

33. Engine Installation



Revision #	Date	Detail of changes
1	4-9-2009	Original
2	4-23-2012	Addition of torque Specs. Also use of Special Process Control form.
3	6-27-2013	Document number changed

33. Engine Installation

LS-1

Section Overview: Correct Installation of engine to engine mount.

Required Parts: Jabiru 3300A engine

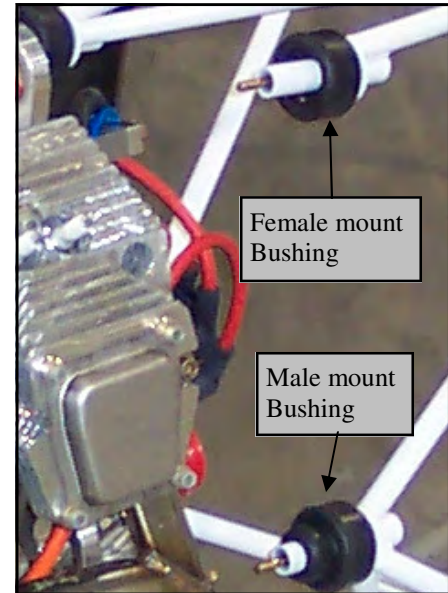
Required Hardware: 4 AN4-31A bolts, 8 AN960-416 washers, 4 AN363-428A heat nut

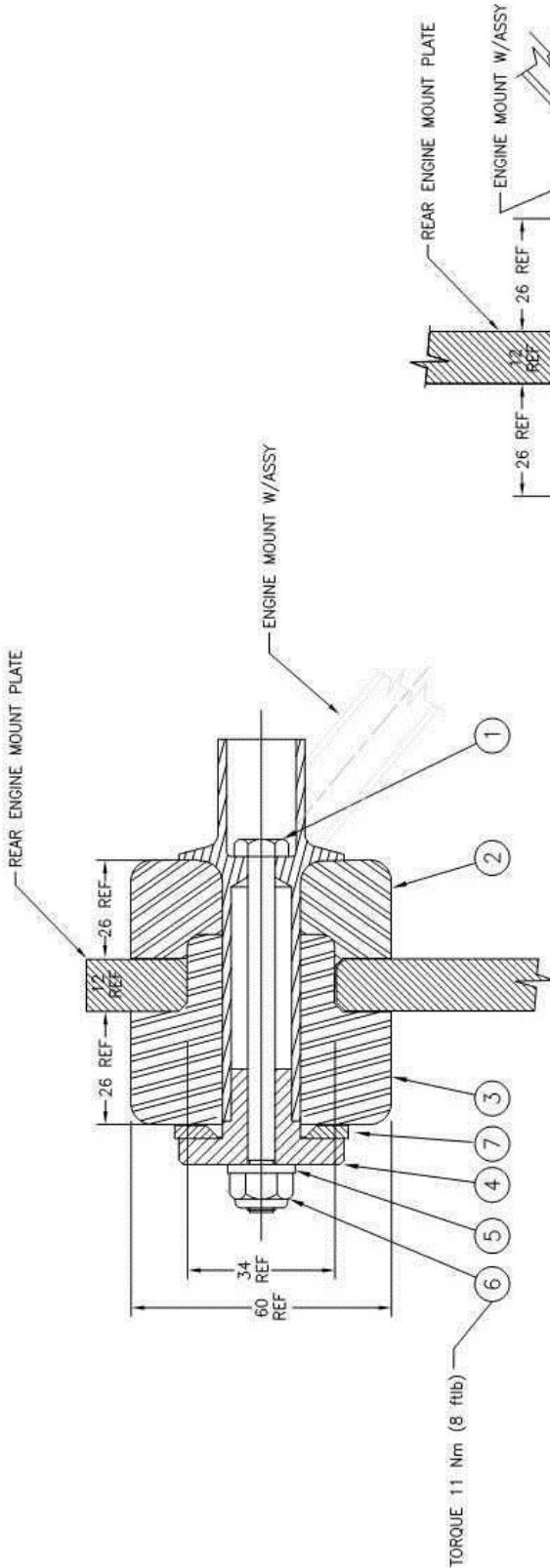
Required Tools: SAE socket set, SAE wrench

Required Conditions: None

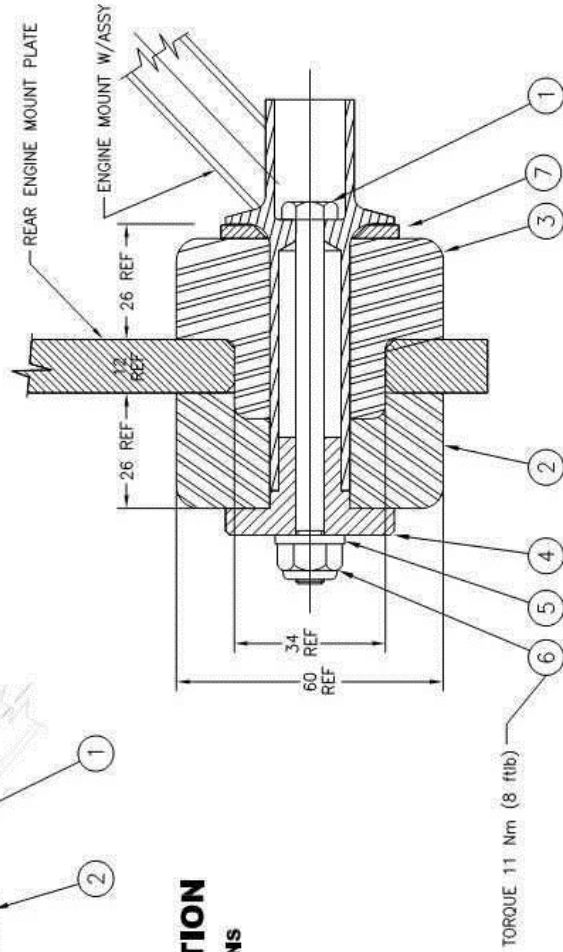
Required Skills or Training: Basic use of hand tools, and knowledge required to use them, ability to read and carry out directions, read and understand simple CAD drawings.

1. Installation of the Jabiru 3300 engine to the engine mount is fairly straight forward.
2. Refer to the drawing at the end of this document #9606004 for the correct configuration of the installation.
3. Locate the male rubber bushings. Slide 1 of these on each of the lower mount pins.
4. Locate the female bushings, slide 1 of these on each of the upper mount pins.
5. Insert a AN4-31A bolt into each mount pin from the rear facing forward.
6. Using the proper hoist place the engine against the mount as need to align the mount pin with their respective engine back plate mounts.
7. Slide the male rubber bushings onto the upper pins.
8. Insert the aluminum washer ,#4 on drawing , into the rubber bushing and the mount pin.
9. IF the bolt is not protruding from the aluminum washer, use a clamp or other similar tool to compress the rubber bushing until bolt threads are showing.
10. Install a AN960-416 nut on the bolt.
11. Than install a AN363-428A heat nut on the bolt, tighten only by hand do not torque.
12. Lower the hoist and allow the engine to slide onto the lower mount bushings.
13. Install the female bushing onto the mount pins.
14. Install the Aluminum washer, #4 on drawing.
15. Compress the bushing as earlier described and install an AN960-416 washer on the bolt
16. Than install a AN363-428A heat nut, tighten but do not torque.
17. With all of the bolts and nut installed the final torque values can be set.
18. Before torqueing, verify that the Torque wrench to be used is within the calibration period .
19. Torque all bolts to 8ftlbs as specified on drawing 9606004.
20. Log and record on the Special processes control sheet AA-SPC-LS1-1, that the bolts were torque to the value specified and that the wrench calibration was verified before beginning.





UPPER ENGINE MOUNT CONFIGURATION
APPLICABLE JABIRU 2200, AND 3300 ENGINE INSTALLATIONS



LOWER ENGINE MOUNT CONFIGURATION
APPLICABLE JABIRU 2200, AND 3300 ENGINE

ITEM	PART No.	DESCRIPTION	QTY.
7	4214934	WASHER- ENG MNT SPACER	1
6	MS21042-4	NUT	1
5	AN960-416	WASHER	1
4	4094224	WASHER ENGINE MOUNT	1
3	PG10722N	CUSHION MOUNT MALE	1
2	PG10712N	CUSHION MOUNT FEMALE	1
1	AN4-31A	BOLT	1

SCALE	1	010528
ISS.	1	001109
DATE		
DWG. NO.	9606004	
SHEET 1 OF 1	A3	
TITLE	VIBRATION MOUNT INSTALLATION	
AVTECH P/L	HINKLER AIRPORT	
A.C.N. 010 786 973	BLINDBERG	
APK		
APPR.		
PURCHASED PARTS TO	PS22J-10	
LIMITS		