

Made by: S. Przybył
Approved by: P. Stępnicki
Valid from: 15-04-2020



MBL Classics

Gyroplane Departament

Assembling Instruction
CONTENTS OF THE KIT MANUAL

Instruction no.: X4.000.00

Version: 1

Number of pages: 2



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CONTENTS AND SEQUENCE OF THE KIT ASSEMBLY

1. **STEP 1** – X4.ENG.01 - ENGINE INSTALLATION MANUAL
2. **STEP 2** – X4.INT.01 - INTERIOR ASSEMBLY MANUAL
3. **STEP 3** – X4.ENG.02 - ENGINE INSTRUMENTS INSTALLATION MANUAL
4. **STEP 4** – X4.ENG.03 - COOLING SYSTEM WITH THERMOSTAT - INSTALLATION MANUAL
5. **STEP 5** – X4.ENG.04 - OIL SYSTEM INSTALLATION MANUAL
6. **STEP 6** – X4.TAL.01 - TAIL INSTALLATION MANUAL
7. **STEP 7** – X4.ENG.05 - MAST MOUNTING MANUAL
8. **STEP 8** – X4.ENG.06 - INTERCOOLER SYSTEM INSTALLATION MANUAL
9. **STEP 9** – X4.FUS.01 - FUEL SYSTEM AND FUEL TANK INSTALLATION MANUAL
10. **STEP 10** – X4.EQU.01 - BATTERY INSTALLATION MANUAL
11. **STEP 11** – X4.EQU.02 - INSTRUMENT PANEL INSTALLATION MANUAL
12. **STEP 12** – X4.EQU.03 - RADIO AND ANTENNA INSTALLATION MANUAL
13. **STEP 13** – X4.FUS.02 - ROTOR SPEED SENSOR INSTALLATION MANUAL
14. **STEP 14** – X4.ENG.07 - PROPELLER INSTALLATION MANUAL
15. **STEP 15** – X4.PRE.01 - PREROTATION INSTALLATION MANUAL
16. **STEP 16** – X4.CON.01 - CENTRAL CONSOLE INSTALLATION WITH CONTROL DEVICES ADJUSTMENT MANUAL
17. **STEP 17** – X4.MLG.01 - BLEEDING BRAKE HYDRAULIC SYSTEM MANUAL
18. **STEP 18** – X4.EQU.04 - SETTING THE EMSIS DEVICE MANUAL
19. **STEP 19** – X4.000.01 - PUSH RODS AND FLEXIBLE SHAFT INSTALLATION MANUAL
20. **STEP 20** – X4.000.02 - LEVELING ROTOR HEAD MANUAL
21. **STEP 21** – X4.000.03 - STICKERS INSTALLATION MANUAL
22. **STEP 22** – X4.000.04 - ANTI-SLIP TAPES INSTALLATION MANUAL
23. **STEP 23** – X4.000.05 - CHECKING PITCH ANGLE OF THE GYROPLANE – MANUAL
24. **STEP 24** – X4.ROT.01 - INSTRUCTION OF ASSEMBLING OF ROTOR BLADES AND HUB-BAR AND ROTOR ALIGNMENT
25. **STEP 25** – X4.ENG.08 - OIL FILLING OF THE ENGINE LUBRICATION SYSTEM MANUAL
26. **STEP 26** – X4.ENG.09 - VENTING COOLING SYSTEM MANUAL (ROTAX ENGINE)

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Gyroplane Departament

Assembling Instruction
ENGINE INSTALLATION MANUAL

Instruction no.: X4.ENG.01

Version: 1

Number of pages: 12

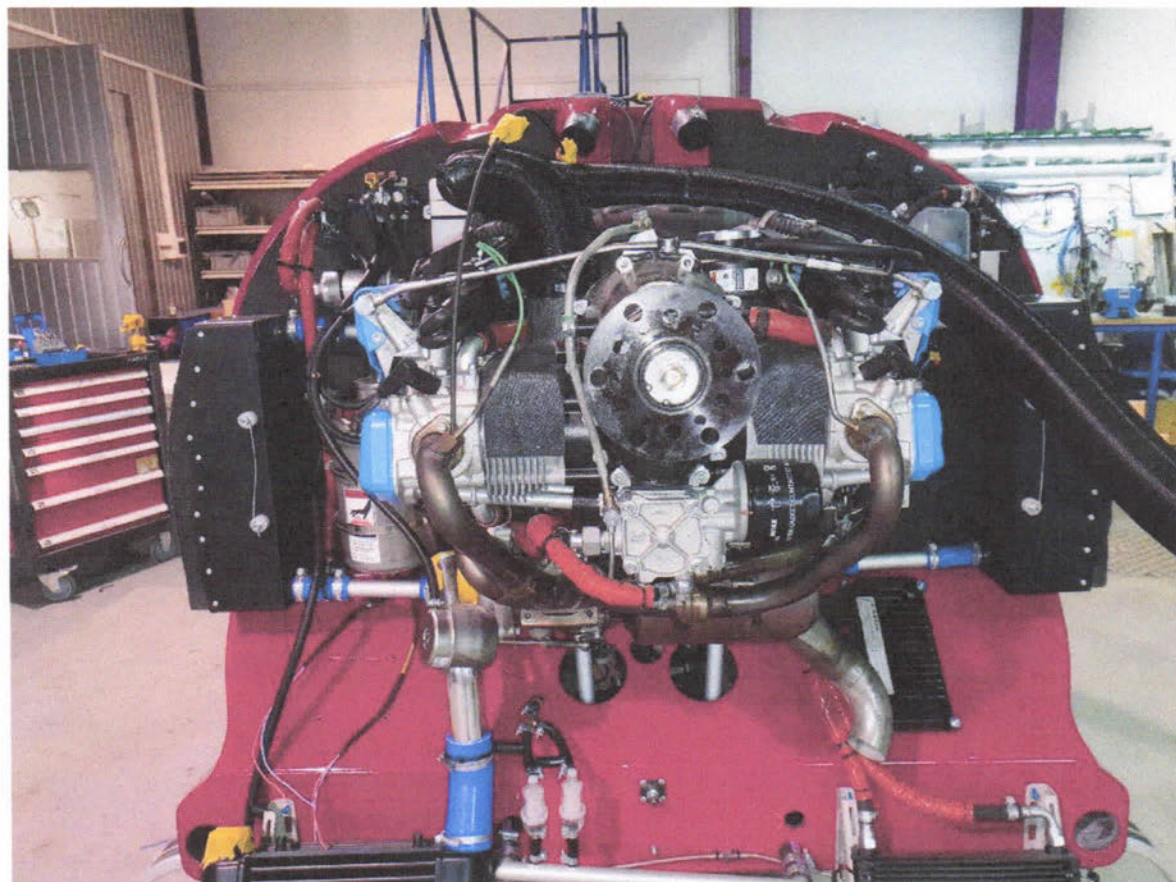
STEP 1



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1. Used components (*Pic.4*)

No.	Component title	Qty	Prats No	No. MBL	Place
1.	Engine Mounting Bushing	4	XE.000.ENG.100.00.01	CA5825	Box
2.	Engine Rotax 915iS	1		CA5826	Box
3.	Silentblock Unit	4		CA5236	Box
4.	Exhaust Elbow	1		CA5827	Optional
5.	Cylinder Head Screw M10 x 110	4		CA5475	Box
6.	Lock Nut M8	8		192002	Pre-mounted
7.	Washer D8.4 x D16	8		939981	Pre-mounted
8.	Bolt M8 x 30	8		191306	Pre-mounted
9.	Nut M10	4		1920B3	Box
10.	Washer 10,5	4		CA6006	Box
11.	Safety Pin 2 x 16	4		6410R7	Box
12.	Washer D8.4 x D24	8		64506A	Pre-mounted

2. Used tools and supplies:

- workshop crane ✓
- Loctite 243 619272 or Drei Bond 5314 ✓
- Loctite SF 7414 ✓

③ Check the position of water pump inlet elbow. Water pump inlet elbow should be mounted using holes shown on Fig. 1. If position of elbow is correct go to the next point of the manual. If not change the position according to engine producer manual: BRP Rotax: Installation Manual 915 i A; (IM-915 iS A); 75-00-00 page 10 <https://www.flyrotax.com/services/technical-documentation.html>

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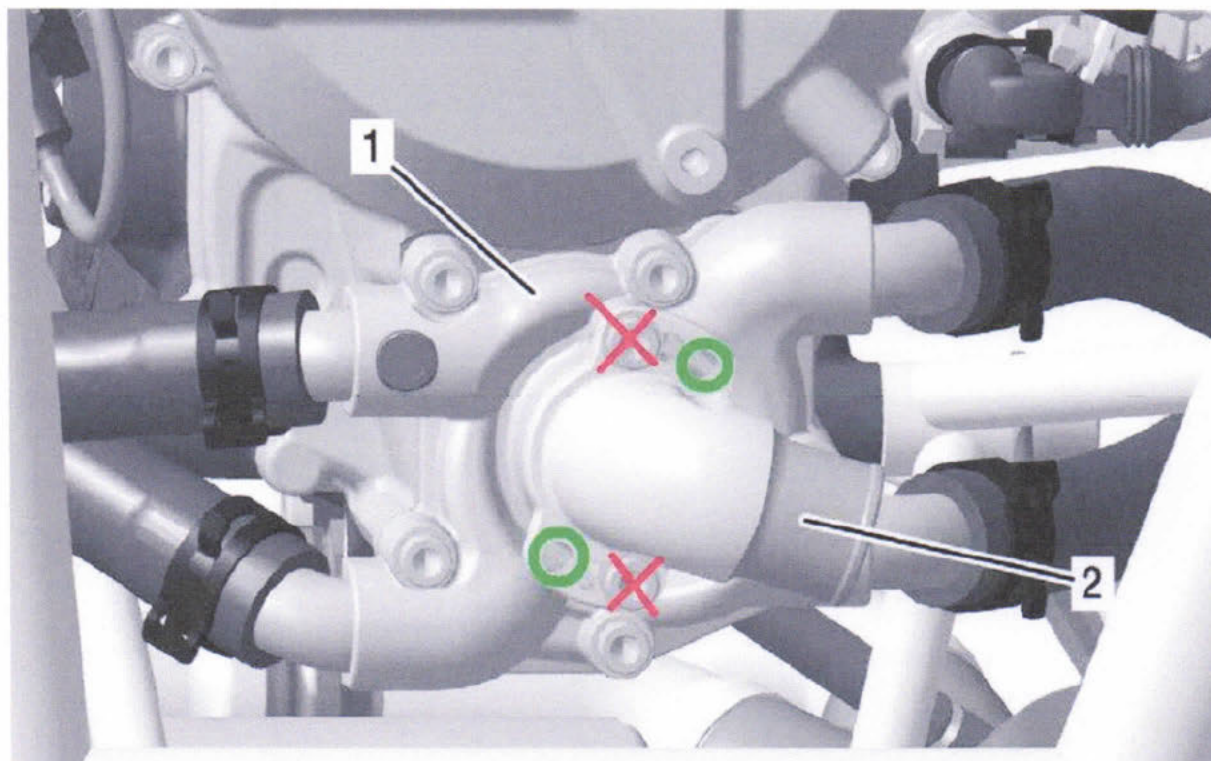
Gyroplane Departament

Assembling Instruction
ENGINE INSTALLATION MANUAL

Instruction no.: X4.ENG.01

Version: 1

Number of pages: 12



Pic.1

4. Check end of the exhaust, if exhaust end looks like on Pic. 2 a) go to next point of manual. If exhaust end looks like on Pic. 2 b) go to the point 11 of this manual.

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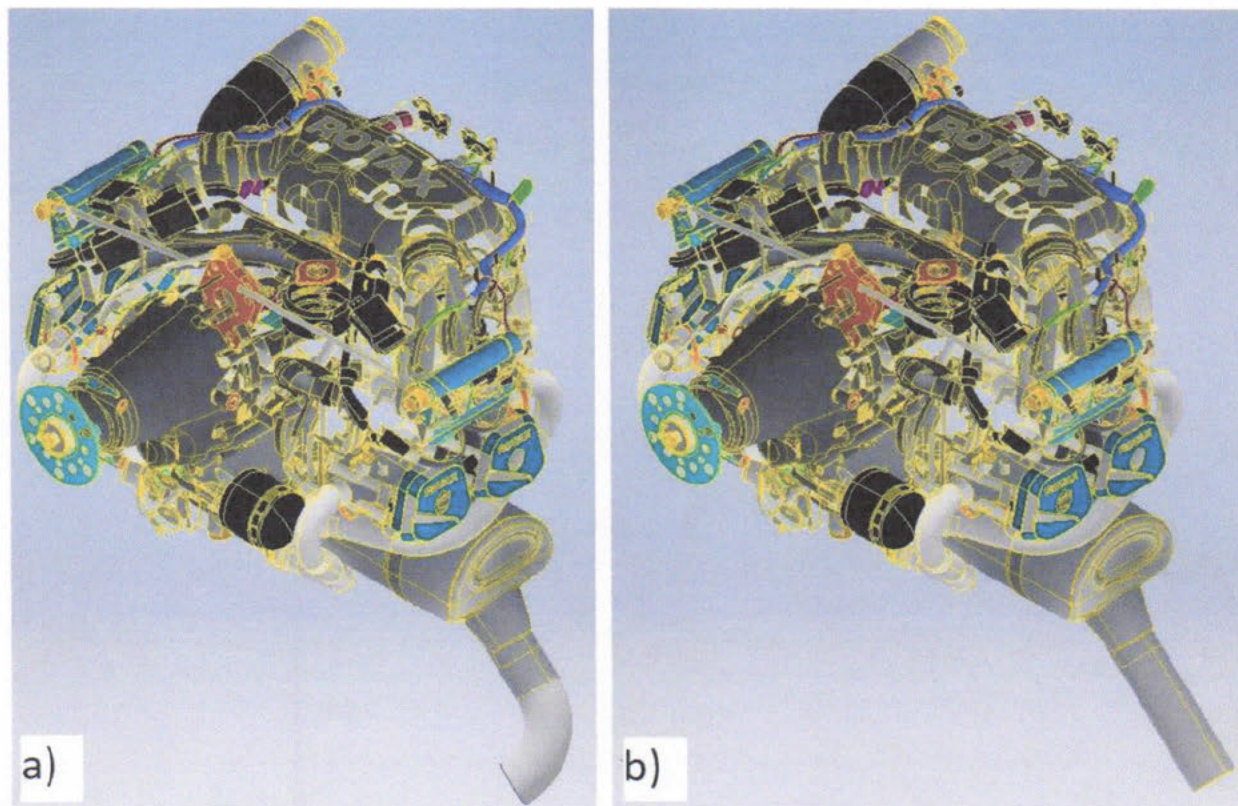
Gyroplane Departament

**Assembling Instruction
ENGINE INSTALLATION MANUAL**

Instruction no.: X4.ENG.01

Version: 1

Number of pages: 12



Pic. 2

6. Remove turbocharger mounting bolts Pic.3.

Attention:

Read the manual BRP Rotax: Installation Manual 915 i A; (IM-915 iS A); 72-00-00 page 13

<https://www.flyrotax.com/services/technical-documentation.html>

6. Mount engine on workshop crane lifter according to manual BRP Rotax: Installation Manual 915 i A, (IM-915 iS A); 10-10-00 page 7.

<https://www.flyrotax.com/services/technical-documentation.html>

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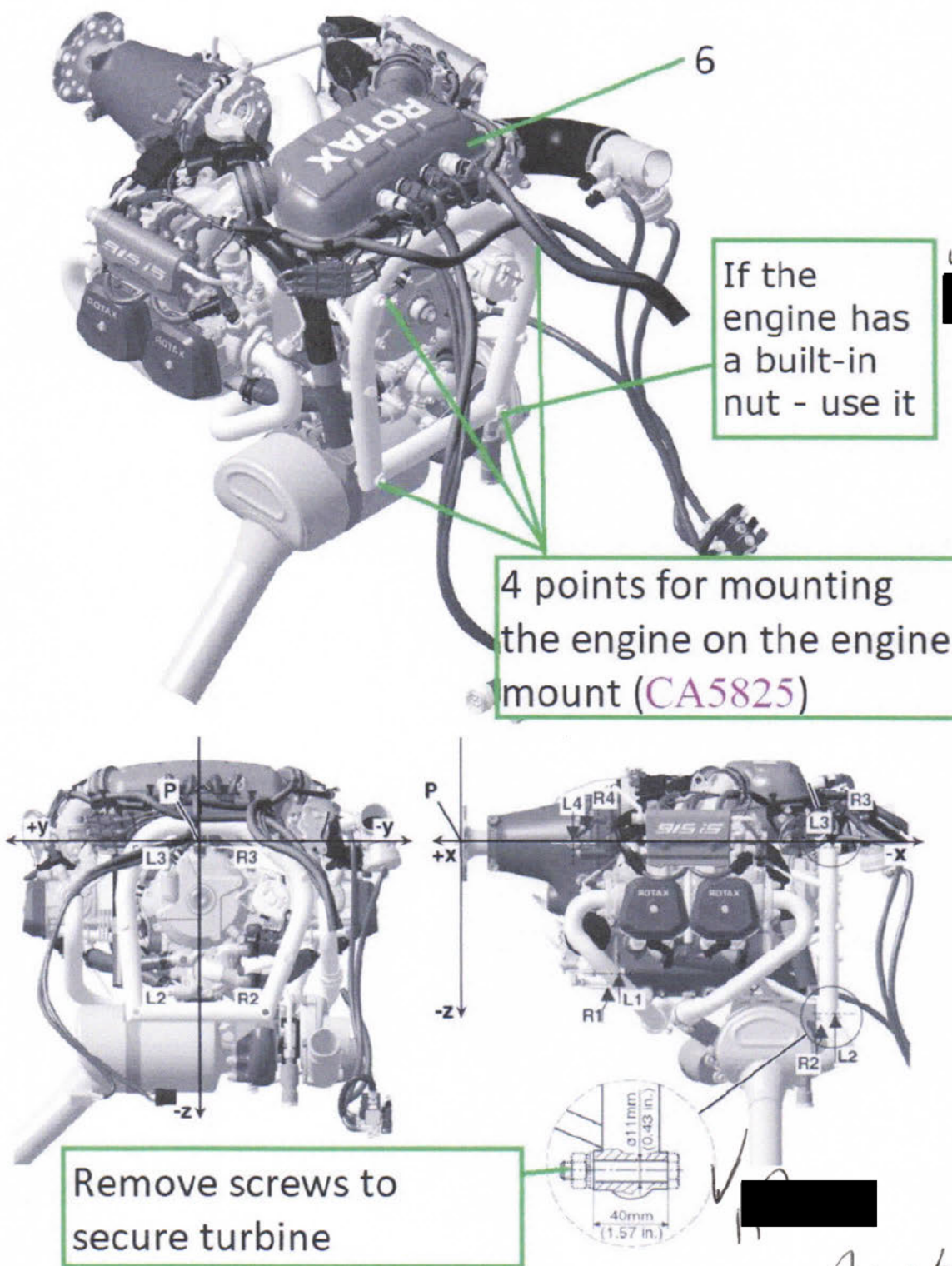
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Assembling Instruction
ENGINE INSTALLATION MANUAL

Instruction no.: X4.ENG.01

Version: 1

Number of pages: 12



Pic.3

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**Assembling Instruction
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Instruction no.: X4.ENG.01

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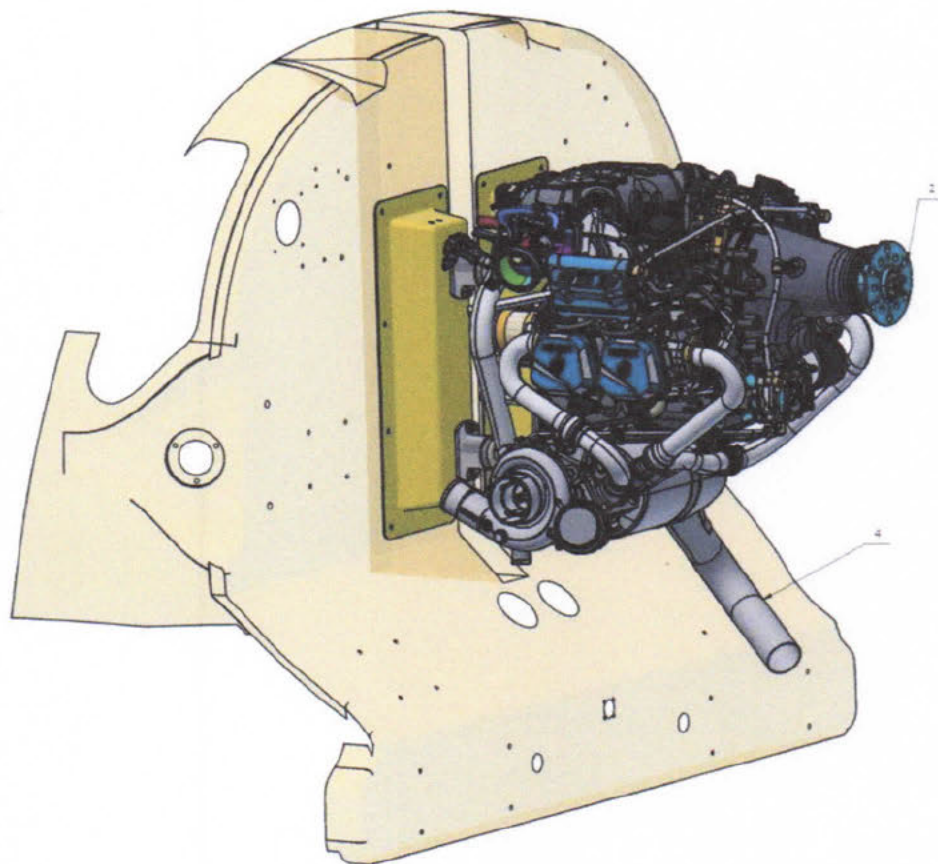
Number of pages: 12

7. Dismantling the engine from the box

a) Suspend the engine according to the manual *BRP Rotax: Installation Manual 915 i A, (IM-915 iS A); 10-10-00 page 4*

<https://www.flyrotax.com/services/technical-documentation.html>

b) Unscrew the bolts securing the engine to the box



Pic. 4

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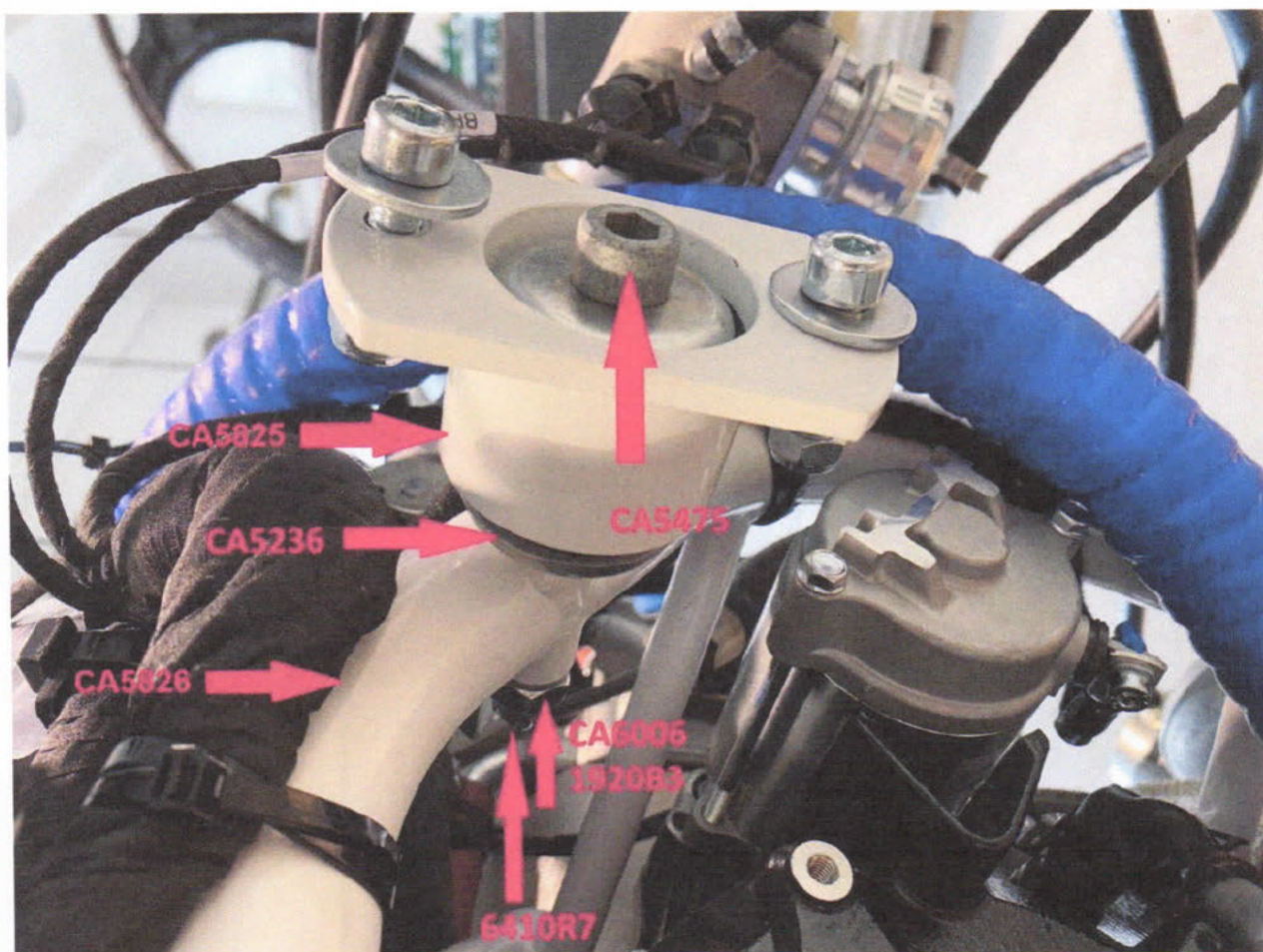
Gyroplane Departament

Assembling Instruction
ENGINE INSTALLATION MANUAL

Instruction no.: X4.ENG.01

Version: 1

Number of pages: 12



Pic. 5



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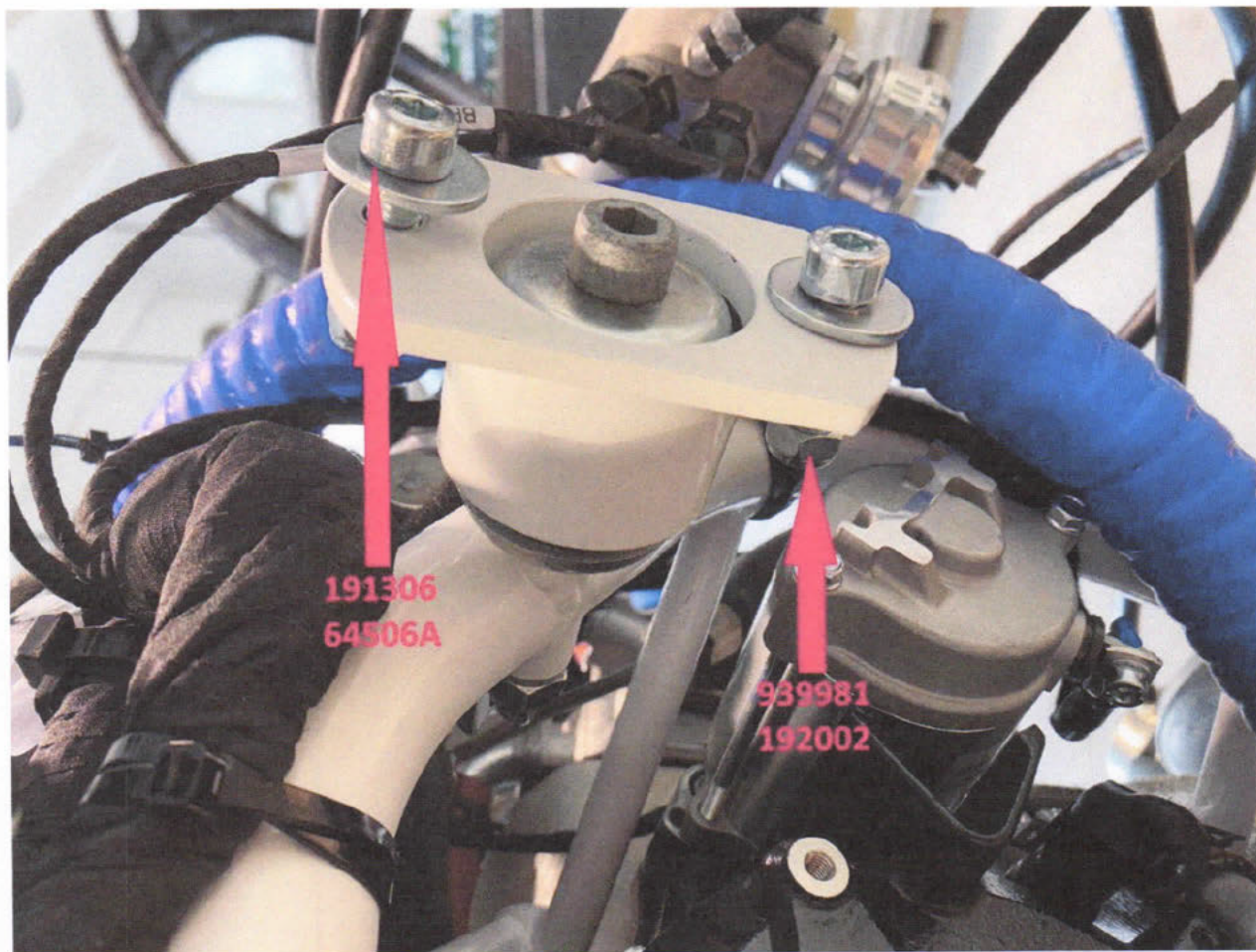
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**Assembling Instruction
ENGINE INSTALLATION MANUAL**

Instruction no.: X4.ENG.01

Version: 1

Number of pages: 12



Pic. 6



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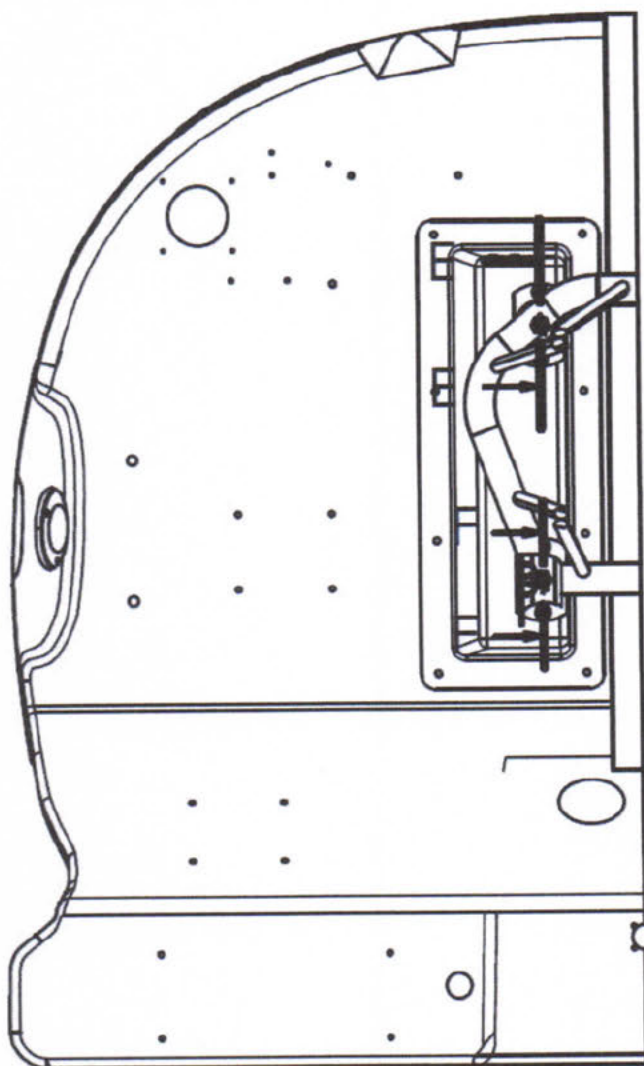
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Assembling Instruction
ENGINE INSTALLATION MANUAL

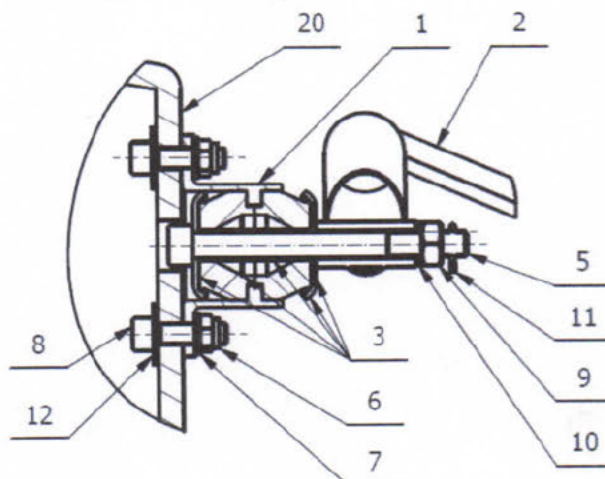
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Version: 1

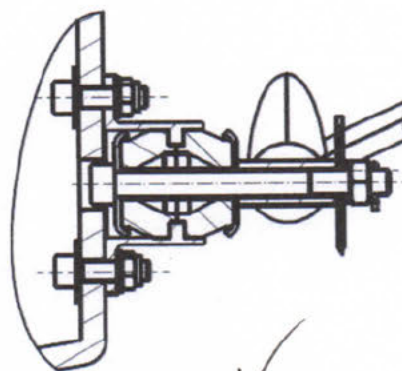
Number of pages: 12



E-E (1 : 3)



F-F (1 : 3)



Pic. 7



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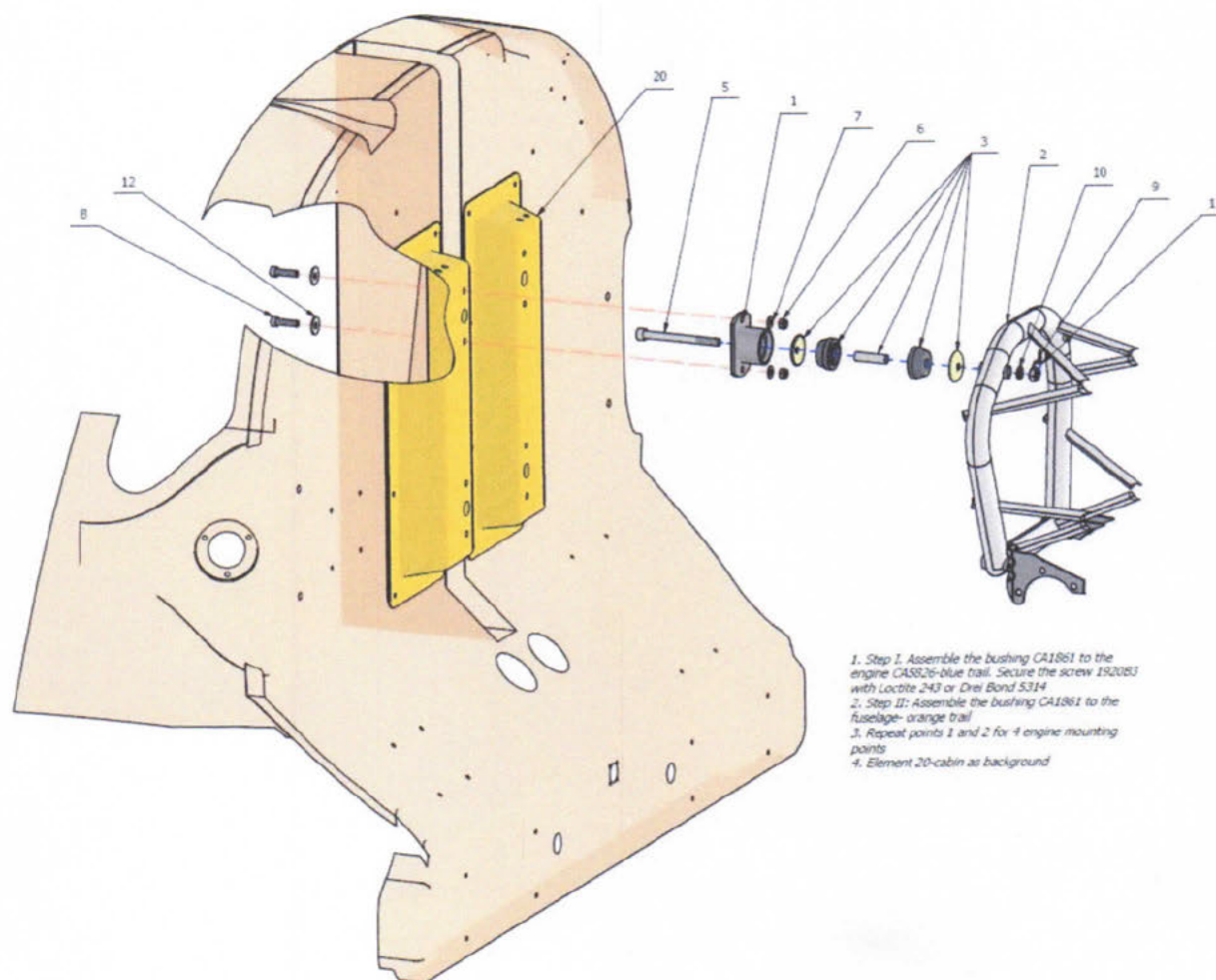
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**Assembling Instruction
ENGINE INSTALLATION MANUAL**

Instruction no.: X4.ENG.01

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Number of pages: 12



1. Step I: Assemble the bushing CA1861 to the engine CA5825-blue trail. Secure the screw 1920B3 with Loctite 243 or Dri-Bond 5314.
2. Step II: Assemble the bushing CA1861 to the fuselage- orange trail
3. Repeat points 1 and 2 for 4 engine mounting points
4. Element 20-cabin as background

Pic. 8

8. Mount the engine mounting bushing CA5825 to the engine CA5825. Tighten (64 Nm) the lock nut 1920B3 secure with Loctite 243. Follow the blue trail (Pic. 8). Repeat the operation for 4 places where the engine is installed.
9. Mount the engine mounting bushing CA5825 to the fuselage. Tighten (24 Nm) the lock nut. Follow the orange trail (Pic. 8). Repeat the operation for 4 places where the engine is installed.
10. Put seals on bolts and nuts, secure with Loctite SF 7414.

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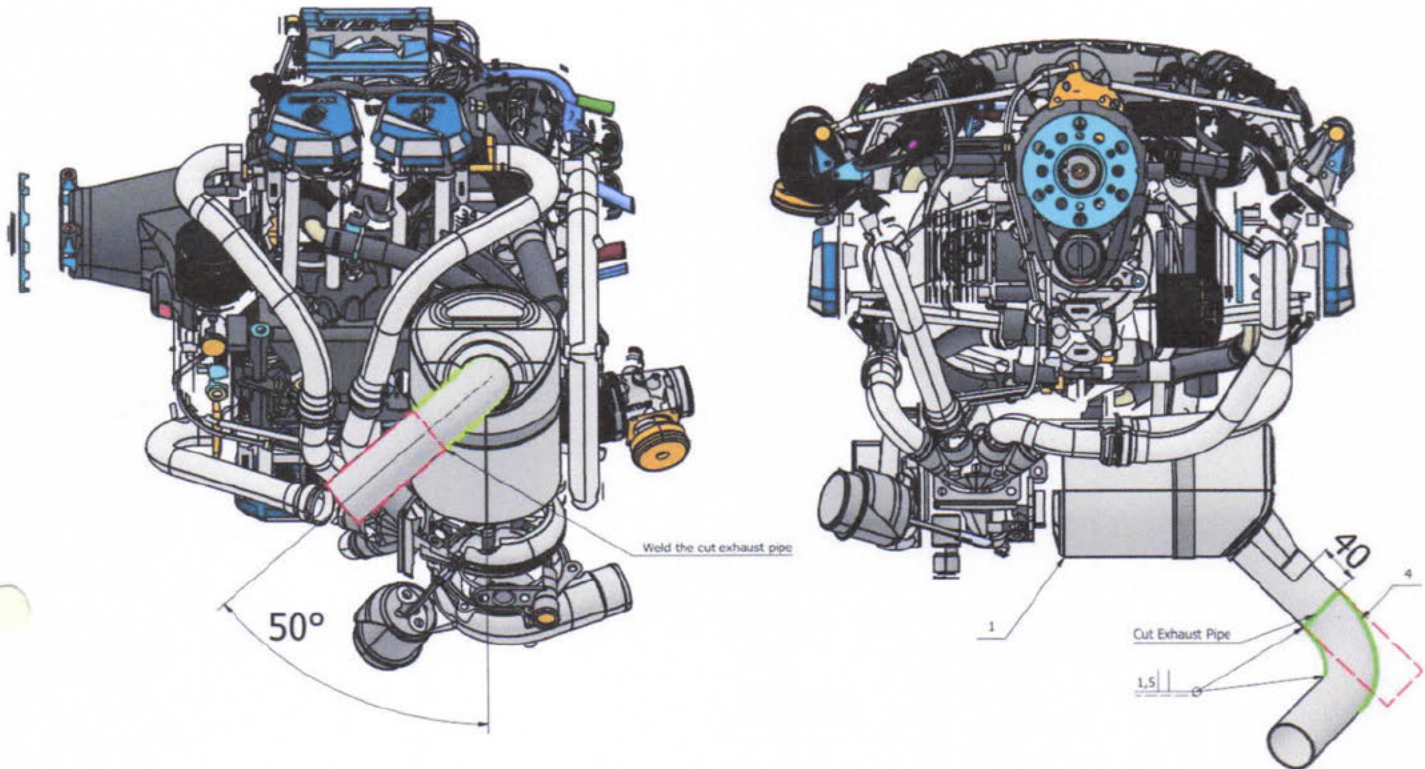
Gyroplane Departament

Assembling Instruction
ENGINE INSTALLATION MANUAL

Instruction no.: X4.ENG.01

Version: 1

Number of pages: 12



Pic. 9

11. Welding exhaust end *Pic. 9*.

- a) Cut pipe transverse to the axis 40mm from pipe reinforcement,
- b) Weld the elbow at 50 degrees from the vertical according to the engine position mounted on the aircraft),
- c) Weld the cut exhaust pipe.

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QUALITY CHECK

1.	Check that engine end is in correct position	✓
2.	Check that all bolts are tight.	✓
3.	Check that position of water pump inlet is correct.	✓
4.	Check that torque marker was used on nuts.	✓



Aug 4, 2022