

**WILLS WING**



# **Fusion 141 and 150**

## **Owner / Service Manual**

October 15, 1998 - Third Edition

**Assembly Diagrams Only**



# **Fusion 141 and 150**

## **Owner / Service Manual**

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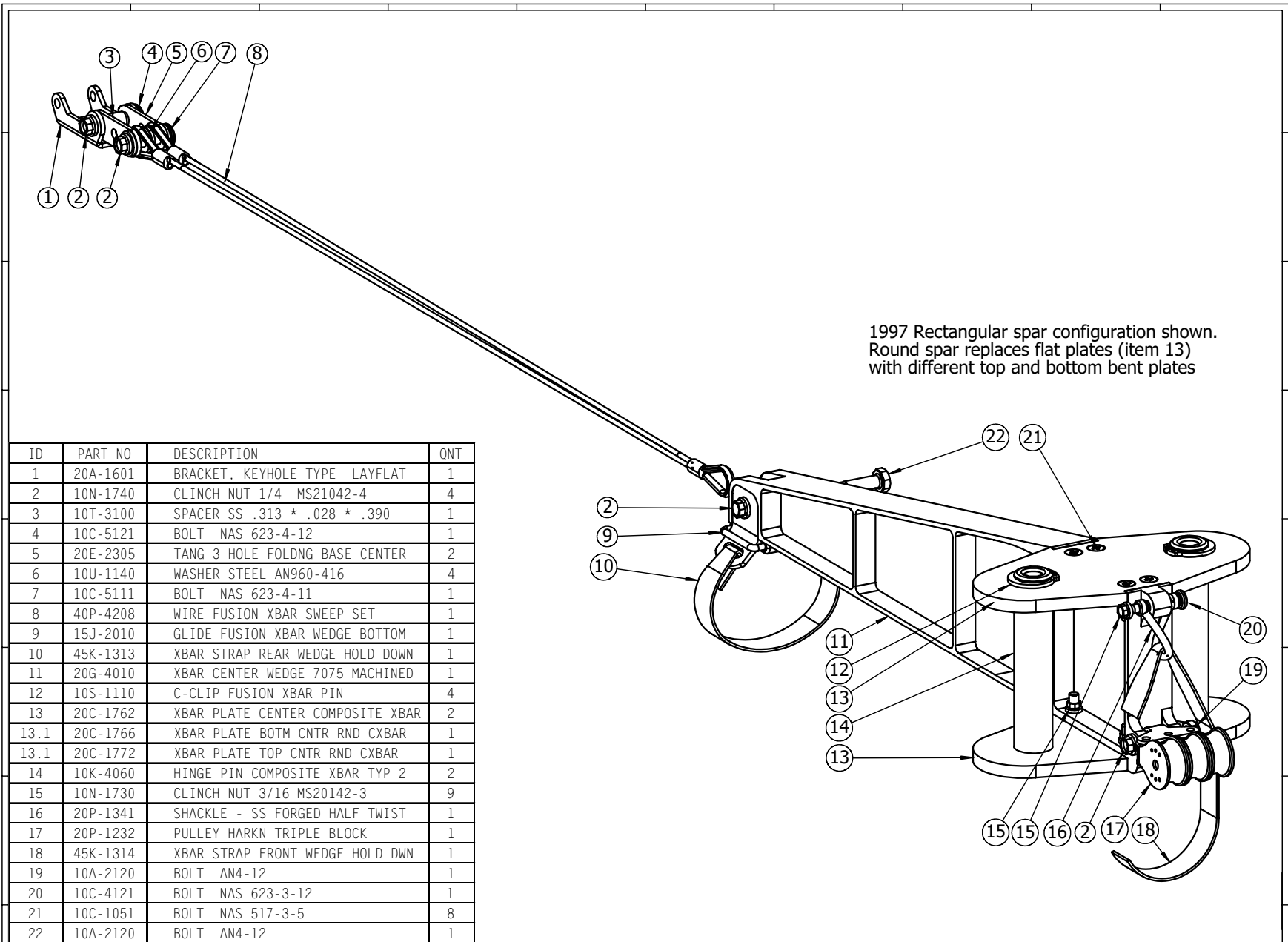
*500 West Blueridge Ave • Orange, CA • 92865 • Phone (714) 998-6359 • FAX (714) 998-0647  
Internet Web address: <http://www.willswing.com> • E-mail: [comments@willswing.com](mailto:comments@willswing.com)*

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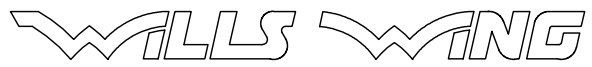
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# 83E01.1 Fusion Crossbar Center



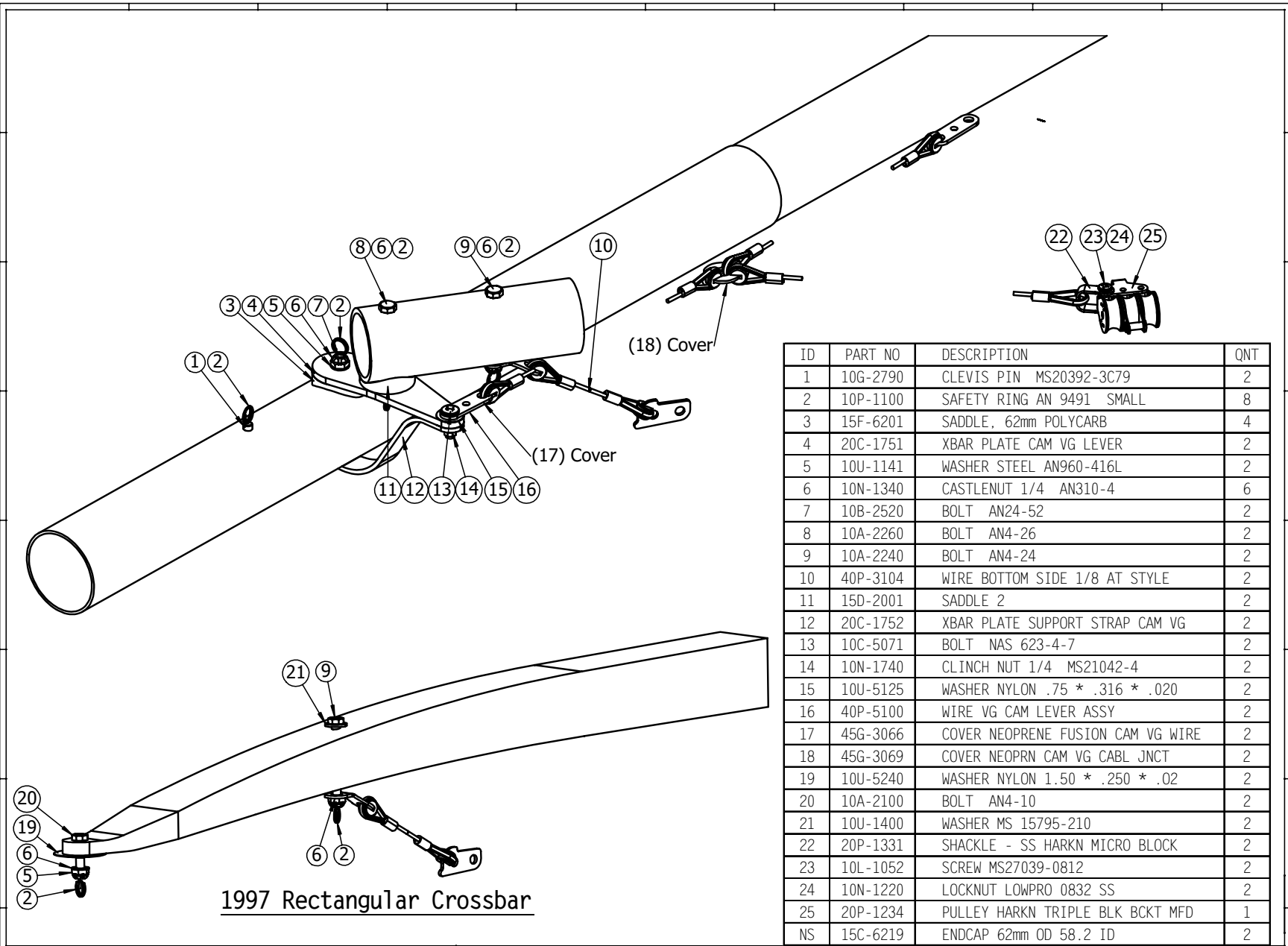
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1	20A-1601	BRACKET, KEYHOLE TYPE LAYFLAT	1
2	10N-1740	CLINCH NUT 1/4 MS21042-4	4
3	10T-3100	SPACER SS .313 * .028 * .390	1
4	10C-5121	BOLT NAS 623-4-12	1
5	20E-2305	TANG 3 HOLE FOLDNG BASE CENTER	2
6	10U-1140	WASHER STEEL AN960-416	4
7	10C-5111	BOLT NAS 623-4-11	1
8	40P-4208	WIRE FUSION XBAR SWEEP SET	1
9	15J-2010	GLIDE FUSION XBAR WEDGE BOTTOM	1
10	45K-1313	XBAR STRAP REAR WEDGE HOLD DOWN	1
11	20G-4010	XBAR CENTER WEDGE 7075 MACHINED	1
12	10S-1110	C-CLIP FUSION XBAR PIN	4
13	20C-1762	XBAR PLATE CENTER COMPOSITE XBAR	2
13.1	20C-1766	XBAR PLATE BOTM CNTR RND CXBAR	1
13.1	20C-1772	XBAR PLATE TOP CNTR RND CXBAR	1
14	10K-4060	HINGE PIN COMPOSITE XBAR TYP 2	2
15	10N-1730	CLINCH NUT 3/16 MS20142-3	9
16	20P-1341	SHACKLE - SS FORGED HALF TWIST	1
17	20P-1232	PULLEY HARKN TRIPLE BLOCK	1
18	45K-1314	XBAR STRAP FRONT WEDGE HOLD DWN	1
19	10A-2120	BOLT AN4-12	1
20	10C-4121	BOLT NAS 623-3-12	1
21	10C-1051	BOLT NAS 517-3-5	8
22	10A-2120	BOLT AN4-12	1



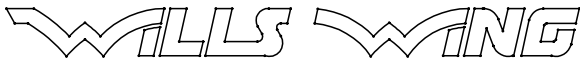
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TITLE: <b>Fusion Crossbar Center</b>				
Document ID: 83E01.1	DWG ID: Xbar Plate Center.DRW	DATE: 04-07-97	REVISED: 12-15-97	BY: Pearson

# 83E02.2 Fusion Front Leading Edge and Cam VG



ID	PART NO	DESCRIPTION	QNT
1	10G-2790	CLEVIS PIN MS20392-3C79	2
2	10P-1100	SAFETY RING AN 9491 SMALL	8
3	15F-6201	SADDLE, 62mm POLYCARB	4
4	20C-1751	XBAR PLATE CAM VG LEVER	2
5	10U-1141	WASHER STEEL AN960-416L	2
6	10N-1340	CASTLE NUT 1/4 AN310-4	6
7	10B-2520	BOLT AN24-52	2
8	10A-2260	BOLT AN4-26	2
9	10A-2240	BOLT AN4-24	2
10	40P-3104	WIRE BOTTOM SIDE 1/8 AT STYLE	2
11	15D-2001	SADDLE 2	2
12	20C-1752	XBAR PLATE SUPPORT STRAP CAM VG	2
13	10C-5071	BOLT NAS 623-4-7	2
14	10N-1740	CLINCH NUT 1/4 MS21042-4	2
15	10U-5125	WASHER NYLON .75 * .316 * .020	2
16	40P-5100	WIRE VG CAM LEVER ASSY	2
17	45G-3066	COVER NEOPRENE FUSION CAM VG WIRE	2
18	45G-3069	COVER NEOPRN CAM VG CABL JNCT	2
19	10U-5240	WASHER NYLON 1.50 * .250 * .02	2
20	10A-2100	BOLT AN4-10	2
21	10U-1400	WASHER MS 15795-210	2
22	20P-1331	SHACKLE - SS HARKN MICRO BLOCK	2
23	10L-1052	SCREW MS27039-0812	2
24	10N-1220	LOCKNUT LOWPRO 0832 SS	2
25	20P-1234	PULLEY HARKN TRIPLE BLK BCKT MFD	1
NS	15C-6219	ENDCAP 62mm OD 58.2 ID	2



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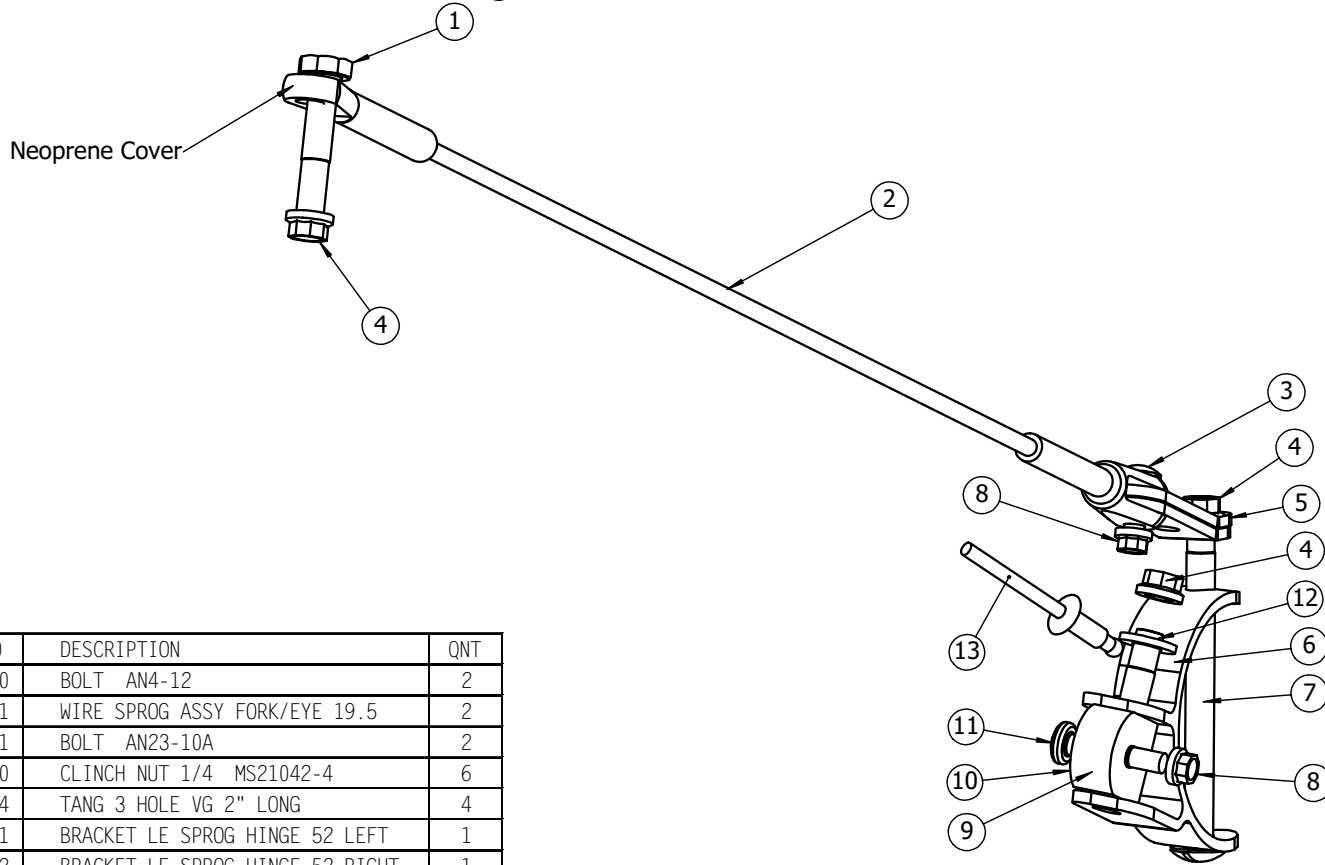
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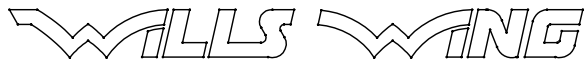
83E03.2

Fusion Sprog Wire and Bracket (Carbon Sprog)

**Note:**  
See 83E10 'Fusion Aluminum Sprog and Hardware Assembly'  
for Current Model Configuration



ID	PART NO	DESCRIPTION	QNT
1	10A-2120	BOLT AN4-12	2
2	40P-6001	WIRE SPROG ASSY FORK/EYE 19.5	2
3	10B-1101	BOLT AN23-10A	2
4	10N-1740	CLINCH NUT 1/4 MS21042-4	6
5	20E-2304	TANG 3 HOLE VG 2" LONG	4
6	20G-2451	BRACKET LE SPROG HINGE 52 LEFT	1
6	20G-2452	BRACKET LE SPROG HINGE 52 RIGHT	1
7	10B-2400	BOLT AN24-40	2
8	10N-1730	CLINCH NUT 3/16 MS20142-3	4
9	10B-2201	BOLT AN24-20A	2
10	20G-2448	SPROG FORK HINGE PILLAR	2
11	10C-4081	BOLT NAS 623-3-8	2
12	10U-1140	WASHER STEEL AN960-416	2
13	10R-0366	RIVET AL 3/16 * .375 CHAAPQ6-4	2
NS	45G-3065	COVER NEOPRENE FUSION SPROG	2



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TITLE: **Fusion Sprog Wire and Bracket (Carbon Sprog)**

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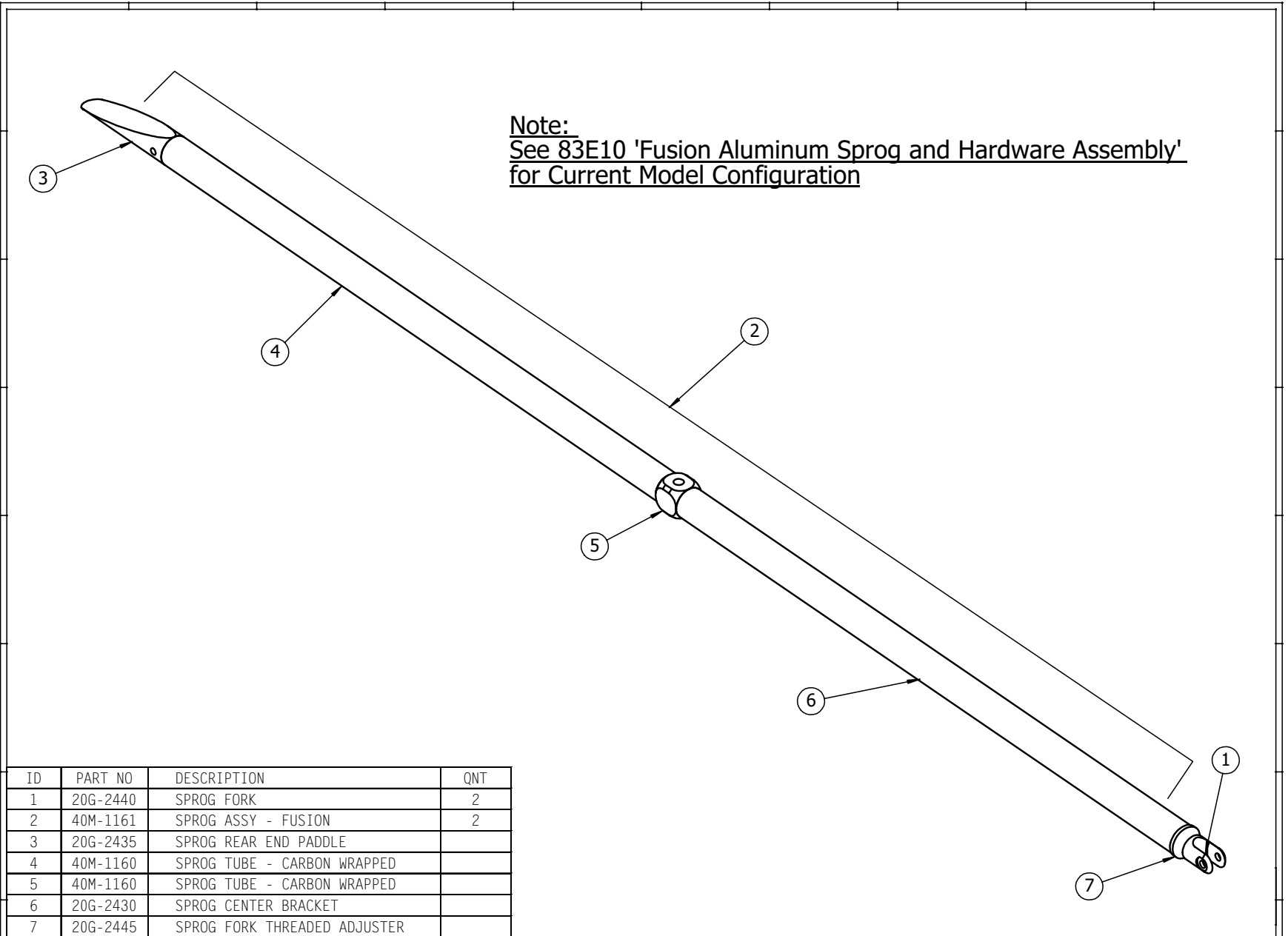
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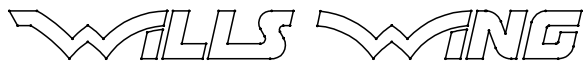
BY: Pearson

83E07.0

Fusion Sprog (Carbon)



ID	PART NO	DESCRIPTION	QNT
1	20G-2440	SPROG FORK	2
2	40M-1161	SPROG ASSY - FUSION	2
3	20G-2435	SPROG REAR END PADDLE	
4	40M-1160	SPROG TUBE - CARBON WRAPPED	
5	40M-1160	SPROG TUBE - CARBON WRAPPED	
6	20G-2430	SPROG CENTER BRACKET	
7	20G-2445	SPROG FORK THREADED ADJUSTER	



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TITLE: **Sprog**

Document ID:  
83E07.0

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DATE:  
04-07-97

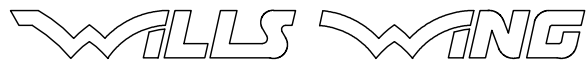
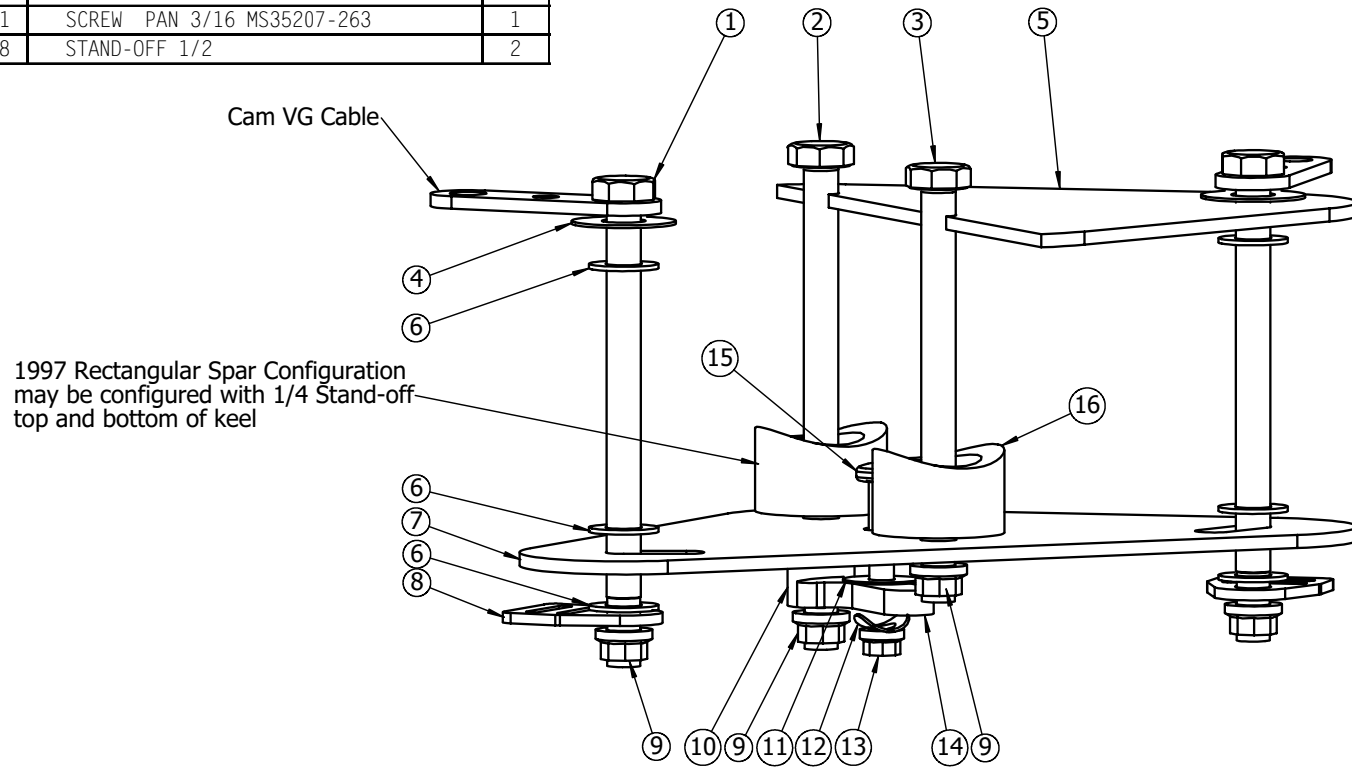
REVISED:  
06-10-97

BY:  
Pearson

T.U.S. .X ± .05  
 .XX ± .015  
 .XXX ± .003  
 .XXXX ± .0005  
 ANGLES ± 1/2°

# 83E04.1 Fusion Noseplate

ID	PART NO	DESCRIPTION	QNT
1	10A-2321	BOLT AN4-32A	2
2	10A-2341	BOLT AN4-34A	1
3	10A-2301	BOLT AN4-30A	1
4	10U-5125	WASHER NYLON .75 * .316 * .020	2
5	20C-1621	NOSEPLATE RAMAIR TOP EXTENDED	1
6	10U-1141	WASHER STEEL AN960-416L	6
7	20C-1631	NOSEPLATE FUSION BOTTOM SLOTTED	1
8	20E-2321	TANG 1 HOLE 2 SLOT 5/8 WEBBING	2
9	10N-1740	CLINCH NUT 1/4 MS21042-4	4
10	20G-2901	COLLAR KEYHOLE TANG BOLT	1
11	10U-5093	WASHER NYLON .560 * .192 * .015	1
12	10U-8010	WASHER WAVE KEYHOLE ANCHOR	1
13	10N-1730	CLINCH NUT 3/16 MS20142-3	1
14	20C-1501	SAFETY ALUM KEYHOLE ANCHOR	1
15	10L-1061	SCREW PAN 3/16 MS35207-263	1
16	15F-1608	STAND-OFF 1/2	2



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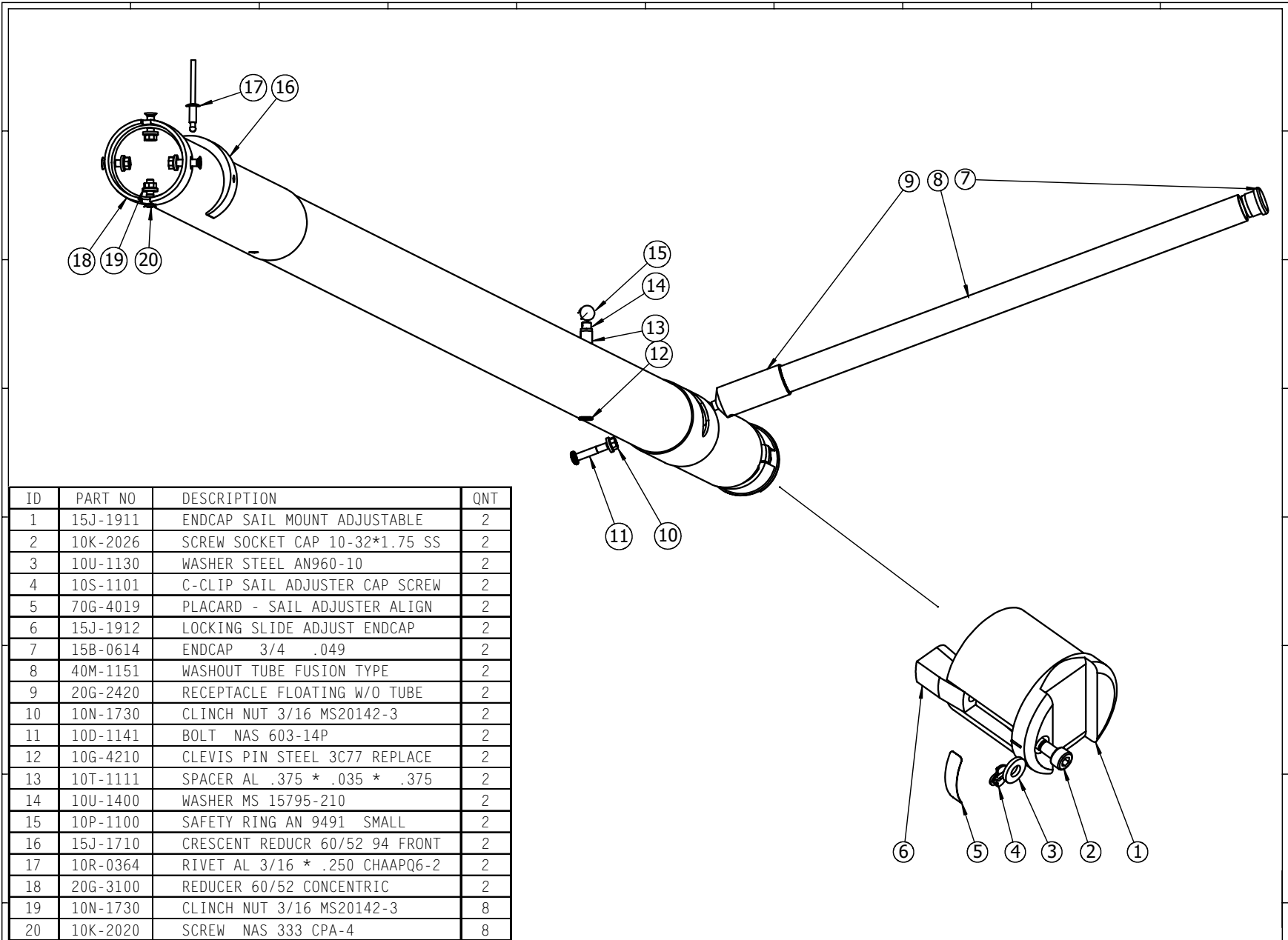
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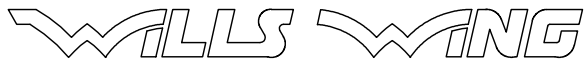
REVISED: 12-15-97

BY: Pearson

**83E05.1 Fusion Rear Leading Edge**



ID	PART NO	DESCRIPTION	QNT
1	15J-1911	ENDCAP SAIL MOUNT ADJUSTABLE	2
2	10K-2026	SCREW SOCKET CAP 10-32*1.75 SS	2
3	10U-1130	WASHER STEEL AN960-10	2
4	10S-1101	C-CLIP SAIL ADJUSTER CAP SCREW	2
5	70G-4019	PLACARD - SAIL ADJUSTER ALIGN	2
6	15J-1912	LOCKING SLIDE ADJUST ENDCAP	2
7	15B-0614	ENDCAP 3/4 .049	2
8	40M-1151	WASHOUT TUBE FUSION TYPE	2
9	20G-2420	RECEPTACLE FLOATING W/O TUBE	2
10	10N-1730	CLINCH NUT 3/16 MS20142-3	2
11	10D-1141	BOLT NAS 603-14P	2
12	10G-4210	CLEVIS PIN STEEL 3C77 REPLACE	2
13	10T-1111	SPACER AL .375 * .035 * .375	2
14	10U-1400	WASHER MS 15795-210	2
15	10P-1100	SAFETY RING AN 9491 SMALL	2
16	15J-1710	CRESCENT REDUCR 60/52 94 FRONT	2
17	10R-0364	RIVET AL 3/16 * .250 CHAAPQ6-2	2
18	20G-3100	REDUCER 60/52 CONCENTRIC	2
19	10N-1730	CLINCH NUT 3/16 MS20142-3	8
20	10K-2020	SCREW NAS 333 CPA-4	8

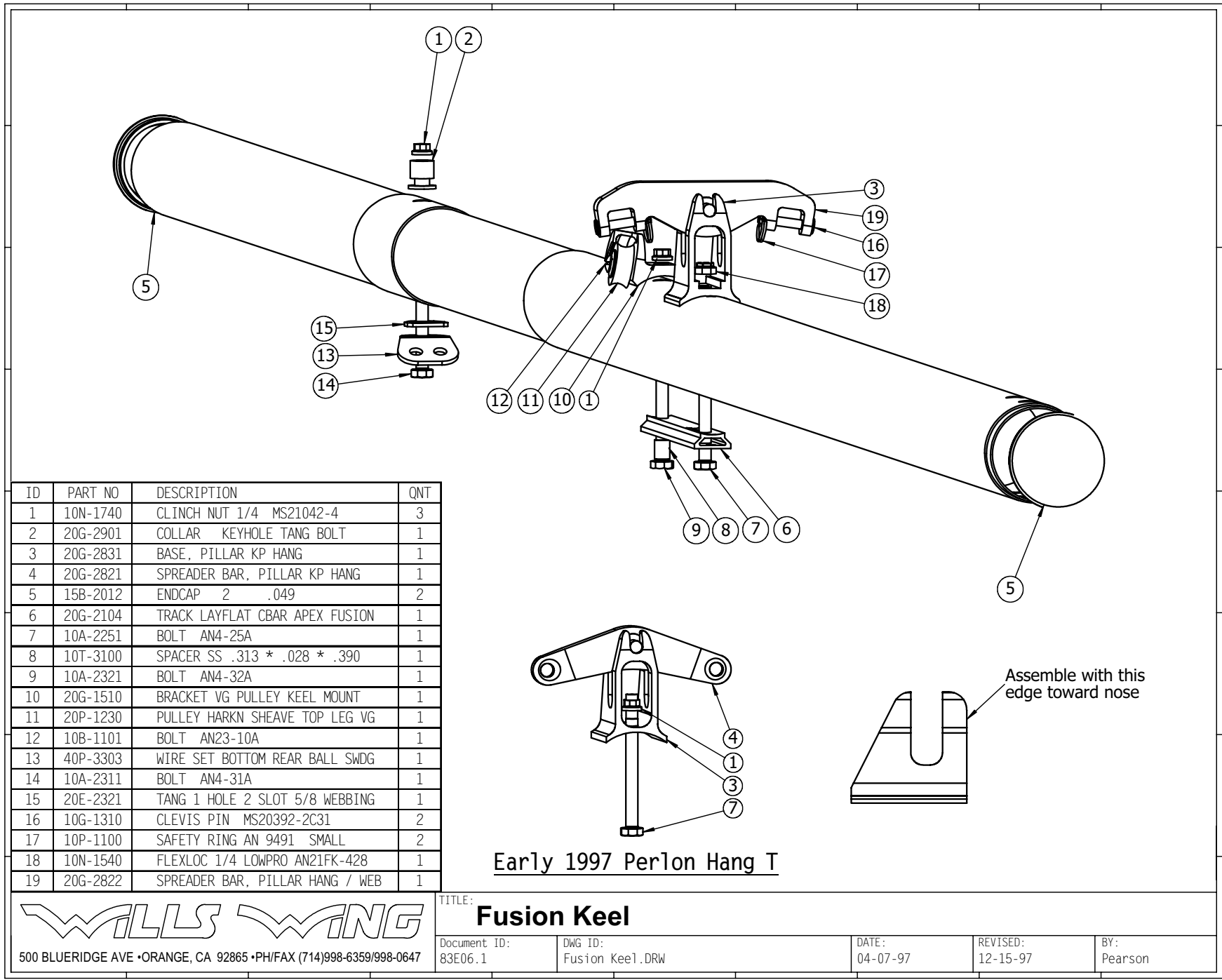


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TITLE: **Fusion Rear Leading Edge**

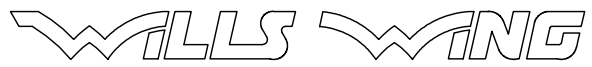
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83E06.1 Fusion Keel



ID	PART NO	DESCRIPTION	QNT
1	10N-1740	CLINCH NUT 1/4 MS21042-4	3
2	20G-2901	COLLAR KEYHOLE TANG BOLT	1
3	20G-2831	BASE, PILLAR KP HANG	1
4	20G-2821	SPREADER BAR, PILLAR KP HANG	1
5	15B-2012	ENDCAP 2 .049	2
6	20G-2104	TRACK LAYFLAT CBAR APEX FUSION	1
7	10A-2251	BOLT AN4-25A	1
8	10T-3100	SPACER SS .313 * .028 * .390	1
9	10A-2321	BOLT AN4-32A	1
10	20G-1510	BRACKET VG PULLEY KEEL MOUNT	1
11	20P-1230	PULLEY HARKN SHEAVE TOP LEG VG	1
12	10B-1101	BOLT AN23-10A	1
13	40P-3303	WIRE SET BOTTOM REAR BALL SWDG	1
14	10A-2311	BOLT AN4-31A	1
15	20E-2321	TANG 1 HOLE 2 SLOT 5/8 WEBBING	1
16	10G-1310	CLEVIS PIN MS20392-2C31	2
17	10P-1100	SAFETY RING AN 9491 SMALL	2
18	10N-1540	FLEXLOC 1/4 LOWPRO AN21FK-428	1
19	20G-2822	SPREADER BAR, PILLAR HANG / WEB	1

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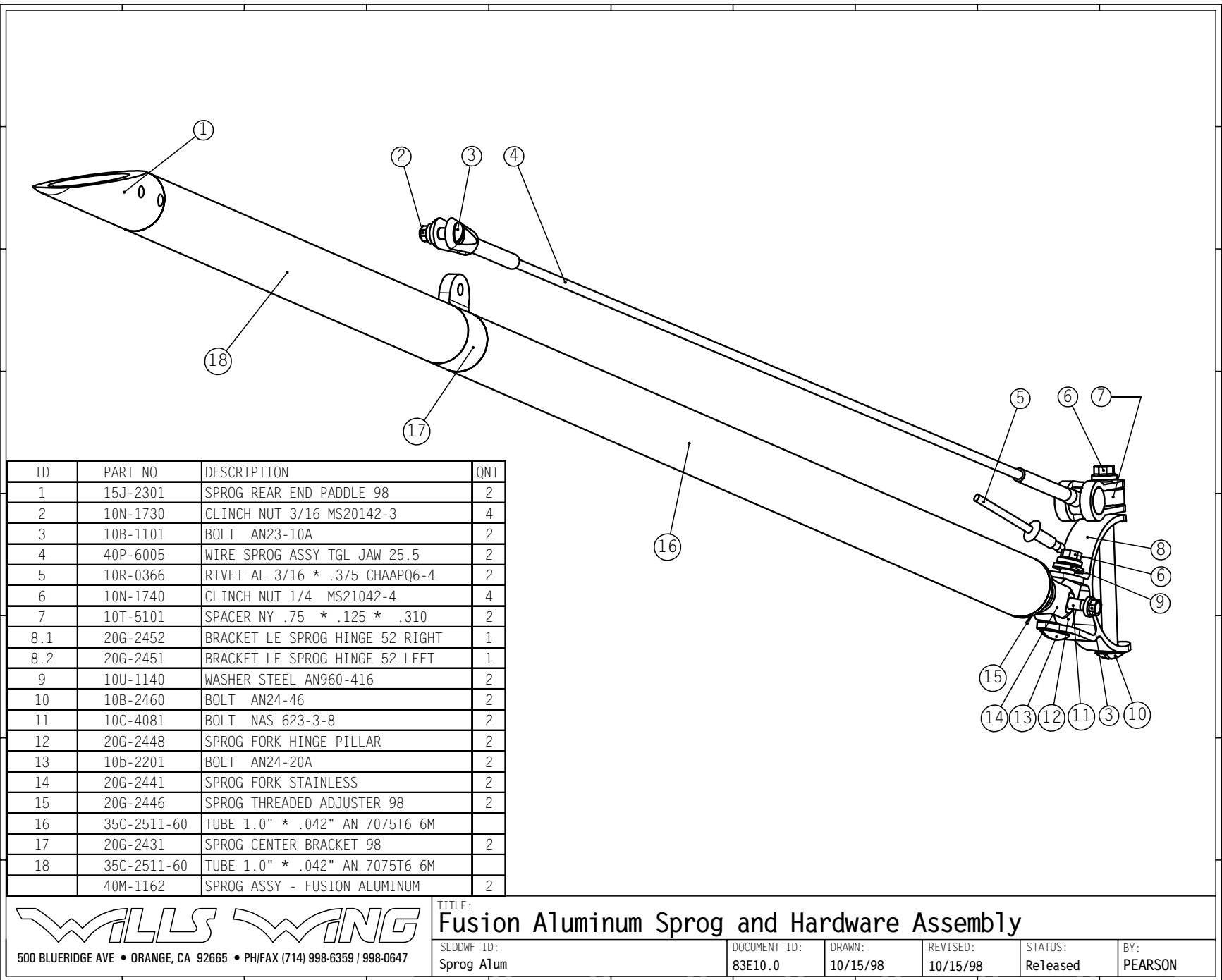


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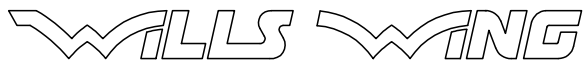
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		BY: Pearson	

83E10.0

Fusion Aluminum Sprog and Hardware Assembly



ID	PART NO	DESCRIPTION	QNT
1	15J-2301	SPROG REAR END PADDLE 98	2
2	10N-1730	CLINCH NUT 3/16 MS20142-3	4
3	10B-1101	BOLT AN23-10A	2
4	40P-6005	WIRE SPROG ASSY TGL JAW 25.5	2
5	10R-0366	RIVET AL 3/16 * .375 CHAAPQ6-4	2
6	10N-1740	CLINCH NUT 1/4 MS21042-4	4
7	10T-5101	SPACER NY .75 * .125 * .310	2
8.1	20G-2452	BRACKET LE SPROG HINGE 52 RIGHT	1
8.2	20G-2451	BRACKET LE SPROG HINGE 52 LEFT	1
9	10U-1140	WASHER STEEL AN960-416	2
10	10B-2460	BOLT AN24-46	2
11	10C-4081	BOLT NAS 623-3-8	2
12	20G-2448	SPROG FORK HINGE PILLAR	2
13	10b-2201	BOLT AN24-20A	2
14	20G-2441	SPROG FORK STAINLESS	2
15	20G-2446	SPROG THREADED ADJUSTER 98	2
16	35C-2511-60	TUBE 1.0" * .042" AN 7075T6 6M	
17	20G-2431	SPROG CENTER BRACKET 98	2
18	35C-2511-60	TUBE 1.0" * .042" AN 7075T6 6M	
	40M-1162	SPROG ASSY - FUSION ALUMINUM	2



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TITLE:

Fusion Aluminum Sprog and Hardware Assembly

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Sprog Alum

DOCUMENT ID:  
83E10.0

DRAWN:  
10/15/98

REVISED:  
10/15/98

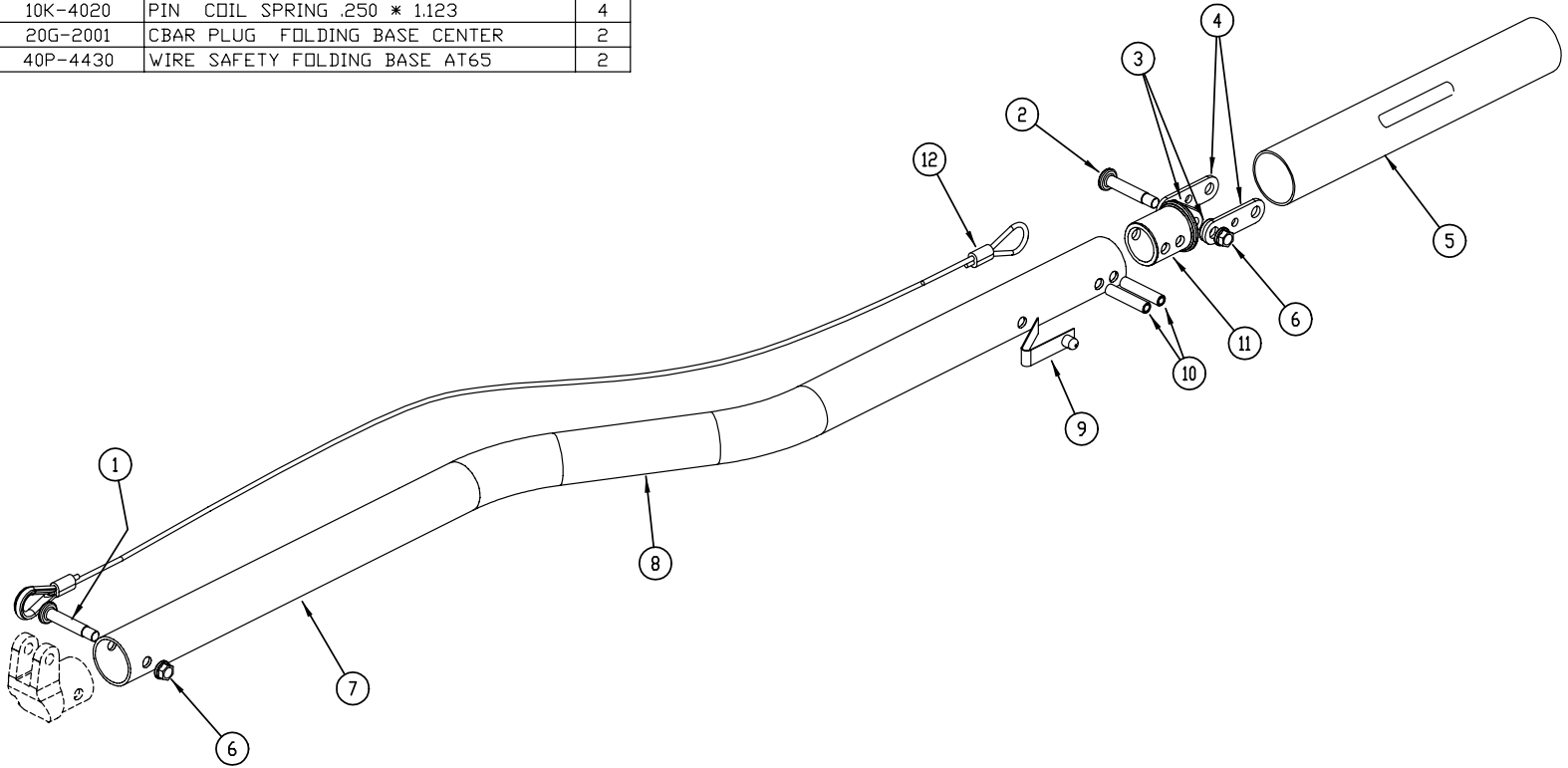
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BY:  
PEARSON

83E09

VG Folding Base Tube

ID	PART NO	DESCRIPTION	QNT
1	10C-5171	BOLT NAS 623-4-17	2
2	10C-5071	BOLT NAS 623-4-7	2
3	10U-5095	WASHER NYLON .560 * .320 * .013	4
4	20E-2305	TANG 3 HOLE FOLDNG BASE CENTER	2
5	40F-1391	SLEEVE FOLDING BASE TUBE CENTER	1
6	10N-1740	CLINCH NUT 1/4 MS21042-4	4
7	40F-1342	BASE TUBE HALF AT68 FOLDING SPD	2
ITEM NO.7 40F-1342 ARE ASSEMBLIES WITH NO USER SERVICABLE PARTS. COMPONENT PARTS ARE LISTED BELOW			
8	15A-1401	GRIP BASE TUBE POLYFOAM	2
9	20A-1502	BUTTON SPRING DOUBLE	2
10	10K-4020	PIN COIL SPRING .250 * 1.123	4
11	20G-2001	CBAR PLUG FOLDING BASE CENTER	2
12	40P-4430	WIRE SAFETY FOLDING BASE AT65	2



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TITLE:

VG FOLDING BASE TUBE

PART NO:  
NA

DWG ID:  
83E09.DWG

DOCUMENT ID:  
83E09.0

REVISED:  
06-26-97 sp

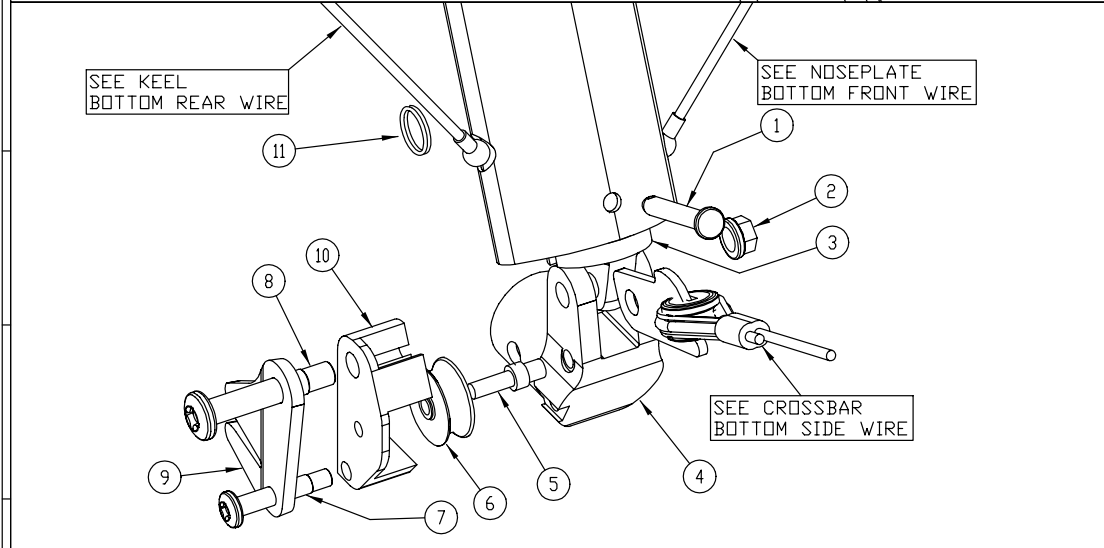
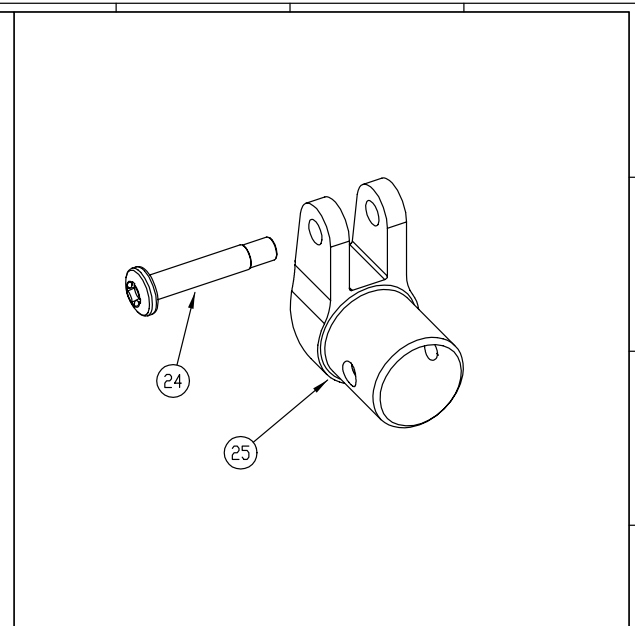
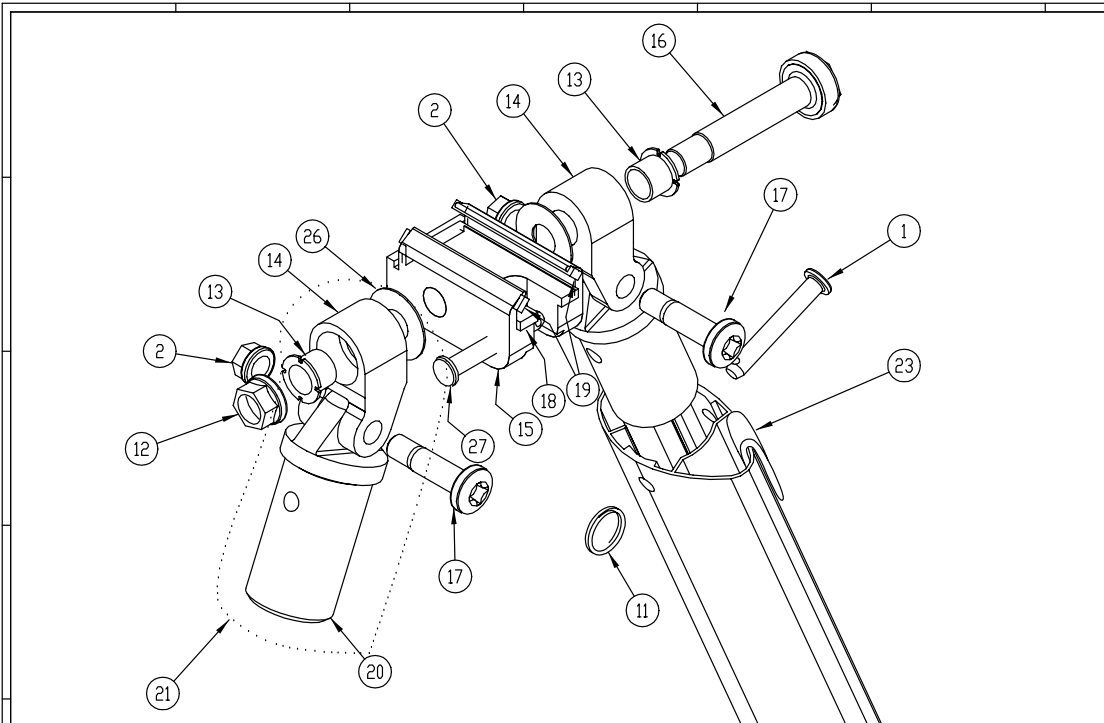
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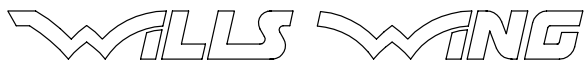
T.U.S. .X ± .05  
.XX ± .015  
.XXX ± .003  
.XXXX ± .0005  
ANGLES ± 1/2°

80E08

VG Control Bar



ID	PART NO	DESCRIPTION	QNT
1	10G-1330	CLEVIS PIN MS20392-2C33	4
2	10N-1740	CLINCH NUT 1/4 MS21042-4	4
3	20G-1424	CBAR PLUG AT LEG BOT STR TDE95	2
4	20G-1802	CBAR BRACKET AT BASE END VG	1
5	10K-4040	PIN VG PULLEY SS MACHINED	1
6	20P-1220	PULLEY ALUM MACH CBAR BASE VG	1
7	10D-1161	BOLT NAS 603-16P	1
8	10C-5241	BOLT NAS 623-4-24	1
9	20C-1801	JAMCLEAT KNIFE V-CUT / ROPE VG	1
10	20G-1803	BRACKET BASE PULLEY ROPE VG	1
11	10P-1100	SAFETY RING AN 9491 SMALL	5
12	10N-1750	CLINCH NUT 5/16 MS21042-5	1
13	10T-5113	BUSH SPLIT HEADED AT CB SHORT	2
14	20G-1711	CBAR ELBOW AT TOP STREAM	2
15	20G-2203	SLIDER LAYFLAT CBAR APEX 3	1
16	10A-3201	BOLT AN5-20A GROUND & SLOTTED	1
17	10C-5111	BOLT NAS 623-4-11	2
18	15J-2003	GLIDE NOTCHED LAFLT APEX SLDR	1
19	15J-2002	GLIDE LAYFLAT APEX SLIDR SIDE	2
20	20G-1433	CBAR PLUG AT LEG TOP STR TDEIN	2
21	45G-3064	COVER NEOPRENE CB APEX RT VG	1
22	45G-3062	COVER NEOPRENE CBAR APEX LEFT	1
23	15A-1610	PROTECTOR VG ROPE - UHMW TAPE	1
24	10C-5121	BOLT NAS 623-4-12	1
25	20G-1801	CBAR BRACKET AT BASE TUBE END	1
26	10U-5125	WASHER NYLON .75 * .316 * .020	2
27	10G-1370	CLEVIS PIN MS20392-2C37	1



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TITLE:

VG CONTROL BAR

T.U.S. .X ± .05  
 .XX ± .015  
 .XXX ± .003  
 .XXXX ± .0005  
 ANGLES ± 1/2°

PART NO:  
NA

DWG ID:  
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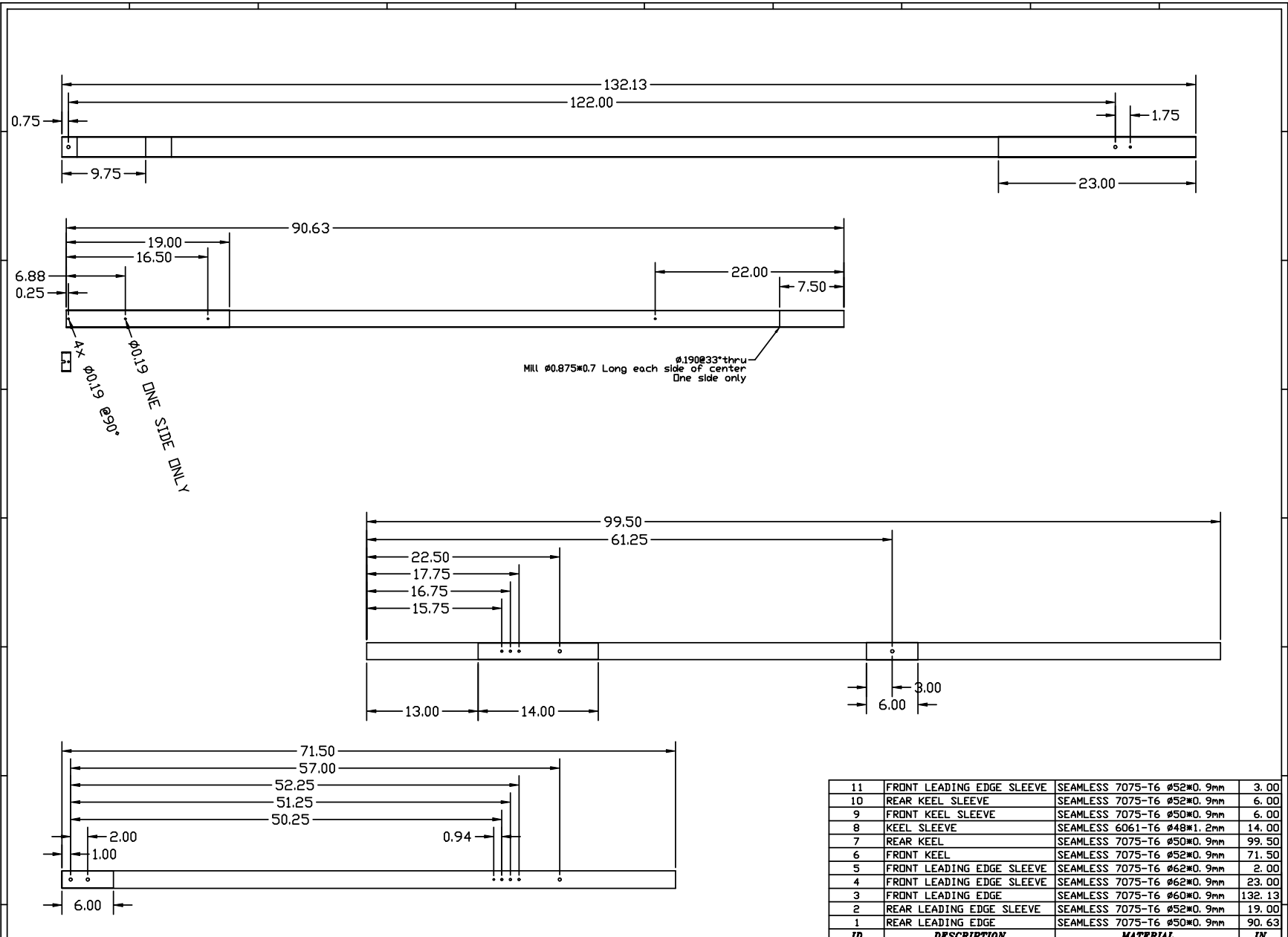
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06-26-97

DRAWN:  
01-15-96 sp

SCALE:  
NA



# Fusion 141 Frame Plans

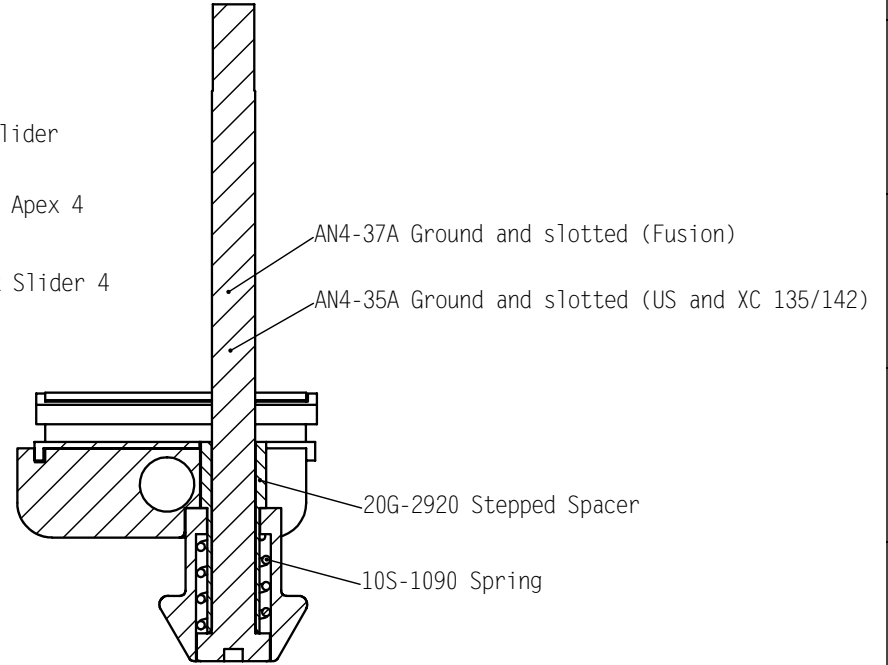
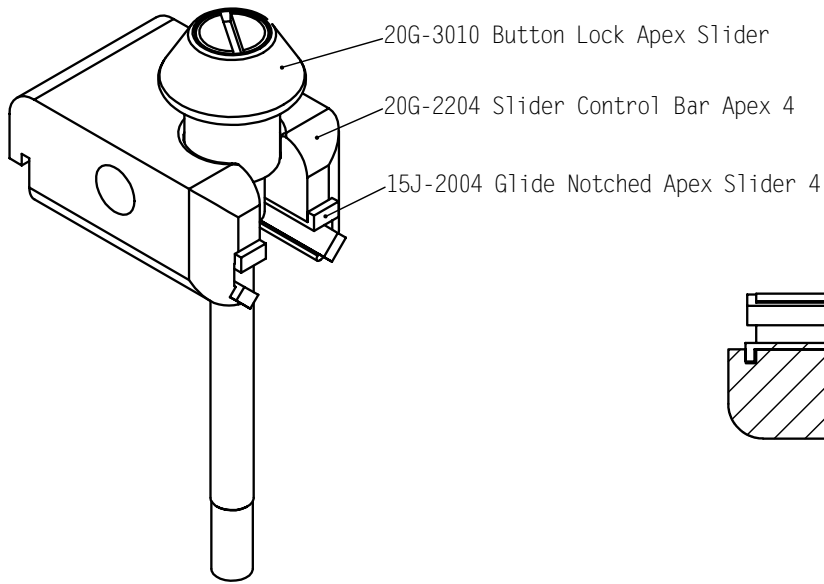


11	FRONT LEADING EDGE SLEEVE	SEAMLESS 7075-T6 Ø52x0.9mm	3.00
10	REAR KEEL SLEEVE	SEAMLESS 7075-T6 Ø52x0.9mm	6.00
9	FRONT KEEL SLEEVE	SEAMLESS 7075-T6 Ø50x0.9mm	6.00
8	KEEL SLEEVE	SEAMLESS 6061-T6 Ø48x1.2mm	14.00
7	REAR KEEL	SEAMLESS 7075-T6 Ø50x0.9mm	99.50
6	FRONT KEEL	SEAMLESS 7075-T6 Ø52x0.9mm	71.50
5	FRONT LEADING EDGE SLEEVE	SEAMLESS 7075-T6 Ø62x0.9mm	2.00
4	FRONT LEADING EDGE SLEEVE	SEAMLESS 7075-T6 Ø62x0.9mm	23.00
3	FRONT LEADING EDGE	SEAMLESS 7075-T6 Ø60x0.9mm	132.13
2	REAR LEADING EDGE SLEEVE	SEAMLESS 7075-T6 Ø52x0.9mm	19.00
1	REAR LEADING EDGE	SEAMLESS 7075-T6 Ø50x0.9mm	90.63
ID	DESCRIPTION	MATERIAL	IN

		TITLE: <b>Fusion 141</b>					T.U.S. .X ± .05	
		PART NO: NA		DWG ID: Frame Plans F.		DOCUMENT ID: NA	MATERIAL: NA	DRAWN: R10-15-98 sp
500 BLUERIDGE AVE • ORANGE • CA • 92665 • PH/FAX (714) 998-6359 / 998-0647							.XXX ± .003	
							.XXXX ± .0005	
							ANGLES ± 1/2°	

# Button Lock Apex Slider Assembly

Note:  
Replaces Item 5 and Item 6 Drawings 82E01 and 84E02  
and Items 15, 18 Drawing 80E06



A-A



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TITLE:

## Button Lock Apex Slider Assembly

Document ID:  
na

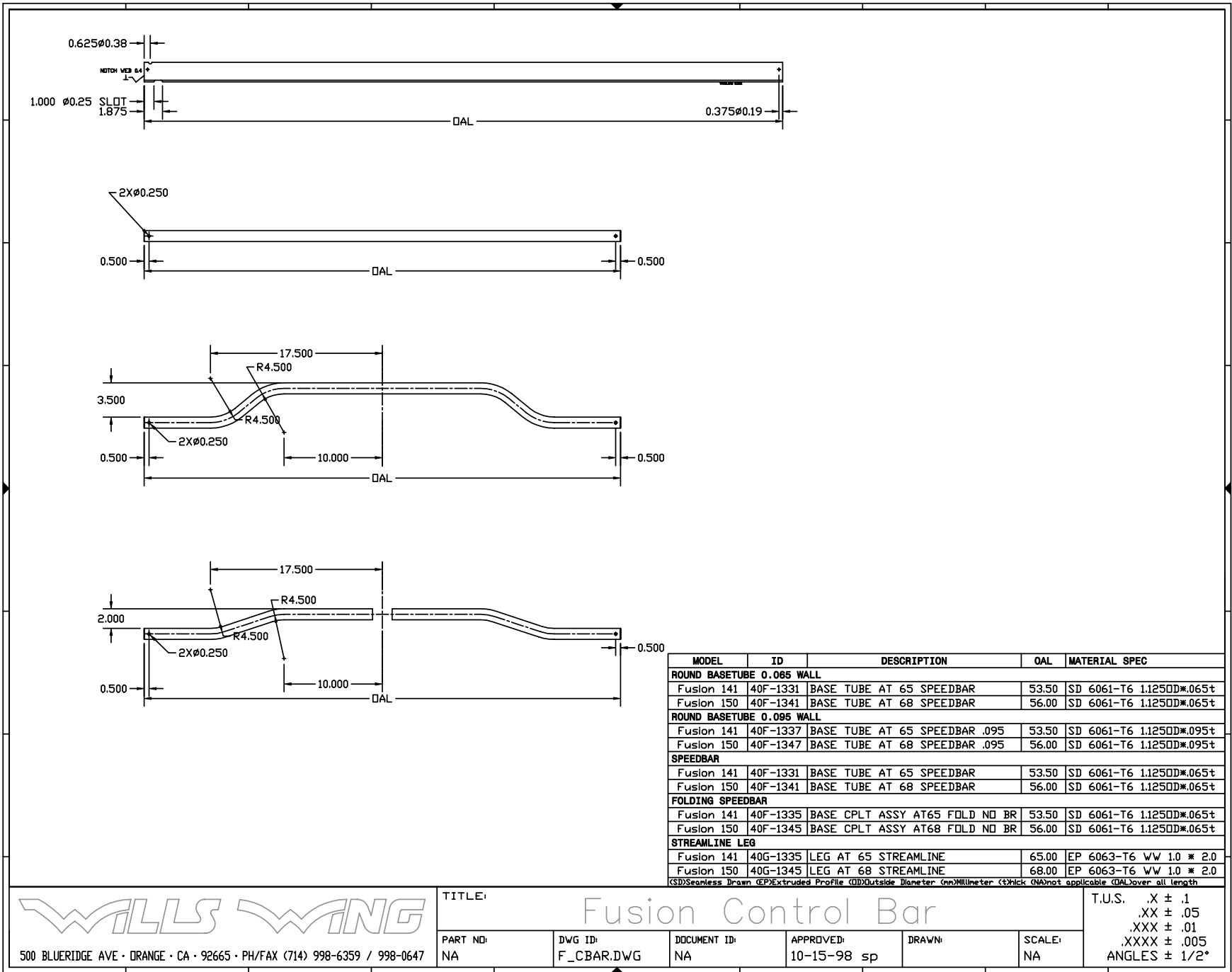
DWG ID:  
na

DATE:  
06-29-98

REVISED:  
-

BY:  
Pearson

# Fusion Control Bar



MODEL	ID	DESCRIPTION	OAL	MATERIAL SPEC
<b>ROUND BASETUBE 0.085 WALL</b>				
Fusion 141	40F-1331	BASE TUBE AT 65 SPEEDBAR	53.50	SD 6061-T6 1.125OD*.065t
Fusion 150	40F-1341	BASE TUBE AT 68 SPEEDBAR	56.00	SD 6061-T6 1.125OD*.065t
<b>ROUND BASETUBE 0.095 WALL</b>				
Fusion 141	40F-1337	BASE TUBE AT 65 SPEEDBAR .095	53.50	SD 6061-T6 1.125OD*.095t
Fusion 150	40F-1347	BASE TUBE AT 68 SPEEDBAR .095	56.00	SD 6061-T6 1.125OD*.095t
<b>SPEEDBAR</b>				
Fusion 141	40F-1331	BASE TUBE AT 65 SPEEDBAR	53.50	SD 6061-T6 1.125OD*.065t
Fusion 150	40F-1341	BASE TUBE AT 68 SPEEDBAR	56.00	SD 6061-T6 1.125OD*.065t
<b>FOLDING SPEEDBAR</b>				
Fusion 141	40F-1335	BASE CPLT ASSY AT65 FOLD NO BR	53.50	SD 6061-T6 1.125OD*.065t
Fusion 150	40F-1345	BASE CPLT ASSY AT68 FOLD NO BR	56.00	SD 6061-T6 1.125OD*.065t
<b>STREAMLINE LEG</b>				
Fusion 141	40G-1335	LEG AT 65 STREAMLINE	65.00	EP 6063-T6 WW 1.0 * 2.0
Fusion 150	40G-1345	LEG AT 68 STREAMLINE	68.00	EP 6063-T6 WW 1.0 * 2.0

(SD)Seamless Drawn (EP)Extruded Profile (OD)Outside Diameter (mm)Millimeter (t)Thickness (NA)not applicable (DAL)over all length

**WILLS WING**  
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TITLE: <b>Fusion Control Bar</b>		T.U.S. .X ± .1 .XX ± .05 .XXX ± .01 .XXXX ± .005 ANGLES ± 1/2°	
PART NO: NA	DWG ID: F_CBAR.DWG	DOCUMENT ID: NA	APPROVED: 10-15-98 sp
DRAWN:		SCALE: NA	