

**ANGLE
6T3-7**

**2 RIVETS A5
6T3-7 to 6T3-3**

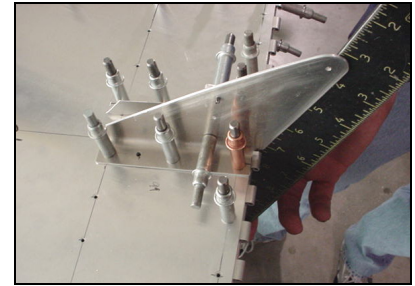
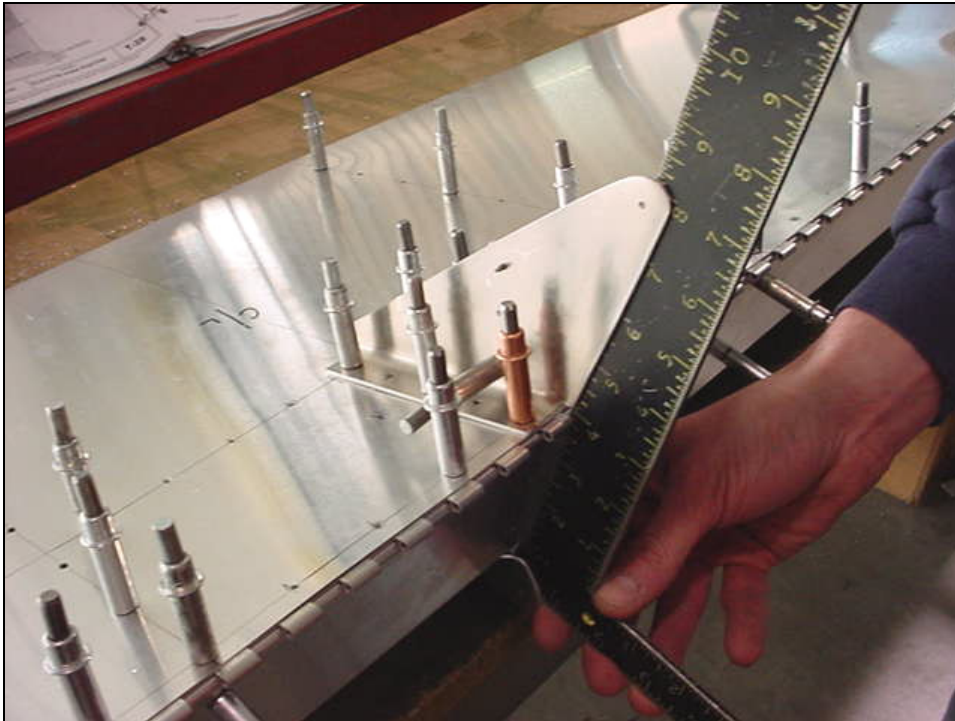
The Angle 6T3-7 is positioned on the right side of the aircraft centerline with the bend on the aircraft centerline. The flange is centered up and down on the front of the elevator. Trace around the flange to mark the location on the elevator. Pre-drill two holes in the skin; hold the angle inside the skin; back drill & cleco.

Trim the top corner to avoid interference with the topside of the elevator skin.



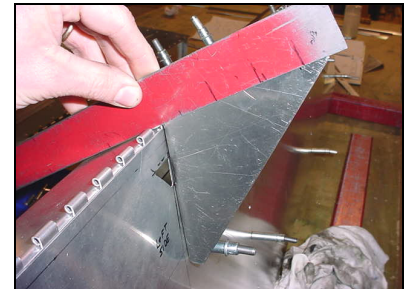
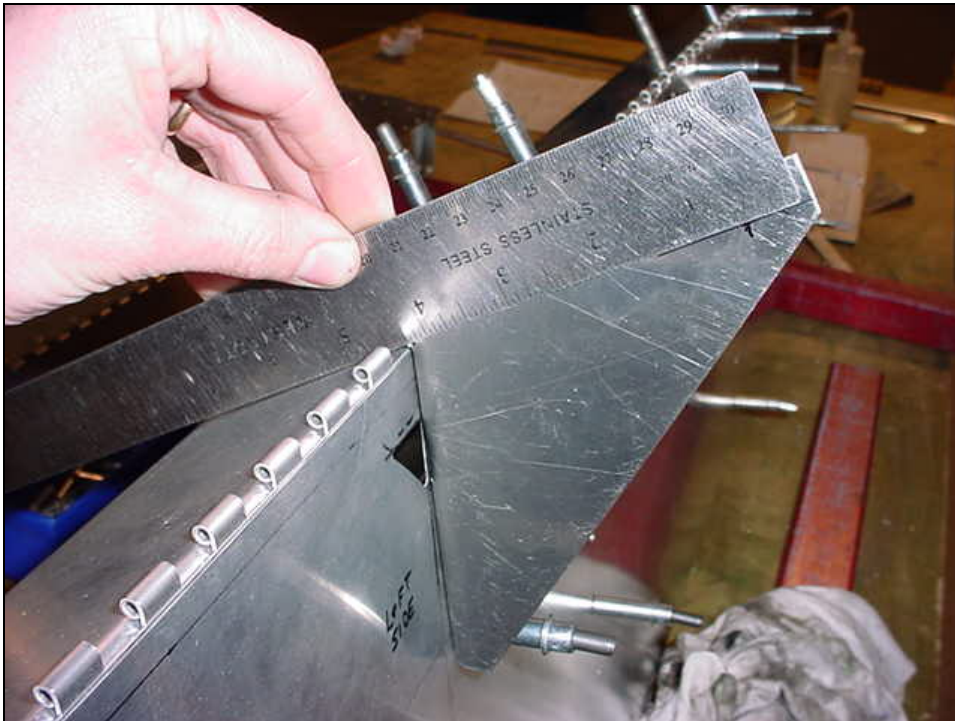
**UPPER ELEVATOR HORN
6T3-4**

Locate the hole for the upper elevator cable.



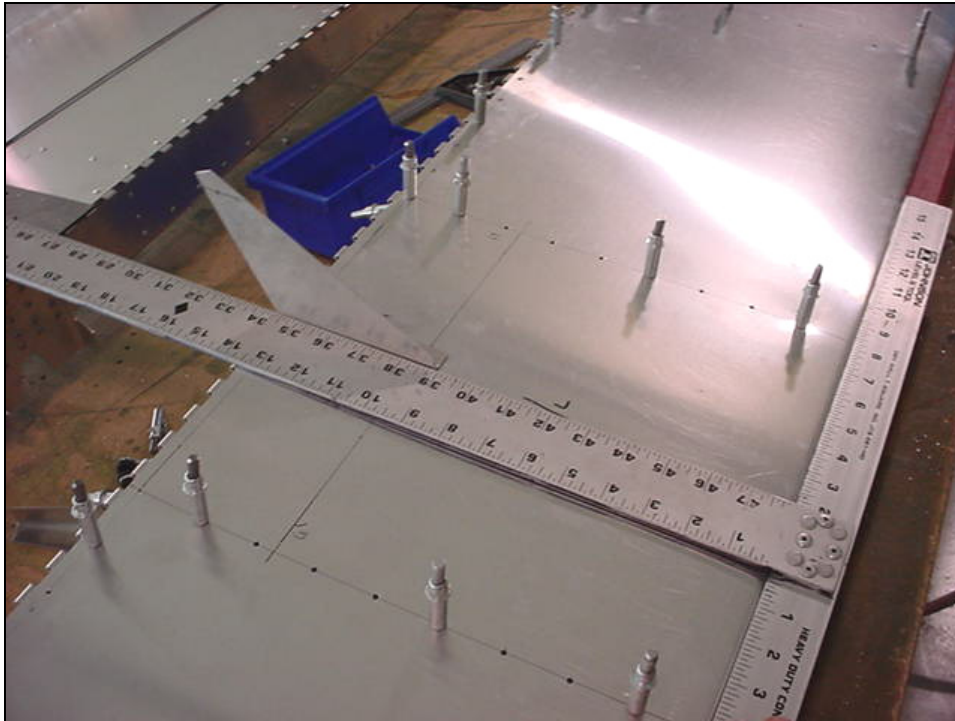
Check: The last rivet is through the top flange of the channel 6T3-2.

Hold a straight edge along the front of the elevator. Adjust the position of the horn to bring the hole for the upper cable even with the straight edge.



Positioning the horn on the elevator.

Drill a pilot hole on the hinge hole. Edge distance = 10mm (notation in the drawing is drawings R10).



Check: 100mm from the center of the piano hinge to the hole for the upper elevator cable.

The horn is on the right side of the aircraft centerline, square to the trailing edge.

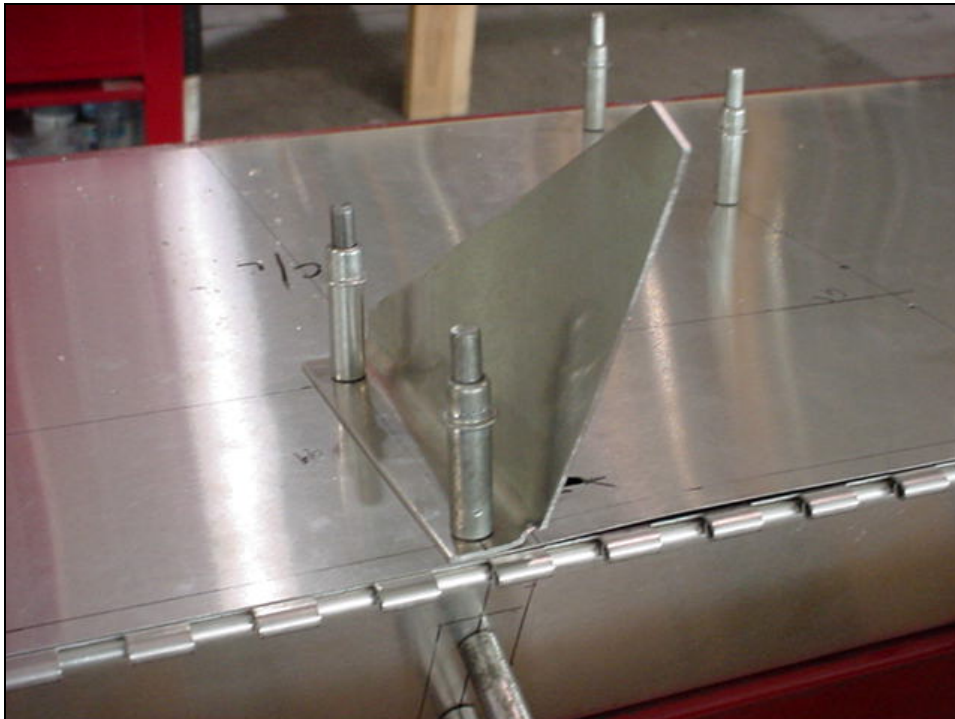


Photo of left side of horn.

4 RIVETS A5
6T3-5 to 6T3-3

1 RIVET A55 (aft hole)
6T3-5 to 6T3-3 & 6T3-2

Note: the last rivet is through the channel 6T3-2. The front rivet is through the piano hinge and the front flange of the elevator.

NOTE: Mark a no rivet zone for the last hole, drilled later through the bent strip 6T3-6 see section 6-T-3C page 4 and 5.



**ELEVATOR HORN
DOUBLER
6T3-6**

Length = 160mm

Cut the side flange.



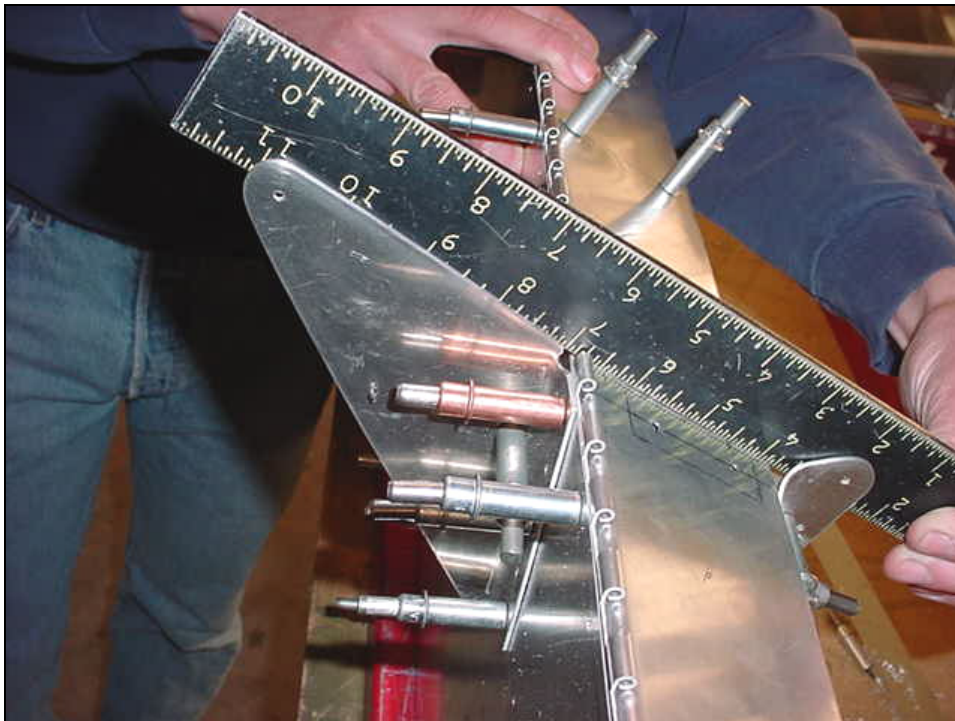
Clamp the doubler to the side of the horn.

Clamp the doubler to the side of the upper horn 6B3-4.



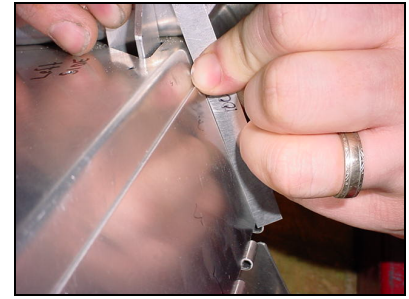
**LOWER ELEVATOR HORN
6T3-5**

Clamp the lower horn to the side of the doubler.
The aft end of the horn is even with the aft edge of the channel 6T3-2.



The hole for the lower elevator cable in the lower horn 6T3-5 is on a 10mm offset from the center of the piano hinge.

Straight edge to show the relationship between the cable hole in the top and bottom horn.

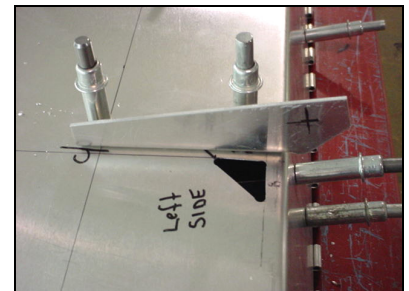
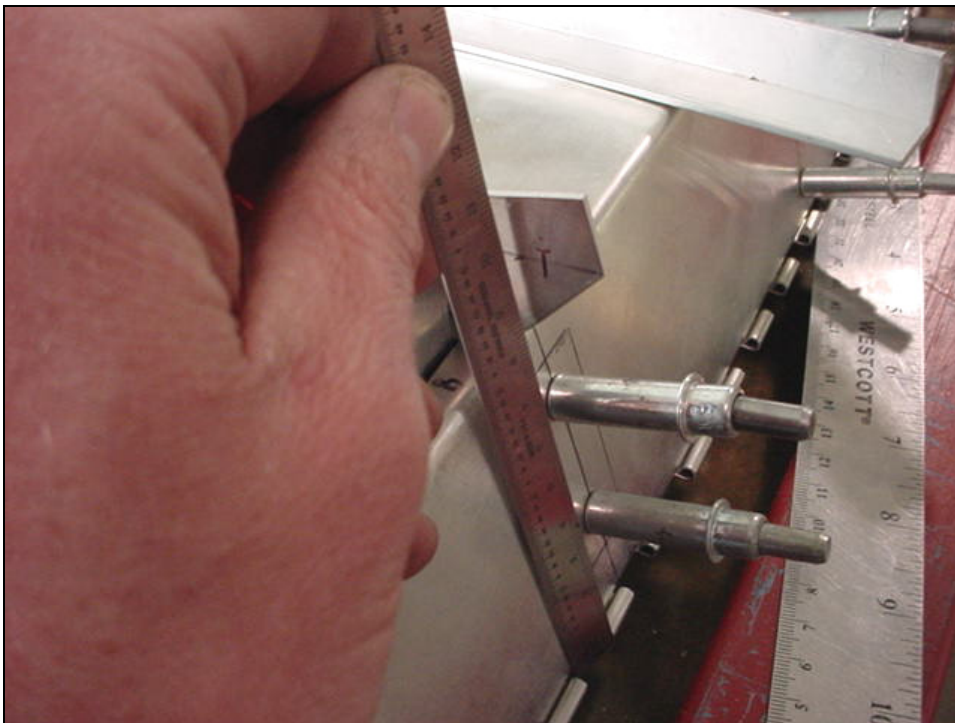


.040" shim to position the strip on the center of the piano hinge.



10mm spacer strip

Trace along the top edge of the strip to mark the Horn.



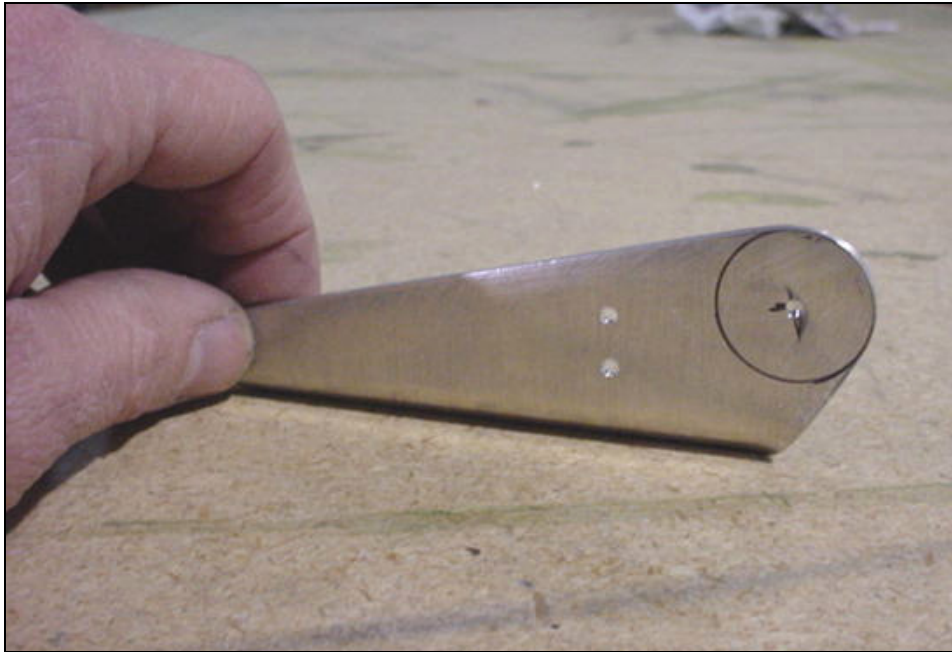
3 RIVETS A5
6T3-5 to 6T3-3

1 RIVET AS5 (aft hole)
6T3-5 to 6T3-3 & 6T3-2

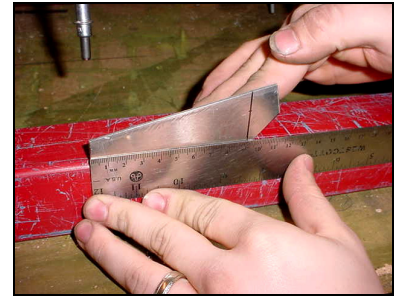
The aft rivet is through the bottom flange of the channel 6T3-2.

NOTE: Mark a no rivet zone for the last hole, drilled later through the bent strip 6T3-6 see section 6-T-3C page 4 and 5.

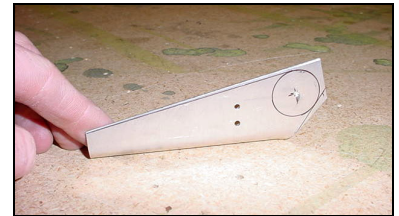
Mark the location of the lower rudder cable 100mm from the center of the piano hinge.



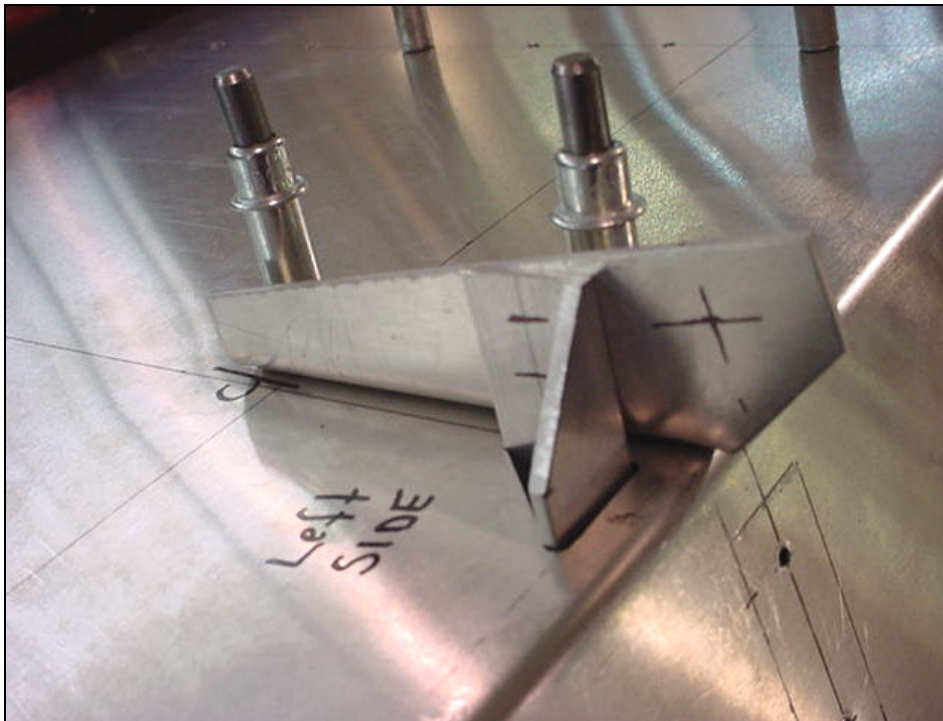
Drill a pilot hole, R10 (edge distance = 10mm).
 Trim the front of the Horn.
 Also radius the upper horn 6T3-4 R10.



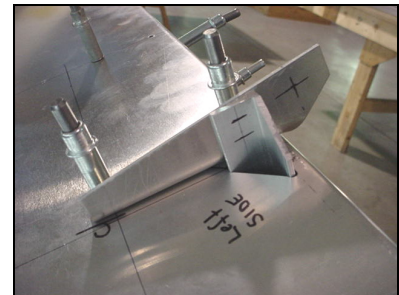
Check: 92mm from the aft end, 24mm up from the bottom flange.



Horn before it is trimmed.

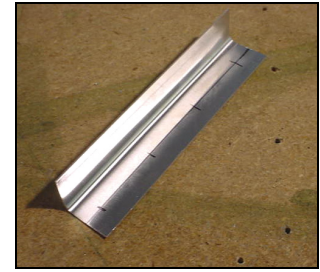
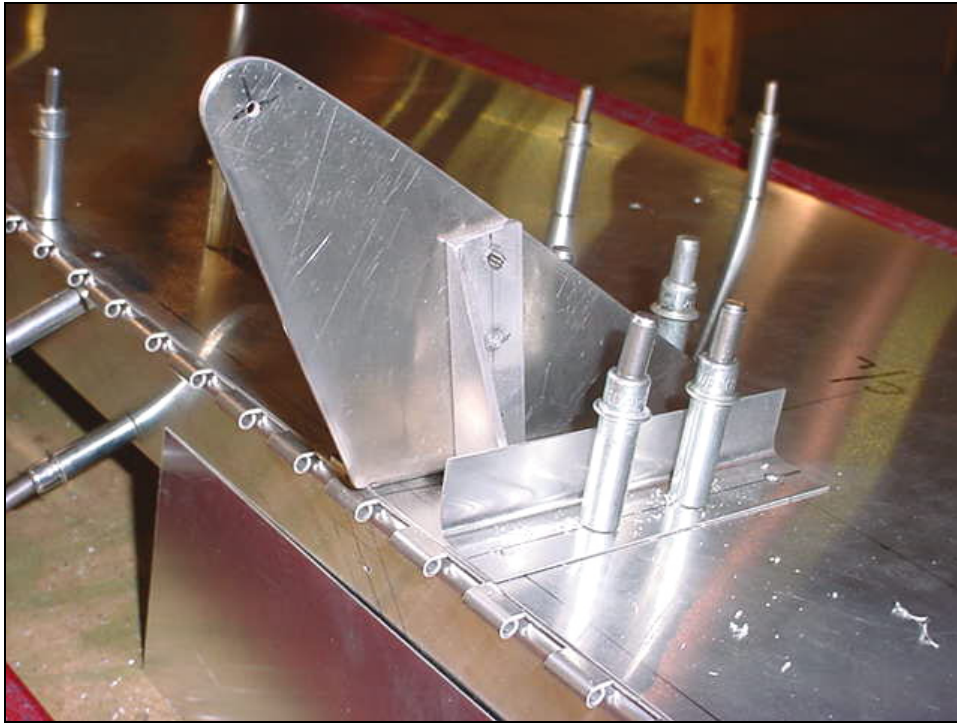


Drill & Cleco the doubler to the horns.



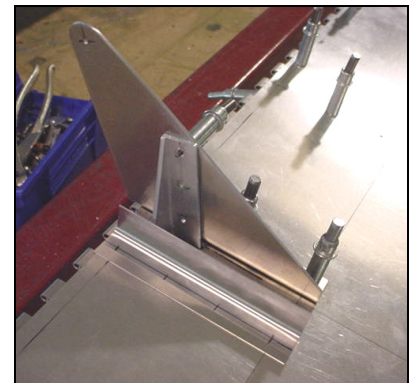
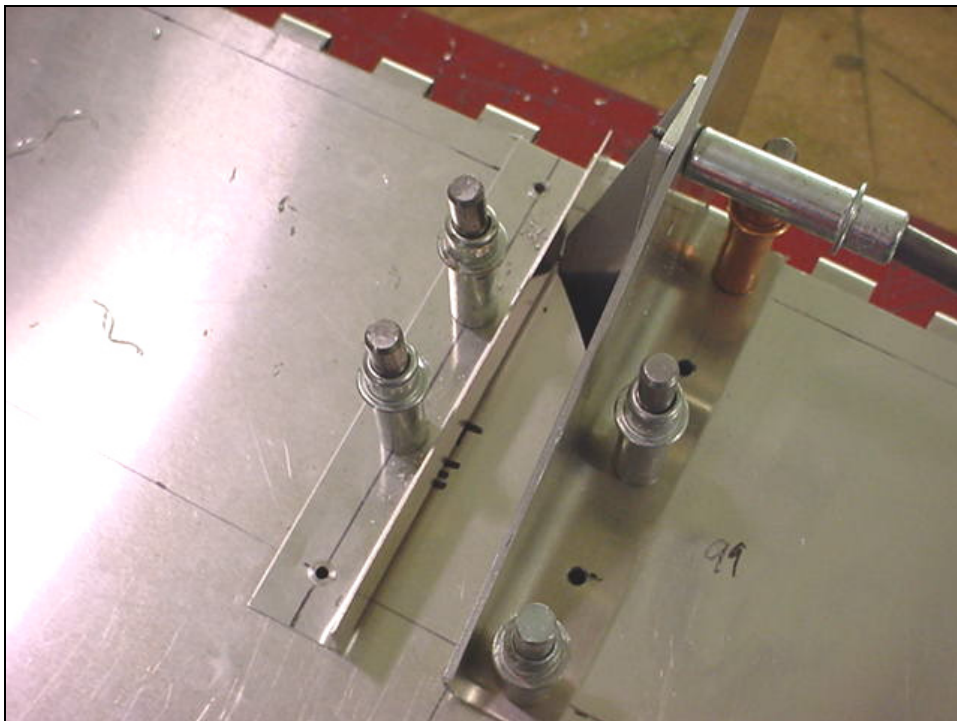
2 RIVETS A5
 6T3-6 to 6T3-5

CHECK: Bottom rivet is not in the bend radius of the horn.



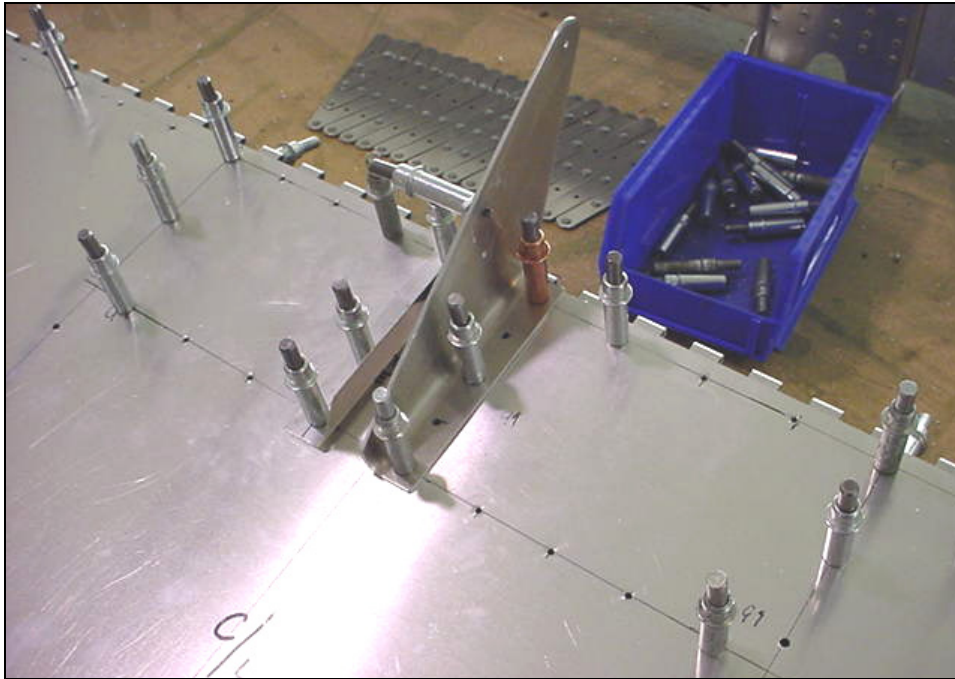
**L ANGLE
4 RIVETS A5**

Topside.
"L" angles on the O/B side of the cut in the skin.



The last rivet is through the channel; the front rivet is through the piano hinge.

Drill & Cleco the "L" angle to the skin.



PIANO HINGE:

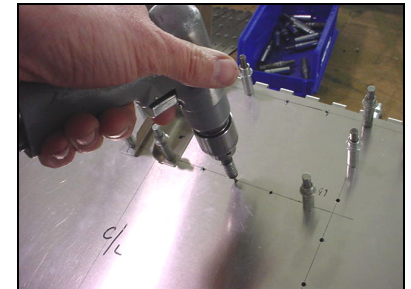
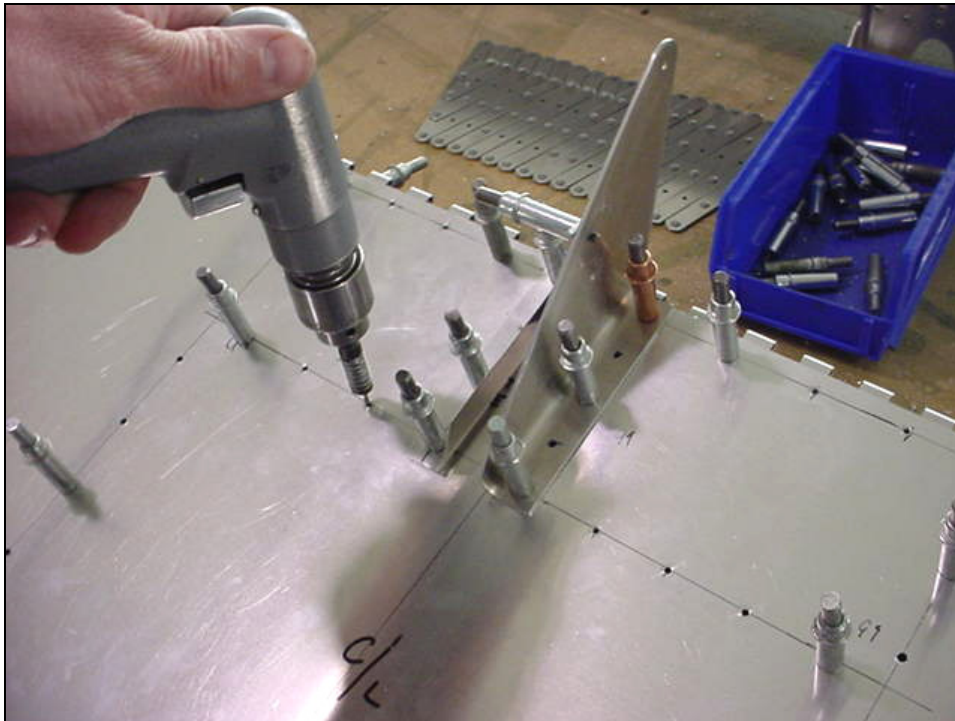
A5 PITCH 40

Center section between ribs. 6T3-3 to 6T2-5

A4 PITCH 40

Outboard of center ribs. 6T3-3 to 6T2-5

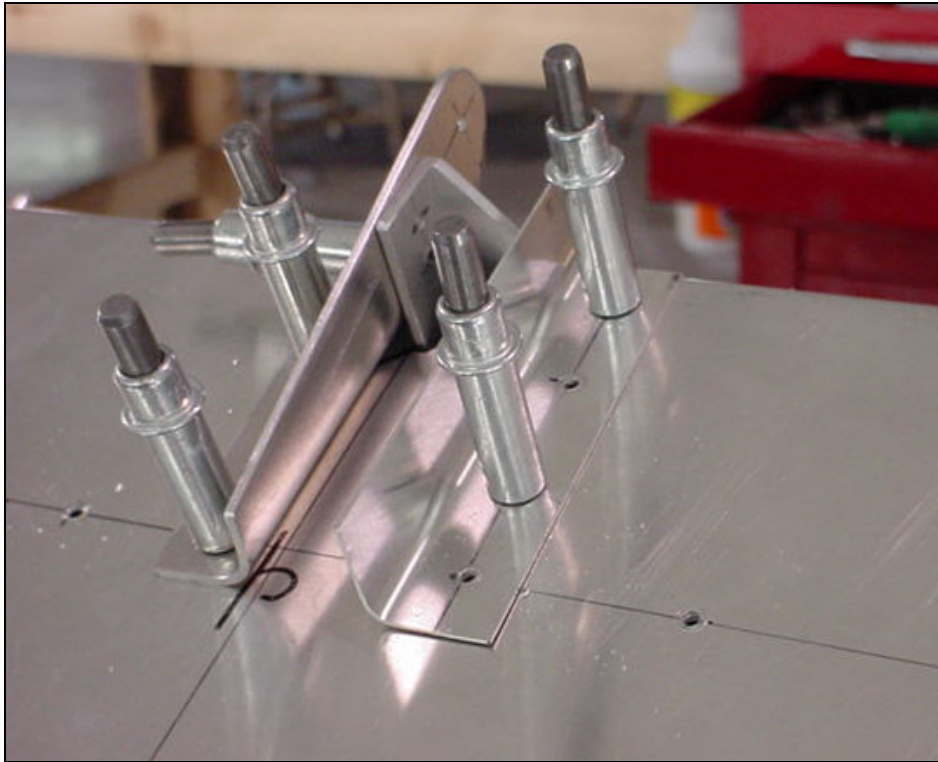
Finish drilling the rivet line through the front of the elevator into the piano hinge (between the two middle ribs 6T3-1).



A5 PITCH 40

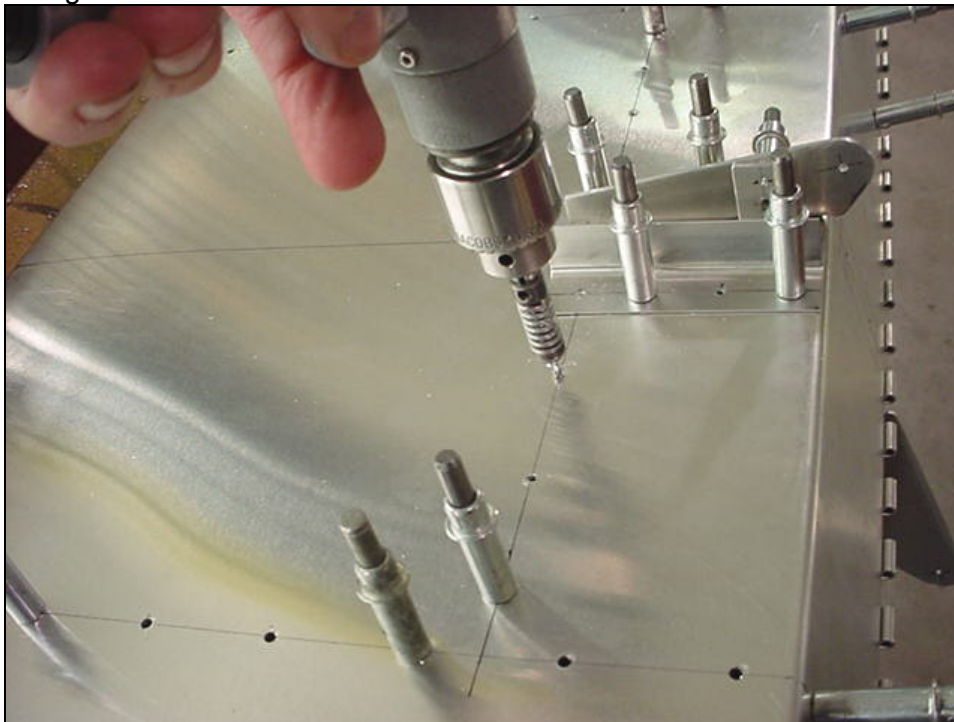
6T3-3 to 6T3-2

Drill & Cleco the top flange of the channel to the skin.



**L ANGLE
4 RIVETS A5**

Bottom side.
L Angles on the O/B side of the cut in the skin.



**A5 PITCH 40
6T3-3 to 6T3-2**

Drill & cleco the bottom side of the elevator skin to the bottom flange of the Channel 6T2-2.