

**PROCEDURE 5.080
RUDDER INSTALLATION**

In this procedure...

The Rudder will be installed on the Vertical Stabilizer and the Aft Rudder Push/Pull Tube Installed.

Material needed for this procedure:

<u>Part Number</u>	<u>Description</u>	<u>Qty.</u>
AN4-12	Bolt	3
AN310-4	Nut	3
AN960-416	Washer	6
MS24665-134	Cotter Pin	3

Step 1. Install Rudder on Vertical Stabilizer.

Connect the Aft Rudder Push/Pull Tube to the Rudder Horn Arm on the Lower Hinge. Insert the push/pull tube through the hole on the vertical shear web and slide the rudder into position. Install the upper and lower rudder hinge bolts.

Step 2. Check Rudder Travel.

Check the rudder for travel in both directions. Minimum travel is 25°. Sand the trailing edges of the vertical stabilizer to achieve minimum travel.

Step 3. Connect Aft Push/Pull Tube.

Connect the push/pull tube and check for clearance and rudder operation using the rudder pedals.
Do Not Final Install Rudder Bolts at this time.