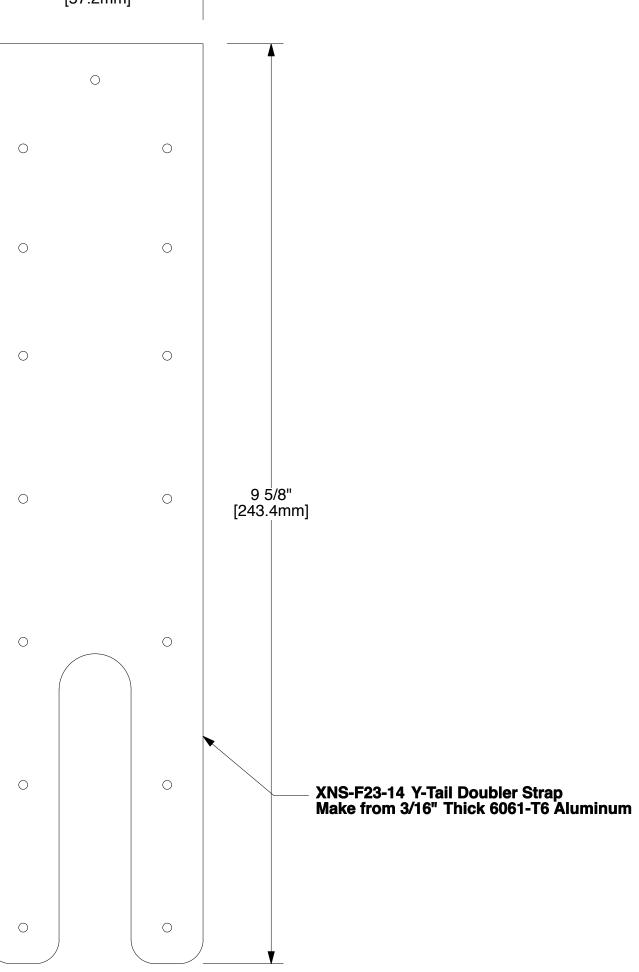
2 1/4" [57.2mm] \circ [243.4mm] -03 Forward "Y" Fitting — 1 Required on -01 - -04 Aft "Y" Fitting 1 Required on -01 Open all pilot holes in "Y" Fittings up to Ø 3/32" [Ø 2.4mm] and deburr Make sure "Y" Fittings are alinged and flat before drilling -04 Aft "Y" Fitting Reference <u>Detail of -16 Y-Tail Doubler Strap</u> Full Scale -03 Forward "Y" Fitting — Reference AN3-10A Bolt, 3 Required on -01 AN960-10 Washer, 6 Required on -01 AN365-1032 Nut, 3 Required on -01 Locate per pilot holes in "Y" Fittings 1/2" [12.7mm] -02 Upper Atach Angle, 1 Required on -01 -AN3-11A Bolt, 4 Required on -01 AN960-10 Washer, 4 Required on -01 AN365-1032 Nut, 4 Required on -01 Locate per pilot holes in "Y" Fittings AN3-10A Bolt, 8 Required on -01 AN960-10 Washer, 16 Required on -01 AN365-1032 Nut, 8 Required on -01 This Service Bulletin details the addition of an Aluminum Structural element to the tail-to-fuselage joint of the Xenos 8 45/64" [220.9mm] Locate per pilot holes in "Y" Fittings -06 Tail Post Channel, 1 Required on -01 Parts List supplied with this Service Bulletin: XNS-F23-14 Y-Tail Doubler Strap Qty 1 AN3-10A Bolt Qty 11 AN3-11A Bolt Qty 4 AN960-10 Washer Qty 6 AN365-1032 Nut Qty 15 Center Fittings in Tail — Section A-A Post Channel AN3-6A Bolt, 2 Required on -01 AN960-10 Washer, 4 Required on -01 AN365-1032 Nut, 2 Required on -01 Locate per pilot holes in "Y" Fittings Aft Strap Build Order:

1. Fabricate Doubler Strap per full size pattern. 2. Remove stub rudder. 3. Remove attach bolts shown in black in XNS-F23-01. 11 3/4" Note: The 11 3/4" dimension between the top corner on the [298.4mm] Upper Angle and the bottom of the Lower Angle must 4. Bend out aft fuse channel a little for doubler strap to clear rivets on both sides.
5. Install using new hardware identified in XNS-F23-01.
6. Re-install stub rudder. Reference Xenos Plans for this step. [298.4mm] be held to assure good fit with the Upper and Lower Longerons -05 Lower Atach Angle, 1 Required on -01 — AN3-8A Bolt, 4 Required on -01 AN960-10 Washer, 8 Required on -01 AN365-1032 Nut, 4 Required on -01 Locate per pilot holes in "Y" Fittings -08 Tail Wheel Mount, 1 Required on -01 xenos XNS-F23-01 Tail Post Assembly New Parts and Hardware shown in Black Scale 1:2 Drawing Scale

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Revision Change Letter Description



The following view is replaced in the Xenos Plans by the View on this Drawing: XNS-F23-01 Tail Post Assembly

IMPORTANT NOTE: Remove all rough edges on surfaces on all aluminum parts.

Service Bulletin #1 Xenos Tail-to-Fuselage Attachment Drawing Number

N/C **XNS-SB-001** 1:2 & Noted