



END VIEW
AIRCRAFT TAILCONE

INSTALLATION "TIPS":

1. FIT NEW TAILCONE BY TRIMMING IT IN VERY SMALL INCREMENTS. TAKE YOUR TIME, DON'T RISK RUINING THE NEW PART.
2. CHECK THE TOP OPENING OF THE TAILCONE FOR PROPER CLEARANCE WHEN RUDDER IS FULLY DEFLECTED IN BOTH DIRECTIONS. CAREFULLY TRIM AS NECESSARY.
3. BEFORE DRILLING ATTACHMENT HOLES, REINSTALL ELEVATOR I.A.W. CESSNA SERVICE MANUAL. AFTER ADJUSTING THE POSITION OF TAILCONE TO INSURE EVEN AND ADEQUATE ELEVATOR CLEARANCE, CAREFULLY DRILL ATTACHMENT HOLES.
4. DO NOT USE EXCESSIVE TORQUE ON ATTACHMENT HARDWARE.

TRIM AS NECESSARY SO THAT RUDDER POST MOVES THROUGH COMPLETE ARC NEEDED FOR PROPER OPERATION
SEE NOTE ⑥

EDGE FITS UNDER EXISTING TAILCONE SKIN
USE EXISTING CLIP NUTS FROM CESSNA TAILCONE
6 PLCS

A TYPICAL TAILCONE STINGER INSTALLATION
SEE NOTE ④

AVFAB STINGER ASSEMBLY
P/N 42-0322

ATTACH TO AIRCRAFT USING 4 MS24893S48 SCREW & 6 EC1080-017-08SS DIMPLED WASHER
20 PLCS SEE NOTE ⑤

ITEM	QTY	PART #	VENDOR #	SPECIFICATIONS	NOMENCLATURE
△		42-0322			TAILCONE STINGER ASSEMBLY
△	1	42-0322-11		SEE NOTE ④	LEFT HAND DOOR
△	1	42-0322-12		SEE NOTE ④	RIGHT HAND DOOR
△	12	MS1957-45			SCREW
△	20	MS24893S48			SCREW
△	20	NAS1169C-8			DIMPLED WASHER
ALL 42- PART #S ARE OF AVIATION FABRICATORS, CLINTON, MO					

ASSEMBLY NOTES:

- ① REMOVE EXISTING TAILCONE STINGER ASSEMBLY PER CESSNA SERVICE MANUAL.
- ② REMOVE LIGHT ASSEMBLY FROM OLD STINGER ASSEMBLY AND INSTALL ON NEW STINGER. USE EXISTING HARDWARE OR REPLACE WITH LIKE HARDWARE.
- ③ PLACE NEW STINGER ASSEMBLY UP TO THE AIRCRAFT, HOLDING THE FWD EDGE INSIDE THE EXISTING TAILCONE ON THE UPPER HALF, AND MARK THE CENTER MOST TWO HOLES ON TOP OF THE STINGER ASSEMBLY, MAINTAINING ATLEAST A 1/2" HOLE TO EDGE MATERIAL THICKNESS. REFER TO END VIEW.

!! IMPORTANT !! WHEN MARKING ATTACHMENT HOLES MAKE CERTAIN TAILCONE IS IN A FIXED POSITION SO THAT IT DOES NOT MOVE. CONTINUALLY CHECK FOR PROPER RUDDER CLEARANCE.
- ④ DRILL TWO HOLES USING #29 DRILL BIT THROUGH THE STINGER AND SECURE IT TO THE AIRCRAFT USING △ SCREWS. MARK AND DRILL THE OTHER UPPER HOLES TO MATCH THE AIRCRAFT.
- ⑤ FINALLY MARK AND DRILL LOWER HALF HOLES TO MATCH THE AIRCRAFT. DRILL 3/8" HOLE INTO TAILCONE FOR DIMPLED WASHER AFTER ALL HOLES HAVE BEEN ALIGNED WITH #29 DRILL PILOT HOLES.
- ⑥ CHECK THAT THE RUDDER TAIL POST CAN COMPLETE THE FULL ARC TRAVEL THAT IS NECESSARY FOR PROPER OPERATION. TRIM TOP OF TAILCONE AS NEEDED.
7. CONNECT ALL ELECTRICAL WIRING.
8. SECURE STINGER ASSEMBLY TO TAILCONE USING ITEM △ SCREWS AND △ EYELETS.
- ⑨ FINISH INSTALLATION BY INSTALLING ITEMS △ AND △ DOORS INTO PLACE USING ITEM △ SCREWS.
10. THE TAILCONE ASSEMBLY WEIGHS 9.5 LBS +/- .5 LBS WITHOUT PAINT. IT IS THE INSTALLER'S RESPONSIBILITY TO WEIGH THE TAILCONE PRIOR TO FINAL INSTALLATION. INSTALLING THE AVFAB TAILCONE STINGER ASSEMBLY DOES NOT CHANGE THE ARM (FUSELAGE STATION OR FS) FROM THE ORIGINAL CESSNA TAILCONE STINGER INSTALLATION.
11. IT IS THE RESPONSIBILITY OF THE INSTALLER TO COMPLY INSTRUCTIONS FOR CONTINUED AIRWORTHINESS. REFER TO DOCUMENT AF-505.

DATE	BY	REVISION RECORD	AUTH.	D.R.	C.K.
06-16-10	B	ADDED NOTE 11 REFERRING TO ICA DOCUMENT AF-505 ADDED NOTE 10 REFERRING TO TAILCONE WEIGHT	JRL	STP	JRL
10-02-06	A	ADDED INSTALLATION TYPING NOTES TO DRAWING PER EDO # AF0007 REMOVED INAPPROPRIATE REFERENCES ON TOP HALF OF TAILCONE FROM END VIEW DETAIL PER EDO # AF0006 ADDED CALLOUT TO MAIN VIEW TO SHOW THAT FRONT EDGE FITS UNDER EXISTING TAILCONE SKIN AND THAT THE LOWER PORTION OF TAILCONE FROM ORIGINAL CESSNA TAILCONE IS BEING CLIP NUTS FROM CESSNA TAILCONE PER EDO # AF0004 ADDED NEW NOTE 8 AND REPHRASED NOTES 7, 8, & 9 PER EDO # AF0007 ADDED IMPORTANT NOTE CALLOUT TO NOTE 3 TO HAVE TAILCONE IN FIXED POSITION PER EDO # AF0007 UPDATED NOTE 6 TO ENLARGE HOLES TO 3/8" FOR THE DIMPLED WASHER PER EDO # AF0008 REMOVED ITEM 4 TO P/N MS24893S48 FROM APPROVED HARDWARE PER EDO # AF0008 REMOVED ITEM 5 TO P/N NAS1169C-8 EYELET FROM APPROVED HARDWARE PER EDO # AF0008 PER EDO # AF0008	JRL	STP	JRL

APPLICABLE AIRCRAFT	AVIATION FABRICATORS		STC #
CESSNA 340 & 340A	805 N. FOURTH ST. CLINTON, MISSOURI 64735 (860)885-9317		PART # 42-0322
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TOLERANCE UNLESS OTHERWISE SPECIFIED	TITLE		DRAWING #
ANGLE DECIMAL FRACTIONAL ±.XX ±.XX ±.XX	CE 340 TAILCONE STINGER INSTALLATION		D-10415
SCALE	DRAWN BY	APPROVAL	SHEET # OF
NTS	JEREMY HOLT	G.R. LOWE	1 1
			DATE
			02-26-02