

CHAPTER 2 - KIT REMOVAL FROM THE TRANSPORT



2-1 SAFETY RECOMMENDATIONS:

Before starting the removal **V400** Kit from the transport (Container or Truck) the assembler shall:

- PROVIDE transport device, such as tables with casters, and the load lifting device , such as Winch, Crane or Hoist, all with load capacity above 1,000 pound (400 kg);
- USE **PERSONAL PROTECTIVE EQUIPMENT - PPE**, safety glasses, boots and gloves.



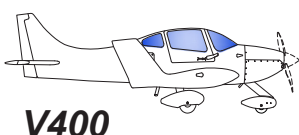
- DO NOT START any operation without these safety preparations.

2-2 INTRODUCTION:

The handling of the **V400** Kit shall be carried out with great care.

The entire operation must be planned, and PROVIDE:

1. the manufacture of the Wood Stands (**A**, **B**, **C** and **D**), as described in Chapter 1, so that the handling of the Kit is safe, avoiding damage to the structure of the aircraft, before removing the **V400** Kit from the Container or on the transport (Truck);





2. qualified persons to assist in the removal of the **V400** Kit from the Container or Truck;
3. a flat, smooth and clean surface of the workshop where the **V400** Kit will be mounted;
4. PPE for all persons involved in the operation.

The Fuselage and the Wings Set come from the factory fixed in TRANSPORT SUPPORTS (1) (2) (3), used only for this operation (figures 2-1 and 2-2). Inside the Fuselage are other parts that are part of the Kit.

WEIGHTS TO BE OBSERVED FOR REMOVAL OF THE KIT:

- *FUSELAGE PACKED WITH KIT PARTS* - **300 lb (140 kg)**
- *WINGS SET* - **220 lb (100 kg)**

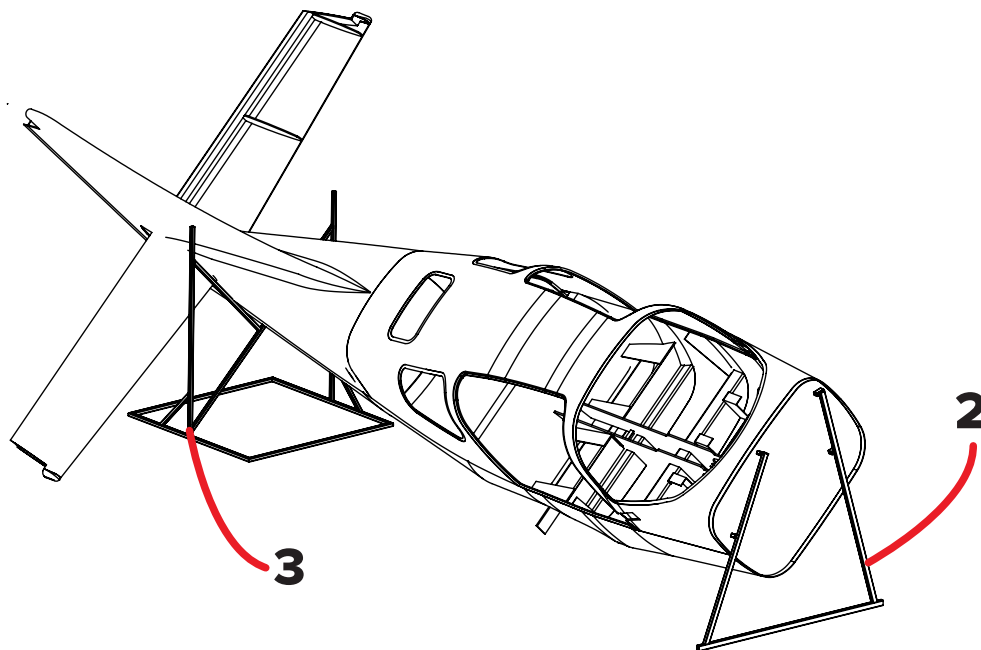
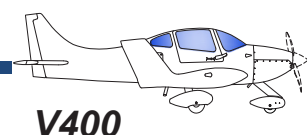


FIGURE 2-1 - FUSELAGE PACKED



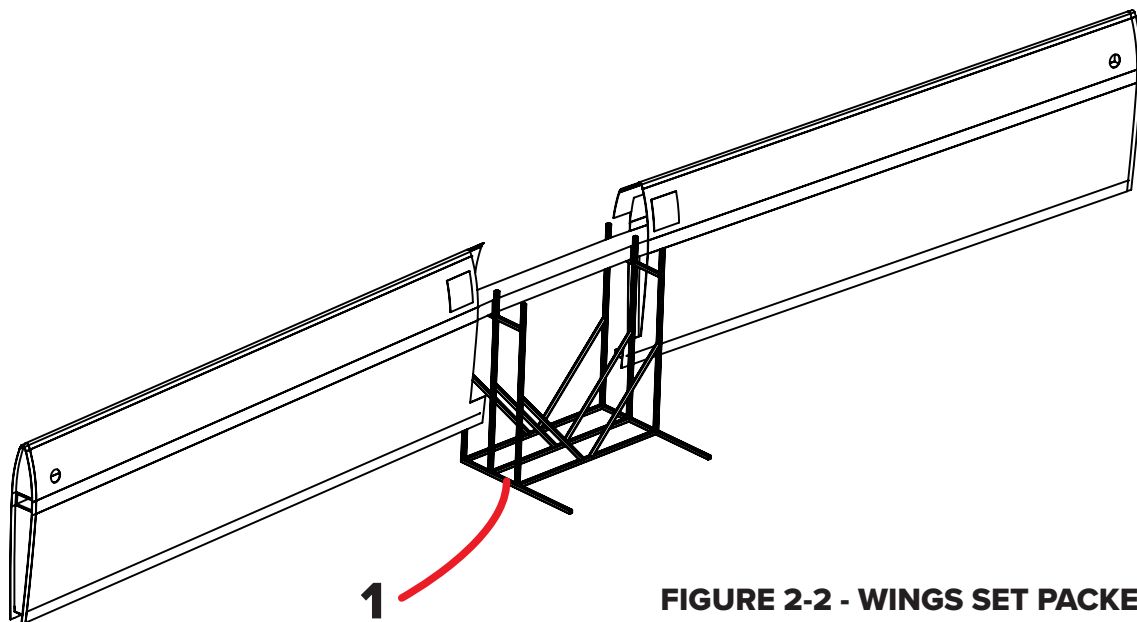


FIGURE 2-2 - WINGS SET PACKED

2-3 MATERIAL:

1. manual tools suitable for this type of operation;
2. 06 plates of 2" thickness of soft foam, in the about dimensions of 16 x 5 inches (40 x 13 cm).
3. 03 webbing sling / lifting belt with load capacity above 1,000 pounds, and length above 15 ft (4 m), and width 3 in (7.5 cm);

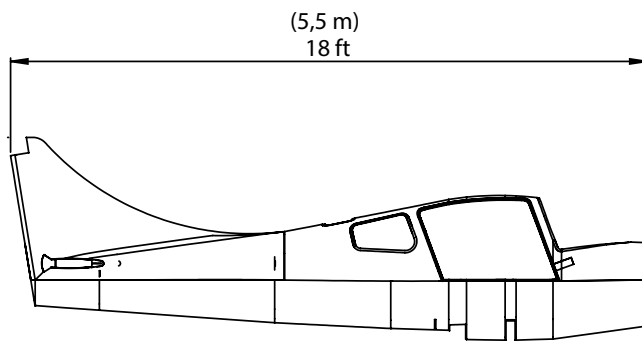
**2-4 PROCEDURES:**

1. PLAN the workshop locations where Fuselage and Wings Set will be located. CONSIDER areas around these two components so that there is good circulation and access to all parts of these components;

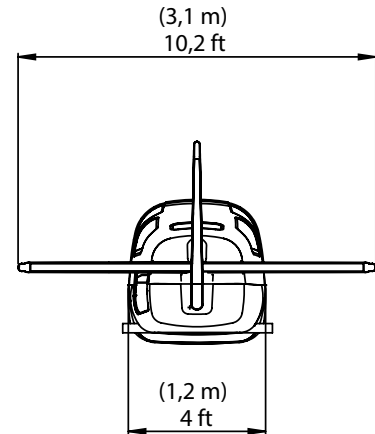




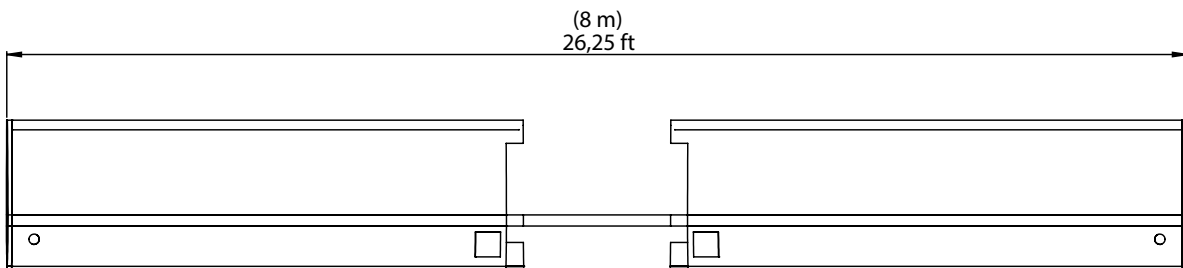
2. OBSERVE figure 2-3;



FUSELAGE LATERAL VIEW



FUSELAGE REAR VIEW



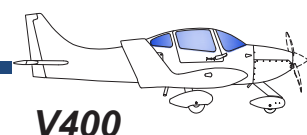
WINGS SET TOP VIEW

FIGURE 2-3 - DIMENSION OF FUSEGE AND WINGS SET

3. VERIFY that the Wood Stands type **A**, **C** and **D** (SEE Chapter 1) are properly positioned in the workshop according to the planning carried out;
4. PLACE on each Wood Stands a soft foam plate to protect the surfaces of the Wings and Fuselage (figure 2-6);

REMOVAL OF THE WING ASSEMBLY:

5. REMOVE all plastic film that packs the Wing Set, before any operation;



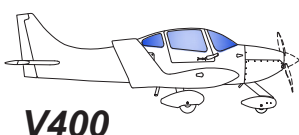
6. PLACE the webbing sling / lifting belt on the WINGS TRANSPORT SUPPORTS (1) (figure 2-4);
7. POSITION the load lifting device as close as possible to the Container or the Truck, to allow the Wings Set to be lifted by the webbing sling / lifting belt ;
8. LIFT not more than 2 to 3 inches the WINGS TRANSPORT SUPPORTS (1) of the transport floor (figura 2-4);
9. REMOVE with care the Wings Set from the interior of the transport (Container or Truck) by lifting ONLY by the WINGS TRANSPORT SUPPORTS (1) by the webbing sling / lifting belt (figure 2-4);
10. KEEP the balance of the Wings Set with the help of 2 people, without performing any type of physical effort (figure 2-4);
11. MOVE the Wings Set to the place where the Stands type **A** are positioned;

**ATTENTION!****RISK OF ACCIDENT AND DAMAGE TO THE WINGS SET.**

HANDLE the Wing Set **ALWAYS** by means of the Transport Supports (1).

NEVER FASTEN the lifting belt by the skin of the Wings. This can damage and compromise the integrity of this set.

12. PLACE the webbing sling / lifting belt on the Spar (figure 2-5);
13. LIFT the Wings Set by the Spar enough to remove of the WINGS TRANSPORT SUPPORTS (1);



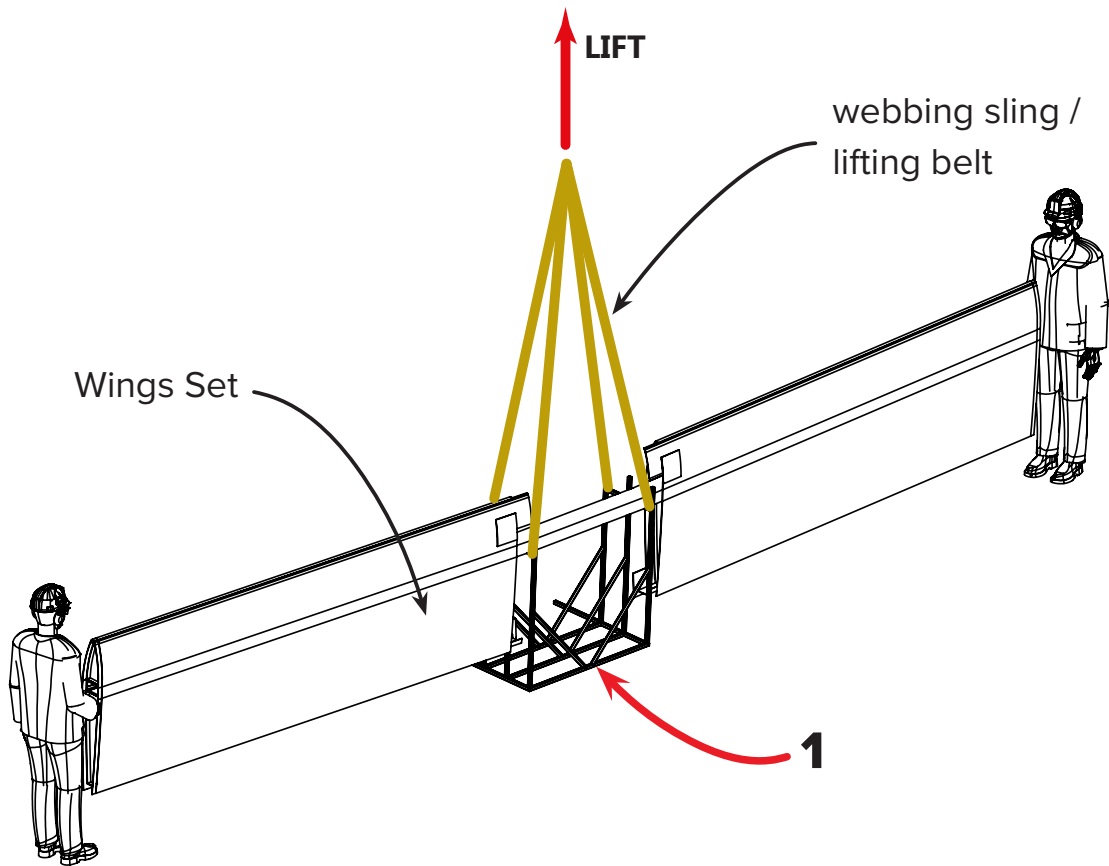
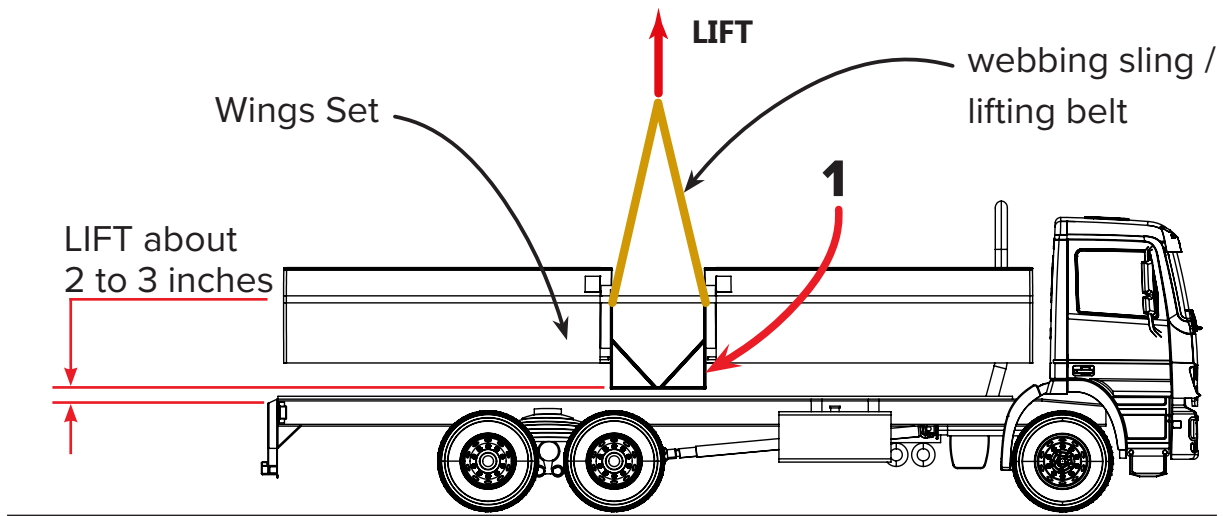
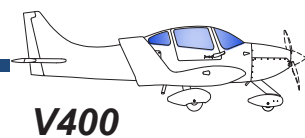


FIGURE 2-4 - WINGS SET REMOVAL FROM TRANSPORT



14. REMOVE the WINGS TRANSPORT SUPPORTS (1);
15. TURN the Wings Set carefully, with the upper surface to upward;
16. PLACE the Wings Set on the Stands type **A** (figure 2-6);
17. CHECK that the the Wings Set is well supported and without movement;

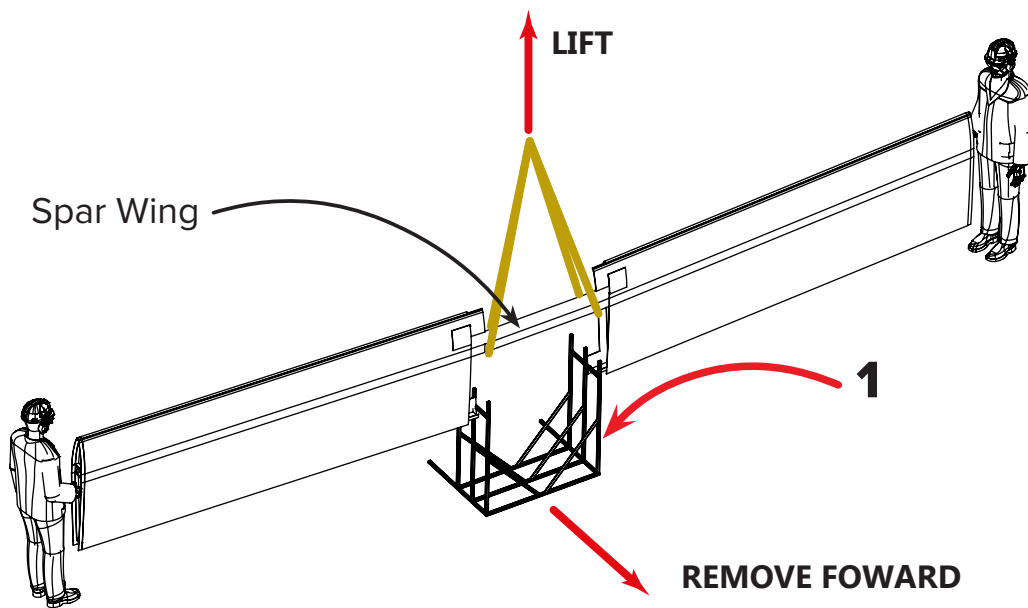


FIGURE 2-5 - REMOVAL OF WINGS TRANSPORT SUPPORTS

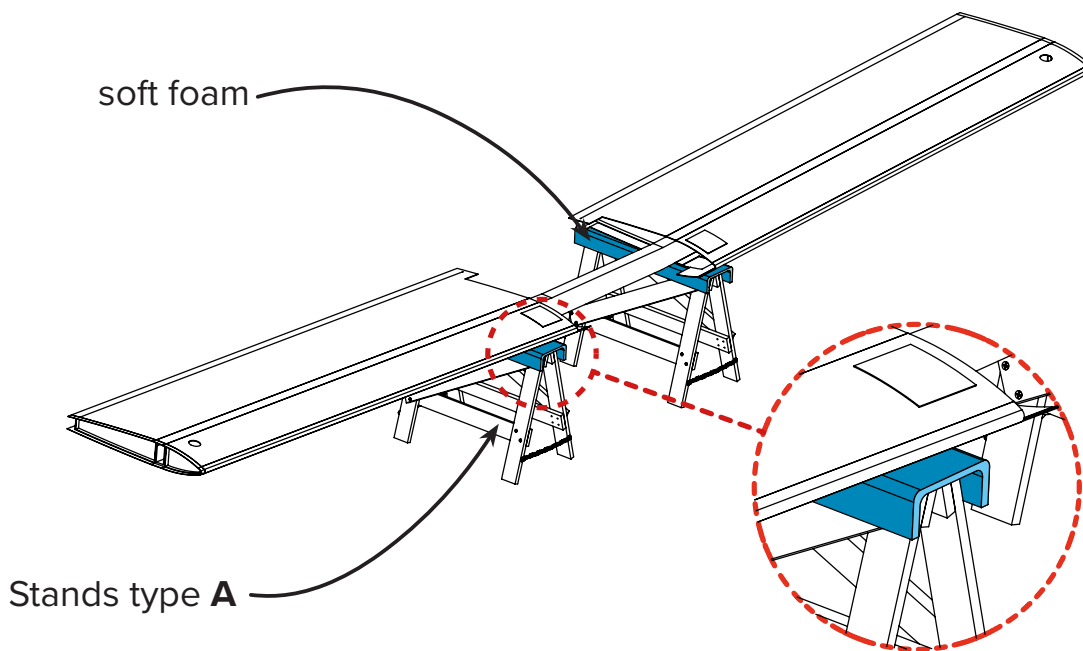
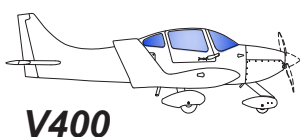
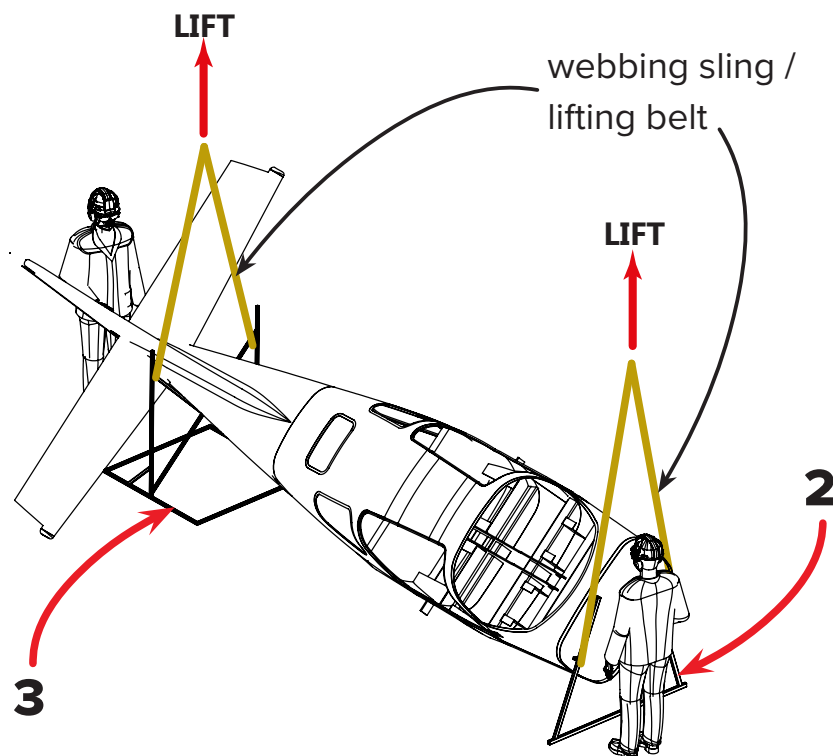
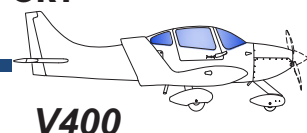


FIGURE 2-6 - POSITION OF WINGS SET ON THE STANDS TYPE A




FUSELAGE REMOVAL

18. REMOVE all plastic film that packs the Fuselage, before any operation;
19. REMOVE from the interior of the Fuselage all the parts deposed therein;
20. PLACE the webbing sling / lifting belt on the FRONT FUSELAGE TRANSPORT SUPPORT (2) and the REAR FUSELAGE TRANSPORT SUPPORT (3);
21. POSITION the lifting device as close as possible to the Container or the Truck (transport), to allow to remove and lifting of the Fuselage by the webbing sling / lifting belt;
22. REMOVE the Fuselage from the interior of the transport by lifting ONLY by the FRONT (2) and REAR (3) FUSELAGE TRANSPORT SUPPORTS by the lifting belt (figure 2-7);


FIGURE 2-7 - FUSELAGE REMOVAL FROM TRANSPORT


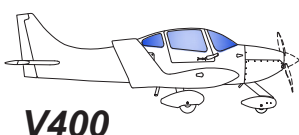
23. LIFT from 2 to 3 inches the FRONT (2) and REAR (3) FUSELAGE TRANSPORT SUPPORTS of the transport floor, in the same way as shown in Figure 2-4;
24. REMOVE the Fuselage from the interior of the transport (Container or Truck) by lifting ONLY by the FUSELAGE TRANSPORT SUPPORTS (2) and (3) by the webbing sling / lifting belt;
25. KEEP the balance of the Fuselage with the help of 2 people during this movement, without performing any type of physical effort (figure 2-8A);
26. MOVE the Fuselage to the place where the Stands type **C** and **D** are positioned;
27. PLACE the FUSELAGE TRANSPORT SUPPORT (2) (3) on the floor with the Fuselage;
28. REMOVE the webbing sling / lifting belt of the FUSELAGE TRANSPORT SUPPORTS (2) (3);
29. PLACE the webbing sling / lifting belt on the Fuselage, as shown in Figure 2-8B;

**ATTENTION!****RISK OF ACCIDENT AND DAMAGE TO THE FUSELAGE.**

HANDLE the Fuselage **ALWAYS** by means of the FRONT (2) and REAR(3) TRANSPORT SUPPORTS.

ONLY PLACE the lifting belt by the skin on the Fuselage in the position indicated in Figure 2-8. Any other position can damage and compromise the integrity of the Fuselage.

KEEP the Fuselage balanced, during its movement, by two people holding by the Stabilizer and Fire Wall.



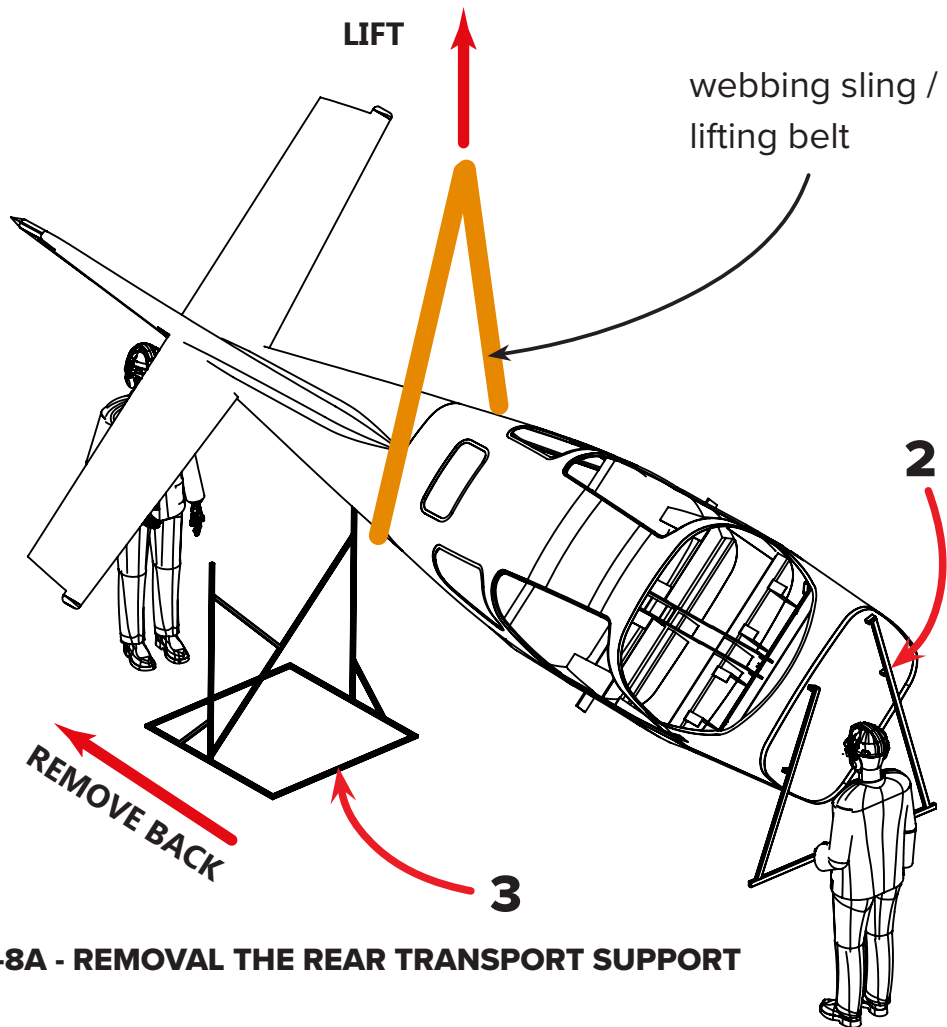


FIGURE 2-8A - REMOVAL THE REAR TRANSPORT SUPPORT

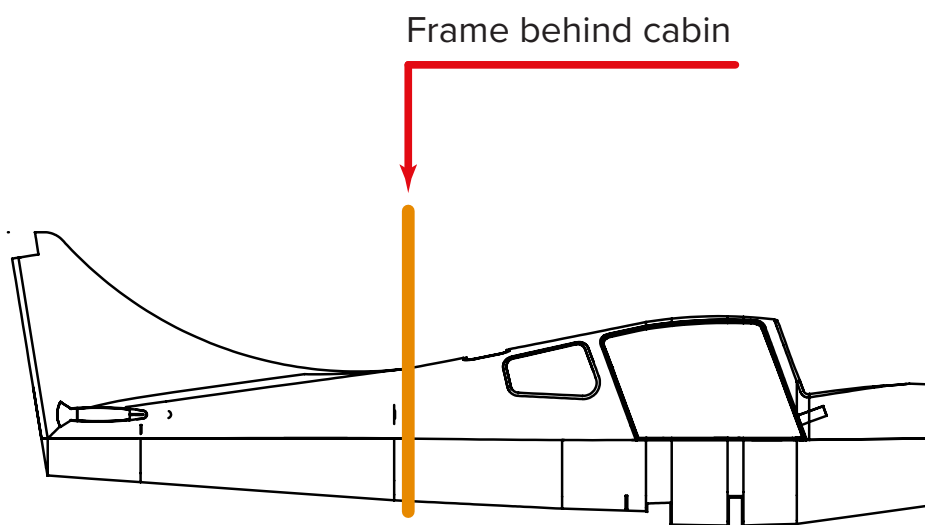


FIGURE 2-8B - POSITION FOR WEBBING SLING /LIFTING BELT ON FUSELAGE

30. LIFT the Fuselage by the lifting belt enough to remove REAR TRANSPORT SUPPORT (3);
31. REMOVE the REAR TRANSPORT SUPPORT (3);
32. TURN by the Stabilizer and the FRONT TRANSPORT SUPPORT (2) the Fuselage carefully to the level position;
33. PLACE the Fuselage on the Stands type **C** and **D** (figure 2-9);
34. REMOVE the FRONT TRANSPORT SUPPORT (2) by its screws;
35. CHECK that Fuselage is well supported and without movement;

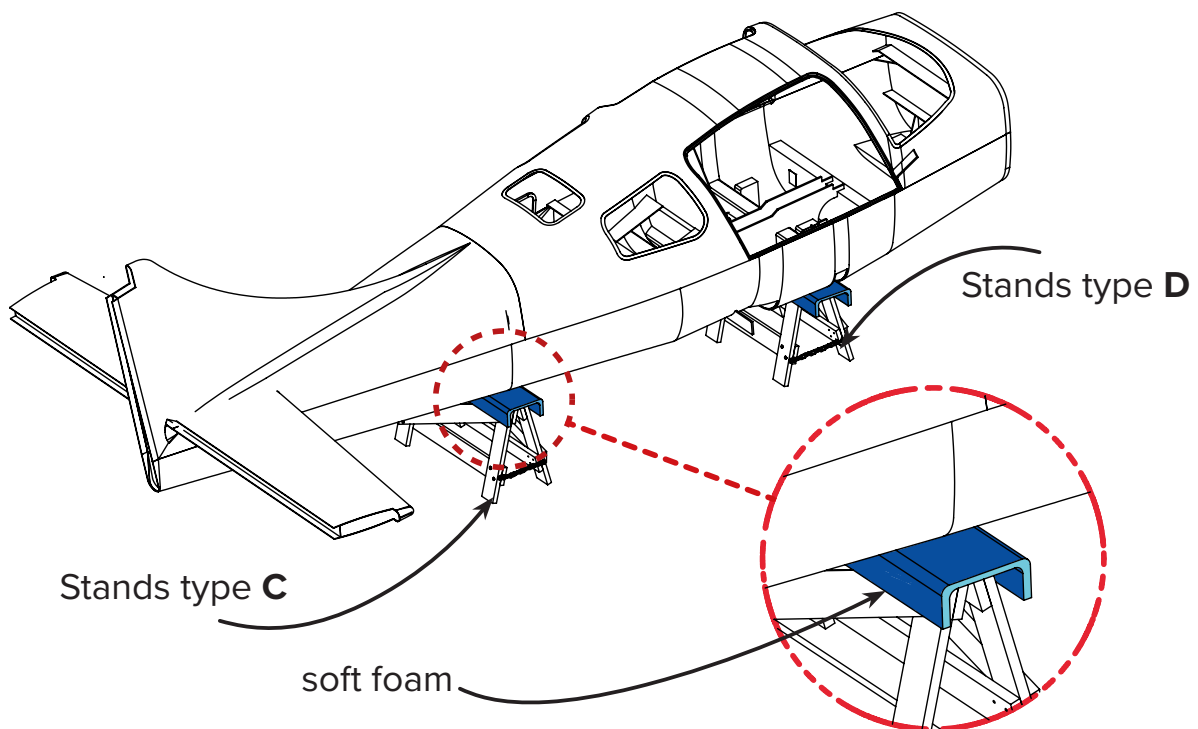
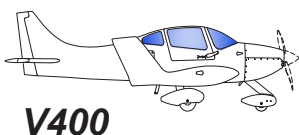


FIGURE 2-9 - POSITION OF FUSELAGE ON THE STANDS TYPE C AND D



**WORKSHOP AREA**

36. CLEAN the entire area around the Fuselage and the Wings Set.

