



NOTE: FITTINGS REQUIRED TO BE BENT SHOULD BE CUT LONG AND HOLES DRILLED PRIOR TO FINISH SHAPING BENT END.

NOTE: DRILL 5/16" HOLES ONLY TO 1/4" UNTIL ACTUAL FITTING OF PARTS. WHEN WINGS ARE IN PLACE, DRILL FROM 1/4" TO JUST SMALLER THAN 5/16" DIA. REAM TO 5/16".

DRILLING WING ATTACH (5/16") HOLES IN PARTS 40 & 41.

NOTE: UPPER WINGS ARE SWEEPED BACK AT 6 DEGREE ANGLE. WING FITTINGS REQUIRE BEADING. FITTINGS TO BE BENT SHOULD BE CUT LONG & AFTER HOLES ARE DRILLED AND PART FINISHED.

LOWER WING: SPAR CARRY THRU'S HAVE HOLES DRILLED. THE ONLY PLACE TO CORRECT FOR MOVEMENT IS IN WING FITTINGS. DRILL ONE 5/16" HOLE IN ONE FITTING EXAMPLE REAR OUTSIDE OR FRONT OUTSIDE. RIG WINGS TO AIRCRAFT. WHEN FUSELAGE IS IN POSITION & WINGS ARE IN POSITION DRILL REMAINING HOLES. DRILL SLIGHTLY UNDER SIZE & REAM TO FIT.

CENTER SECTION: MARK, BUT DO NOT DRILL ANY HOLES IN CENTER SECTION FITTINGS. ASSEMBLE FRONT INSIDE & REAR INSIDE ATTACH FITTINGS TO CENTER SECTION. RIG FUSELAGE & CENTER SECTION. MARKS SHOULD LINE UP WITH CARAGE HOLES. USE CABANE HOLES FOR GUIDE & DRILL ATTACH FITTING. INSTALL OUTSIDE ATTACH FITTINGS FRONT & REAR & BACK DRILL HOLES.

NOTE: THESE STEPS CAN BE COMPLETED ANY TIME AFTER FUSELAGE & CABANES ARE COMPLETELY WELDED.

UPPER WINGS: AFTER CENTER SECTION HAS BEEN LOCATED & ATTACH FITTING HOLES DRILLED INSTALL INSIDE FITTINGS ON WING SPARS. RIG WINGS IN PLACE. ALIGN WING END TO CENTER SECTION END UP & DOWN - (HORIZONTAL PLANE). USE EXISTING HOLES AS DRILL GUIDE & DRILL HOLES IN WING. ATTACH FITTINGS INSTALL OUTSIDE WING FITTING & BACK DRILL. REMOVE WINGS & CENTER SECTION & REAM ALL HOLES TO 5/16".

NOTE: TO DRILL FITTINGS WITHOUT DAMAGE TO HOLES, EGG SHAPING ETC. USE SMALL C-CLAMPS & CLAMP FITTINGS & CABANES IN PLACE. DRILL AT LEAST 1/16" UNDERSIZE.

NOTE: DO NOT BEND FITTINGS PARALLEL TO GRAIN. BEND PERPENDICULAR.

NOTE: TWO LONG DRILL BITS WILL BE REQUIRED. ONE SLIGHTLY LESS THAN 5/16" SAY A 9/32" AND A 1/8". DRILL WITH THE LARGER BIT TO MARK CENTER OF HOLE THEN CHANGE TO 1/8" BIT. SPEEDS UP PROCESS AND REDUCES WEAR & TEAR ON HOLE. TO MAKE LONG BITS - USE A ROD APPROX. THE SAME SIZE AS DRILL BIT. 1 LIKE SMALLER, & WELD TO END OF BIT. IF ROD IS SMALLER IT WILL EASILY PASS THRU DRILLED HOLE TO REACH SPAR ON OTHER END. USE 36" LONG RODS. SOFT - HARDWARE STEEL IS FINE.

NOTE: FOR UPPER WING ROOT FITTINGS, BEND UP 6° FOR R.H. & DOWN 6° FOR L.H. DRILL FRONT FITTING OF UPPER WING FRONT & REAR SPAR. REAR FITTING TO BE DRILLED WITH WING ASSEMBLED TO CENTER SECTION.

NOTE: BEND PERPENDICULAR TO GRAIN. DO NOT BEND PARALLEL TO GRAIN.

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REVISION:	DATE:
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