

5/16" transfer punches

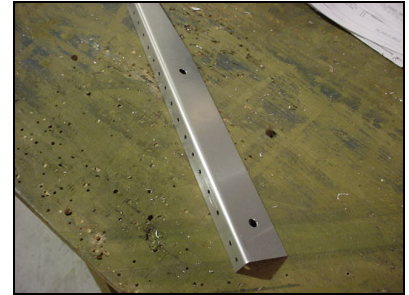


5/16" Drill guide bushing (use the specified drill bit)

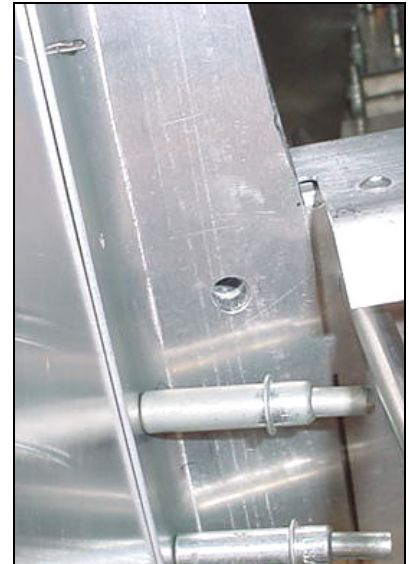
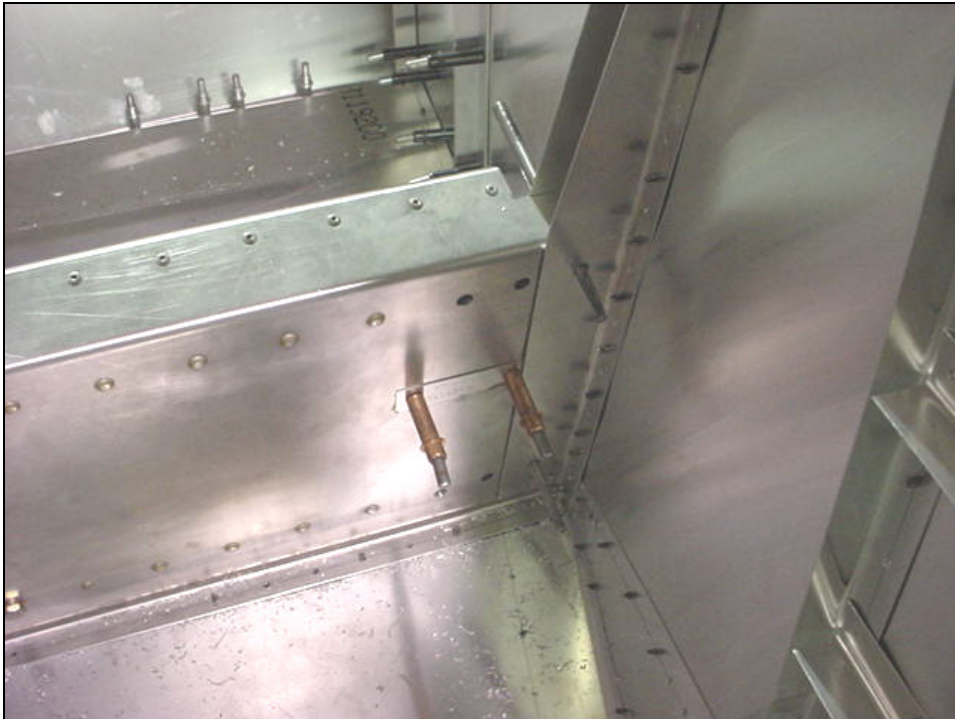
Remove on the wing attachment uprights.



Insert the drill guide bushing in the O/B 5/16" hole through the Wing Attachment 6B13-1
Either use a transfer punch or a drill guide bushing to make the hole.

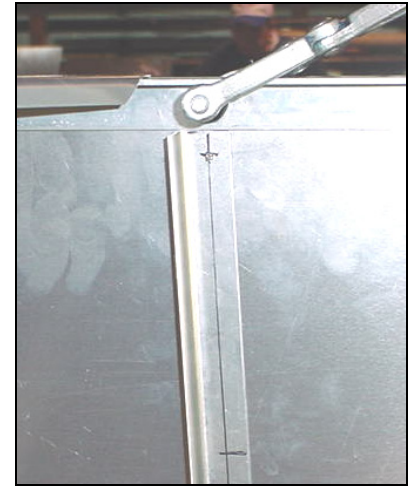


Remove the wing attachment upright to open the pilot hole to 5/16"



5/16" hole before the drill guide bushing is installed.

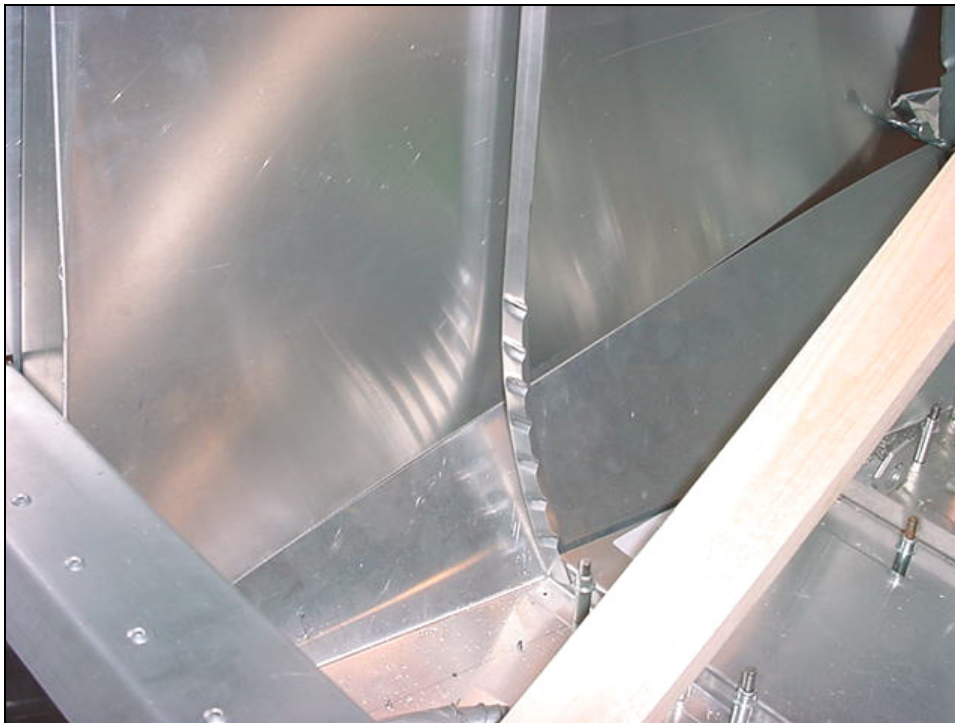
Re-install both wing attachments to the side skin. Insert the drill guide bushing and drill the second wing attachment upright.



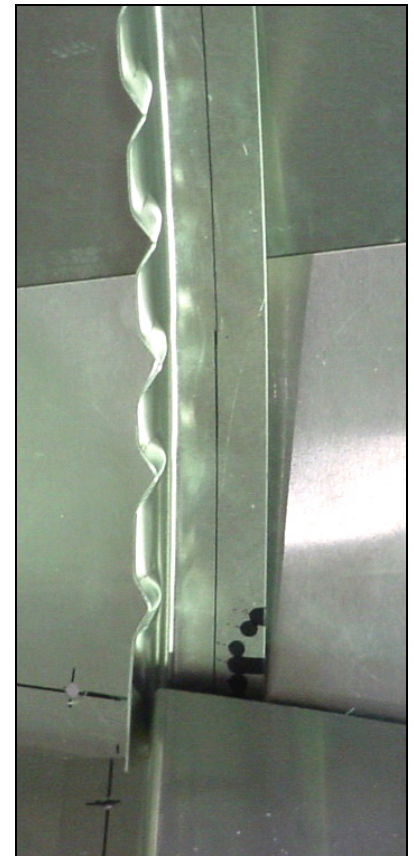
**VERTICAL
L ANGLE**

Ref 6-B-15

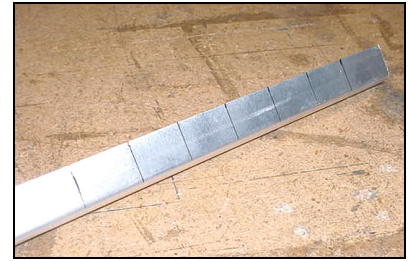
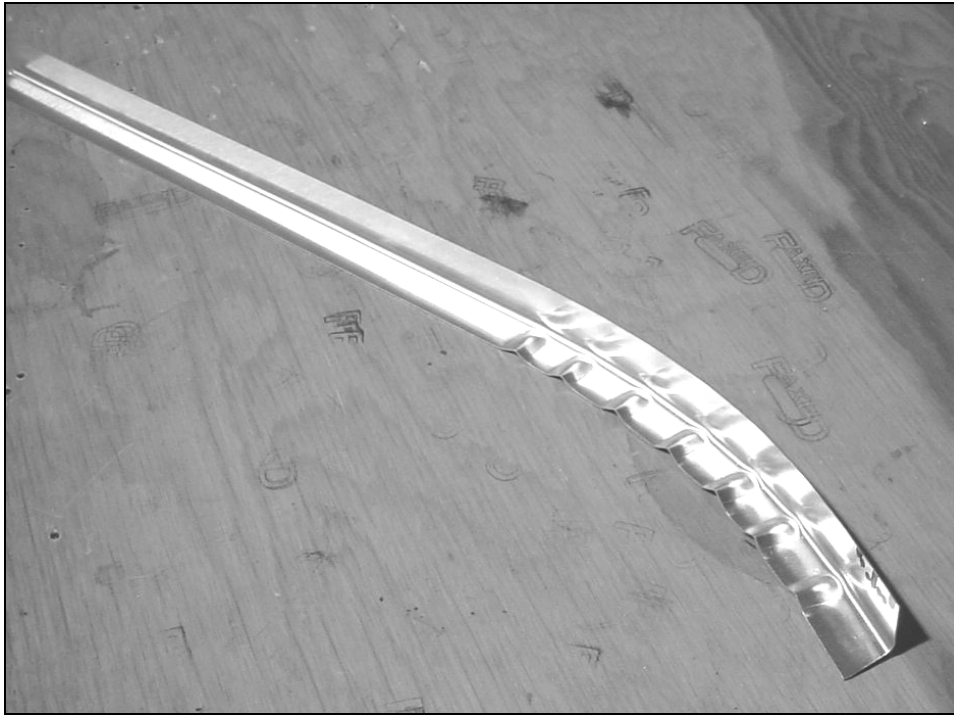
Crimp the bottom of the L angle.



The inboard flange of the vertical L angle overlaps the back side of the Heel Support 6B8-8



Detail of right side looking forward.



7 Crimps
Ref bottom diagram on 6-B-15

Crimps on the inboard flange only.



Step 1



Position the crimping tool and twist



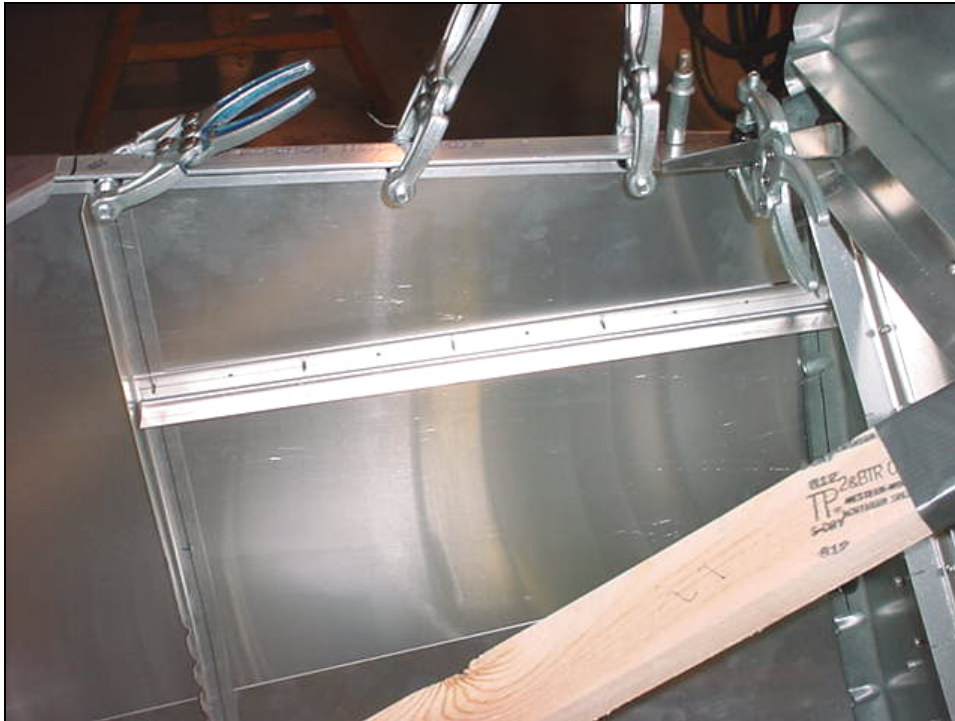
Step 2



Hand Crimper (previously used in the wings to form 6W6 & 7)

P/N CRIMP

- 1) Twist to the right to form one side of the crimp
- 2) Then twist to the left to form the other side of the crimp.



First Horizontal L Angle
Orientation: the bend is towards the bottom.



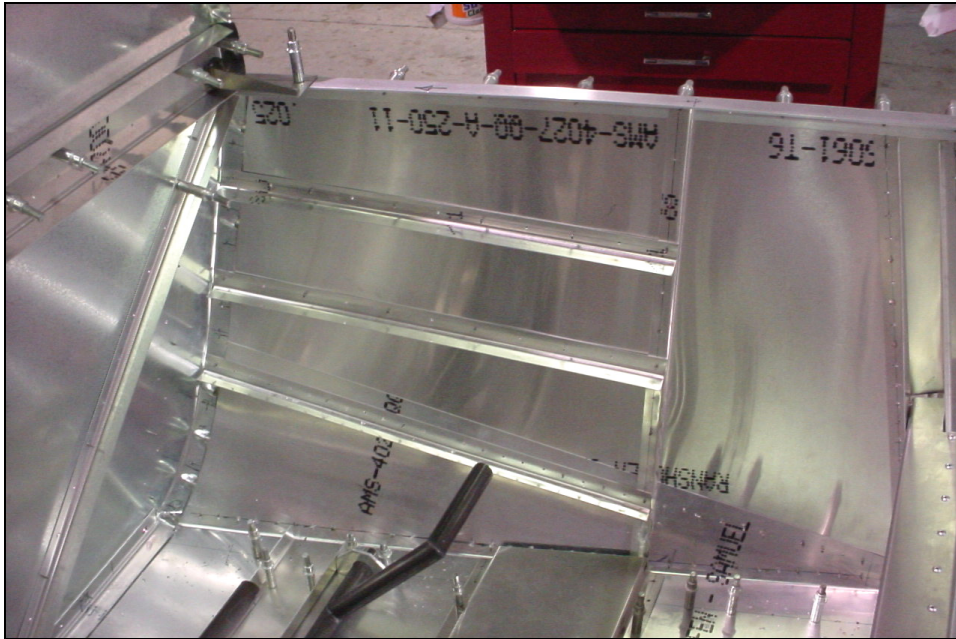
First layout out the location of the horizontal L angles down the vertical L angle, Pre-drill the intersection holes with pilot holes.



A4 PITCH 40
L Angle to 6B11-2

Drill and Cleco from outside.

Lay out the rivet across end holes. Layout the rivet pitch.
Drill an end hole in L angle, cleco in place and back drill end hole through firewall flange.

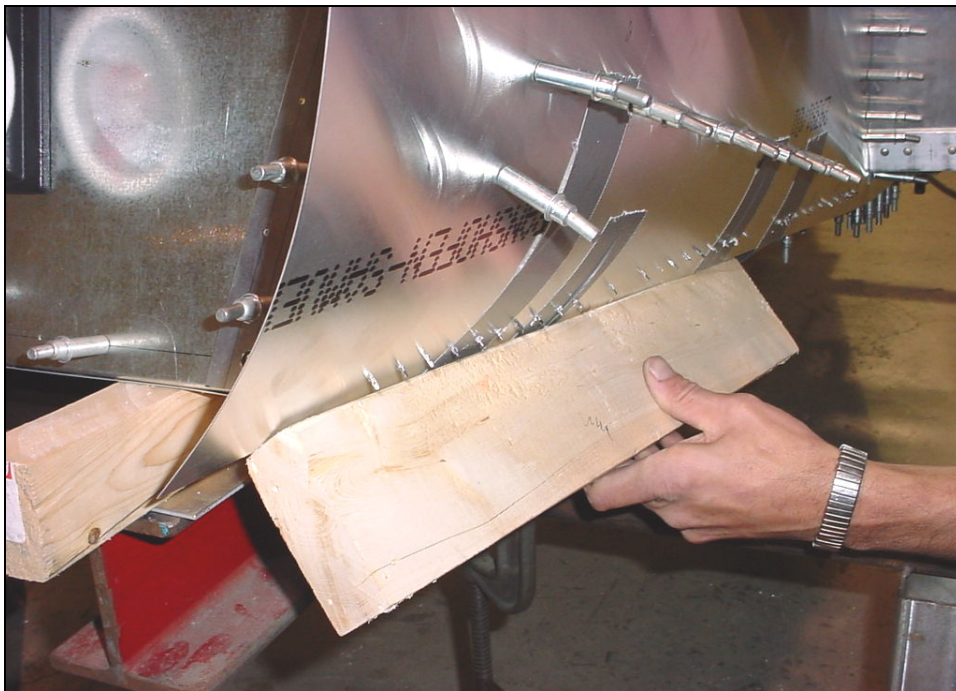


Second Horizontal
L Angle

Third horizontal
L Angle

A4 PITCH 40
L Angle to 6B11-2

Cut the length of the L angle to overlap the firewall flange at the front and the vertical L angle at the rear.



A4 PITCH 20
L Angle to 6B10-1 & 6B11-2

Drill and Cleco from the
inside.

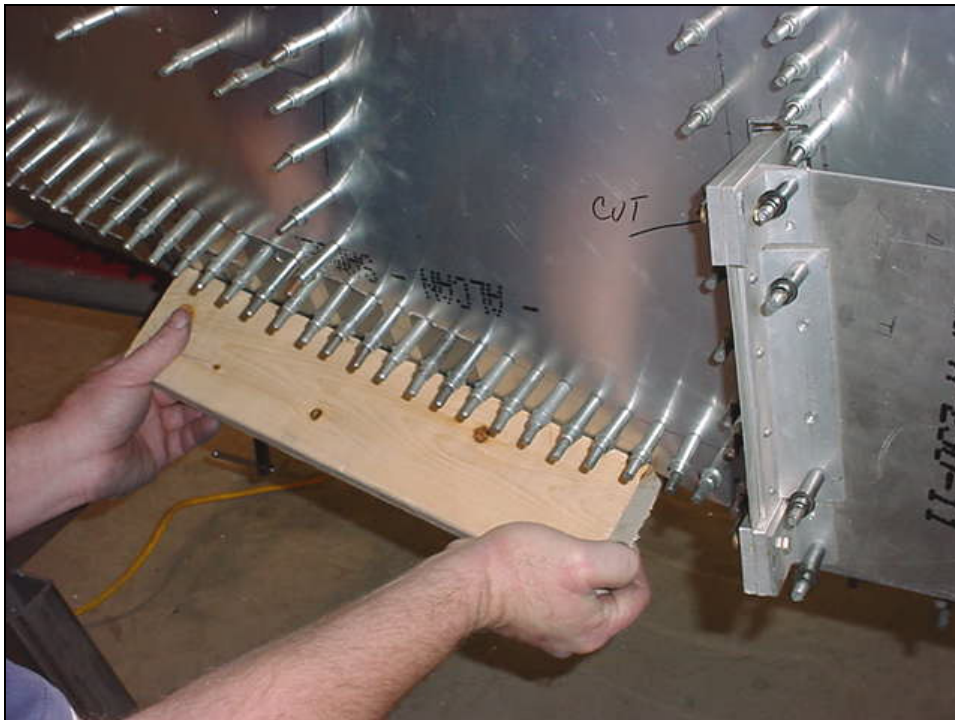
Hold a 2x4 board on the outside of the fuselage to push the side skin against the firewall and the side of the Cabin Floor Skin. It may also help to use duct tape to hold the skin in place.



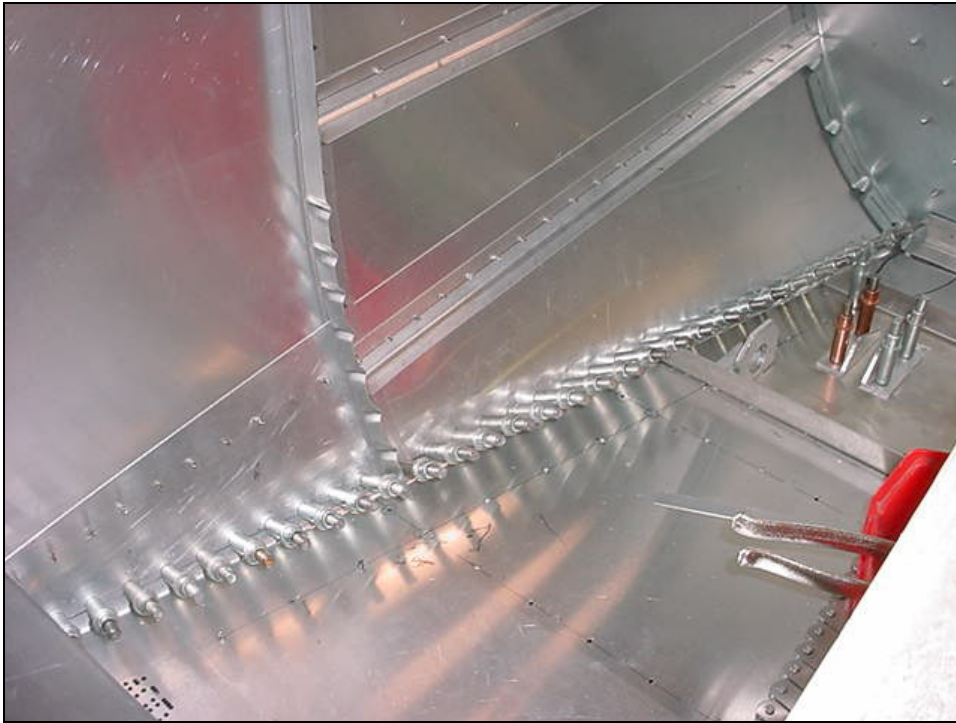
A4 PITCH 20
Bottom rivet line
6B10-1 to 6B11-2

Drill and Cleco from inside.

Parallel rivet line 10mm up from the bottom bend in the Cabin Floor Skin.
Have an assistant hold a 2x4 board to push the bottom of the side skin
against the bottom bend of the Cabin Floor Skin.



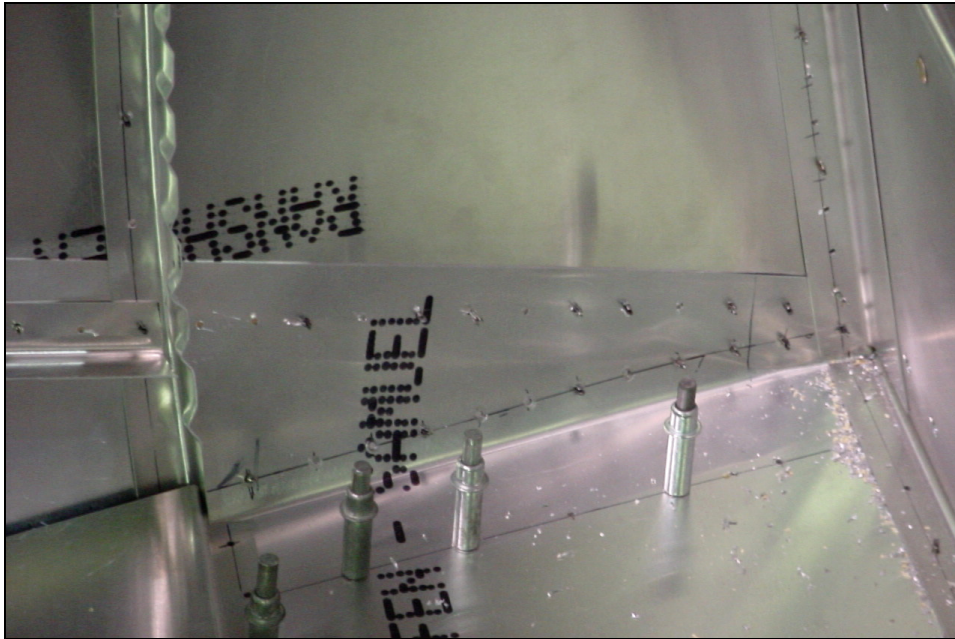
Two people required, hold the outside of the skin with a 2x4 board.



Inside view.

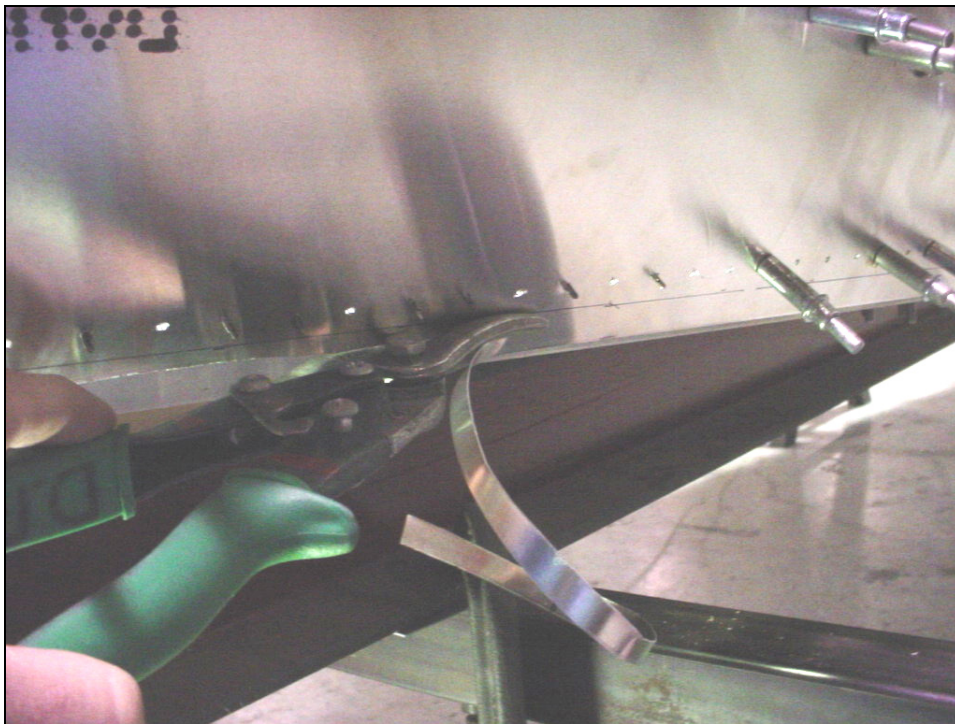


Outside view.



A4 PITCH 20
6B10-1 to 6B11-2

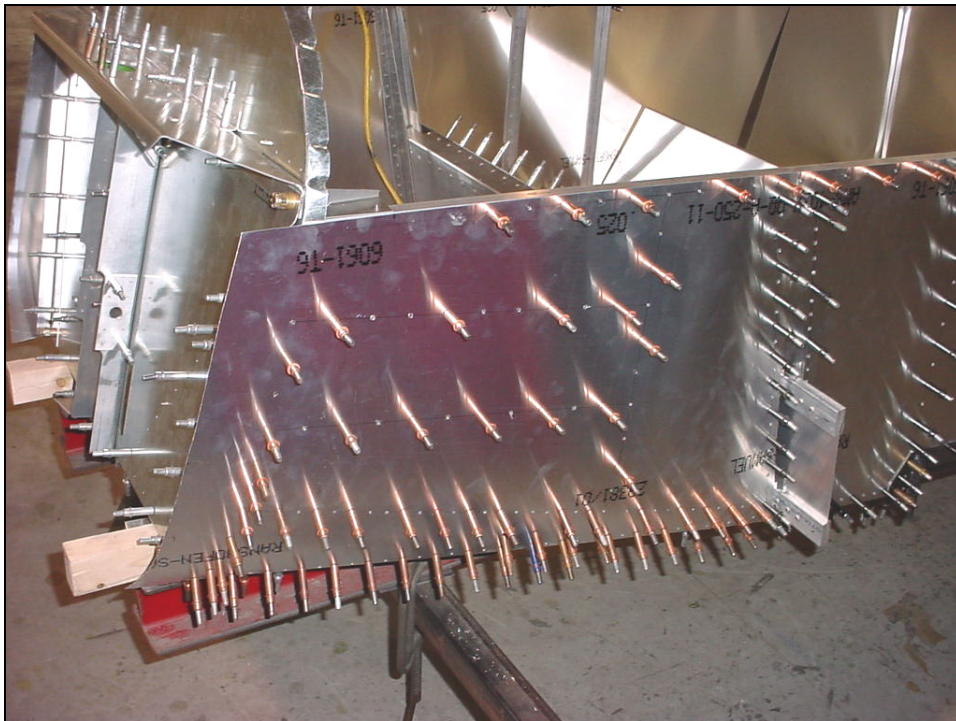
Finish drilling the top of the Cabin Floor Skin to the Fuselage Side Skin, section between the Vertical L Angle and the spar



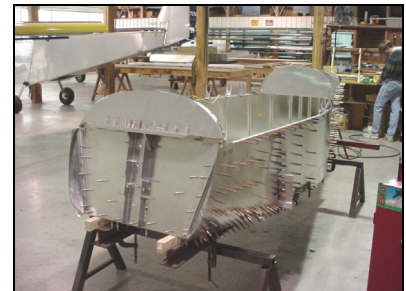
After the holes are drilled trim the overhang.



Inside view of left side.



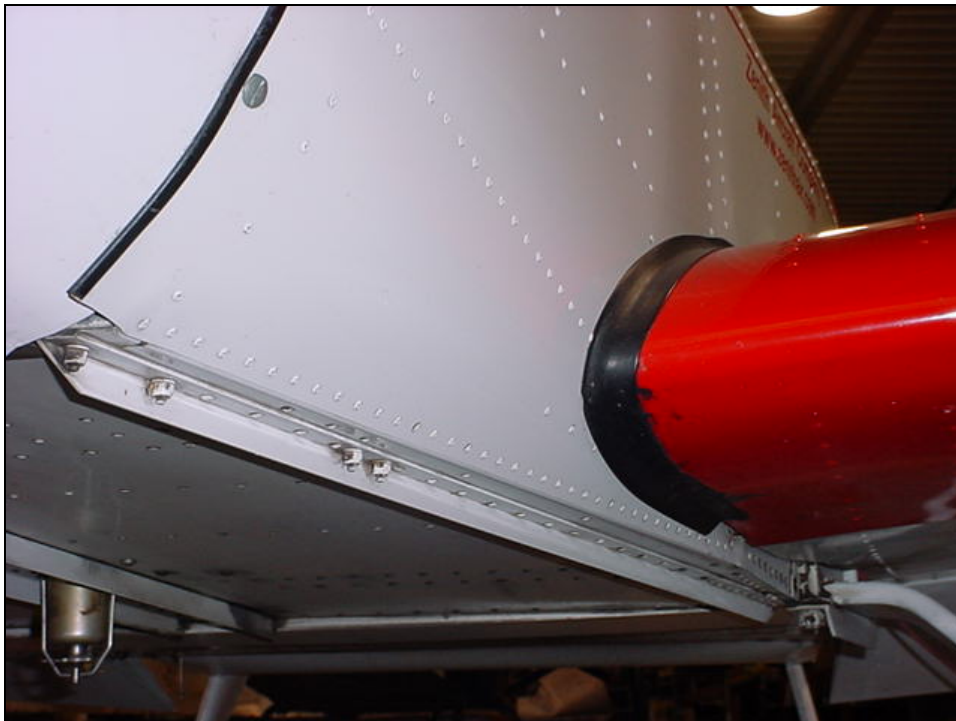
Finish drilling the top edge of the side skin to the Longeron 6B11-2, the first rivet is 140mm from the firewall rivet line (to allow for the overlap of the Forward Top Skin 6C1-4)



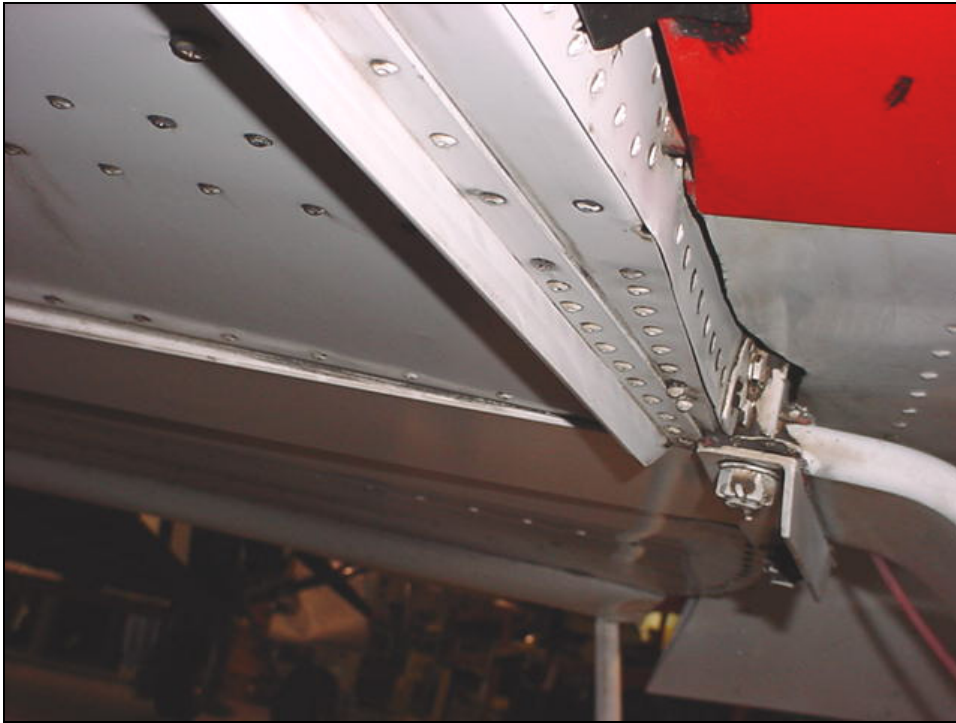
A4 PITCH 40
Ref 6-B-11



Detail of the bottom rivet line in the side skin



Wing to the fuselage



Bottom view of the rivets in the Gusset 6B10-4, transition to the bend in the cabin floor skin



Rivet lines