



Fiberglass reinforced bubble door.



Fiberglass door supplied with a sharp point in bottom front corner.



Front bottom reinforcement in fiberglass door has to be trimmed to fit the curvature of the door opening on the fuselage.



Grind away the reinforcement frame to fit the door inside the opening in the fuselage.



Notch the fiberglass even with the bottom of the windshield.

**HORIZONTAL REFERENCE:** the edge of the front reinforcement is the reference line to install the doors to the fuselage.



**VERTICAL REFERENCE:** The fiberglass reinforcement frame along the front bottom – approximately 5 to 10mm clearance with the fuselage.



**REFERENCE:** 7-F-19 to install the hinge to the Door Sill.

Fit piano hinge to 7F19-12D Door Sill with A4 rivets, pitch 40.



Aft edge. Top of tape even with bottom edge of piano hinge.

Use a piece of tape as a reference line on the fuselage to cut the top of the fiberglass door.





Trim the top of the fiberglass door flush with the edge of the piano hinge. Drill and rivet the Fiberglass Bubble Door to the hinge with A4 rivets, pitch 40.



Locate the center of the handle reference from the center of the striker plate. Using a #20 drill, drill a hole in the center of the handle.



Install the stainless steel sticker plate on the cabin side.



Use a step drill to drill the large hole.



Clean up the hole from the inside.



Outside handle in closed position.

2 holes for the screws.



Inside handle in closed position.

Backing plate under screws.





Trim the aft edge of the door flush with the door opening on the fuselage. With a pencil trace the opening on the fiberglass door.



**DETAIL:** Aft bottom.



The back edge of the door is a straight line flush with the front edge of the fuselage side skin (no overlap).



Top edge of the tape is approximately 6mm from the door opening.

Stick long strips of tape along the top edge of the solid rivets in the cabin frame.



Trim the bottom edge of the door even with the top of the tape line.





Installed bubble doors.



Door springs open, door in the unlatch position.

