



Overlaps on top of the rear seat panel 6B5-1



**REAR TORQUE TUBE BEARING SUPPORT 6B17-1**



Remove the center seat back channel 6B16-2 to install the bearing support 6B17-1.

Clamp.



A5 PITCH 30

Layout the rivet line.



Drill and cleco.

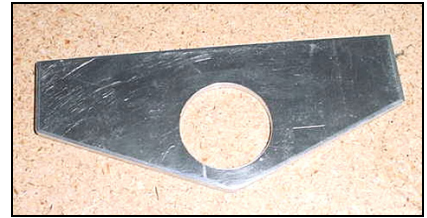
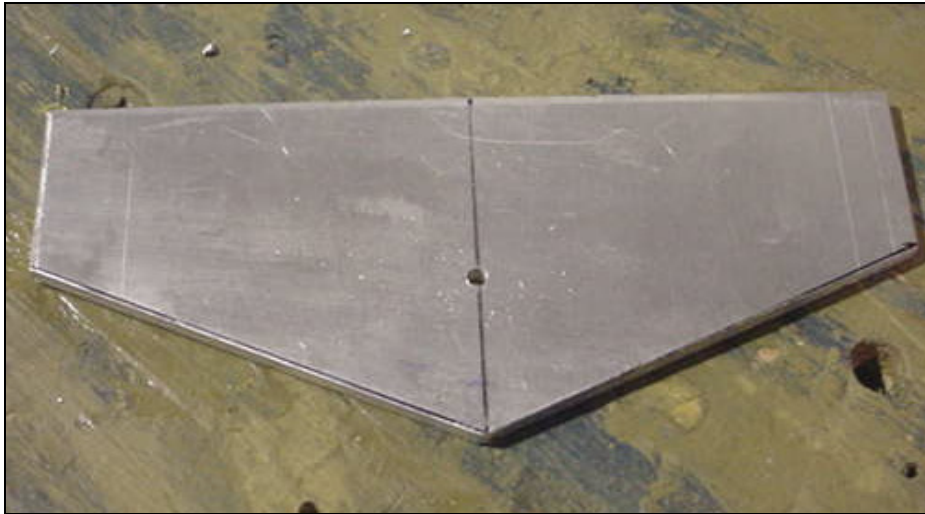


**11 RIVETS A5**  
6B17-1 to 6B5-1 & 6B16-5

Layout the rivet line and pre-drill with pilot holes.  
Wait to drill the bottom flange until after the torque tube is installed, see page 9.



Bottom flange rests on bottom skin 6B1-4  
Wait to drill in bottom skin, see page 9.



**REAR TORQUE TUBE  
BEARING  
6B17-3**

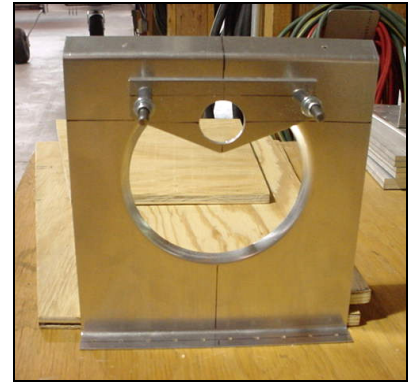
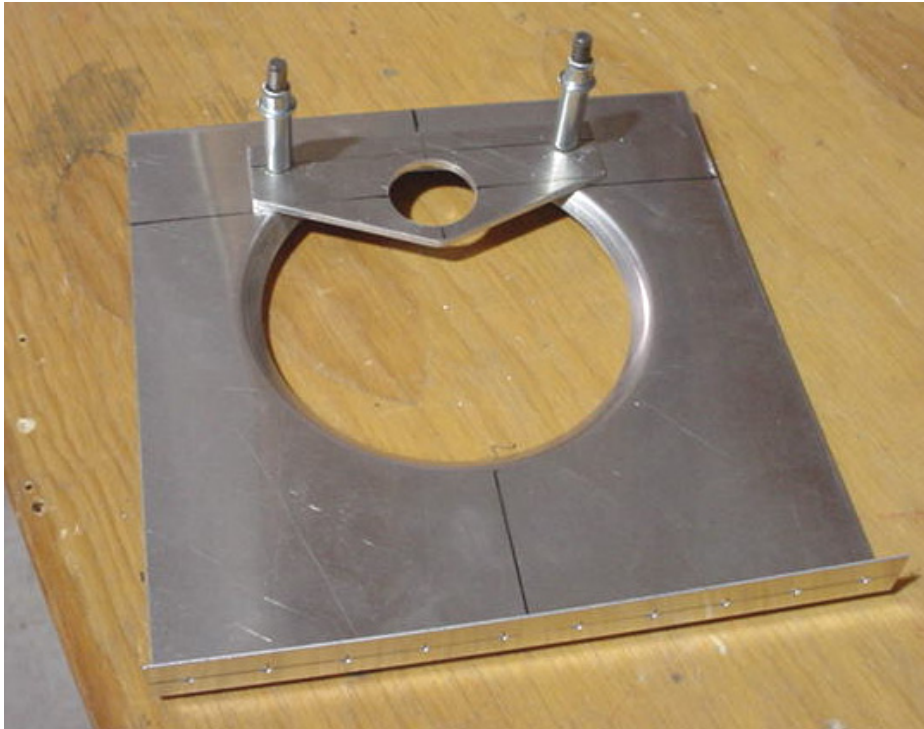
1-1/8" HOLE

Center of the hole is located 20mm from the edge of the part (20mm square to the sides).

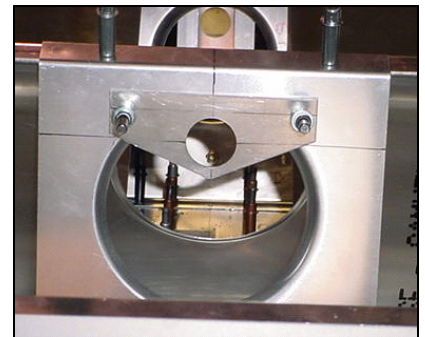


Clamp the rear torque tube bearing 6B17-3 to the back side of the bearing support.

155mm from the bottom flange to center of 1-1/8" hole (Revision July 2005).

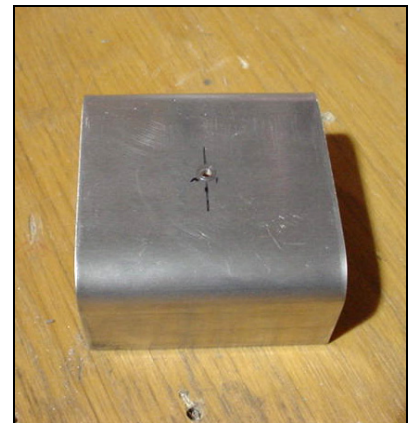
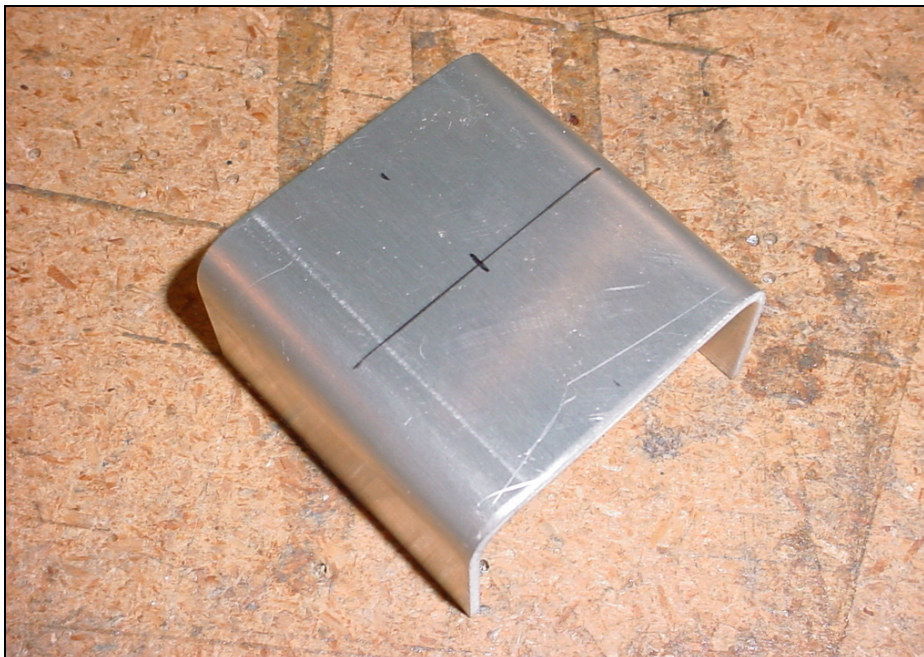


**2 BOLTS AN3-5A**



**Rear view**

Cleco the bearing support assembly to the fuselage.

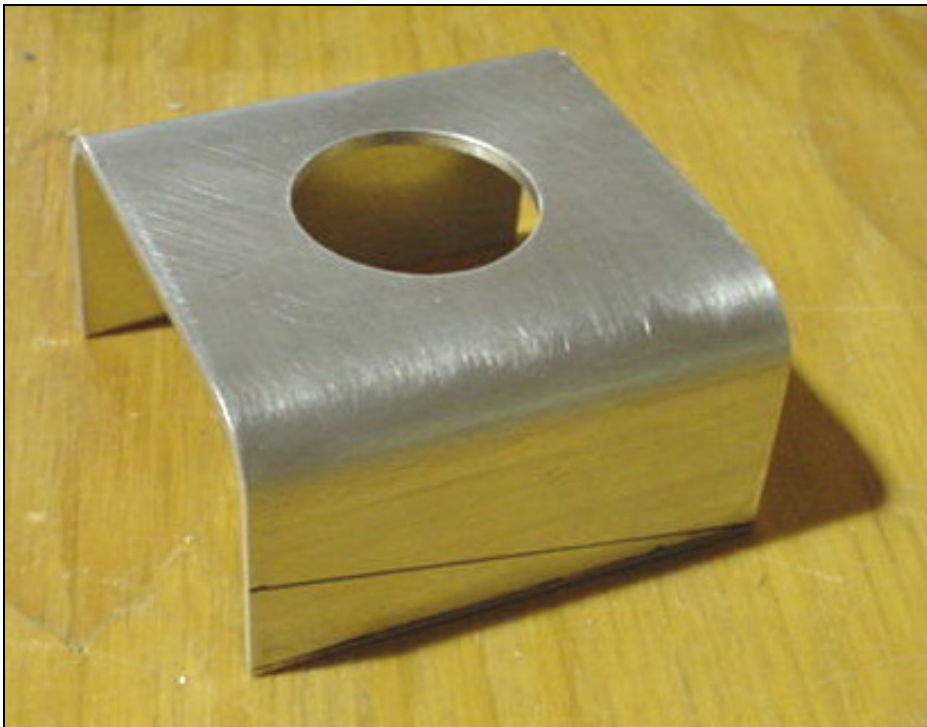


**FORWARD TORQUE TUBE  
BEARING  
6B17-6**

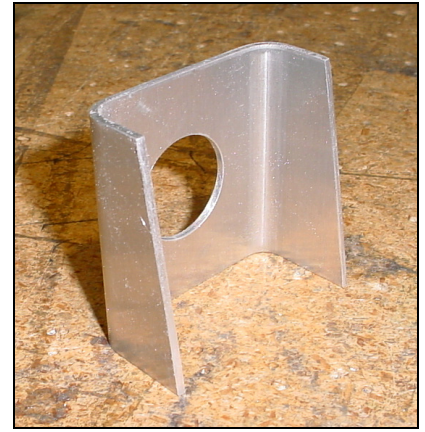
Locate the center.



1-1/8" flat face drill bit.

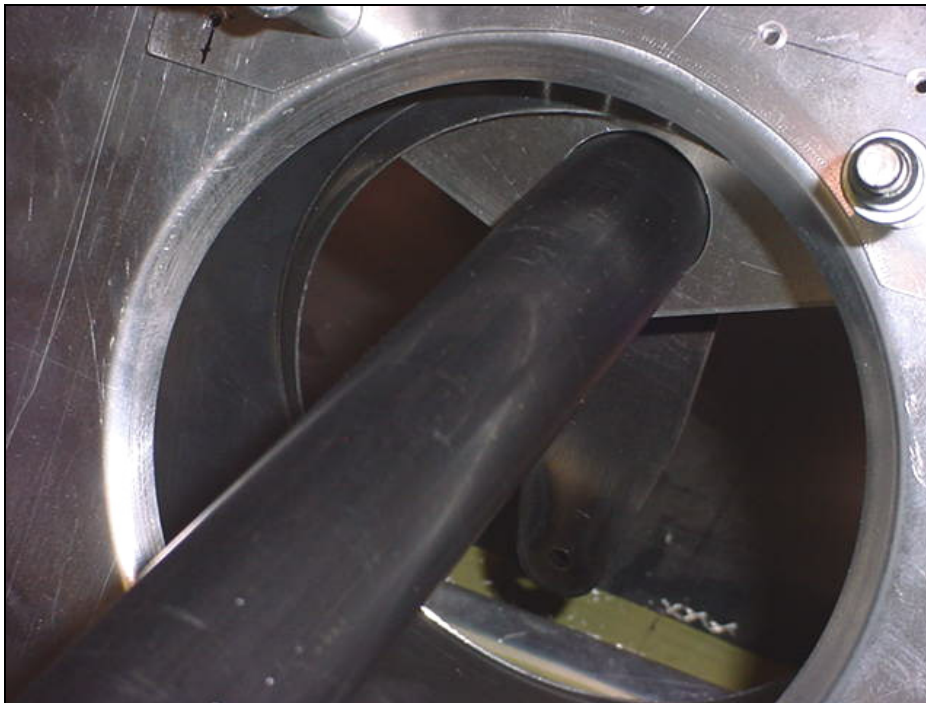


In a drill press, drill the 1-1/8" hole in the center of the Bearing.

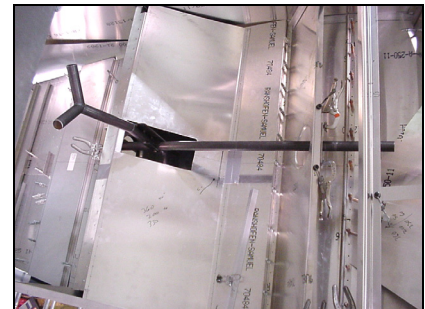


t=.090"

Trim the sides.



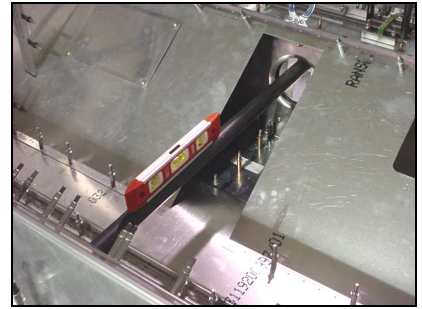
**TORQUE TUBE  
6B17-4**



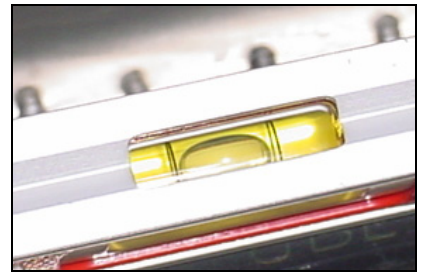
Insert the Torque tube through the Rear Bearing 6B17-3.



Level the top of the torque tube.



CHECK: Approximately 4mm clearance between the front lightening hole on the center spar section and the top of the torque tube.



The forward torque tube bearings fits in between the upright extrusions on the center spar section.

Clamp the sides of the forward bearing to the center spar uprights 6W4-4





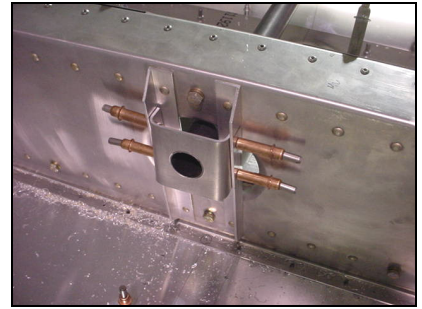
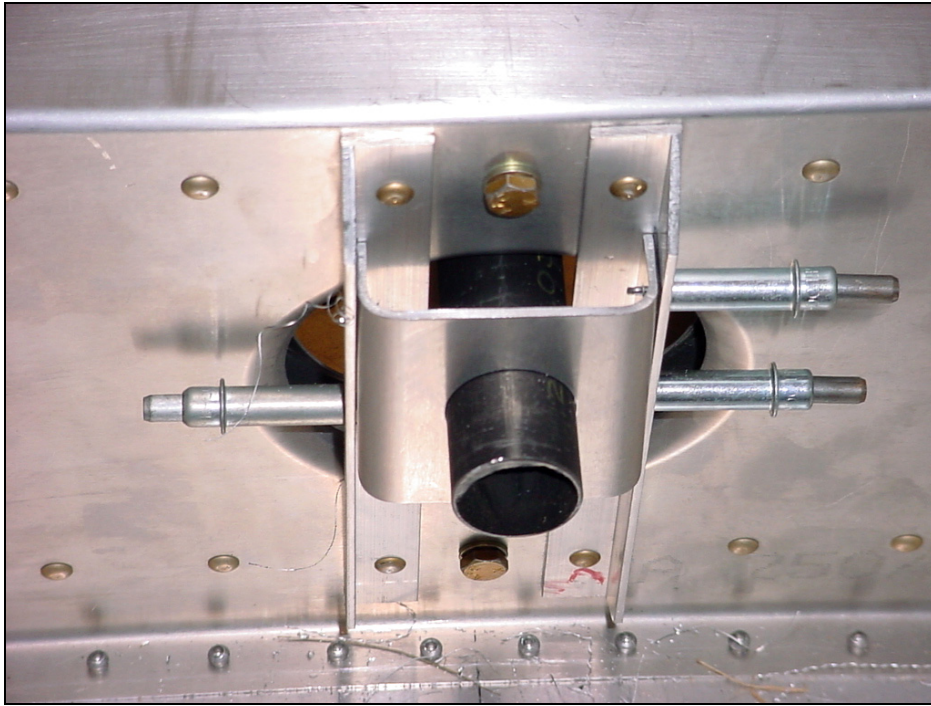
The bearing is square to the torque tube.



Rear view looking forwards.  
 Drill and cleco the bottom flange of the rear torque tube bearing support 6B17-1 to the bottom skin 6B1-4



**A5 PITCH 20**  
 6B17-1 to 6B1-4



**4 BOLTS AN3-4A**

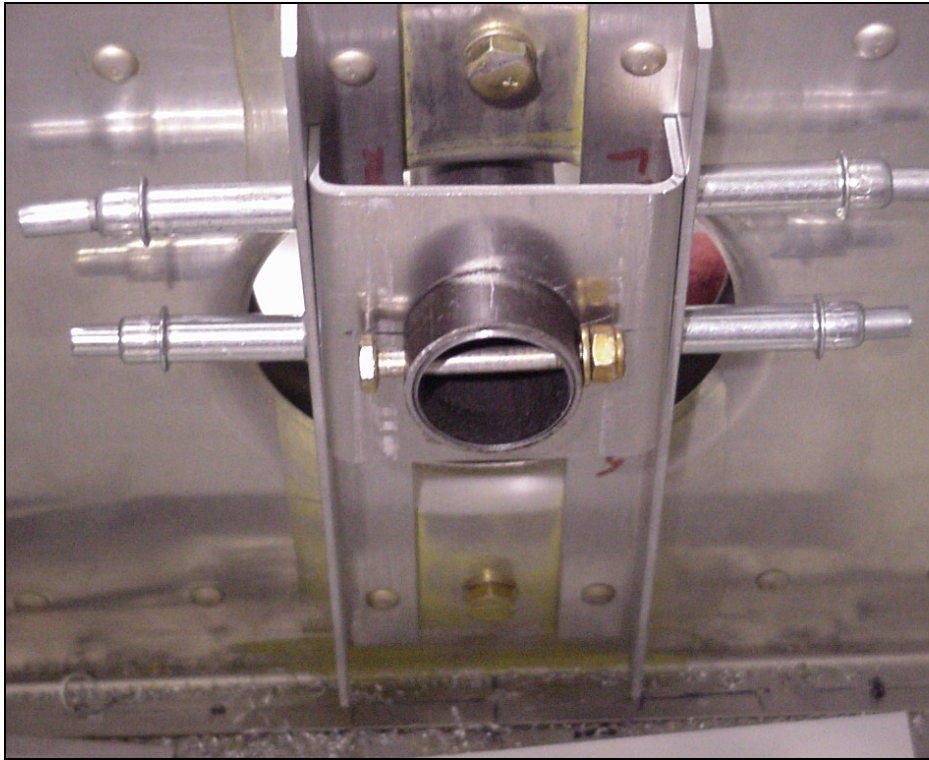
Drill and Cleco, first with pilot holes than with 3/16" holes.



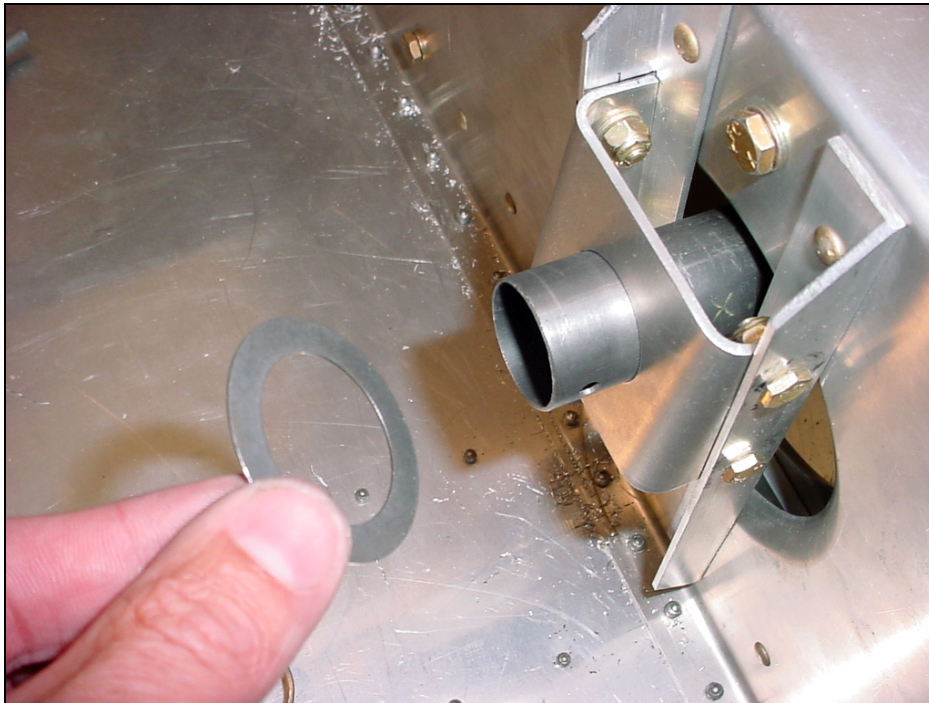
**STOP RING 6B17-5**

Use a V block in a drill press to drill the 3/16" hole.

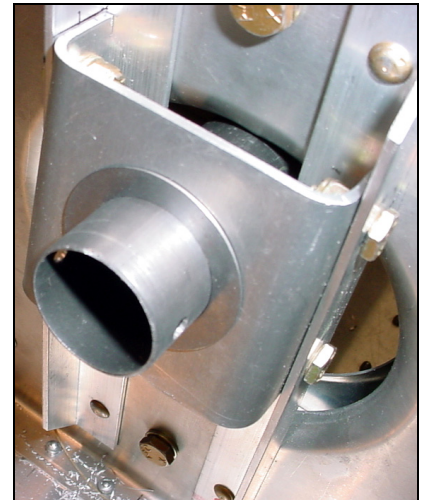
Stop ring is flush to the front end of the torque tube.  
Back drill the hole.



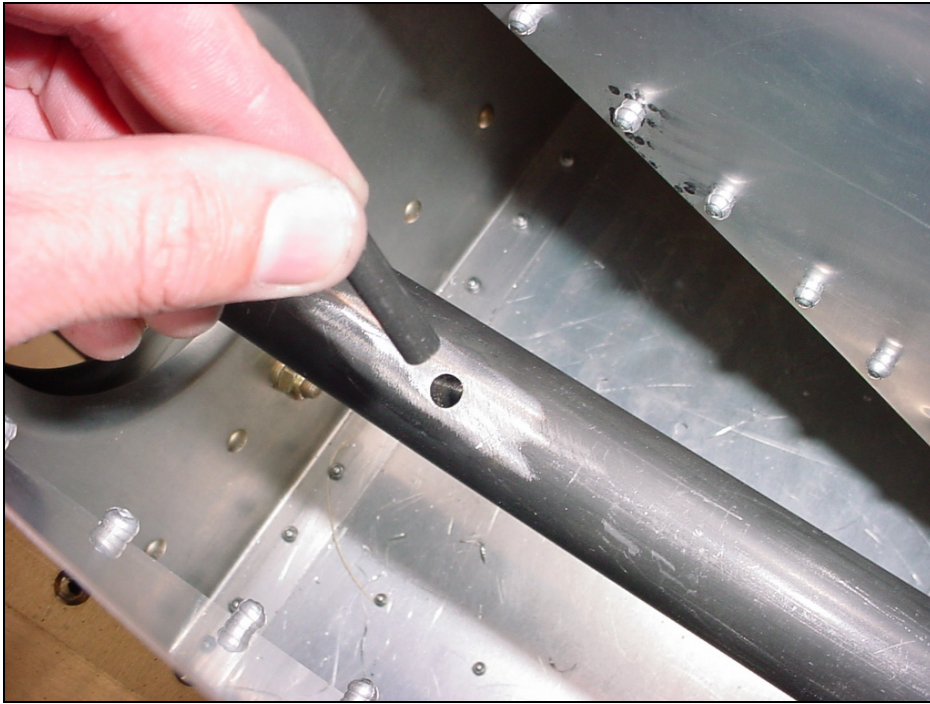
Bolt the bearing to the spar.



Add the stainless still shim.



Ref. right middle diagram on drawing 6-B-17



Bolt. AN3-16A

Insert the 1/4" OD x .028" wall 4130N tube inside the welded 3/8" tube on the torque tube 6B17-4



Center stick 6B17-2