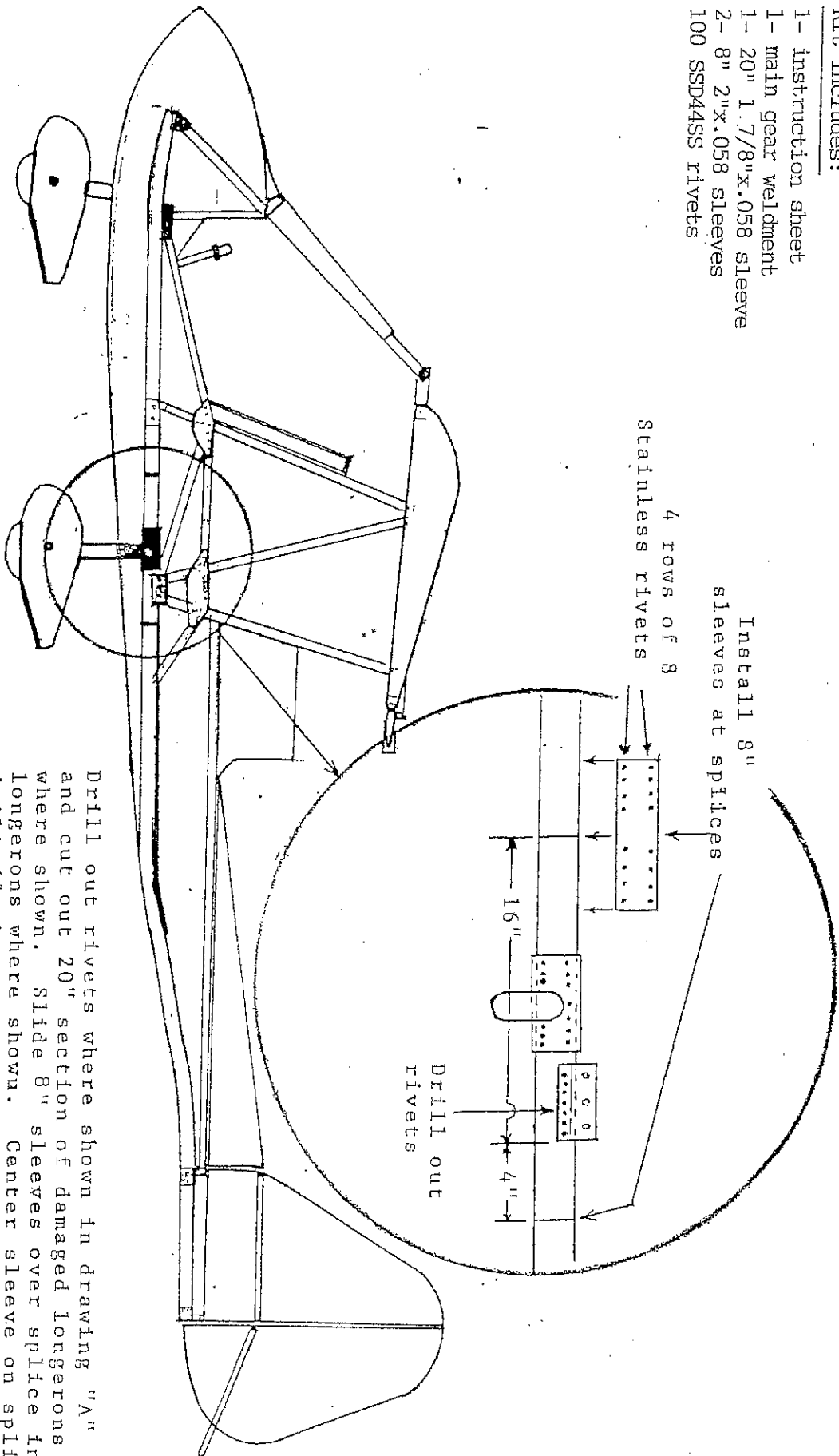


Kit Includes:

- 1- instruction sheet
- 1- main gear weldment
- 1- 20" 1.7/8"x.058 sleeve
- 2- 8" 2"x.058 sleeves
- 100 SSD44SS rivets



REPLACEMENT PROCEDURES FOR  
DAMAGED GEAR WELDMENTS ON  
1 & 2 PLACE CHALLENGERS

Drill out rivets where shown in drawing "A" and cut out 20" section of damaged longrons where shown. Slide 8" sleeves over splice in longrons where shown. Center sleeve on splice, drill (#30) and install stainless rivets, (after installing new repair section). Drill and install stainless rivets in down tubes Russett, gear weldment and 1 1/4" cross tube as before. Re-install landing gear cables. NOTE: WHEN CUTTING OUT DAMAGED SECTION, BE SURE TO CUT ON THE INSIDE OF MEASURED MARKS SO THAT THE OPENING IS 20" EXACTLY.

**STEP #1**

4.75"

**Cut the longeron 4.75" forward of the weldment as shown ( 5.25" with older 5" weldment )**

**Cut the longeron splice to 15.875"**

**STEP #2**

15 7/8"



**STEP #3**

Carefully measure back 15-7/8" from the front cut to the rear, mark and cut

Use a tubing cutter if available but make sure these cuts are nice and square. A hack saw will work but mark where to cut by wrapping a piece of straight edge paper around the longeron and mark with Sharpy marker.

Cut the outer sleeve splices to the lengths shown below, assemble new longeron piece, new weldment, front and rear splices and assemble as shown here. You will have to slide the outer splices out to center on cuts made previously.



**STEP #4**

Cut this outer sleeve 5.125" if you have the 6" weldment shown here but add a half inch for the older 5" weldment.

The front sleeve should be 4.75" for the newer weldment and 5.25" for the older weldment.

**USE PLENTY OF STAINLESS RIVETS. THREE OR FOUR ROWS AT EACH LOCATION.**