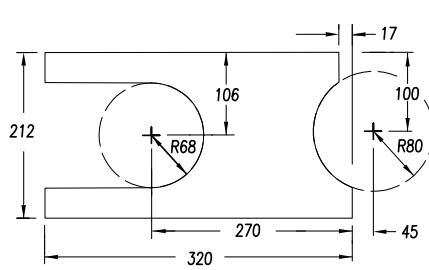
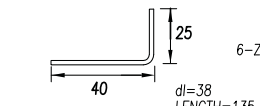


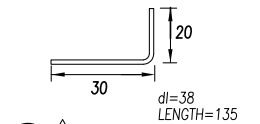
1 **EXTRUSION ANGLE**
EXT. 6061-T6 1"x1-1/2"x1/8" (2 REQ'D)



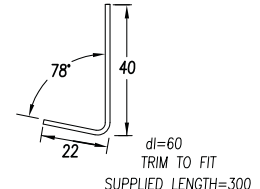
2 **WING ROOT DOUBLER**
t=.125" 6061-T6 (2 REQ'D)



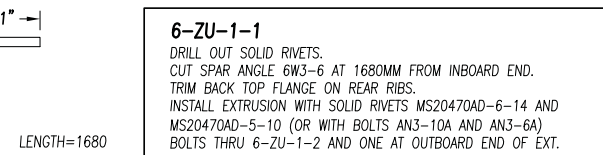
3 **NOSE RIB ANGLE**
t=.040" 6061-T6 (4 REQ'D)



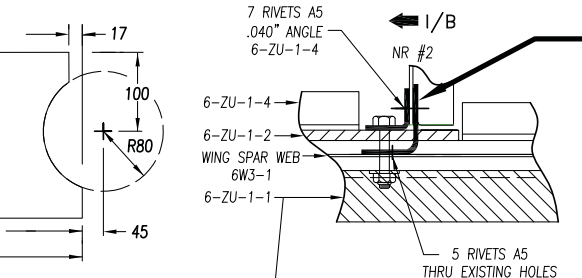
4 **RIB ANGLE**
t=.040" 6061-T6 (2 REQ'D)



5 **BOTTOM CAP ANGLE**
t=.063" 6061-T6 (2 REQ'D)



6-ZU-1-1
DRILL OUT SOLID RIVETS.
CUT SPAR ANGLE 6W3-6 AT 1680MM FROM INBOARD END.
TRIM BACK TOP FLANGE ON REAR RIBS.
INSTALL EXTRUSION WITH SOLID RIVETS MS20470AD-6-14 AND MS20470AD-5-10 (OR WITH BOLTS AN3-10A AND AN3-6A) BOLTS THRU 6-ZU-1-2 AND ONE AT OUTBOARD END OF EXT.

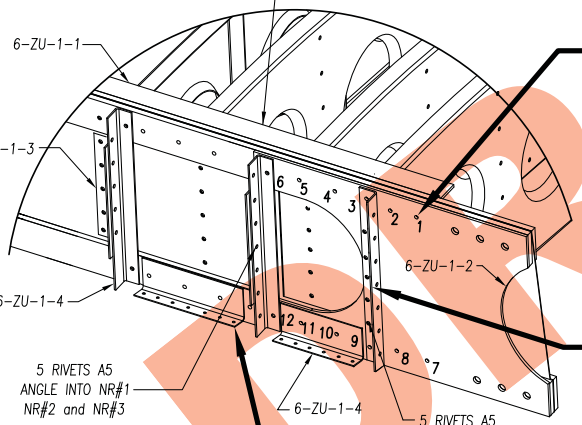


6-ZU-1-3
REPLACE 6W3-9 WITH 6-ZU-1-3.
TRIM 1/8" OFF END OF NOSE RIB#2
RIB SANDWICHED BETWEEN 6-ZU-1-5
AND 6-ZU-1-3. RIVET TO SIDE OF RIB

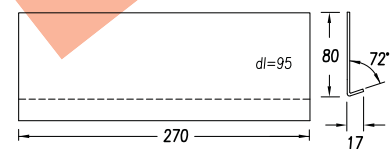
6-ZU-1-2 AIRFRAME BOLTS
REMOVE NOSE RIB #1, #2 and #3. DRILL OUT BOTTOM SOLID RIVETS TO ADD 6-ZU-1-2 ON FRONT SIDE OF SPAR.

TOP (REFERENCE NUMBER)
1 AN4-12A
2 AN3-11A
3 AN3-12A ANGLE NR #1 (2 WASHERS)
4 AN3-11A (2 WASHERS)
5 AN3-11A (2 WASHERS)
6 AN3-12A ANGLE NR #2 (2 WASHERS)
7 AN4-11A
8 AN3-11A (2 WASHERS)
9 AN3-11A ANGLE NR#1
10 AN3-11A 6-ZU-1-4
11 AN3-11A 6-ZU-1-4
12 AN3-11A ANGLE NR#2

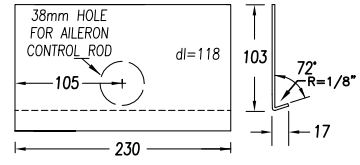
BOTTOM
AN3-6A END OF 6-ZU-1-1



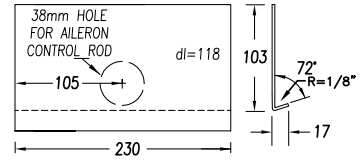
6-ZU-1-4
ADD ANGLE BETWEEN NOSE RIBS 1-2 AND 2-3 SOLID RIVETED



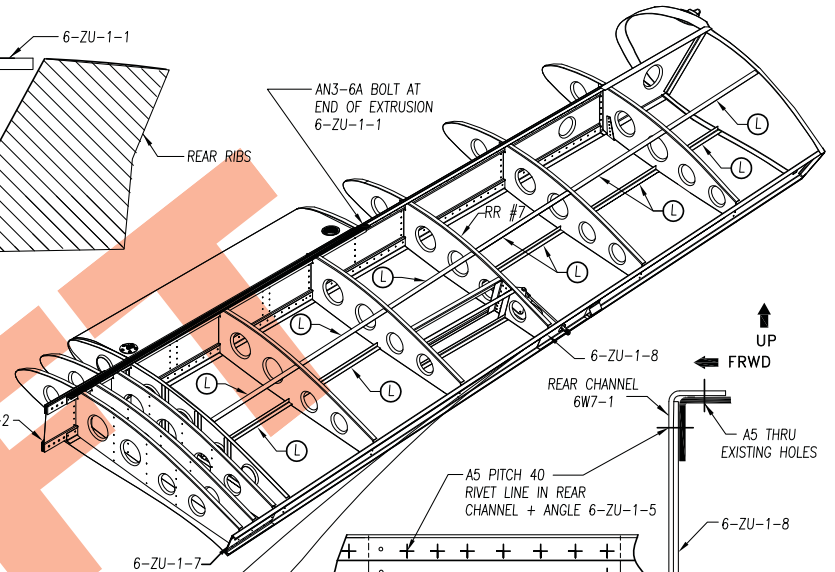
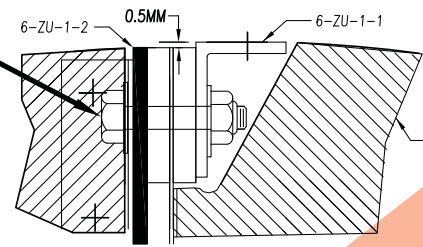
6 **CHANNEL ANGLE**
t=.040" 6061-T6 (4REQ'D)



7 **REAR CHANNEL DOUBLER**
t=.040" 6061-T6 (2 REQ'D)



8 **AILERON ROD HOLE DOUBLER**
t=.032" 6061-T6 (2 REQ'D)



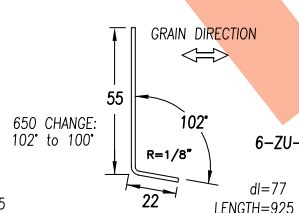
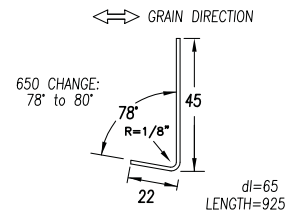
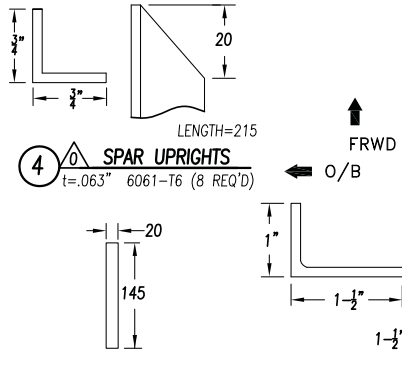
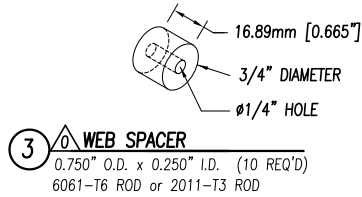
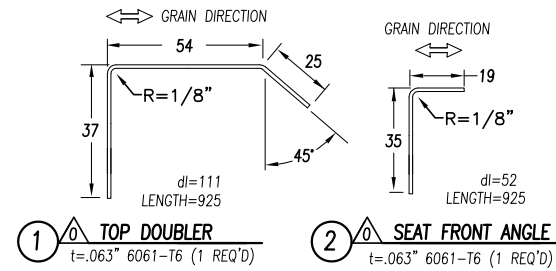
6-ZU-1-8
ADD DOUBLER PLATE CENTERED ON HOLE FOR AILERON ROD.

6-ZU-1-6
TOP FLANGE OF REAR CHANNEL IS DOUBLED ALONG FULL LENGTH WITH SPAR ANGLE 6-ZU-1-3 OVERLAP EACH PIECE 100MM

6-ZU-1-7
REPLACE HINGE DOUBLER 6W7-3 WITH REAR DOUBLER 6-ZU-1-5

6-X-0 TECHNICAL DATA CH 601 XL / 650 ASTM SLSA REQUIREMENTS:
GROSS WEIGHT 1320 LBS (600kg), VNE =160MPH (260 Km/h), ULTIMATE LOAD +6/-3G

ZODIAC CH 601 XL / 650	UPGRADE DRAWINGS WING SPAR & REAR CHANNEL	6-ZU-1
Copyright © 2009 CHRIS HEINTZ		DATE: 24 NOV 2009



AIRFRAME BOLTS

WING ATTACHMENT BOLTS:

- NAS6205-23 QTY=4
- NAS6205-22 QTY=4
- NAS6205-22 QTY=4

CENTER SECTION BOLTS:

- AN4-17A QTY=4
- AN4-17A QTY=4
- AN4-16A QTY=2

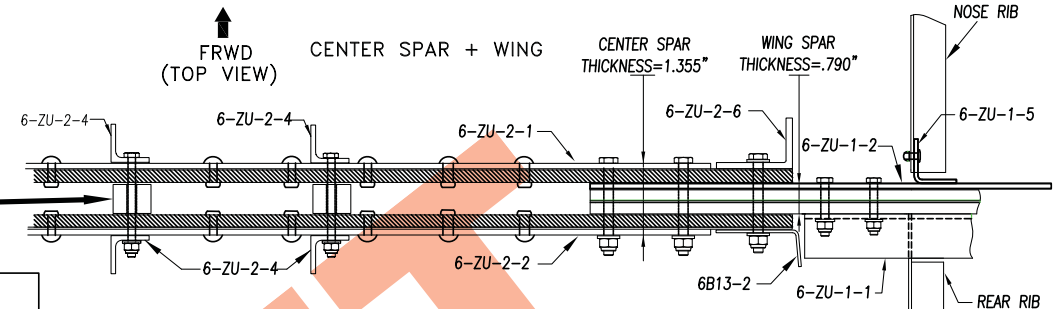
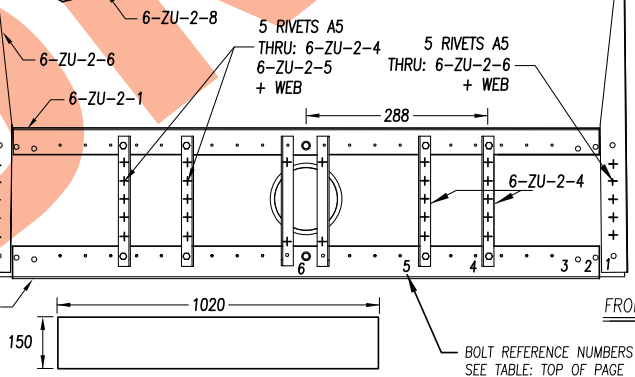
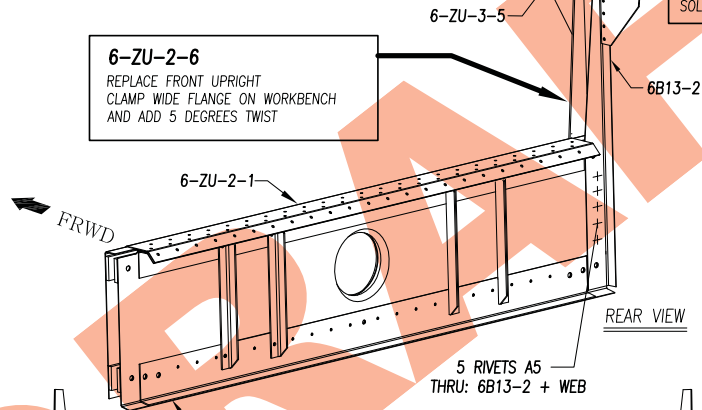
(REFERENCE NUMBERS - SEE BOTTOM DIAGRAM
- SAME BOLTS TOP AND BOTTOM)

6-ZU-2-3

FIRST SOLID RIVET 6-ZU-2-7 AND 6-ZU-2-8 TO CAPS, REPLACE SPACERS AND RE-ASSEMBLE WITH LONGER BOLTS.

6-ZU-2-6

REPLACE FRONT UPRIGHT CLAMP WIDE FLANGE ON WORKBENCH AND ADD 5 DEGREES TWIST



6-ZU-2-1

DRILL OUT SOLID RIVETS ADD DOUBLER ON TOP OF SPAR RE-ASSEMBLE WITH SOLID RIVETS THRU MIDDLE UPRIGHTS

6-ZU-2-4

UPRIGHTS OVERLAP ON TOP OF DOUBLER

6-ZU-2-5

ADD A SHIM BETWEEN WEB AND UPRIGHT. RIVET UPRIGHT TO WEB

6-ZU-2-7

DRILL OUT SOLID RIVETS CUT OFF FRONT BOTTOM FLANGE OF WEB 6W4-1. OVERLAP ANGLE ON FRONT SIDE OF WEB. SOLID RIVET SPAR ASSEMBLY

6-ZU-2-9

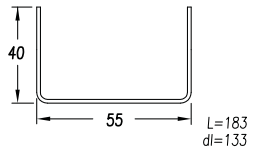
OVERLAP ON OUTSIDE OF FUSELAGE DRILL THRU EXISTING HOLES ADD FRONT RIVET LINE

6-ZU-2-2

DRILL OUT SOLID RIVETS ADD DOUBLER ON BACK SIDE IN TOP CORNER. ASSEMBLE WITH SOLID RIVETS

6-ZU-2-8

DRILL OUT SOLID RIVETS ADD ANGLE ON TOP OF WEB AND BOTTOM FLANGE. SOLID RIVET SPAR ASSEMBLY

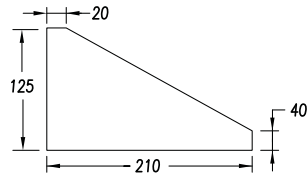


6-ZU-3-5
 ADD GUSSETS 6-ZU-3-4 AND 6-ZU-3-5 OVERLAP OF UPRIGHT 6-ZU-2-6 AND LONGERON 6B11-1
 DRILL OUT RIVETS IN FUSELAGE SIDE SKIN AND INSTALL GUSSET WITH STAINLESS STEEL RIVETS ASS

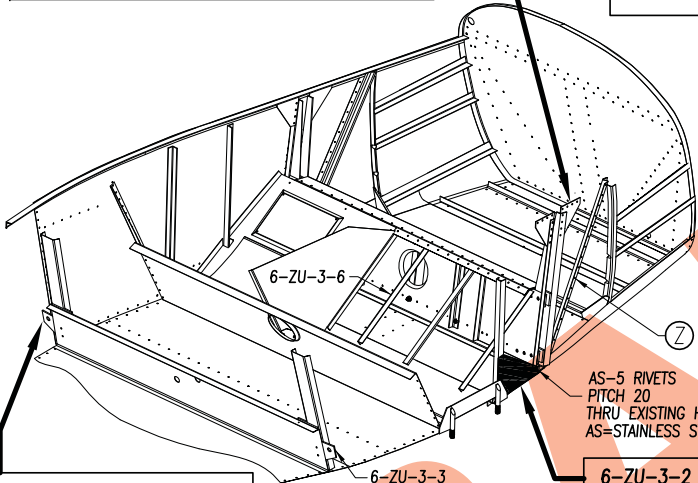
SPAR RIVET LINE
 DOUBLE UP RIVET LINE THRU SPAR EXTRUSION [TOP] AND SPAR ANGLE [BOTTOM] UP TO RR # 5
 A5 PITCH 20

A5 PITCH 20
 BETWEEN NR #1 AND NR#2 INTO 6-ZU-1-5
 BETWEEN NR #2 AND NR#3 INTO 6-ZU-1-5

1 BELLCRANK SUPPORT CHANNEL
 t=.040" 6061-T6 (2 REQ'D)



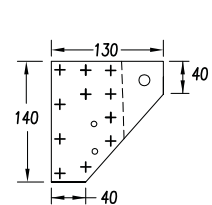
2 SIDE DOUBLER
 t=.063" 6061-T6 (2 REQ'D)



L ANGLES, QTY=4
 ADD L ANGLES BETWEEN REAR RIBS - ENDS
 RIVETED TO FLANGES OF BELLCRANK CHANNEL 6-ZU-3-1
 RIVETED TO TOP AND BOTTOM SKIN WITH A4 PITCH 40
 VIEW FRONT TOP OF RIGHT WING

6-ZU-3-1
 REPLACE BELLCRANK SUPPORT CHANNEL 6W6-10 BY 6-ZU-3-1
 REINSTALL BELLCRANK SUPPORT 6W6-11 PER DRAWINGS 6-W-6
 A5 RIVETS THRU EXISTING HOLES

AS-5 RIVETS
 PITCH 20
 THRU EXISTING HOLES AND ALONG SIDE
 AS=STAINLESS STEEL RIVETS

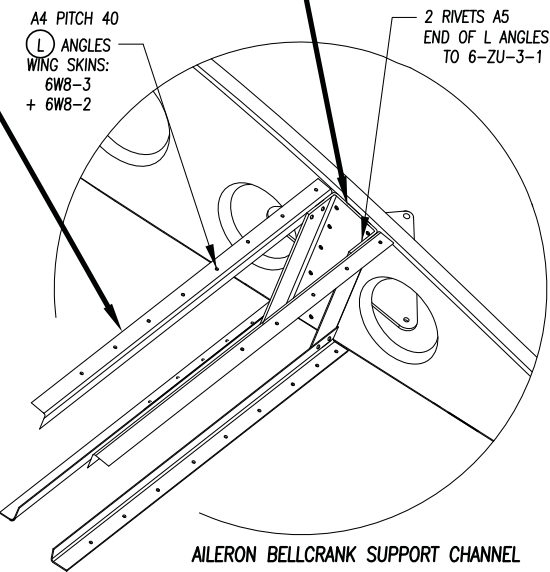


3 ATTACH PLATE
 t=.125" 6061-T6 (1L + 1R REQ'D)

6-ZU-3-3
 XL ONLY - REPLACE REAR WING ATTACH PLATE 6B5-4 WITH THICKER MATERIAL 6-ZU-3-3

6-ZU-3-2
 ADD FUSELAGE SIDE DOUBLER OVERLAPS OUTBOARD FLANGE OF GUSSET 6B10-4
 REPLACE AN3 BOLTS

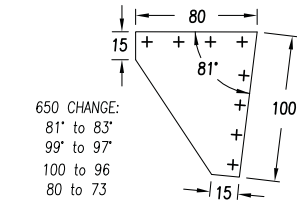
6-ZU-3-6
 REPLACE EXISTING L ON SIDES OF ACCESS CUTOUT WITH LONGER ANGLES 6-ZU-3-6 ADD ANGLE 6-ZU-3-6 IN CORNER OF SEAT 6B15-4 AND ARM REST SIDES 6B18-1
 REINSTALL NUTPLATE OR RIV-NUT FOR SPAR ACCESS COVER 6B18-5



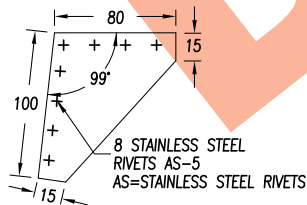
A4 PITCH 40
 L ANGLES
 WING SKINS:
 6W8-3
 + 6W8-2

2 RIVETS A5
 END OF L ANGLES
 TO 6-ZU-3-1

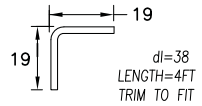
AILERON BELLCRANK SUPPORT CHANNEL



4 REAR UPRIGHT GUSSET
 t=.063" 6061-T6 (2 REQ'D)



5 FRONT UPRIGHT GUSSET
 t=.063" 6061-T6 (2 REQ'D)



6 SEAT ANGLES
 t=.040" 6061-T6 (3 REQ'D)

Z ANGLE
 ADD DIAGONAL STANDARD Z ANGLE TO FUSELAGE SIDE SKIN - FROM FRONT BOTTOM OF SPAR TO CORNER BETWEEN VERTICAL L ANGLE AND LONGERON.

ZODIAC CH 601 XL / 650	UPGRADE DRAWINGS BELLCRANK CHANNEL - SEAT ANGLES	6-ZU-3
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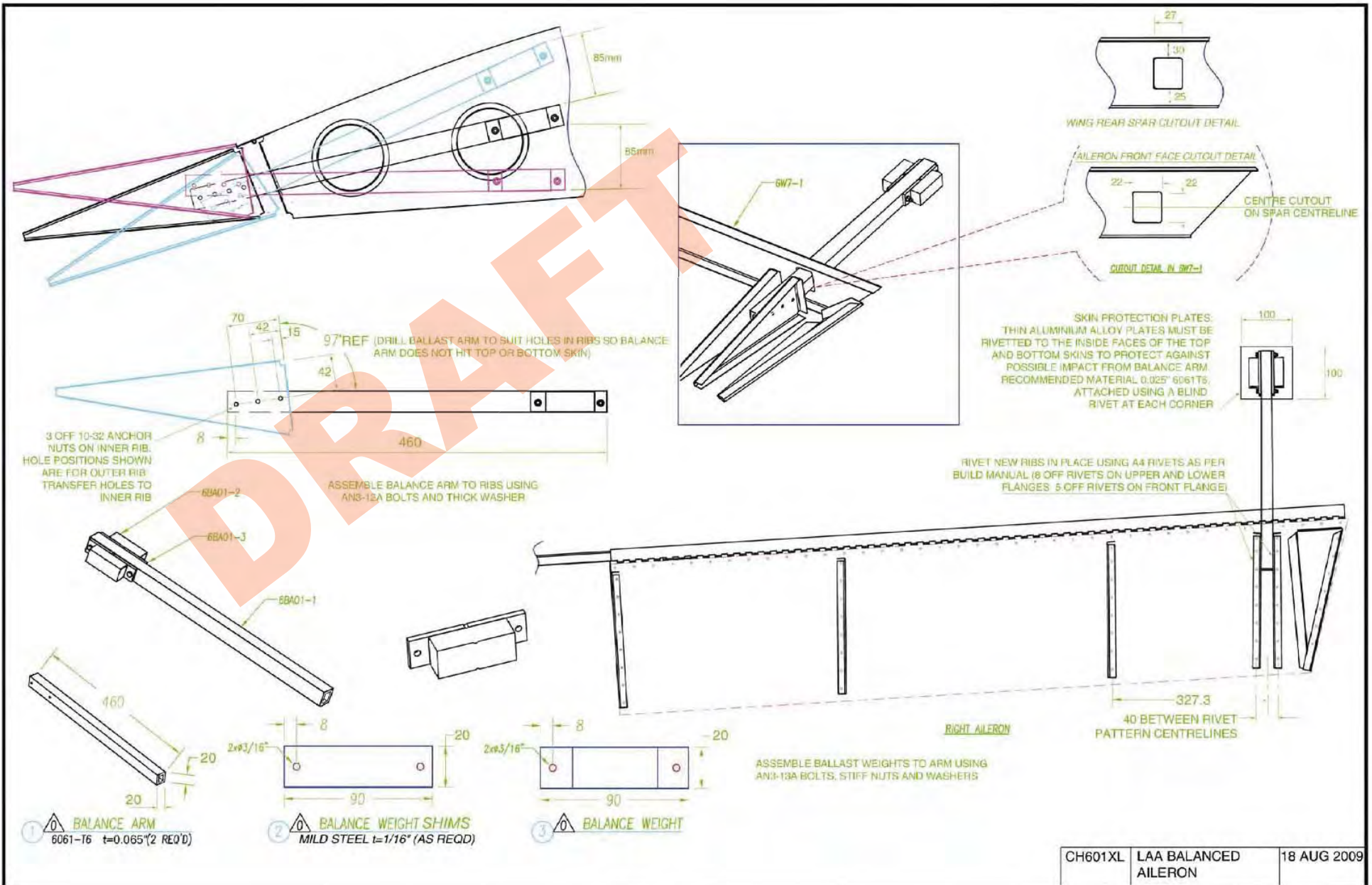


FIGURE 4