING PIN TO REAM THE SECOND HOLE. REAM THE SECOND HOLE TO $\phi .3120/.3130$. INSTALL THE SECOND NEW BOLT TO SECURE THE LEFT HAND STABILATOR HALF.

REPEAT THE PROCEDURE FOR THE RIGHT HAND STABILATOR HALF.

TORQUE BOLTS PER THE FINE THREAD SERIES TORQUE TABLES IN THE "HANDLING AND SERVICING" SECTION OF THE SERVICE MANUAL.

21. INSTALL THE NEW BOLT IN THE STABILATOR REAR SPAR (SKETCH "A", ITEM C, SHEET 9).

TORQUE BOLT PER THE FINE THREAD SERIES TORQUE TABLES IN THE "HANDLING AND SERVICING" SECTION OF THE SERVICE MANUAL.

22. INSTALL THE NEW BOLT IN THE STABILATOR TRIM TAB HORN (SEE SKETCH "A", ITEM B, SHEET 9).

TORQUE BOLT PER THE FINE THREAD SERIES TORQUE TABLES IN THE "HANDLING AND SERVICING" SECTION OF THE SERVICE MANUAL.

23. RECONNECT THE STABILATOR CONTROL CABLES WITH NEW BOLTS (SEE SKETCH "B", ITEM A, SHEET 10). REINSTALL THE BALANCE WEIGHT ON THE ARM WITH NEW BOLTS. ENSURE THAT THE STABILATOR AND STABILATOR TRIM RIGGING ARE IN ACCORDANCE WITH THE REQUIREMENTS STATED IN THE SERVICE MANUAL.

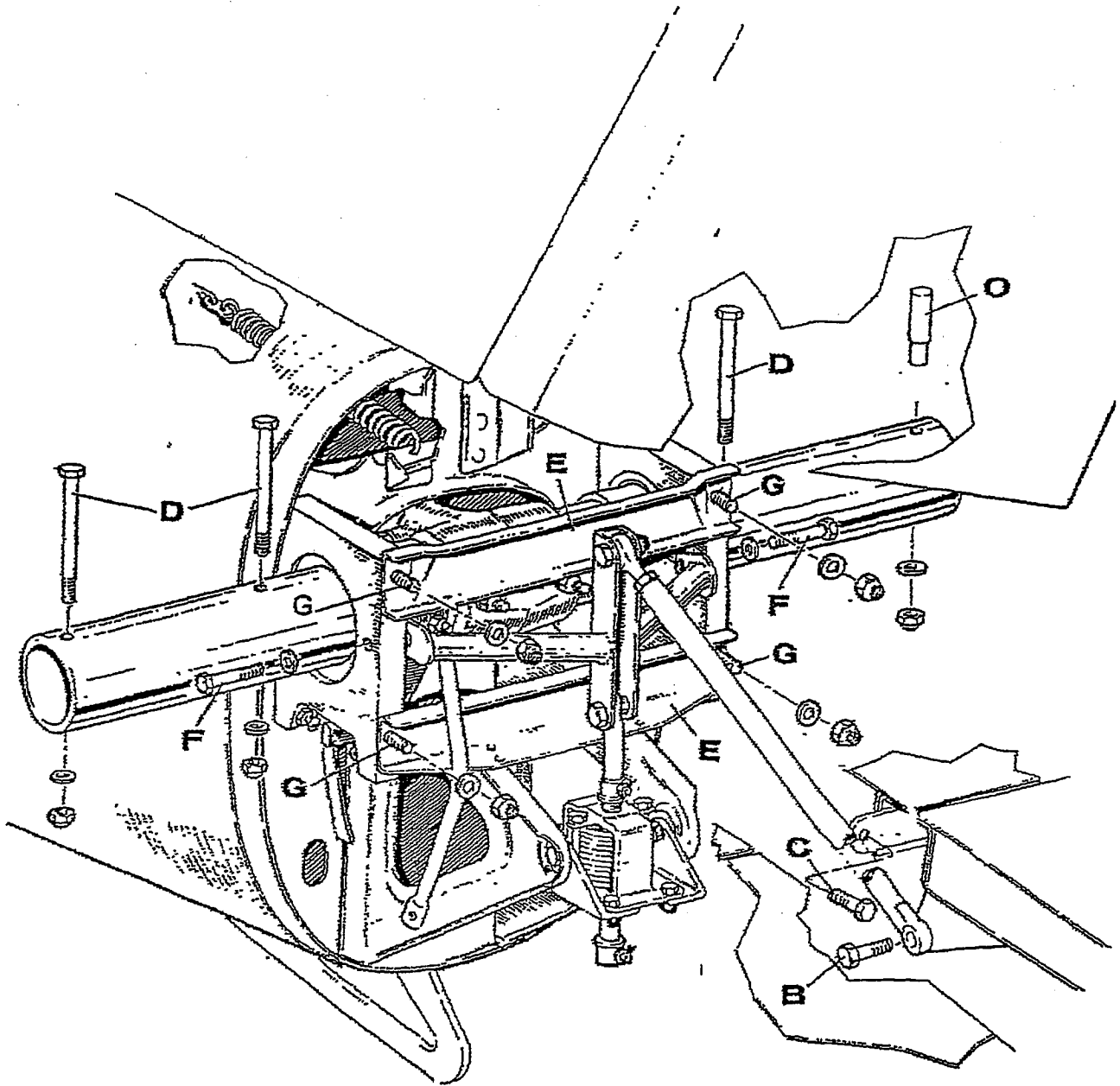
TORQUE BOLTS PER THE FINE THREAD SERIES TORQUE TABLES IN THE "HANDLING AND SERVICING" SECTION OF THE SERVICE MANUAL.

24. REINSTALL THE FUSELAGE TAIL FAIRINGS AND AFT FUSELAGE ACCESS PANEL.

25. MAKE A LOGBOOK ENTRY INDICATING COMPLIANCE WITH THIS KIT. WEIGHT AND BALANCE ARE NOT AFFECTED BY THIS KIT.

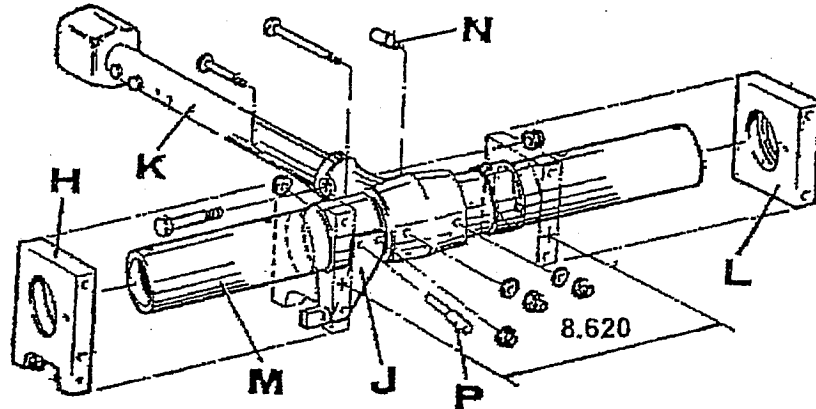
..... END OF INSTRUCTIONS

THE NEW PIPER AIRCRAFT INC. VERO BEACH, FLORIDA		TITLE KIT - TORQUE TUBE REPLACEMENT	
KIT NO:	652-579, 652-580, 652-581, 652-582, 652-583	SHT. 8	DWG NO. 88372
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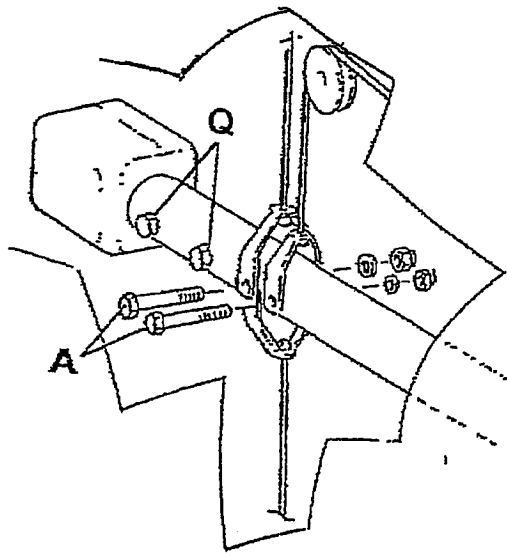


SKETCH A.

THE NEW PIPER AIRCRAFT INC. VERO BEACH, FLORIDA		TITLE KIT - TORQUE TUBE REPLACEMENT	
KIT NO:	652-579, 652-580, 652-581, 652-582, 652-583	SHT. 9	DWG NO. 88372
			B



SKETCH C.



SKETCH B.

THE NEW PIPER AIRCRAFT INC. VERO BEACH, FLORIDA		TITLE KIT - TORQUE TUBE REPLACEMENT	
KIT NO:	652-579, 652-580, 652-581, 652-582, 652-583	SHT. 10	DWG NO. 88372
			B