



Model: K-4192

**Kit, 731-50R
Engine Adapter**

**Installation Instructions
With Illustrated Parts List**

11/2007 - Rev. 01

This product can not be modified without the written approval of Tronair, Inc. Any modifications done without written approval voids all warranties and releases Tronair, Inc., its suppliers, distributors, employees, or financial institutions from any liability from consequences that may occur. Only Tronair OEM replacement parts shall be used.

This Support Kit for Honeywell 731-50R Engine is to be used with Tronair Model: 08-2034-0010 Engine Stand.

ENGINE INSTALLATION INSTRUCTIONS:

1. With the engine hung from the engine sling, remove the existing airframe mounts from the engine.
2. Attach the front engine adaptor assembly to the engine mounting locations. Use Z-6771 (Item 2, **Parts List**) for upper and lower mounts using ball lok pins supplied for each arm (Item 1, **Parts List**).
3. Attach the rear bracket, Z-6770 (Item 3, **Parts List**), to the rear attachment point on the engine. Attach Z-6770 with the two (2) pins attached (See **Figure 2**).
4. Position the front support beam approximately $29 \frac{3}{4}$ inches from the rear support post (See **Figure 1**).
5. Position height of front support approximately $54 \frac{3}{4}$ inches (See **Figure 1**).
6. Position the height of the rear support up approximately $39 \frac{19}{32}$ inches (See **Figure 1**).
7. Position engine into the engine stand and attach Z-6771 (Item 2, **Parts List**) to the front support beam using attached pins (See **Figure 2**).
8. Attach Z-6770 to engine stand with provided pins. (Reference **Figure 2** for complete assembly.)
9. Tighten the lock out screws on the front support beam.
10. The engine sling can now be removed for engine service.
11. Reverse Steps 2-11 to remove the engine from the stand.

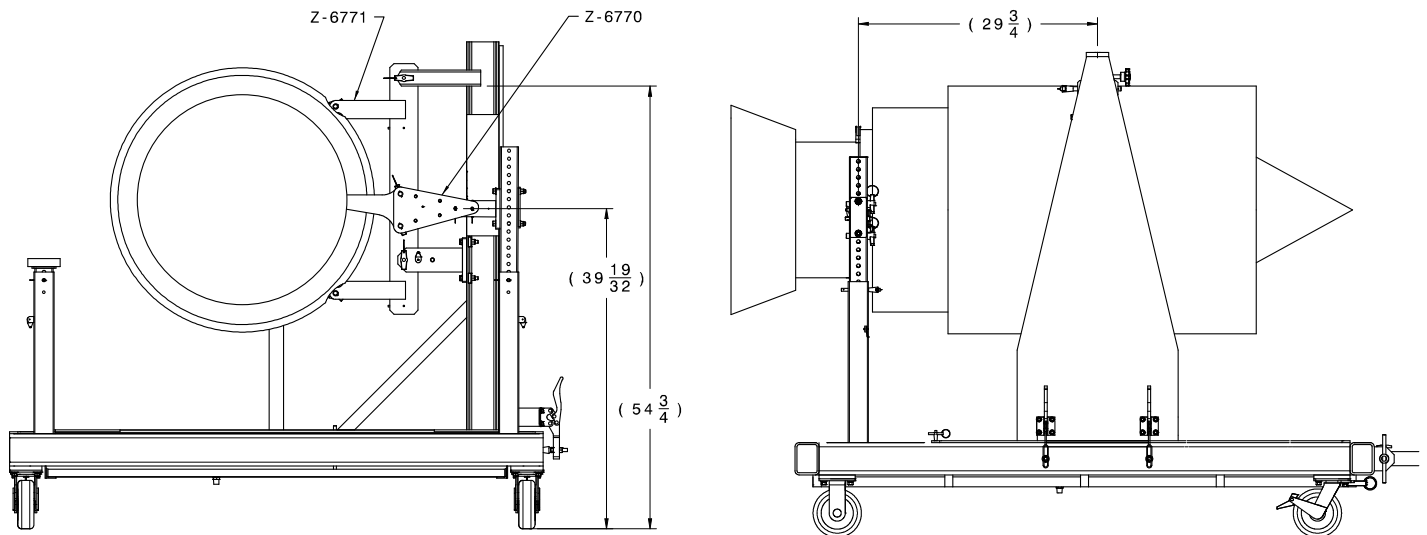


Figure 1

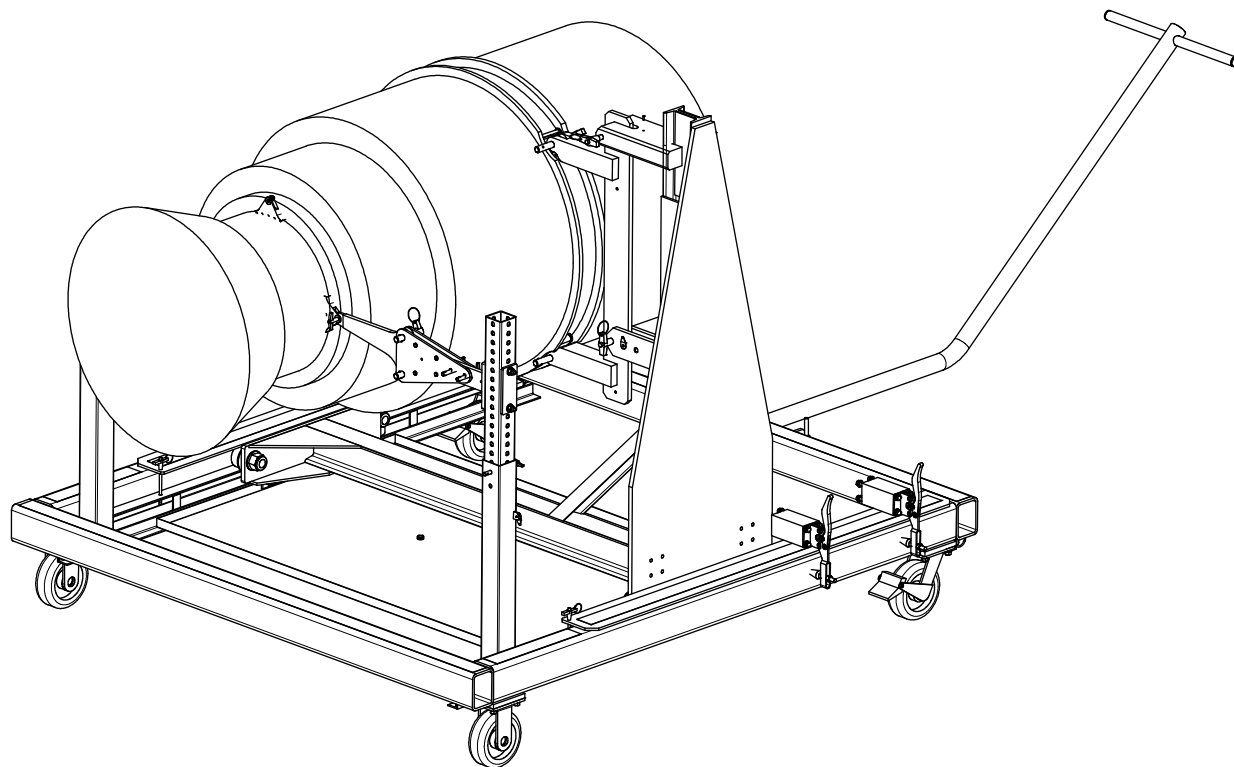
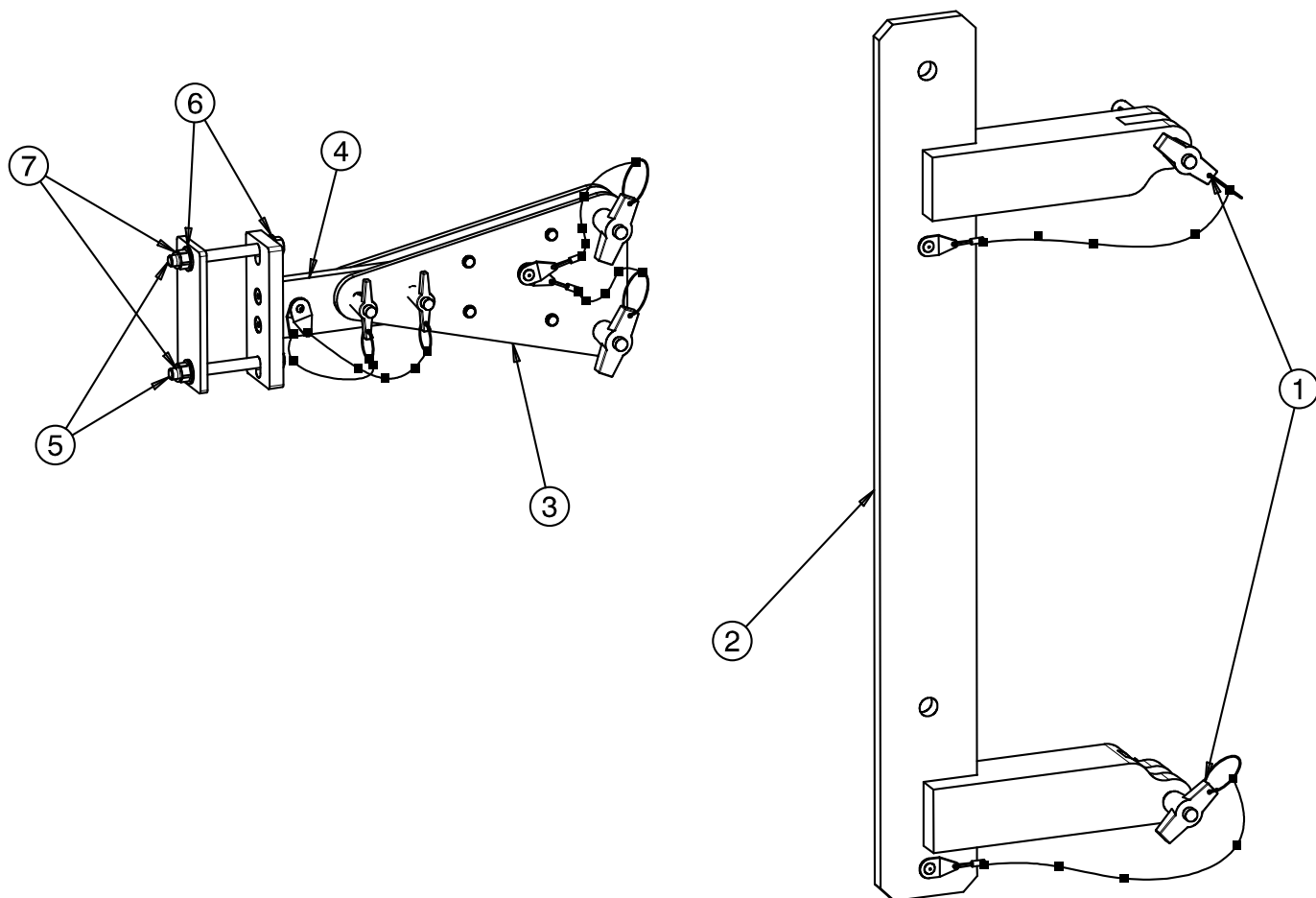


Figure 2

Parts List

When ordering replacement parts/kits, please specify model, serial number and color of your unit.



REPLACEMENT PARTS

ITEM	PART NUMBER	DESCRIPTION	QTY
1	G-1310-1035	Pins, 5/8 x 3.5 Ball Lok	2
2	Z-6771	Assembly, Adaptor Front	1
3	Z-6770	Assembly, Rear Adaptor	1
4	Z-3808	Assembly, Rear Support	1
5	G-1100-107536	Bolt, 3/8-24 Hex Head Grade 5	2
6	G-1250-1070N	Flatwasher, 3/8 Narrow	4
7	G-1202-1075	Stopnut, 3/8-24 Elastic	2