



REF: ACRO II FUSELAGE
KIT: 39184

ITEM NO.	PARTNUMBER	QTY.	Description
11	39185-011	1	Tube 0.875 x 0.035
12	39185-012	1	Tube 0.375 x 0.035
13	39185-013	1	Tube 1.000 x 0.058
14	39185-014	1	Tube 0.750 x 0.035
15	39185-015	1	Tube 0.500 x 0.035
16	39185-016	1	Tube 0.500 x 0.035
17	39185-017	1	Tube 0.500 x 0.035
18	39185-018	1	Tube 0.375 x 0.035
19	39185-019	1	Tube 0.375 x 0.035
20	39185-020	2	Tube 0.875 x 0.049
21	39185-021	2	Tube 0.625 x 0.058
22	39185-022	2	Tube 0.750 x 0.035
23	39185-023	2	Tube 0.750 x 0.035
24	39185-024	2	Tube 0.875 x 0.058
25	39185-025	2	Tube 0.875 x 0.035
26	39185-026	2	Tube 1.000 x 0.058
27	39185-027	2	Tube 0.375 x 0.035
28	39185-028	6	Tube 1.000 x 0.058
29	39185-029	12	Tube 1.000 x 0.058
30	39185-030	4	Tube 0.375 x 0.065
31	39185-031	2	Tube 0.313 x 0.065

NOTES:

- REFER TO ACRO II DESIGN DRAWING FOR COMPLETE ASSEMBLY DETAILS.
THIS IS A MANUFACTURING DRAWING INTENDED TO ASSIST WELD ASSEMBLY OF A VR3 PROFILED TUBE KIT. A COMPLETE SET OF PLANS MUST BE PURCHASED FROM AN AUTHORIZED PLANS PROVIDER
- ENSURE CORRECT POSITIONING BEFORE FINAL WELDING
- REFERENCE DATA
NO OF TUBE PIECES PER KIT: 49 PCS
ESTIMATED WEIGHT OF TUBES: 16 LBS
- MATERIAL SPECIFICATIONS UNLESS OTHERWISE INDICATED
TUBING: 4130 COND N MIL-T-6736B SEAMLESS AIRCRAFT
- TUBE NO 14 IS PROFILED BUT REQUIRES "SQUISHING" AT ASSEMBLY
- TUBES NO 22 AND 27 REQUIRE MINOR HAND TRIMMING.

REV'N	DATE	DRAWN	APPRVD	DESCRIPTION
VR3 ENGINEERING LTD MECHANICAL ENGINEERING & CUSTOM MACHINE DESIGN STRATFORD, ONTARIO, CANADA <small>THIS DRAWING OR THE INFORMATION CONTAINED HEREIN MAY NOT BE REPRODUCED WITHOUT PERMISSION FROM VR3 ENGINEERING</small>				
EMPENNAGE WELDMENT: TUBE KIT ASSEMBLY				
ACRO II				
ISOMETRIC VIEW				
DRAWN: JJ	DATE: SEPT 4 09	PROJECT NO.	DRAWING NO.	REV NO.
'C SCALE: 1:5		1027-08	39185-01	X