Installing Tip Weights in Swept tip Blades

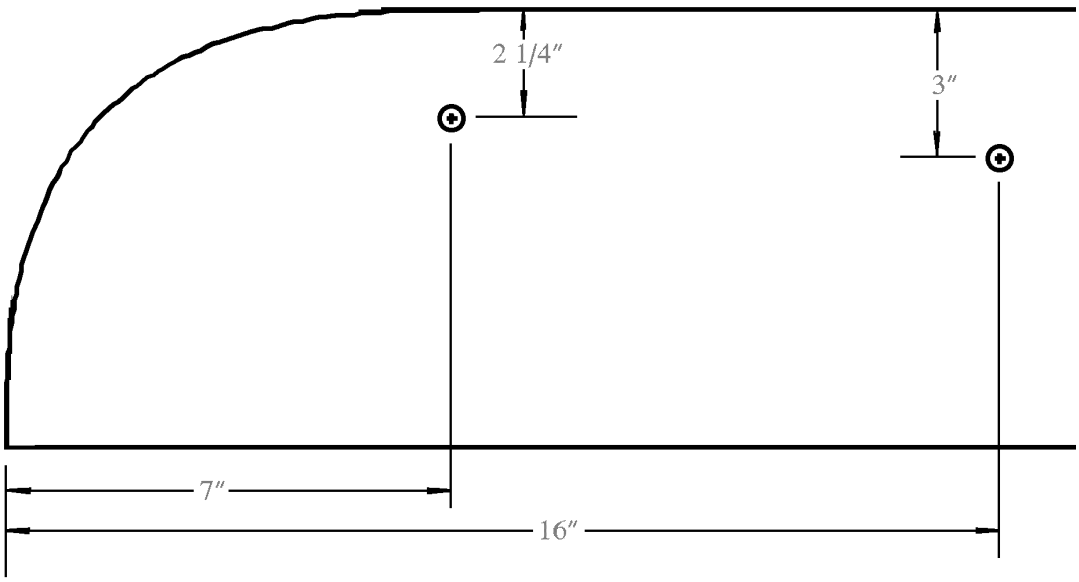
1. Working on the top of the blade, mark the location of the two holes. (See below)
2. Drill both locations through the blade with 1/8" pilot hole. Then with a #3 drill.

Note: The outboard hole (nearest the swept tip) should be going through solid material (The aluminum spar should not be hollow at this location) The inboard hole will be passing through a hollow part of the spar.

3. Enlarge both holes only on the top sides to ¼". Do not drill through the lower side of the aluminum spar.
4. Tap both of the lower sides of the holes to ¼"-28 NF.
5. Using a AN509-416-R22 bolt as a guide countersink the top holes.
6. After threading the bolts flush, measure the excess threads and cut off.
7. Install one bolt in the outboard hole with locktite.

Note: Determine where the epoxy material that makes up the tip ends. You can do this by inserting some safety wire in the inboard hole and bend up toward the tip. When you feel the end, pull out and measure. Repeat on the other blade. The tip material should end approximately 1"-2" from the bolt from step 7 and be within 1" of the other blade. If not, contact the factory.

8. Mix epoxy glue (It must be thin) and squirt 20 cc in the inboard hole. (Use a syringe) Stand blade so root is up for a few minutes to let glue settle in tip.
9. Now pour 1 lb. of #9 lead shot in hole. Then follow it with 50 cc of glue and stand up as in step 9. Let cure over night.
10. Install bolt with locktite. Repeat all steps on other blade.


2 1/4″
3″
7″
16″