Working instruction No. 1 for SI78-12
Retrofit of an IWP 069 Primer valve

I DG-500M

A Installation

Installation is according to drawing 5M80

1. Remove the existing primer valve.
2. Plug the new primer valve into the connectors 5M80/1 and 8M309/2 and connect the assembly with a bolt M6x10 DIN933-8.8 zn, washer 6,4 DIN9021 St zn and self-locking nut M6 DIN985-8 zn. Don't tighten the nut.
3. Install one Ty-rap 140x3,6 at 5M80/1 and one Ty-rap 140x3,6 at 8M309/2. Slip a third Ty-rap 186x4,8 through the first ones. First tighten the first 2 Ty-raps. Then pull the parts 5M80/1 and 8M309/2 with the third Ty-rap firmly against the primer valve. Now tighten the nut (see item 2).
4. Connect the hose which leads from the primer valve to the carburettor to 5M80/1, secure with a Ty-rap 92x1,6.
   Install part 8M288/1 (with filter) into the hose which comes from the Y-fitting according to drawing and fix the hose to part 8M288/1 with the existing hose clamp.
5. Use a 47 mm/1.85 in.) long piece of hose to connect 8M288/1 with the 8M309/2, fix with hose clamps 8-12, install protection caps.
6. Plug and secure the existing connector plug to the new primer valve.
7. Secure the primer valve with a Ty-rap 186x4,8 to the coolant hose.
8. File drawing 5M80 to the aircraft log.

B Material-set part No. **39000810**

amount	DG part no.	designation
1	/	drawing 5M80
1	60503070	injection valve IWP 069
1	40570801	connector for primer valve 5M80/1
1	40873092	connector for primer valve 8M309/2
1	40872880	8M288/1 fitting with filter
1	50061001	bolt M6x10 DIN933-8.8 zn
1	52060001	washer 6,4 DIN125 St zn
1	51060020	Self-locking nut M6 DIN985-8.8 zn
2	60510952	Ty-rap 140x3,6
1	60510951	Ty-rap 92x1,6
2	60510953	Ty-rap 186x4,8
1	39001032	hose 8x2x12, 47 mm long with metal shielding and red heat shrink tubing at the ends
2	60000651	hose clamp 8-12
2	60000640	protection cap for hose clamp

Working instruction No. 1 for SI78-12
Retrofit of an IWP 069 Primer valve

II DG-500MB

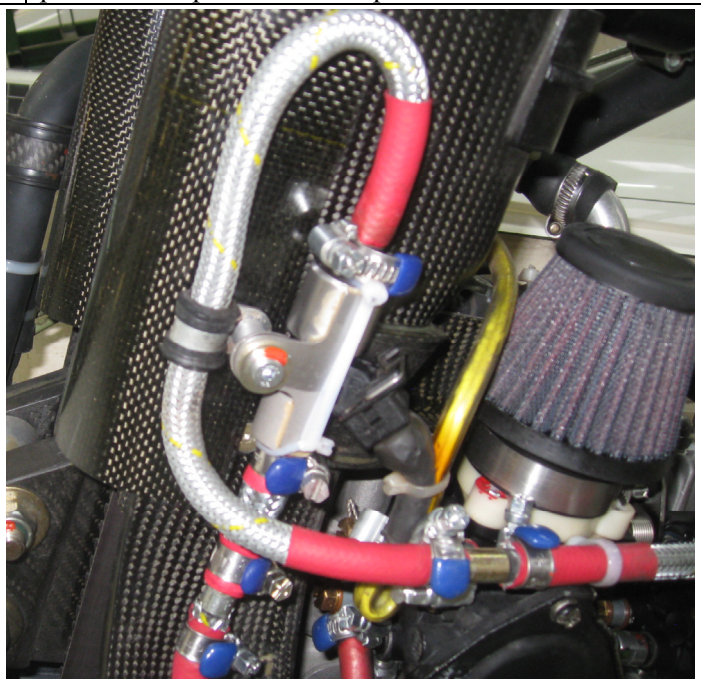
A Installation

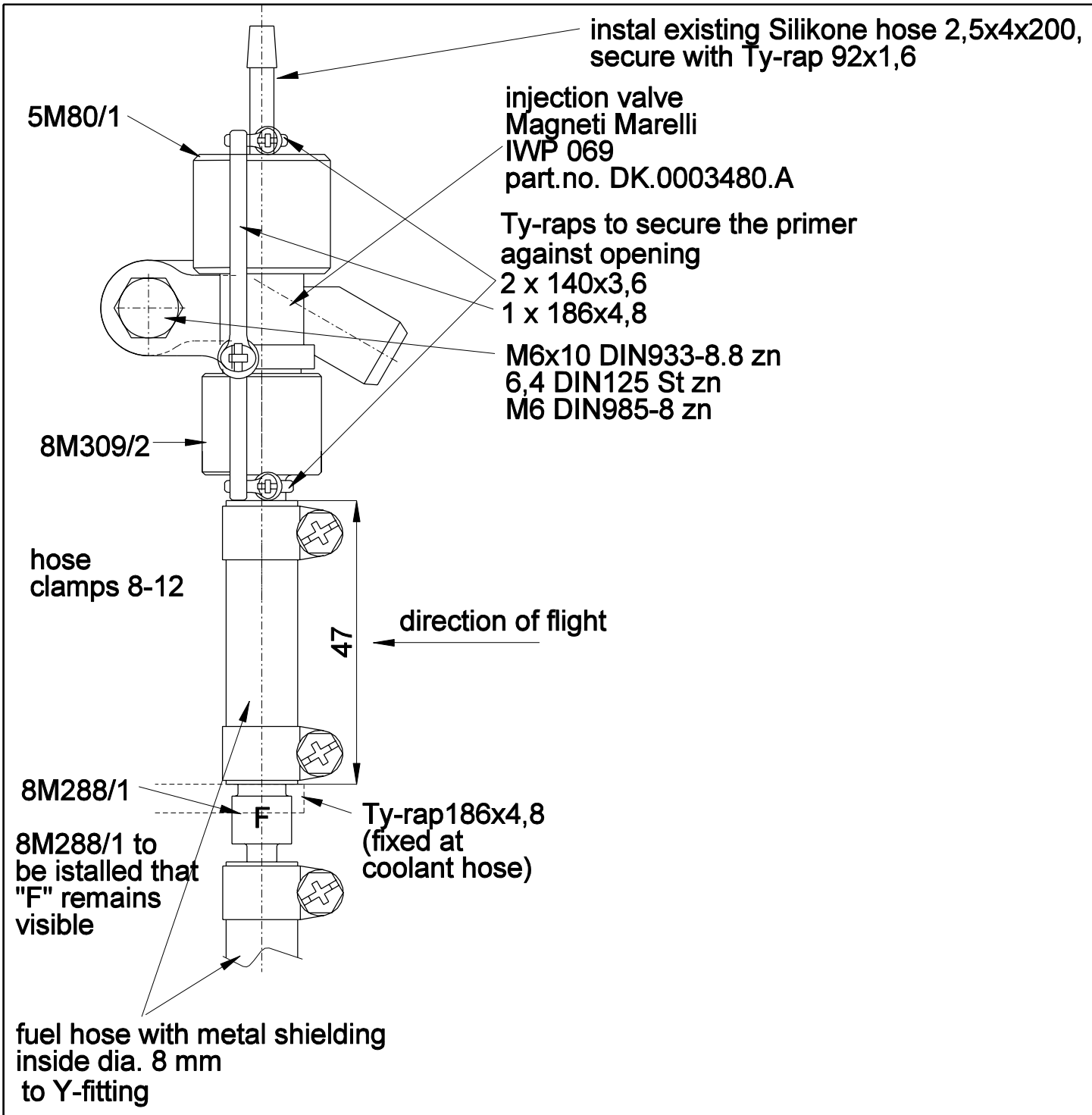
Installation is according to drawing 5M127

1. Remove the existing primer valve.
2. Plug the new primer valve into the connectors 8M309/1 and 8M309/2 and install the assembly with a bolt M5x35 DIN7984-8.8 zn, washer 5,3 DIN9021 St zn and spacer 5M127/1 to the engine mount, secure with Loctite 243. Don't tighten the bolt.
3. Install one Ty-rap 140x3,6 at 8M309/1 and one Ty-rap 140x3,6 at 8M309/2. Slip a third Ty-rap 186x4,8 through the first ones. First tighten the first 2 Ty-raps. Then pull the parts 8M309/1 and 8M309/2 with the third Ty-rap firmly against the primer valve. Now tighten the bolt (see item 2). Mark the bolt head with red securing paint.
4. Connect the hose which leads from the primer valve to the carburettor to the new primer assembly, fix the hose with the existing hose clamp.
   Install a new part 8M288/1 (with filter) into the hose which comes from the T-fitting according to drawing and fix the hose to part 8M288/1 with the existing hose clamp.
5. Use a 47 mm/1.85 in.) long piece of hose to connect 8M288/1 to 8M309/2, fix with hose clamps 8-12, install protection caps.
6. Plug and secure the existing connector plug to the new primer valve.
7. File drawing 5M127 to the aircraft log.

B Material-set part No. **39000811**

amount	DG part no.	designation
1	/	drawing 5M127
1	60503070	injection valve IWP 069
1	40873091	connector for primer valve 8M309/1
1	40873092	connector for primer valve 8M309/2
1	40571271	Spacer 5M127/1
1	40872880	8M288/1 fitting with filter
1	50053503	bolt M5x35 DIN7984-8.8 zn
1	52050020	washer 5,3 DIN9021 St zn
2	60510952	Ty-rap 140x3,6
2	60510953	Ty-rap 186x4,8
1	39001032	hose 8x2x12, 47 mm long with metal shielding and red heat shrink tubing at the ends
2	60000651	hose clamp 8-12
2	60000640	protection cap for hose clamp





Toleranzen nach Arbeitsanweisung BA 1				
Schweißen nach Arbeitsanweisung SA 1				
Ausg.	Änderung	ÄM	Tag	Name

	Tag	Name
Gez.	26.07.12	W. Dirks
Gepr.		
Norm.		

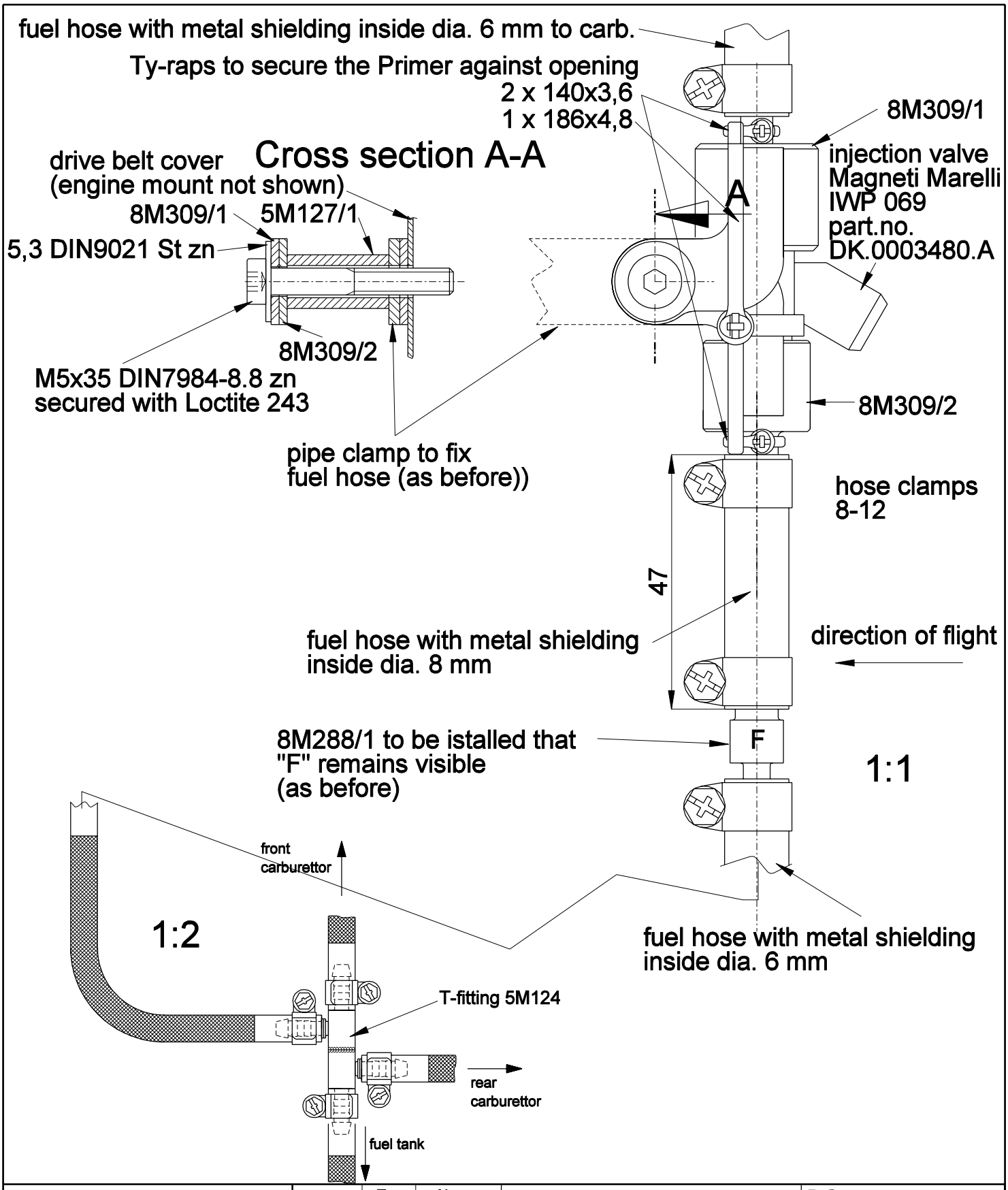
Maßstab 1:1 :

Maße ohne Toleranz-ang. nach:

Primer valve assembly DG-500M

DG Flugzeugbau GmbH
76646 Bruchsal
Otto-Lilienthal-Weg 2

5M80



Toleranzen nach Arbeitsanweisung BA 1				
Schweißen nach Arbeitsanweisung SA 1				
a	Ventil IWP 069		4.10.12	W.Dirks
Ausg.	Änderung	ÄM	Tag	Name

	Tag	Name
Gez.	18.05.99	Schroeter
Gepr.		
Norm.		

Maßstab
1:1
1:2

Maße ohne Toleranz-ang. nach:

Primer valve assembly DG-500MB

DG Flugzeugbau GmbH
76646 Bruchsal
Otto-Lilienthal-Weg 2

5M127