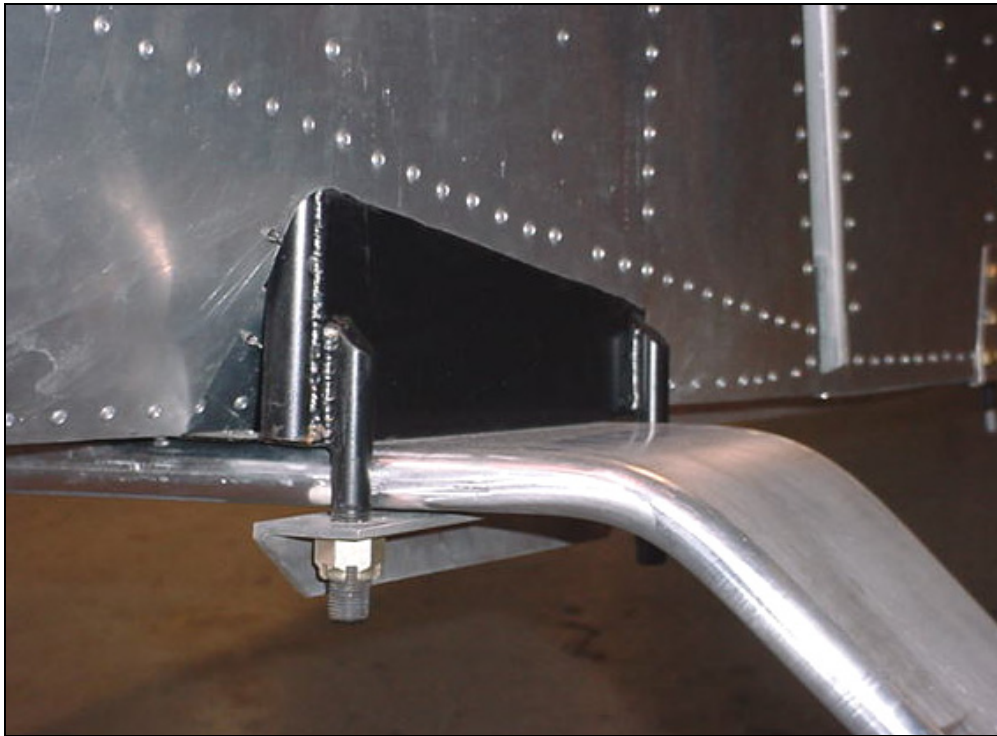


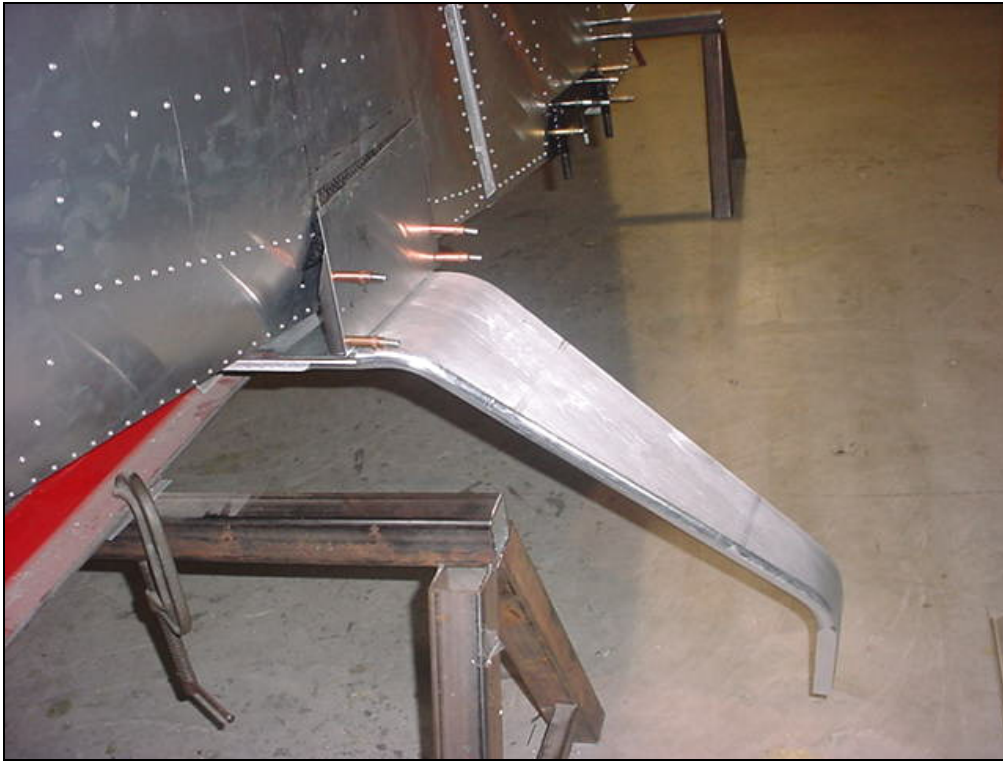


**6TD3-1
TD MAIN GEAR
UPRIGHTS
(QTY=1L + 1R)**



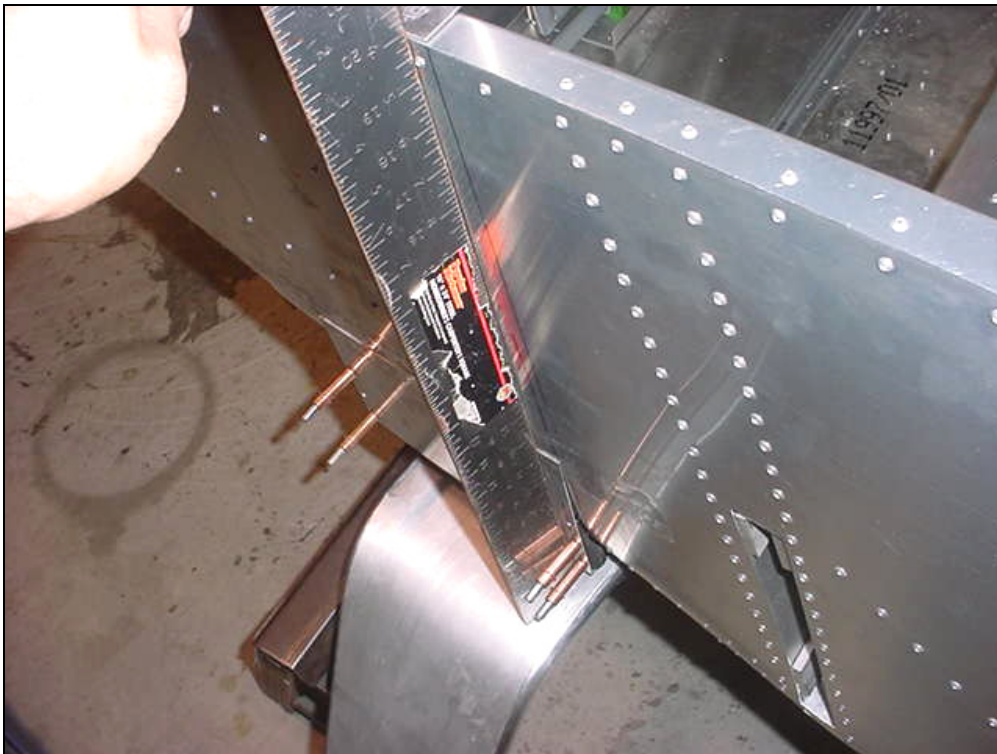
Cutout in the side skin is below the diagonal rivet line.

The TD Gear Upright 6TD3-1 is installed on top of the landing gear 6TD2-7. 6TD3-1 makes the corner between the extension of the cabin floor and the fuselage side.



Make a template to mark the width of the gear attachment on the fuselage: the sides are square to the top of the gear.

Position the gear underneath the fuselage between the reference line.
CHECK that the top of the gear sits flat against the bottom of the fuselage.



NOTE: The sides of the fuselage are not square across the top of the left and right Longerons. The sides are closed approximately 1 degree.



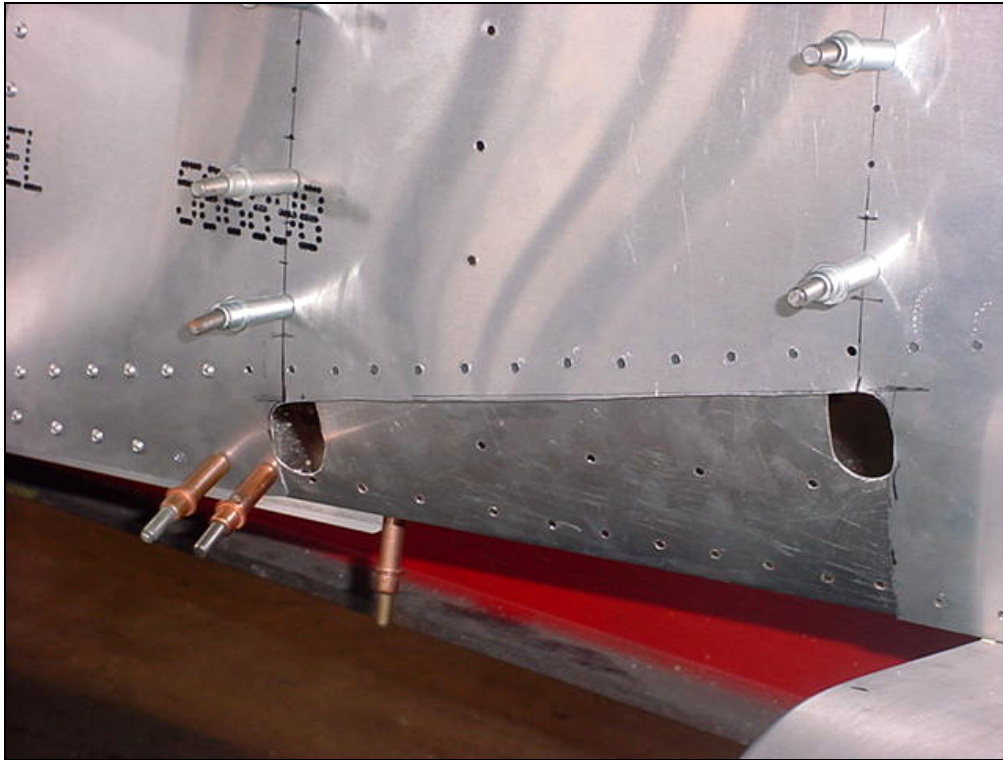
Move the gear out of the way to cut the side skin.

The front and aft edge of the cutout is the width of the Gear Uprights 6TD3-1



The cutout is wider than the gear.
Width of cutout is to outside edge of $\frac{3}{4}$ " tubes welded on the 6TD3-1

Top of cutout is approximately 12mm below the diagonal rivet line (along the top edge of the cabin floor)



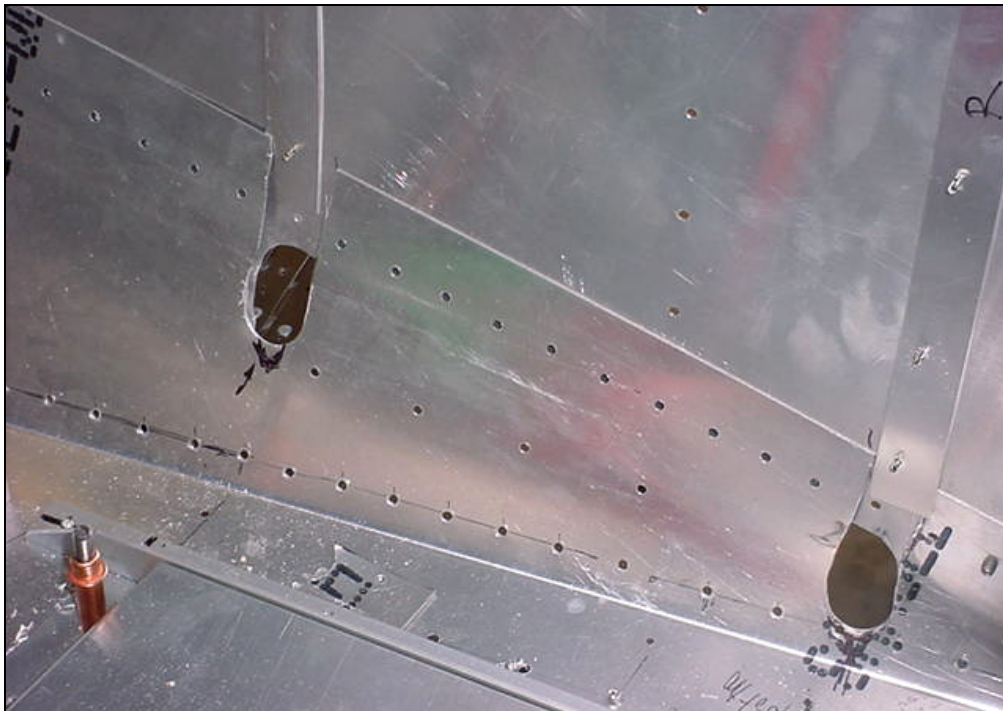
Note: do not drill the bottom rivet line as show in photo across the bottom of the cutout!

A5 PITCH 20
(6B11-2 into 6B10-1)

Add a vertical rivet forward of the cutout and another aft of the cutout. Ref middle diagram on drawing 6-TD-3

Note: vertical rivet lines not shown in this photo.

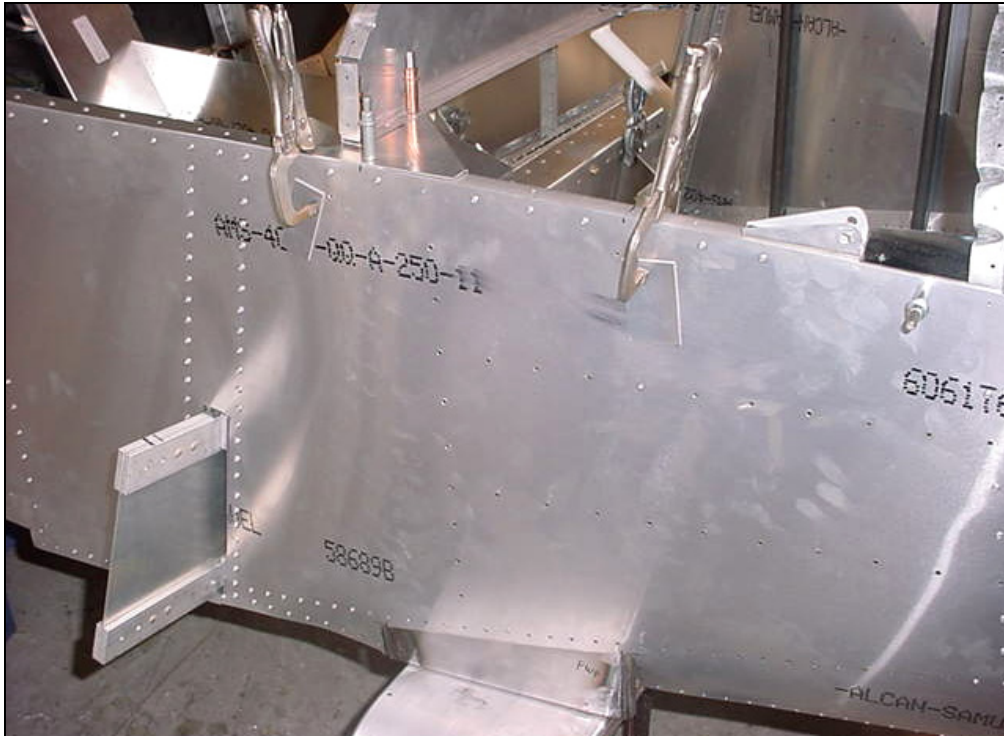
Rectangular cutout in the fuselage Forward Side Skin 6B11-2



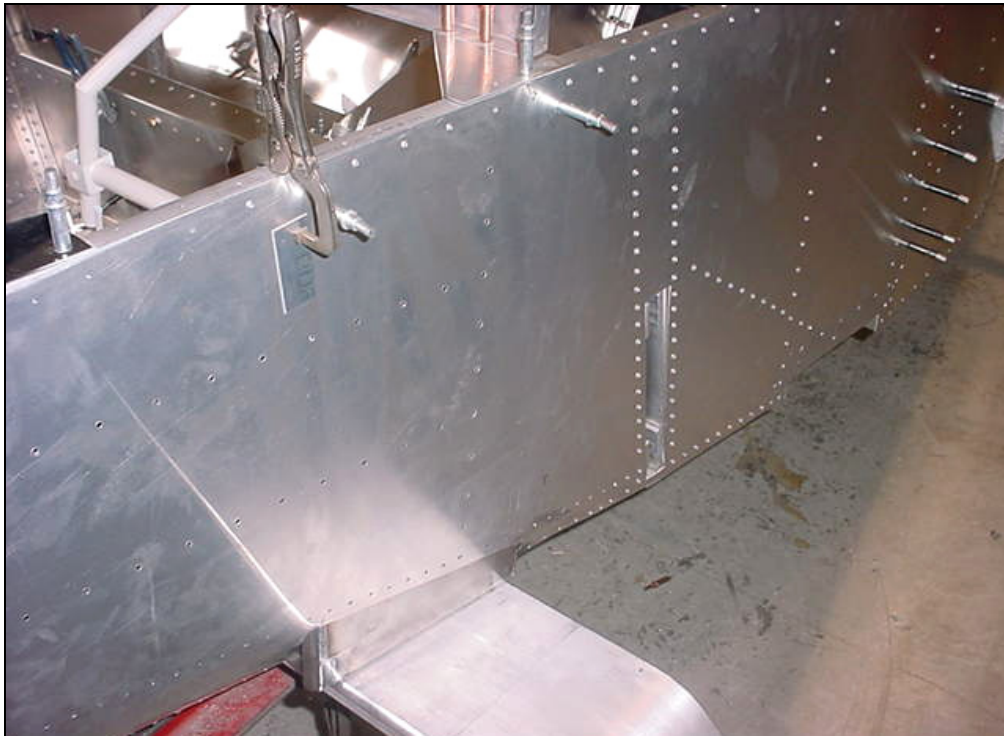
Cutout in the sides of the Cabin Floor Skin 6B10-1 to make room for the $\frac{3}{4}$ " round tube welded on 6TD3-1

Insert the tubes of the gear attachment to check that there is approximately 2mm clearance around the cabin floor.

Inside view of right side.
Cutout in Cabin Floor Skin 6B10-1, cutout to make room for the tube.



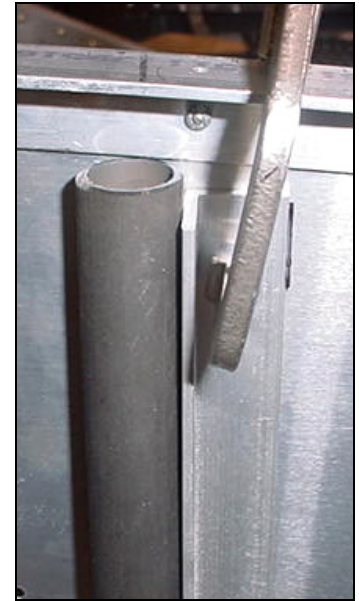
Re-position the Gear against the bottom of the fuselage.
 CHECK: The bottom of the Gear Uprights 6TS3-1 sits flat on the top of the gear. If necessary cut the length of the tubs to fit below the bottom edge of the Longerons.



Note: Piece of aluminum plate between the clamp and the fuselage side skin to prevent marking the skin.

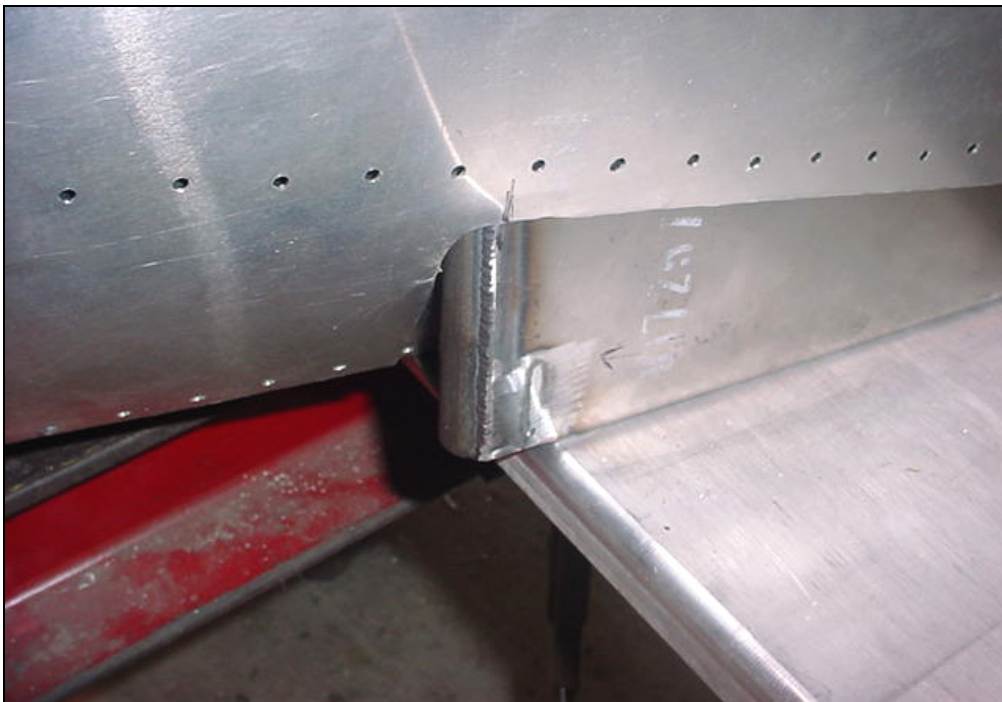
Extrusions are shown on next page.

Clamps are holding the extrusion to the side of the tube. The extrusion will be used as a reference to locate the rivet line through the center of the tube.



Mark the first rivet 6mm from the top end of the tube.

Inside view of fuselage.
Clamp pieces of extrusion along side sides of the 3/4" tube on the Gear uprights 6TD3-1



center line of tube

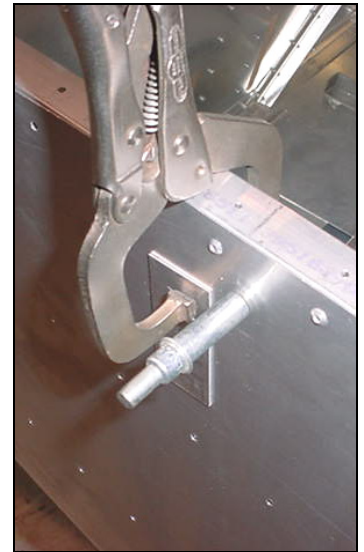
Mark the center of the tube along the bottom of the cutout



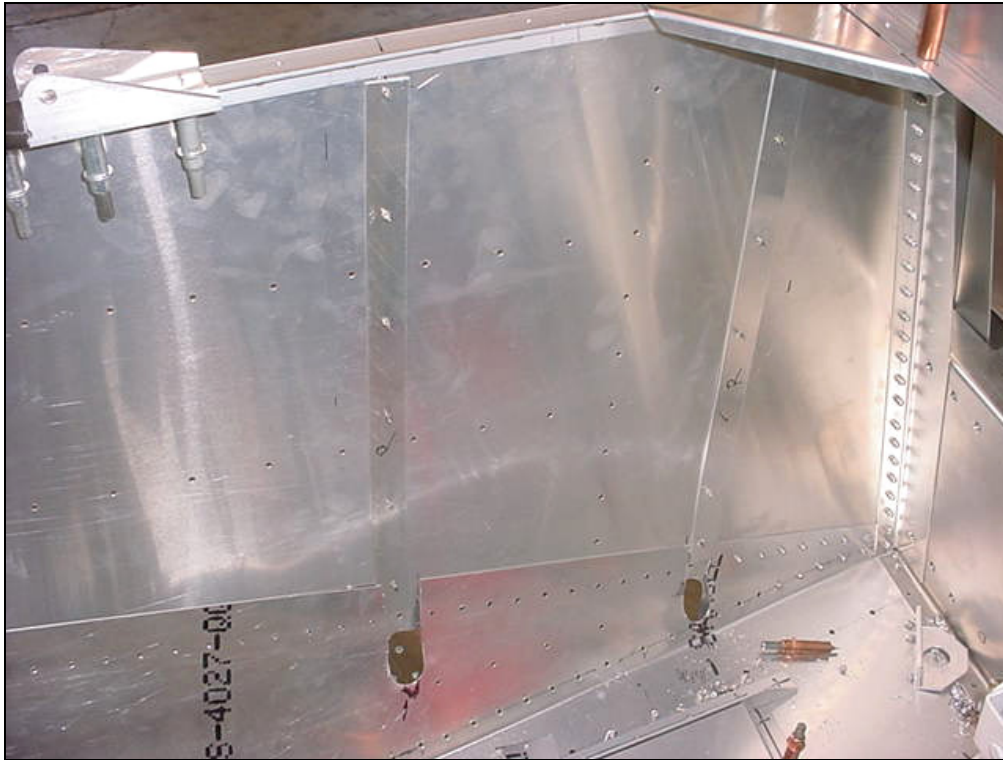
Remove the attachment, locate the center of the tube by measuring from the extrusion 9.5mm. Drill the top hole from inside the fuselage skin. Also drill the bottom hole from outside the fuselage



Reinstall the attachment to back drill the top and bottom holes. The extrusions are still clamps to the fuselage.



Drill & cleco the two upper holes, then drill the bottom holes.



STRIP TEMPLATE
MATERIAL t=.040"

Cleco a strip template on
the inside of the skin.

Remove the attachment, cleco the strip on the back side.
Clearly mark the orientation on the strips on the front and rear strip.

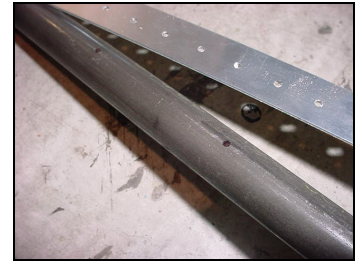
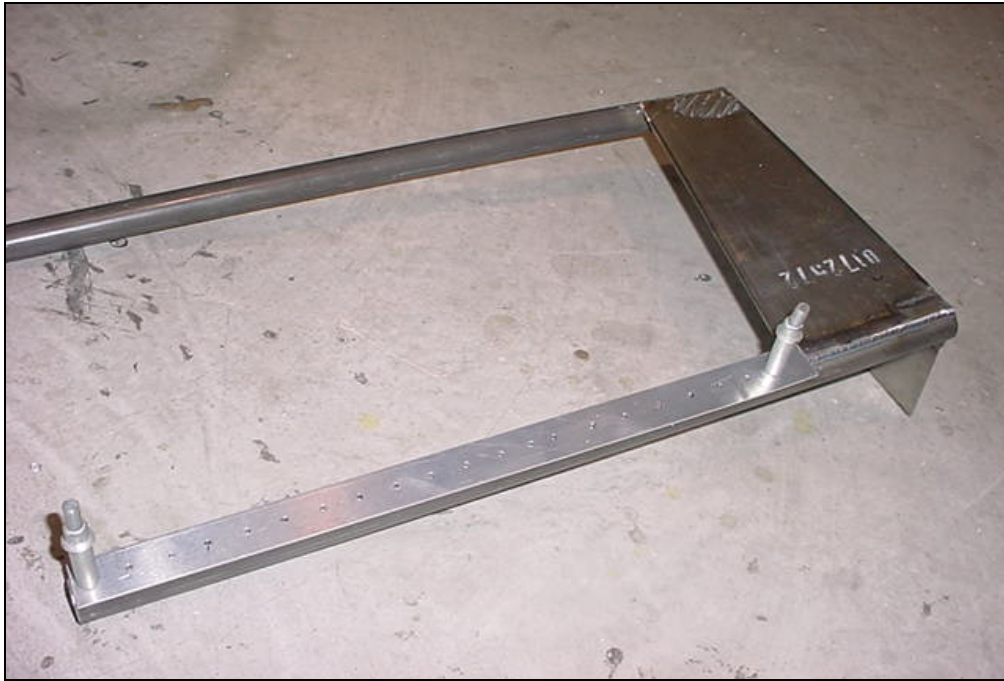


Cleco strip on side of
fuselage between the top
and bottom hole.

A5 PITCH

Drill with #40 pilot holes.

Mark the rivet line on the outside of the skin between the top hole and line at
the bottom. Drill a pilot hole on bottom.

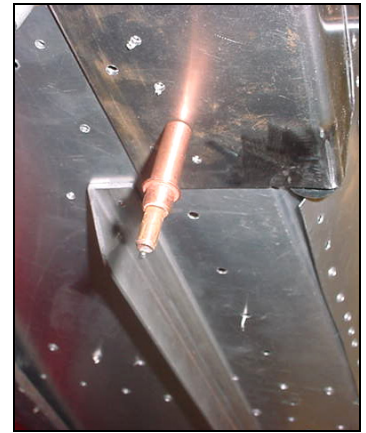


Cleco the strip to the tube and finish drilling the holes.

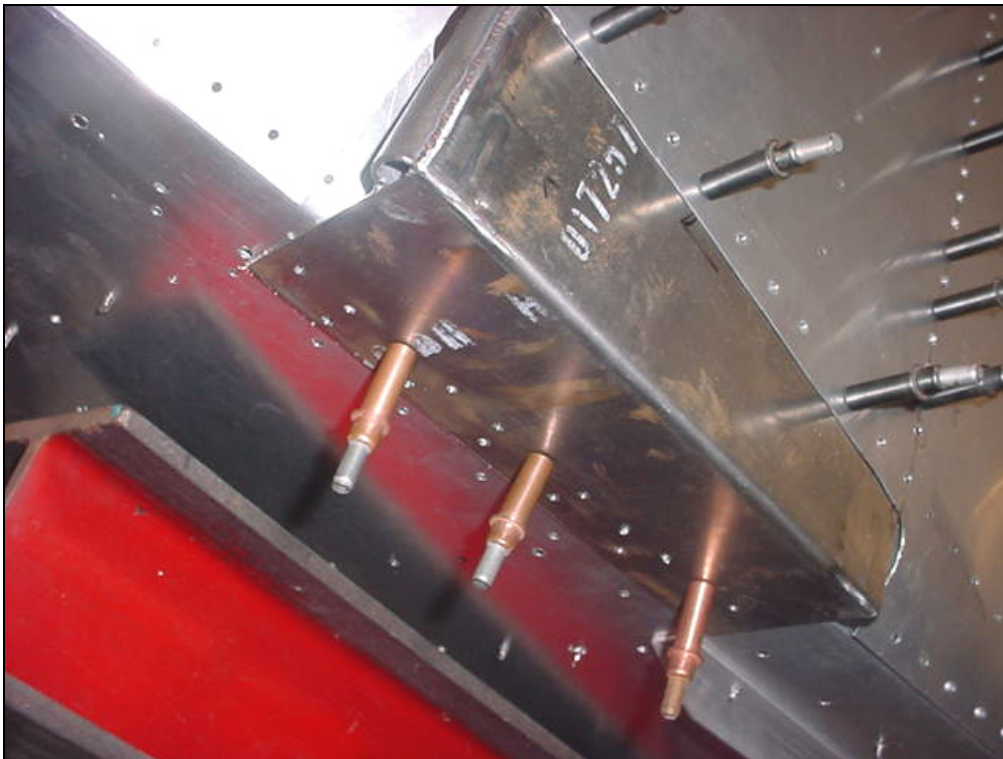
IMPORTANT: Double check the orientation of the strip.



Drill each tube



Bottom rivet line through
the Floor Channel 6TD3-2
A5 PITCH 30



9 RIVETS A5
6F11-2 to 6TD3-1