P/N: 6B6-2
Firewall

P/N: 6B6-1
Firewall Bottom Stiffener

Clamp the stiffener inside the bottom flange of the firewall.

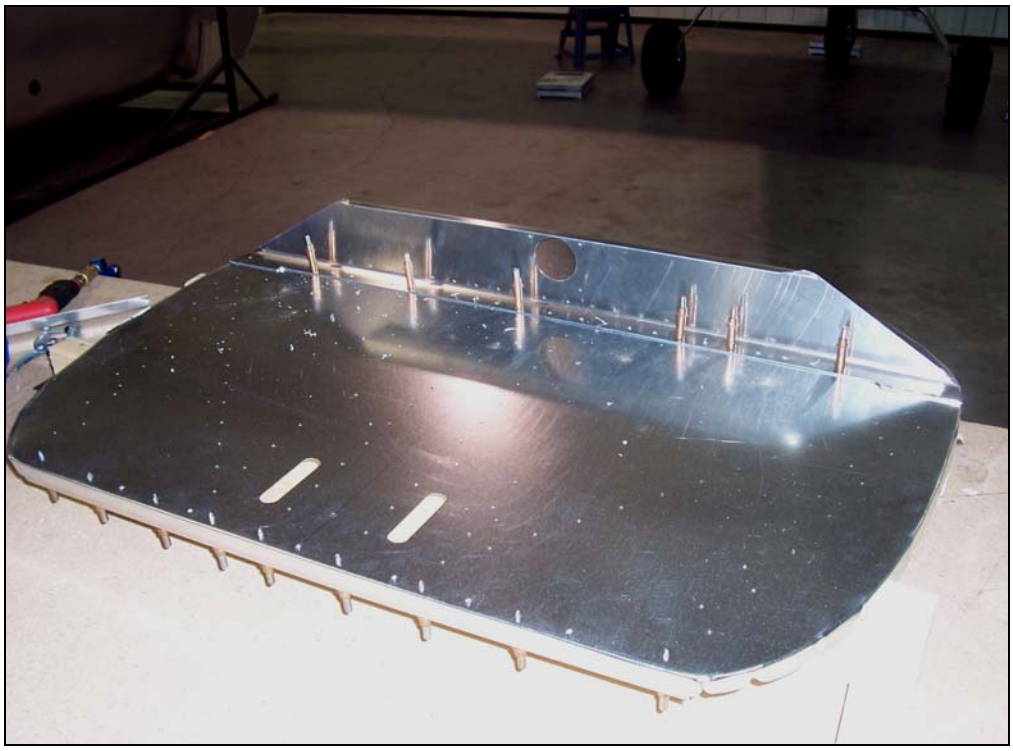
Back drill through the predrilled holes in the Firewall through the Firewall Bottom Stiffener (flange that overlaps firewall, do not drill bottom flange).

A4 Rivets

Cleco every other hole as you drill.

Check: the center line is square to the bottom of the firewall.

Layout the aircraft center line.



P/N: 6B7-1
Firewall Top Stiffener

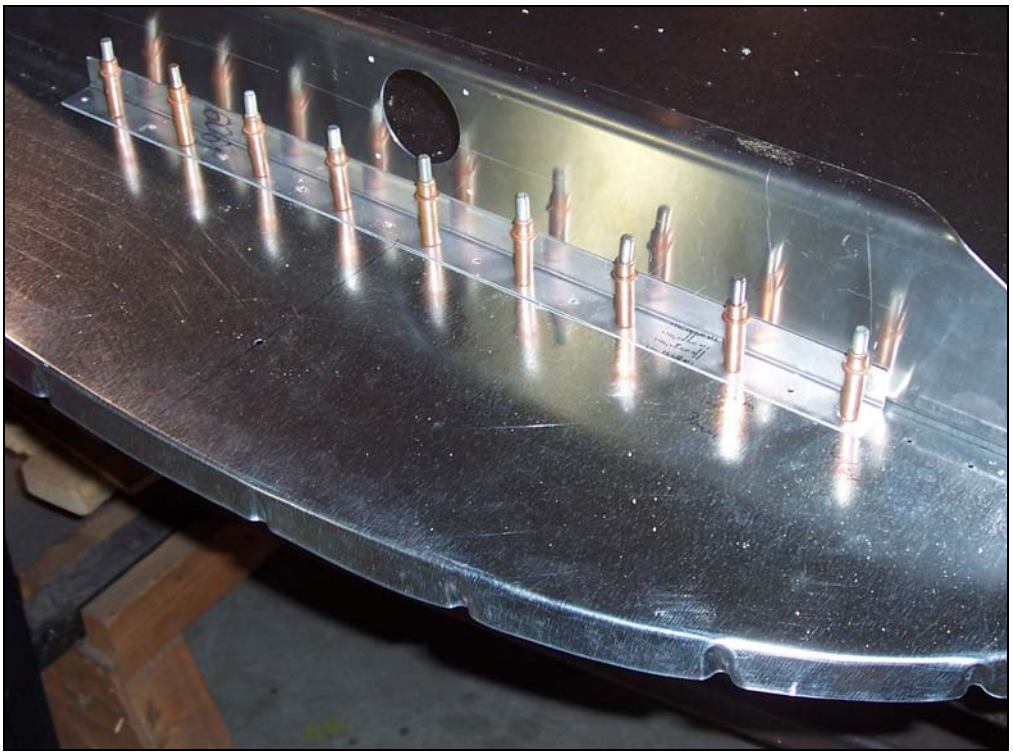
A5 Rivets

Cleco the Firewall Top Stiffener to the Firewall. Expand the predrilled holes first with a #30 drill then to #20, Cleco every other hole as you drill.

CORNER L ANGLE

Ref: top middle diagram on drawing 6-B-7

Cut a piece of L angle 520mm (photo shows holes drilled in the L angle, this is done in the next step).



Mark a center line on the L angle and align with the center line of the Firewall.

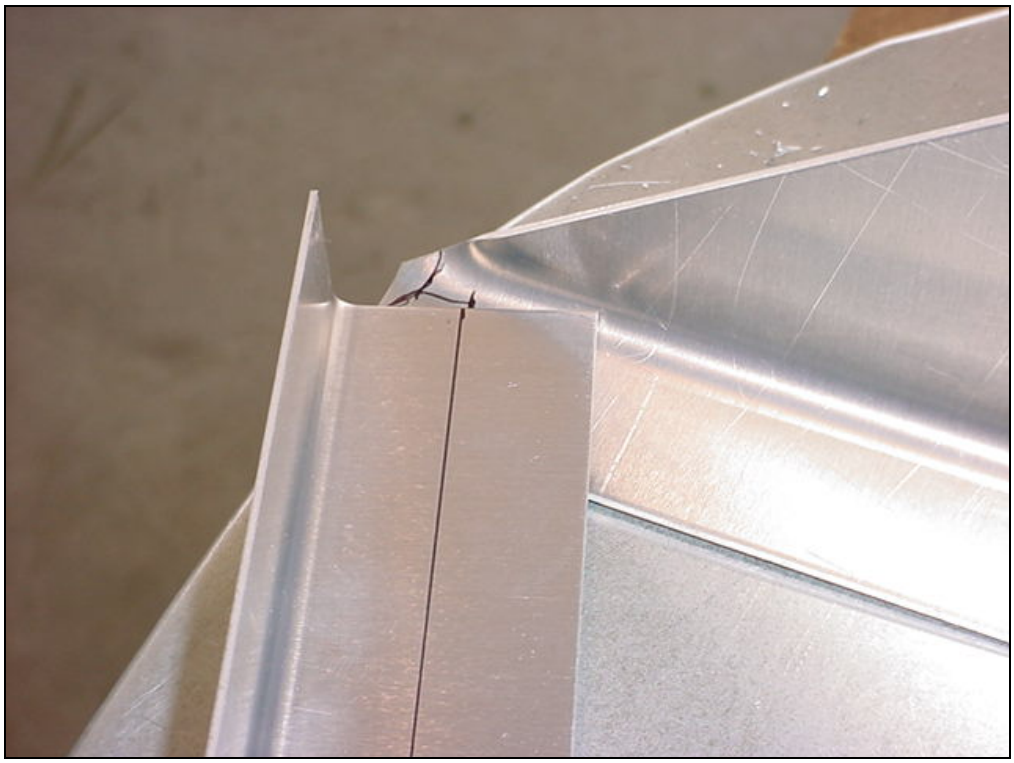
A5 Rivets

Check: There should be 10mm edge distance on the last hole to the end of the L angle. Back drill through the predrilled holes in the Firewall through the L angle and Cleco every other hole.

Note: Be careful that the Drill Chuck does not damage the Firewall Top Stiffener or the Firewall when drilling.

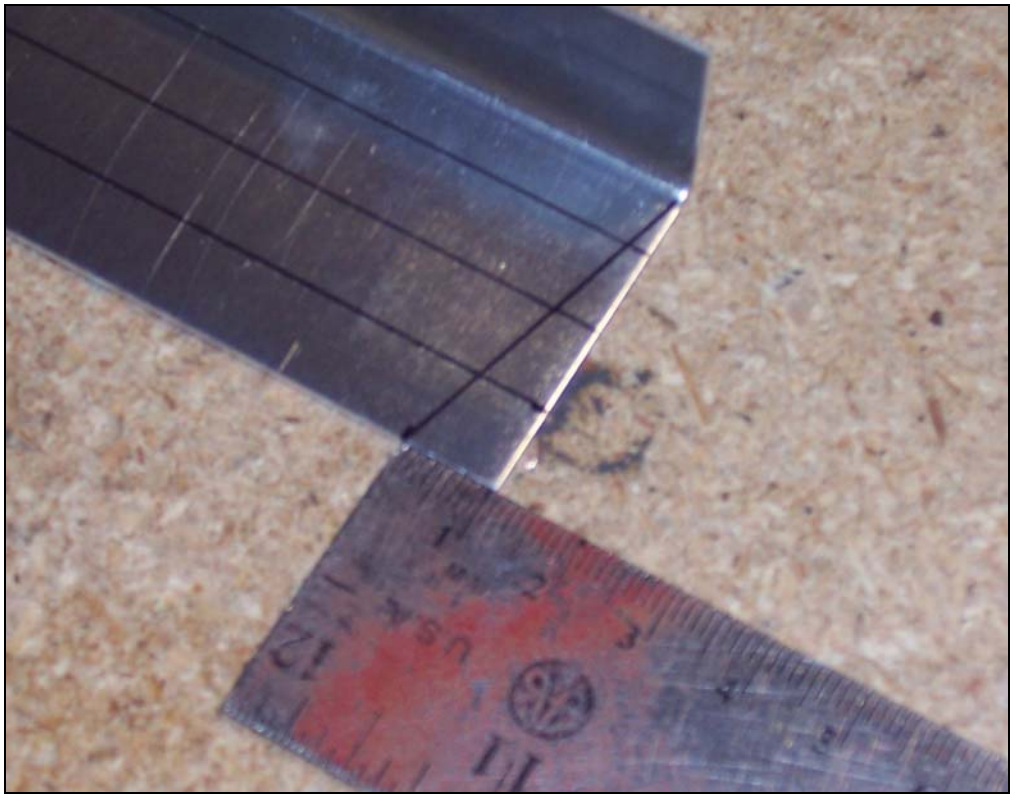
Note: Once you have drilled and Clecoed two holes through the Firewall Top Stiffener to the L angle, you can take them off the Firewall to finish drilling the remaining holes.

Back drill and Cleco the Firewall Top Stiffener to the L angle. An angle drill makes this easy, but is not required.



P/N: 6B6-3
Firewall Side Stiffener

Mark the flange centerline on the 40mm wide flange.
The stiffener is positioned with the centerline over the pilot holes for the top and bottom engine mount fitting.



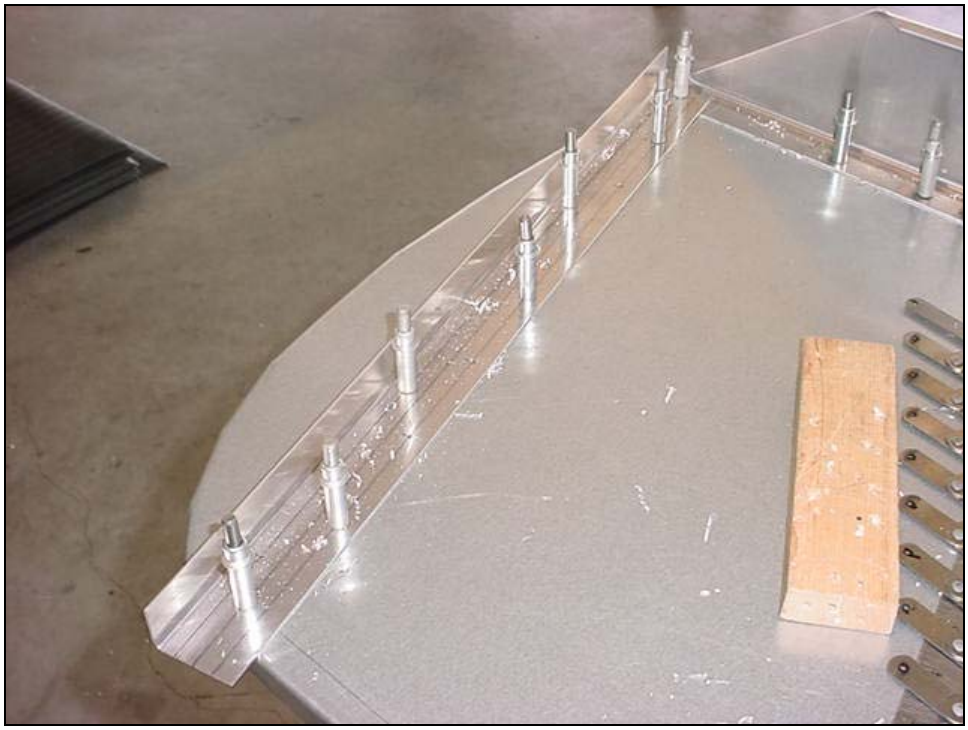
P/N: 6B6-3
FIREWALL SIDE
STIFFENER

IMPORTANT: The top edge of 6B6-3 is even with the bend tangent line. Check it is not pushed up too high into the radius – this will cause a gap between the overlapping flanges)

Mark a line from the start of the bend radius to a point 10mm from the end of the Firewall Side Stiffener. Trim the Firewall Side Stiffener along this line.

Wait to trim the bottom until after the side stiffener is Clecoed to the firewall.

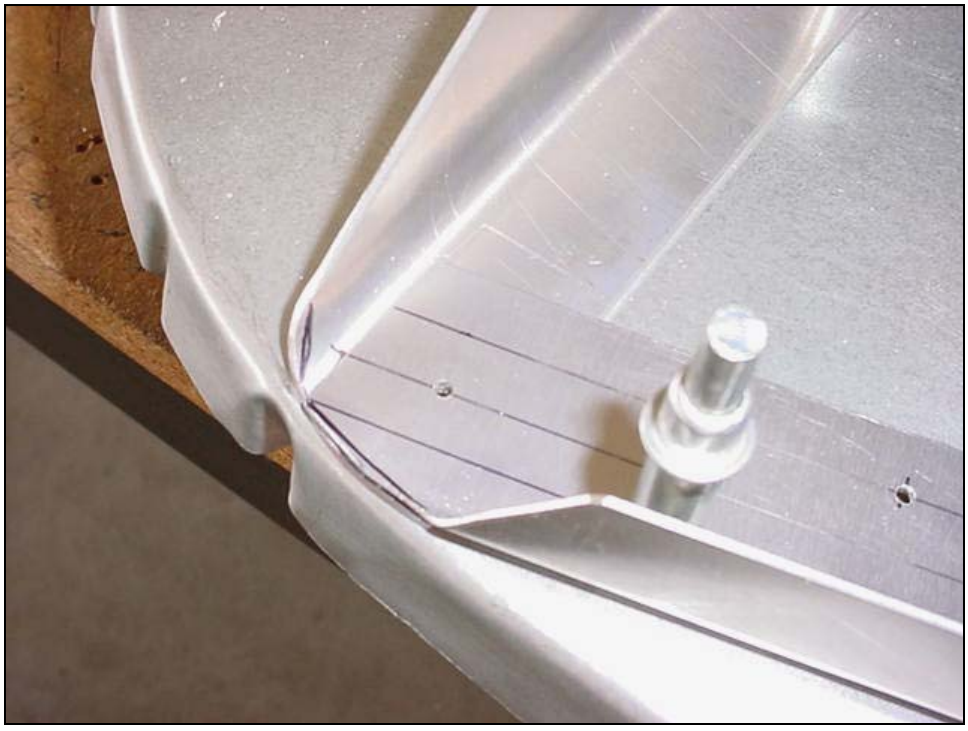
Align the center line through the engine mount hole, drill, and Cleco both top and bottom engine mount holes.



Back drill and Cleco the Firewall Side Stiffeners to the Firewall through the predrilled holes.

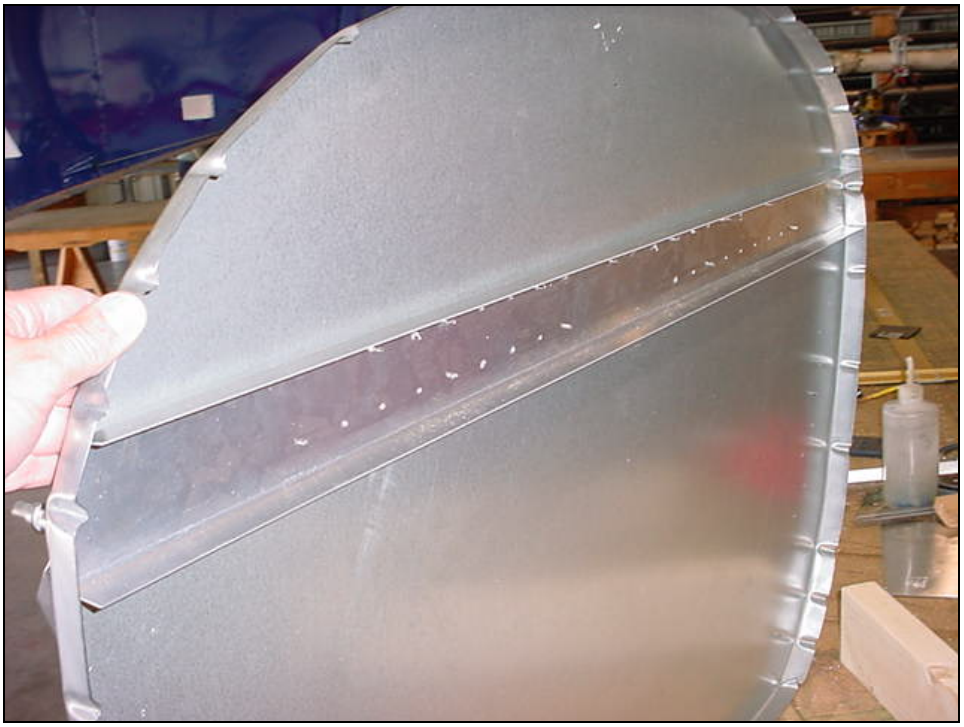
Trace the bottom of the firewall on the stiffeners and trim the stiffeners flush to the bottom edge of the firewall.

A5 Rivets



Layout the contour of the firewall on the side stiffener 6B6-3. Remove and trim.

Mark and round off (file) the point at the end of the stiffener.



P/N: 6B7-2
Firewall Reinforcement

Note: Not all holes have been back drilled in the photo. Back drill all holes through 6B7-2 at this time.

Remove the stiffener and L angle on the front side of the firewall. Trim the ends of 6B7-2 to fit inside the firewall flange. Mark a 10mm line on the backside of 6B7-2 on the top. Clamp, back drill, and Cleco from the front side of the Firewall.

A4 Rivets

Draw a 10mm edge distance line down the L angle. Align the line on the L angle through the predrilled holes in the Firewall. Drill and Cleco the L angle to the Firewall.