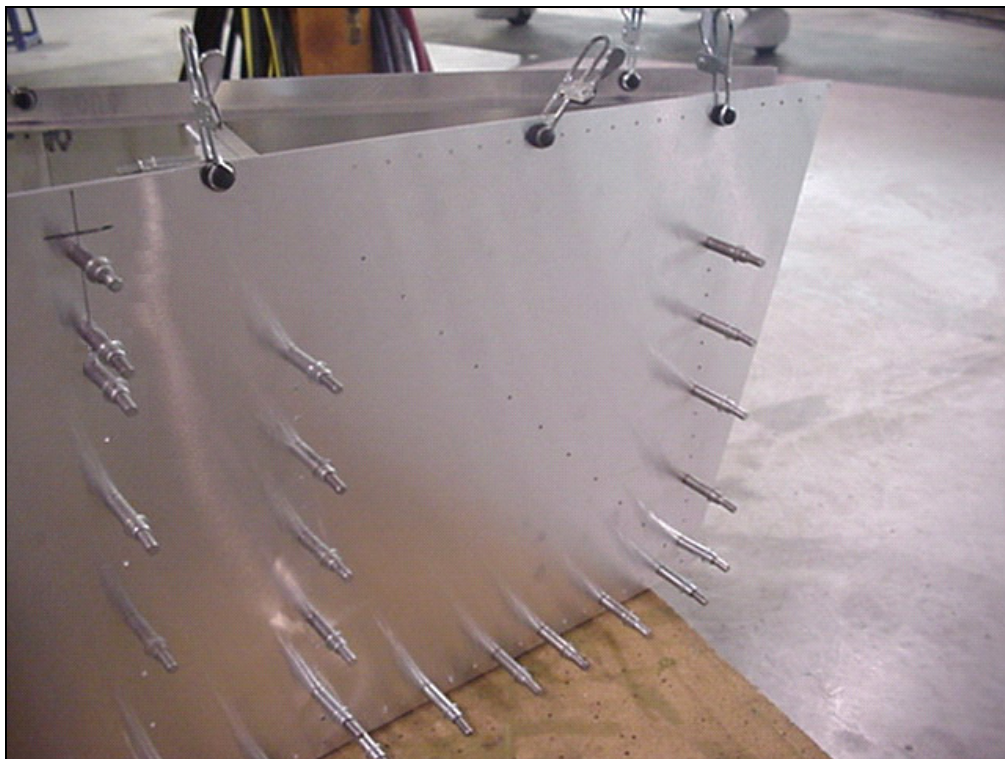




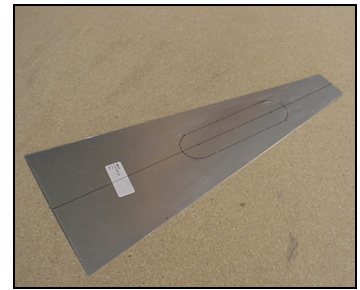
Note: The HT frames are square to the top edge of the side skins.

Drill and cleco the H.T frames.



Diagonal L angle.

Position the diagonal L angles between the front and rear H.T. frame (flange faces down). Drill and cleco.



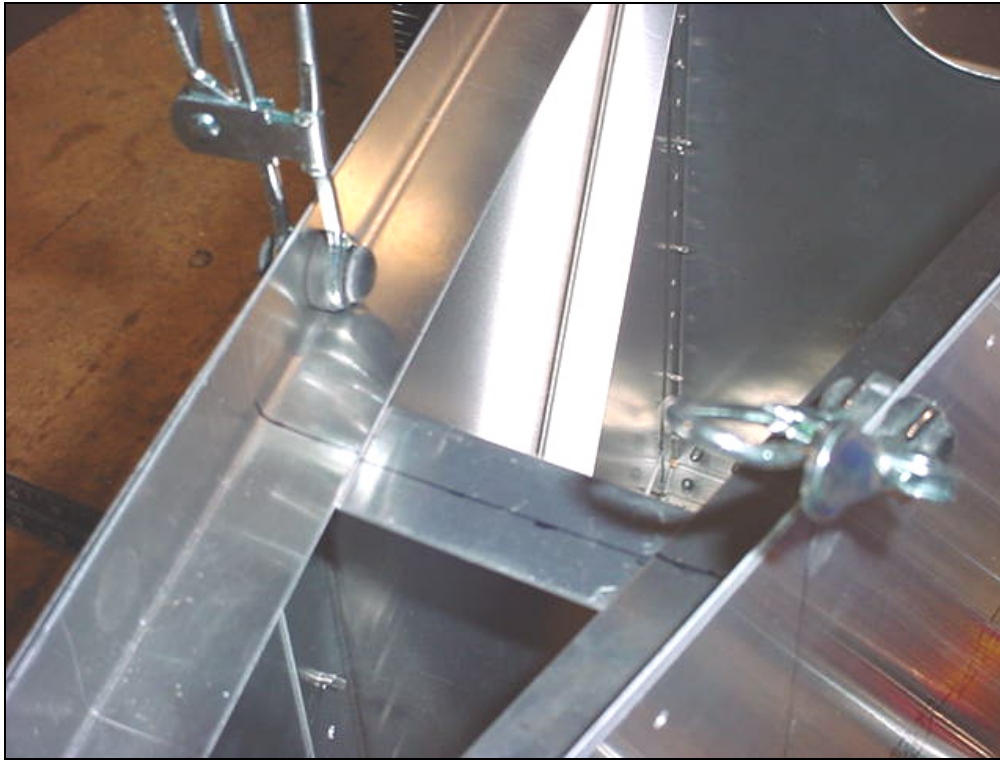
Rear panel (Top) 6B3-6, layout and cutout the middle portion. Use a hole saw or fly-cutter with diameter 60mm. The radius is not critical; it is quite acceptable to do a rough cut with the snips and to file to the radius line with a half round file (remove all sharp edges).

REAR PANEL 6B3-6



6B3-6 Rear Panel

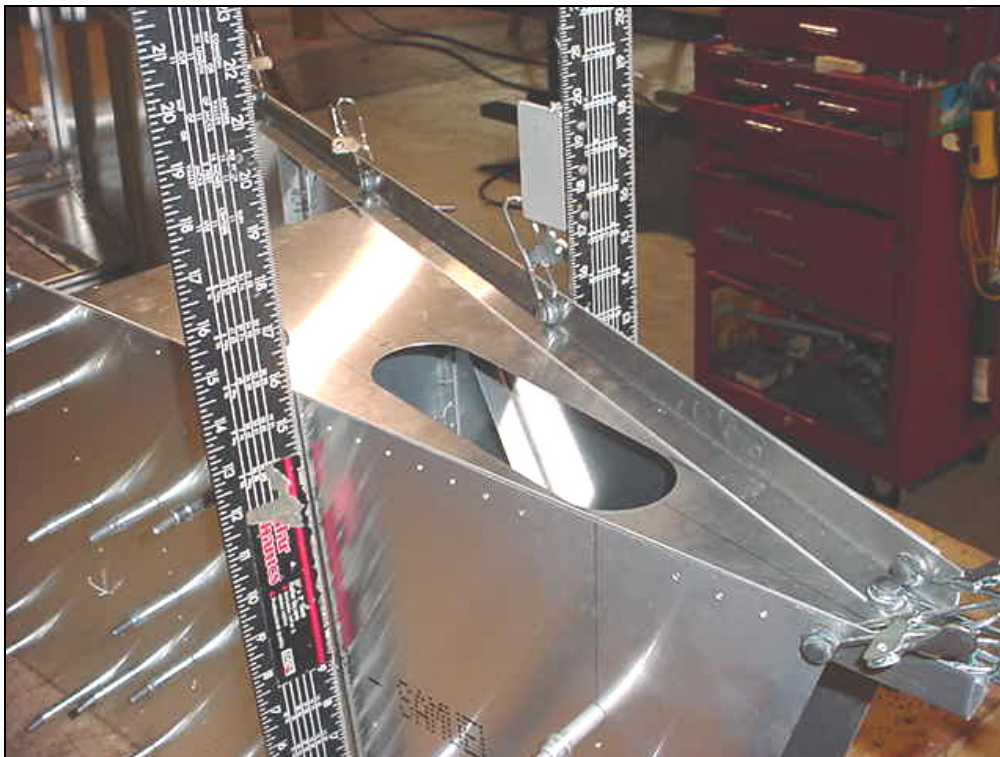
Ready to install on the rear fuselage.



Mark rivet line on front and rear HT frames.

CHECK: The front edge of the longeron 6B2-1 is at 1970mm from the aft top corner of the side skin. Ref. top diagram on drawing 6-B-3

Mark the rivet line of the H.T. frames on the bottom flange of the longerons.

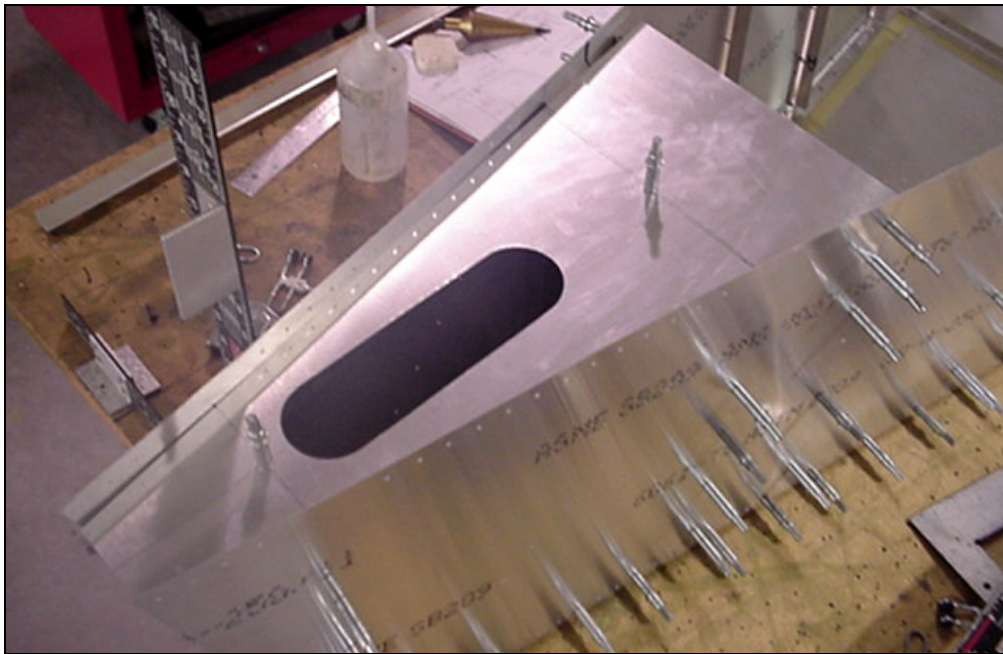


Position the rear panel between the longerons and the HT frame.

Ref. Line up the aft edge of the panel flush with the aft edge of the side skins.

Note: use squares to check the fuselage is not twisted.

Connect the reference marks on the longerons to mark the rivet line through the top flange of the front and rear H.T. frame on the panel.



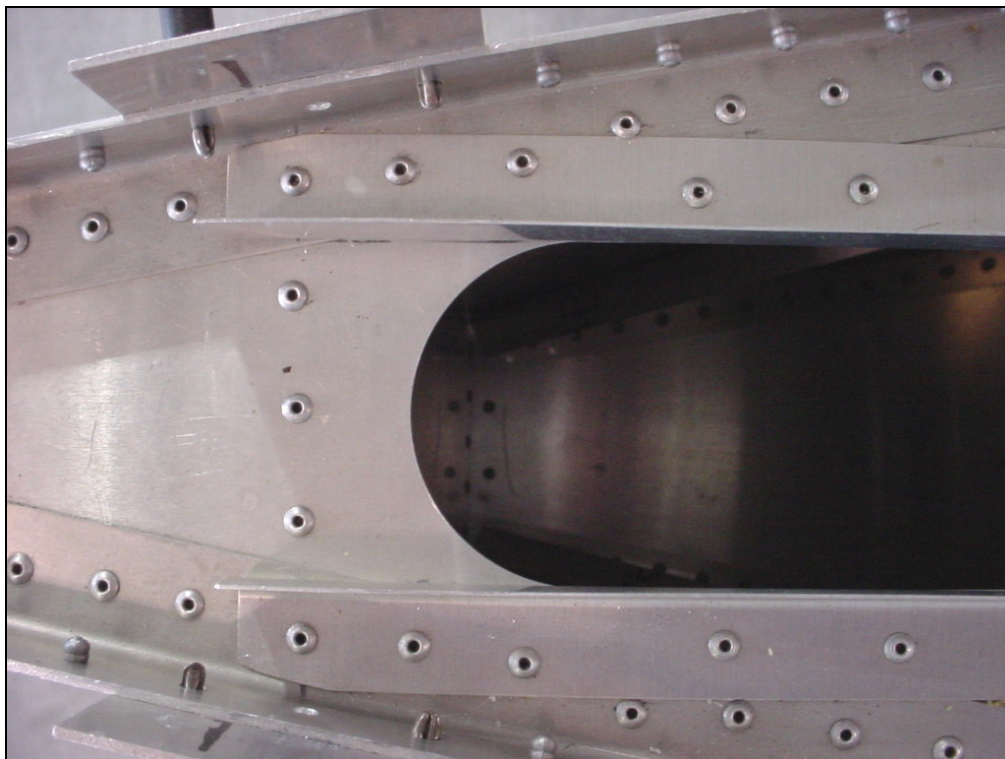
6B3-6 Rear Panel

Drill and cleco the center holes.



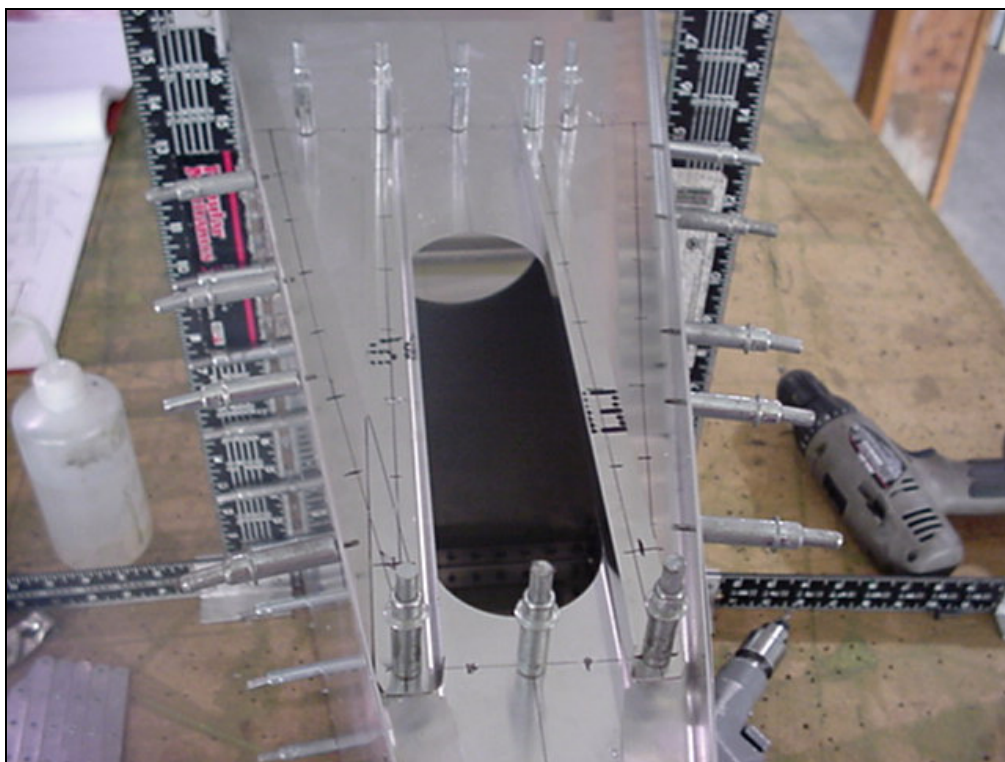
L angles overlap on top of the longerons, trim the flange parallel to the fuselage sides to make room for the bend radius of the longerons.

Clamp the L angles along the sides of the cutout. The end holes are through the top flange of the front and rear H.T. frames.

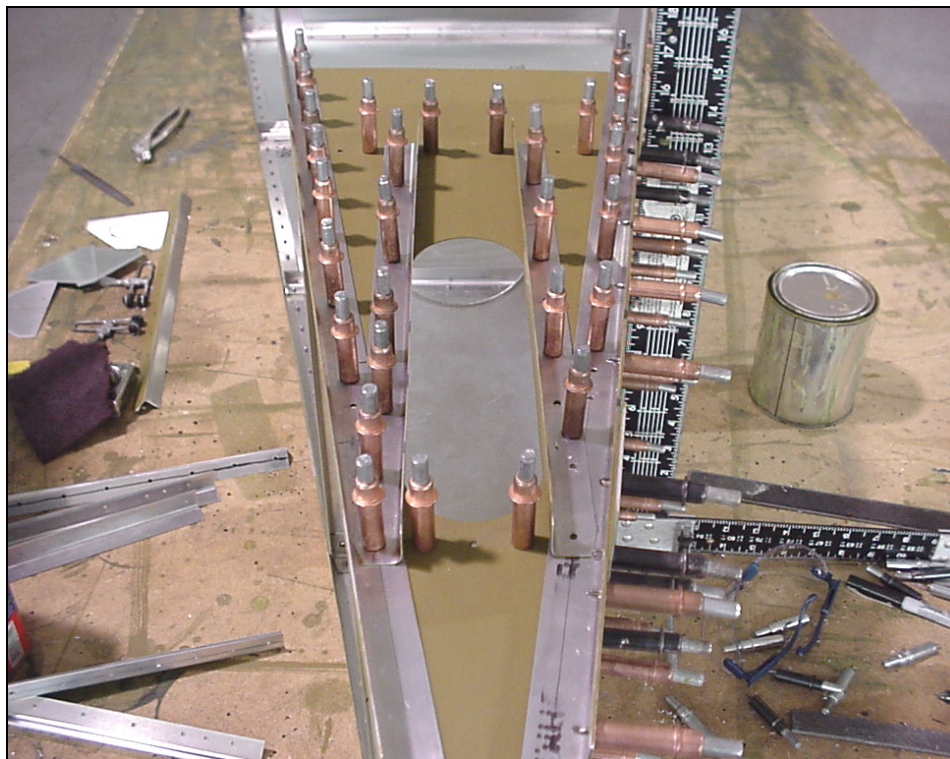


Layout the rivet pitch in the L angles and longerons.

Detail of rivet spacing in the area where the L angles overlap the longeron.

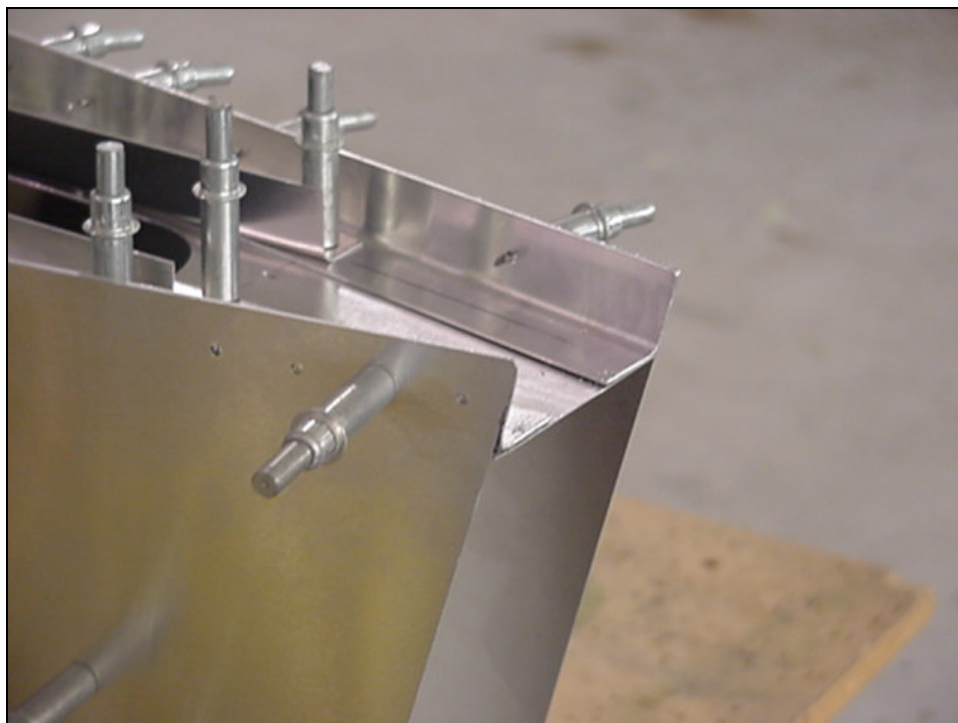


A4 pitch 20 through the top flange of the H.T. Frames.

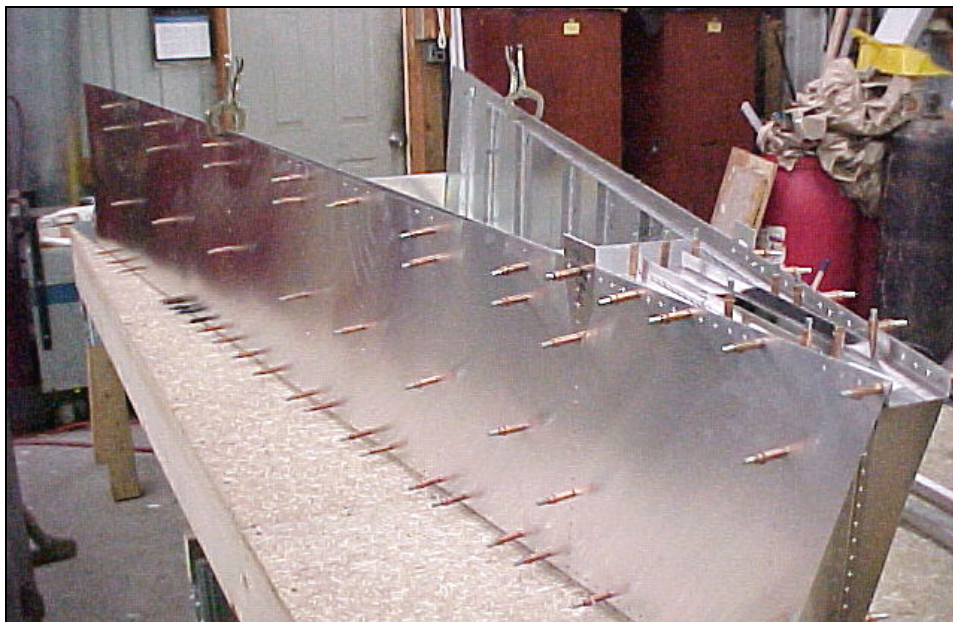


IMPORTANT: Use a plumb bob to check that the centerline of the top panel is aligned over the centerline marked on the bottom skin. Drill & cleco the flanges that overlap with the top panel (L angles, H.T. frames and longerons).

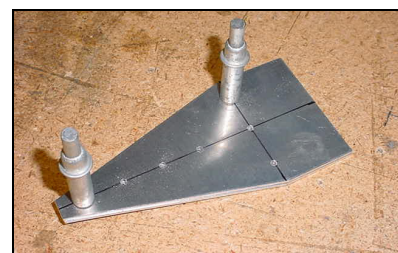
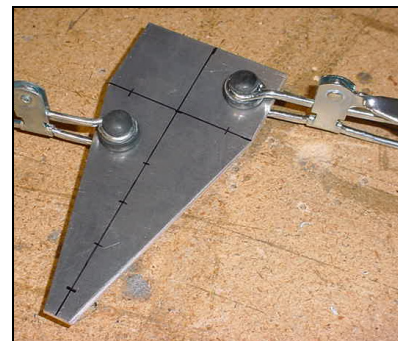
CHECK: Before drilling, check that the fuselage assembly is square.



Trim the aft end of the rear top longerons 6B2-1 flush with the end of the skin.

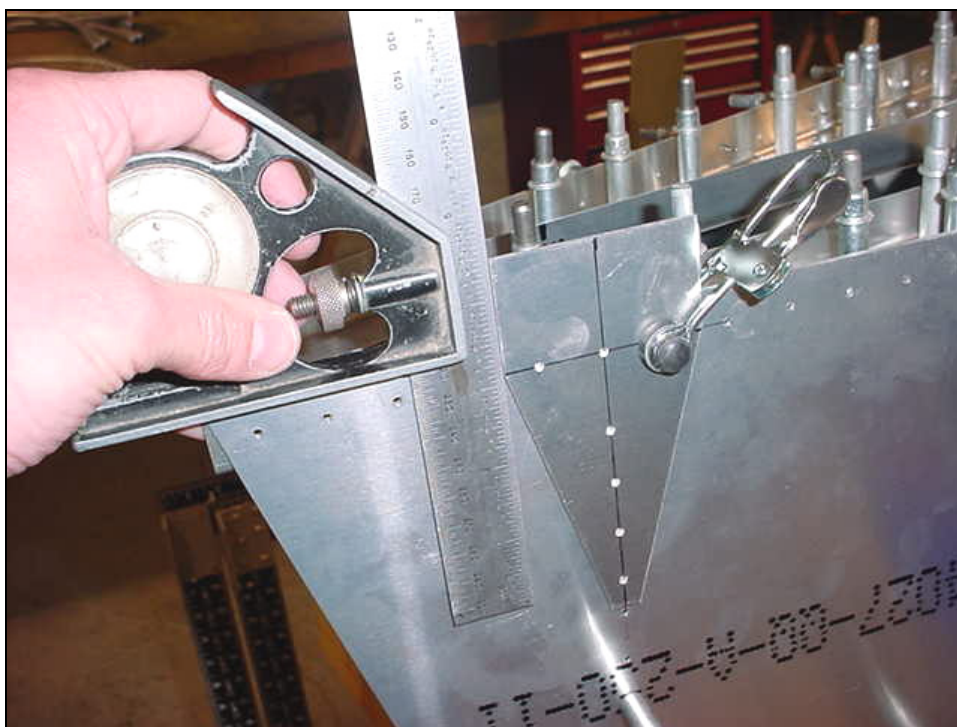


Layout and pre-drill the brackets with #40 pilot holes. Clamp the H.T. attachment brackets 6B1-8 and 6B1-9 to the top longerons. The top edge of the longerons and side skin may not be perfectly even, check for 10mm edge distance.

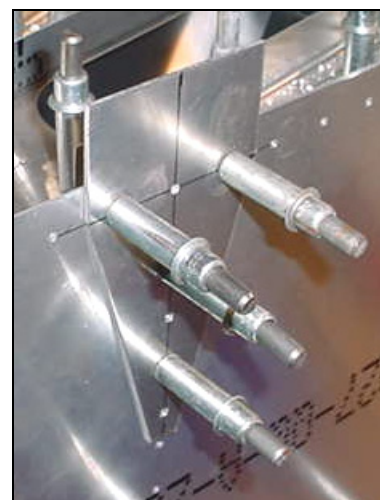


FRONT & REAR H.T. ATTACHMENT BRACKETS 6B1-8 and 6B1-9

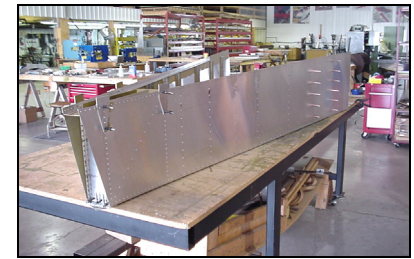
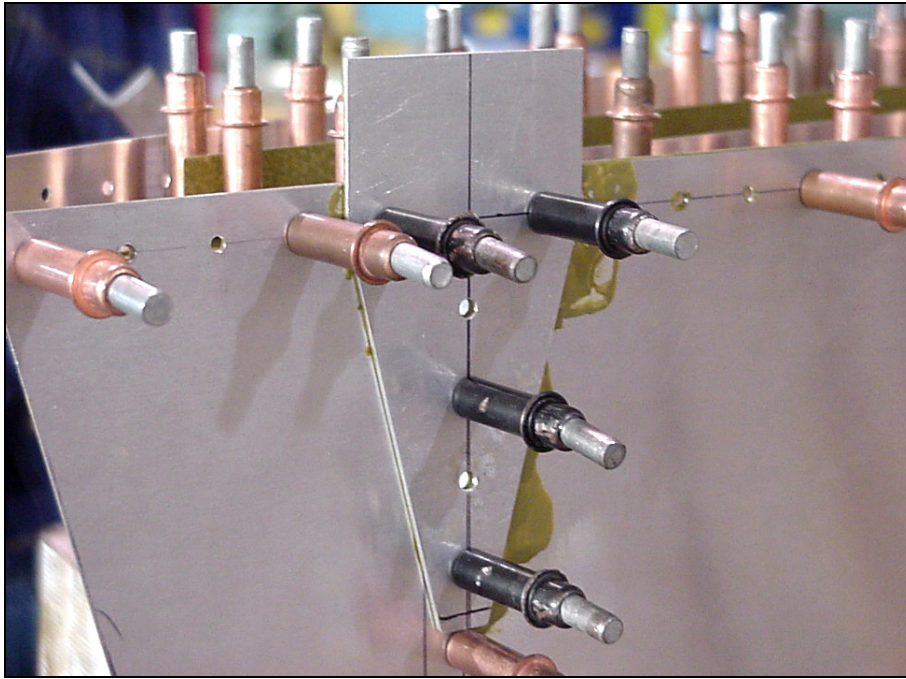
Layout, drill and cleco.



Rear H.T attachment bracket 6B1-8



Rivet lines through the longeron and H.T frame flange.



7 RIVETS A5



**CABLE OUTLET FAIRING
6B4-2**

Drill and cleco when the longeron centerline is visible through the horizontal line and when the H.T. frame flange centerline is visible through the vertical holes. Drill and cleco the top edge of the side skin in the middle of the rear top longeron 6B2-1 between the front and rear brackets 6B3-3 and 6B3-4, A4 pitch 20.



Mark and cut the slot in the side skin for the position of the cable outlet fairing.

Rudder cable outlet in front of the H.T. frame.

Note the no rivet zone through the longeron (side skins 6B3-1) for the installation of the cable outlet fairing 6B4-2

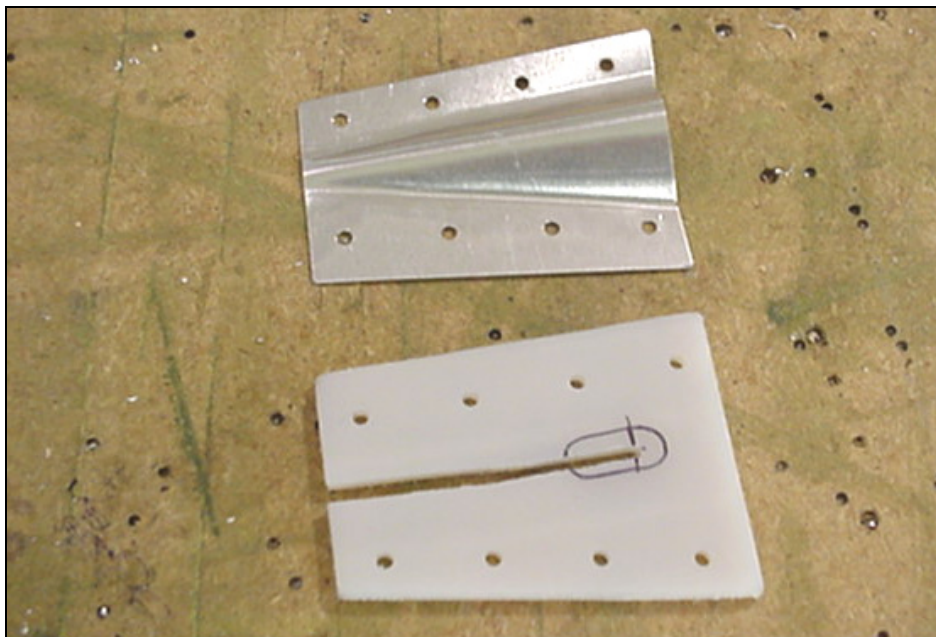
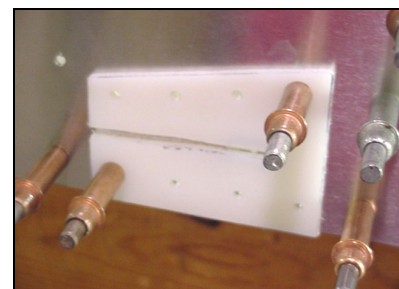
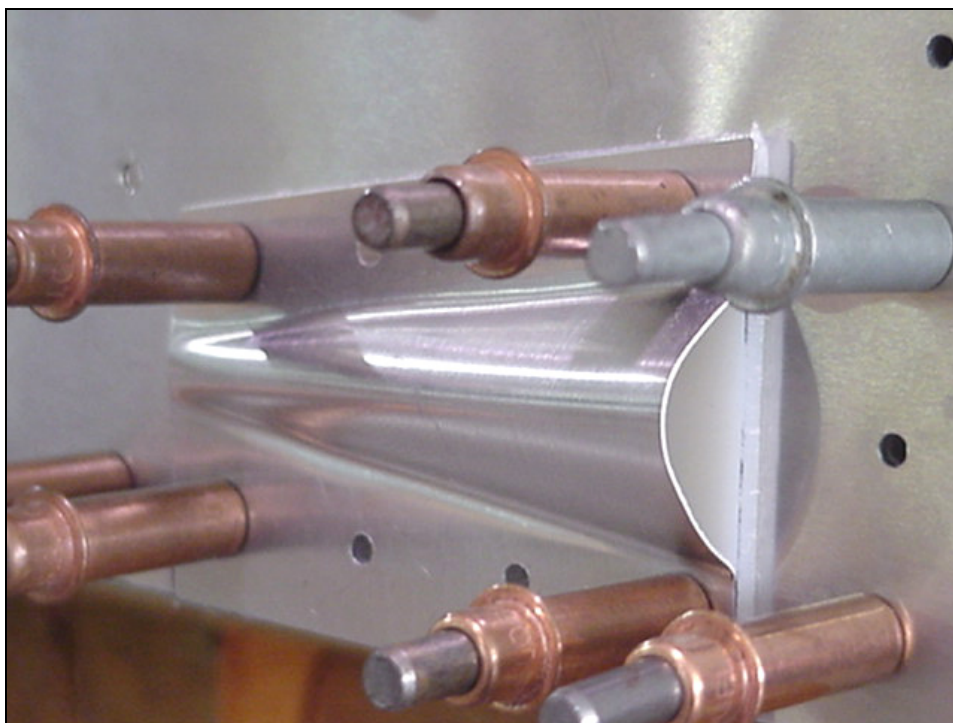


Photo of right side.

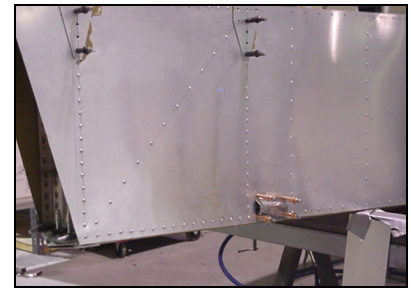
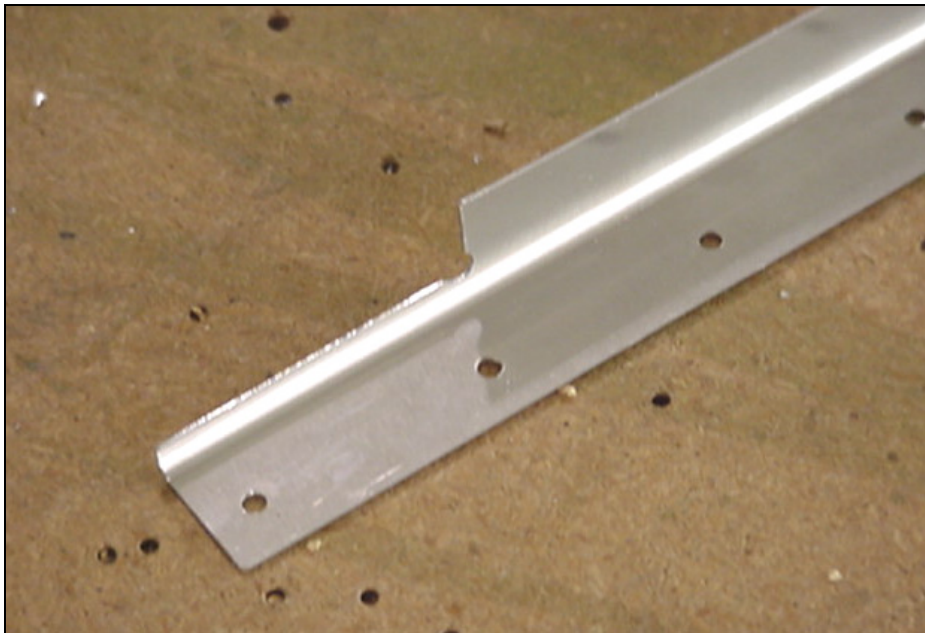
Cut the Nylon Fairlead to the same size as the Cable Outlet Fairing. Back drill the Fairlead using the Fairing as a template. Cut the center slot making it 1/8 and 20mm from rear.

Position the cable outlet fairing over the slot: approximately 30 to 35mm from the bottom of the fuselage to the aft end. Trim top and bottom flanges.



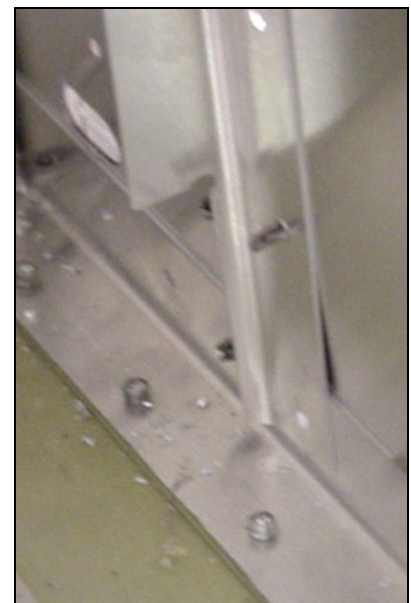
The slot is open towards the front

Rear view
Position the cable outlet fairing and fairlead to the rear fuselage.



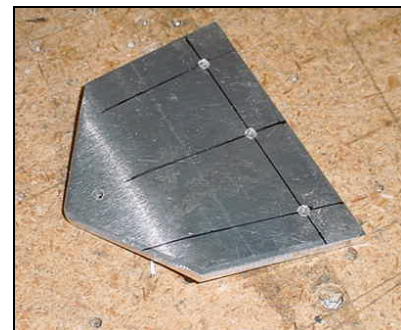
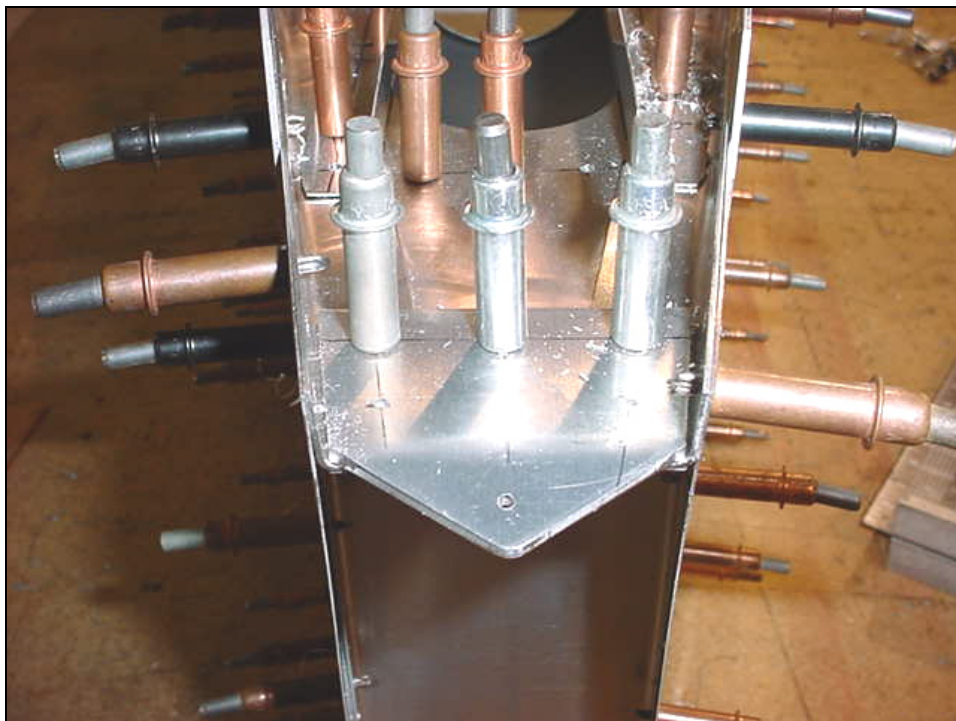
Location of the L angle in front of the cable outlet fairing

The L angle in front of the plastic fairlead will have to be trimmed 50mm from the bottom to allow proper clearance for the rudder cable.



Inside view of left side.

Cutout in bottom portion of L angle to make room for rudder cables.

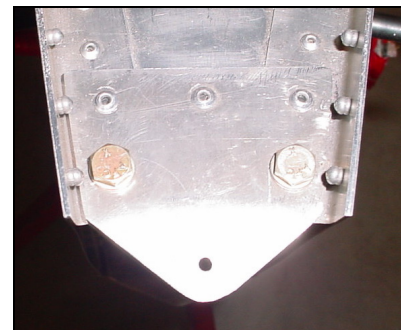
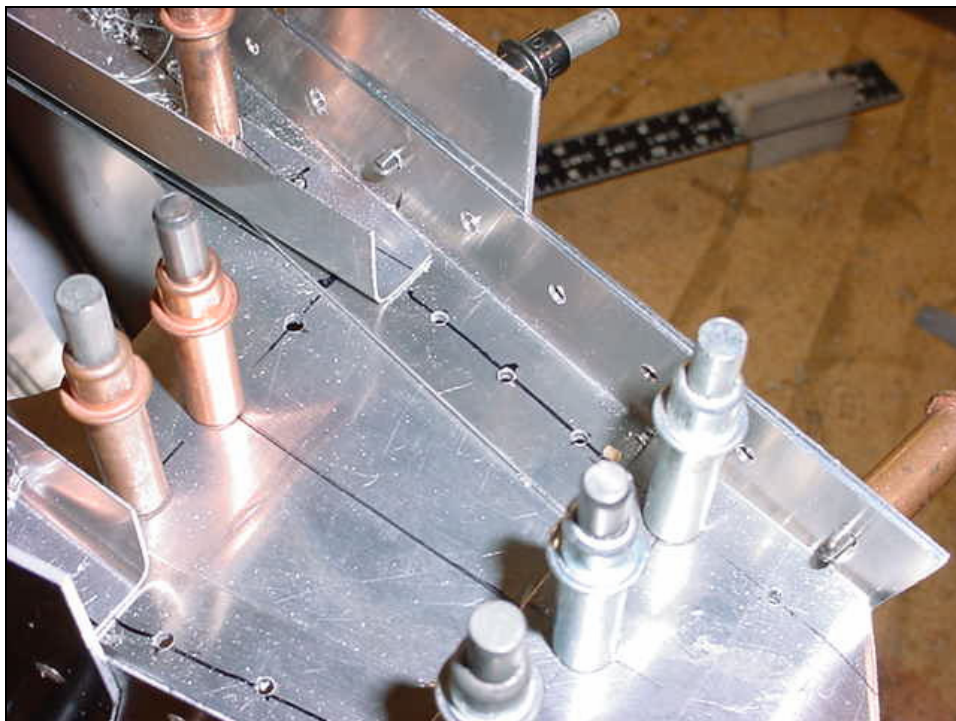


UPPER RUDDER HINGE 6B2-7

LAYOUT: Extend the longeron rivet line on the longerons to the hinge. Also extend the center line.

Before drilling holes, check edge distance for the hole layout in the longeron.

Check the overlap does not sit inside the bend radius of the longeron. If necessary file the corner edge along the sides of 6B2-7



Top view.



2 BOLTS AN3-5A

Finish drilling the holes in the longerons between the L angles and the hinge.

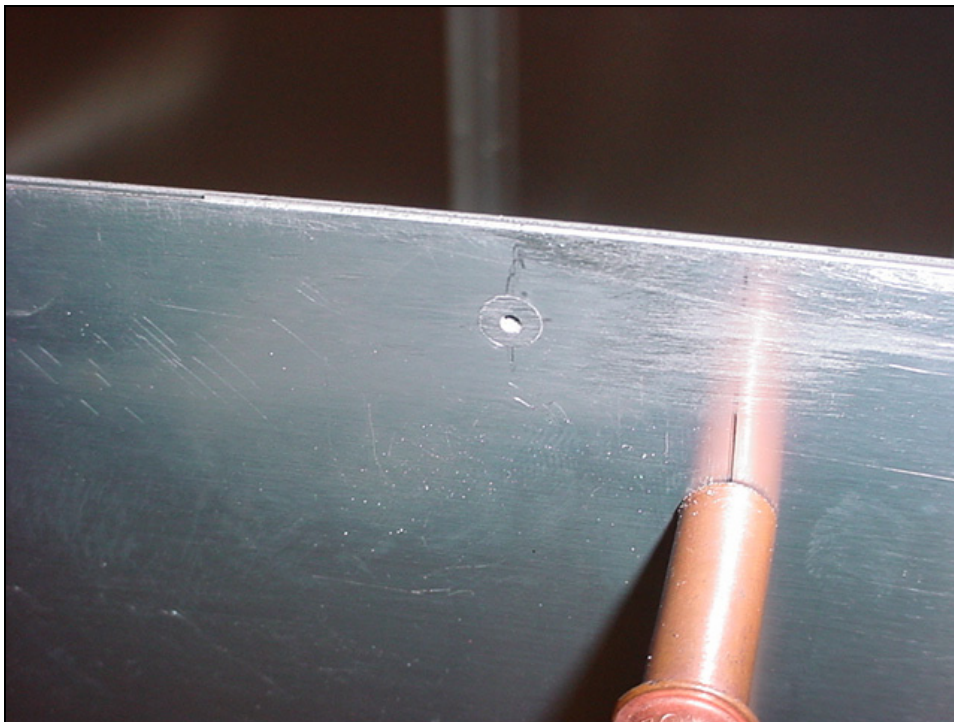


#30 hole

Counter sunk with a drill bit.

The purpose of the tack rivets is to help hold the longerons when the rear top skin 6B21-6 is installed.

Place the tack rivets 20mm from the intersection of the L angles on the Longerons. The rivet line through the Longerons is drilled later through the rear top skin 6B21-6.



FLUSH TACK RIVET

Countersink the skin with a drill bit, then use a flat nose piece on the riveter with a standard A4 rivet

Use a flat head on the riveter only to set the flush tack rivets, otherwise, use the custom machined nose piece (to form the domed head on the A4 rivets).