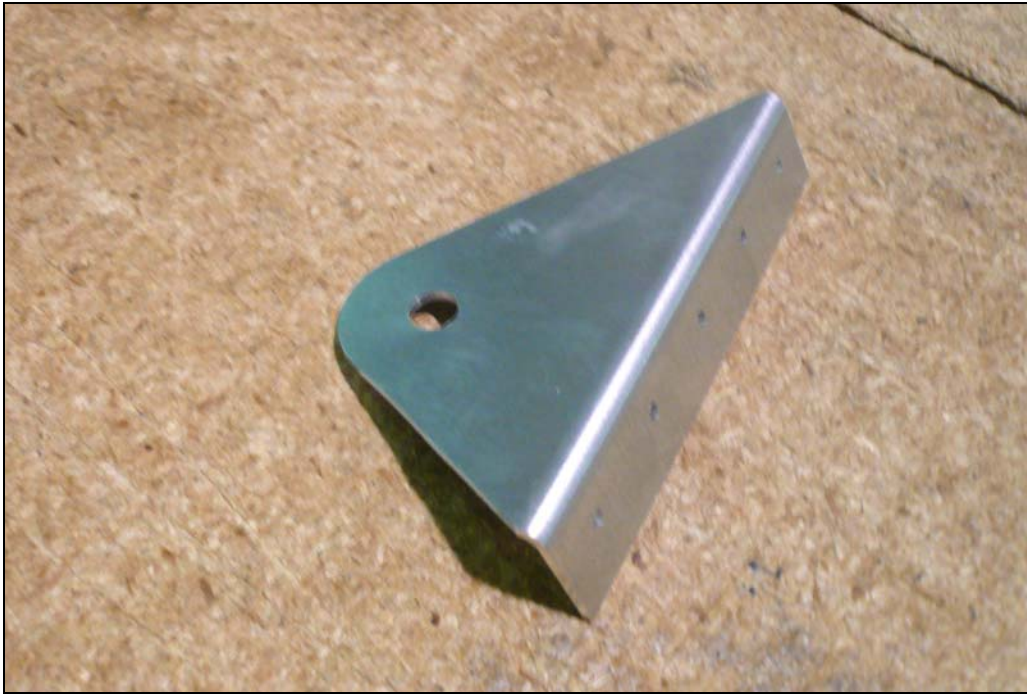


Section 75-FA-8 Seats & Seat Belts



This manual has been prepared for installation of the seats and seat belts. This photo assembly manual is intended as a supplement to the drawings. If there is any discrepancy between this manual and the drawings, the drawings supersede this manual. For more information on building standards and allowable tolerances see "Construction Standards for Zenair Light Aircraft" available from Zenith Aircraft Co.



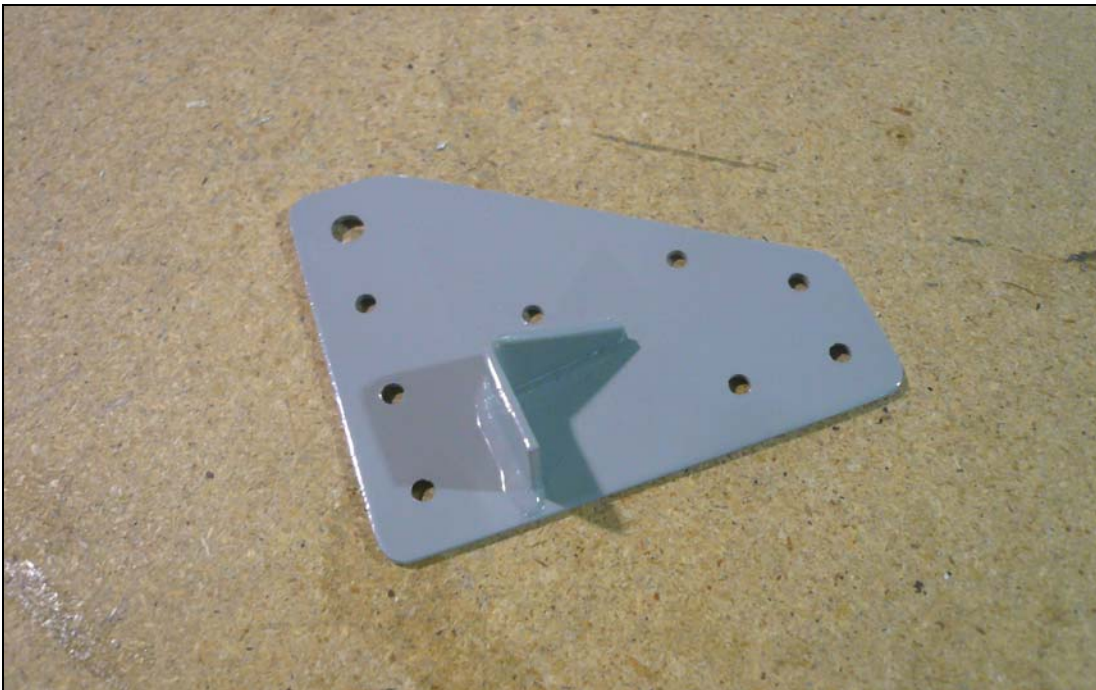
P/N: 75F13-1
Lower Seat Belt
Attachment



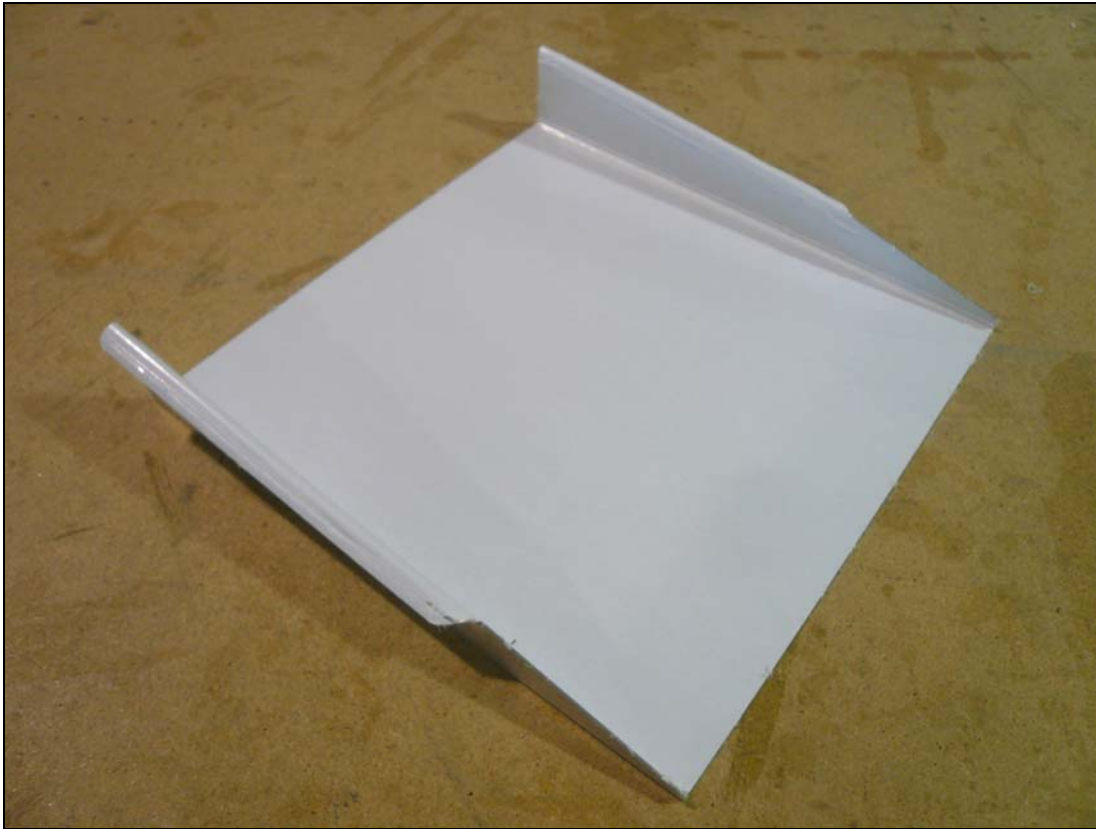
Mark a line 30mm from the top of the Longeron on the Cabin Side on the aft most extrusion (75F7-3). See drawing 75-CS-1 for the specific location of 75F7-3.



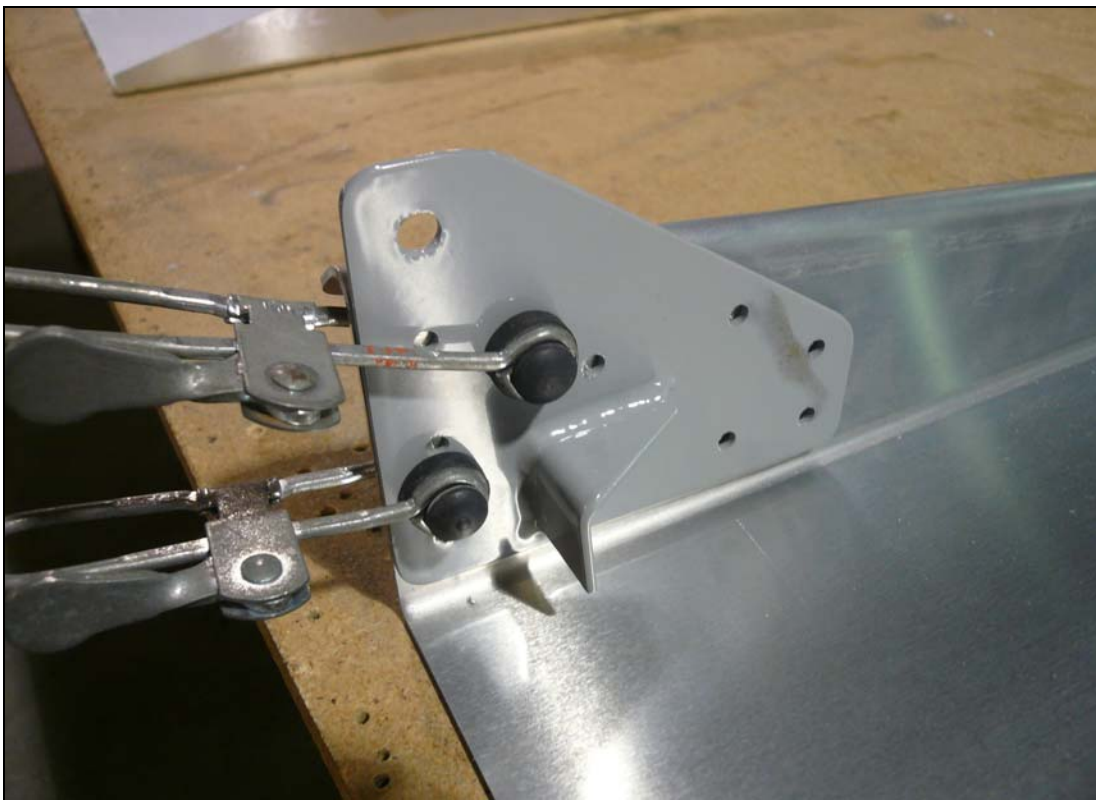
Clamp the top edge of the Lower Seat Belt Attachment flush with the mark on the extrusion. Use a #40 drill bit to back drill through the Seat Belt Attachment into the extrusion and Cleco. Expand the holes with a #30 drill bit then a #20 drill bit.



P/N: 75F13-2
Seat Back Support



P/N: 75F13-6
Seat Pan



Mark a line on the side of the Seat Pan 6mm up from the bottom of the Seat Pan. Position the bottom of the Seat Back Support flush on the line and clamp the Seat Back Support to the Seat Pan.



Use a #20 drill bit to back drill through the Seat Back Support into the Seat Pan and Cleco. Remove the Seat Back Supports, deburr, and rivet the Seat Back Supports to the Seat Pan using AS5 (stainless steel A5 rivets).



P/N: 75F13-4
Seat Back

Install the Seat Back on the Seat Back Supports. Spread the sides of the Seat Pan so the pin on the Seat Back will slip in the hole in the Seat Back Support.



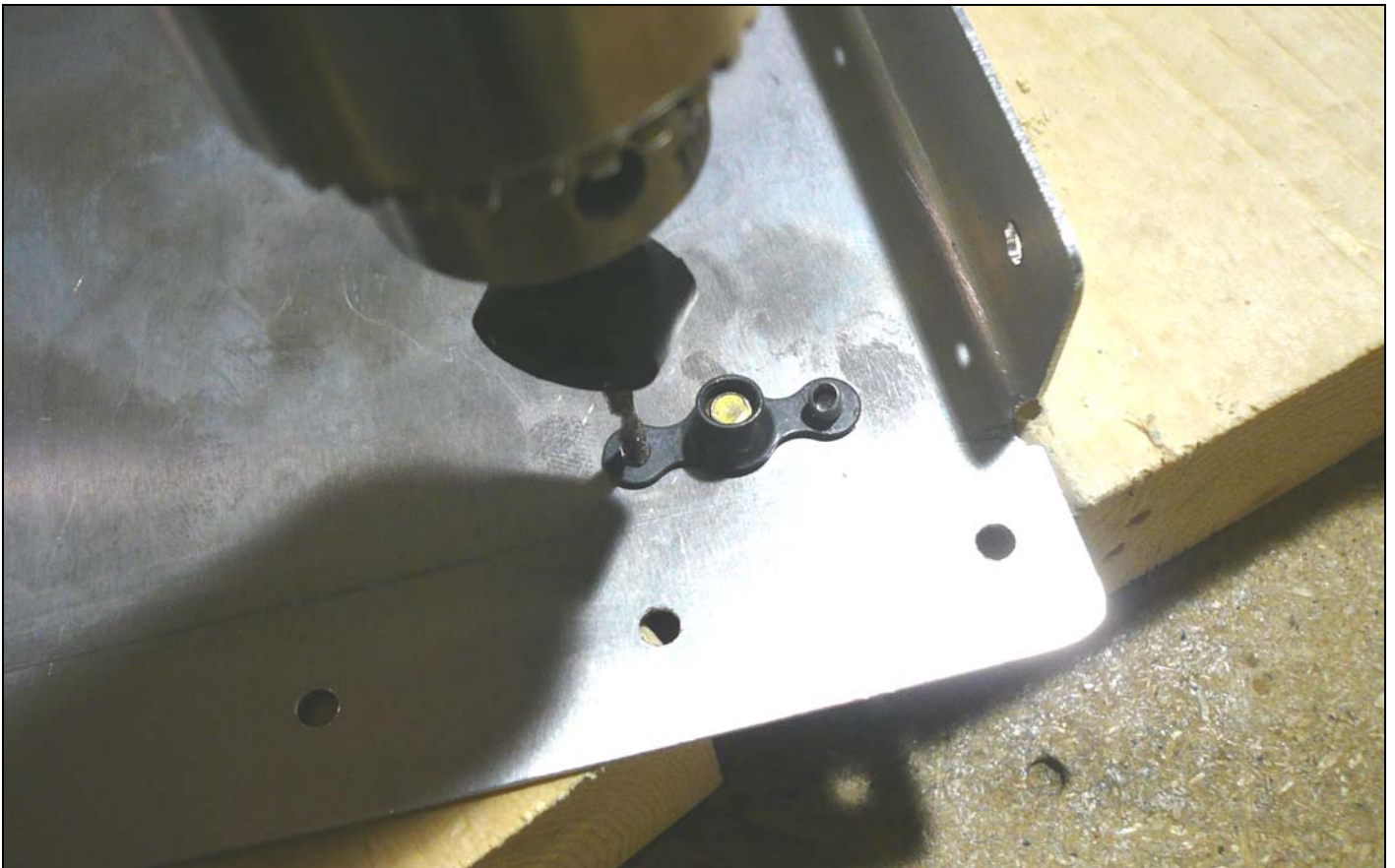
Use a punch to mark a hole location on the pin of the Seat Back. Use a #40 drill bit to drill the hole for the cotter pin. Install the Seat Back on the Seat Back Support. Use a washer and install the cotter pin to retain the Seat Back on the Seat Back Support.



Position the Seat in the Fuselage. Back drill through the Seat Pan into the Seat Base using a #40 drill bit. Expand the holes with a #12 drill bit and Cleco. Several Seat positions can be set by drill additional holes for more nut plates. When positioning the Seat further aft, check that the Seat Back has clearance on the Side Channels.



To center the Nutplate on the hole, tighten the Screw through the hole in the Seat Base on the Nutplate.

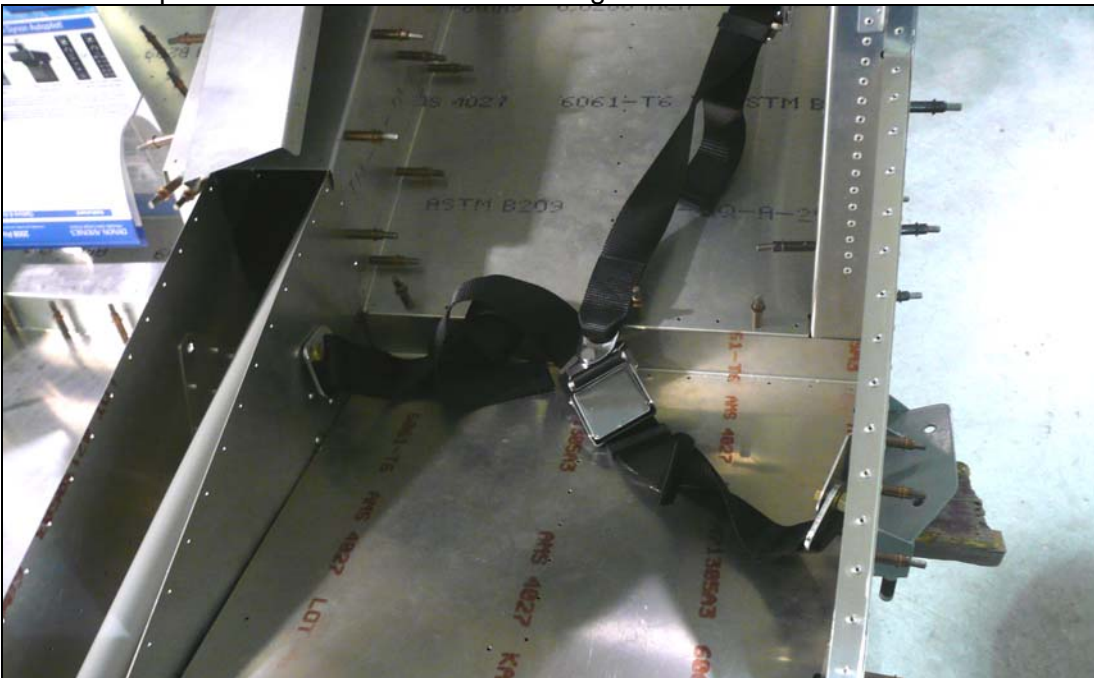


Use a #40 drill bit to back drill through the Nutplate into the Seat Base and Cleco. Deburr the holes and rivet the Nutplates to the Seat Base with A3 rivets.



Re-install the Seat Base in the Fuselage and screw the Seat to the Seat Base.

NOTE: The photo above shows clecos holding in the Seat instead of Screws.



Bolt the Seat Belt to the Seat Belt Attachments. Install a washer between the inboard Seat Belt and Arm Rest Side to prevent the Belt from Rubbing on the Arm Rest Side.

Note: Make sure the Seat Belt does not chafe on any sharp edges.