



**P/N: 6B8-7
CENTER FIREWALL
STIFFENER**



Cleco the Center Firewall Stiffener to the Firewall. Expand the holes with a #30 drill, Cleco every other hole as you drill.



ORIENTATION: Flanges point outboard.



P/N: 6B8-1
GEAR GUSSET



Detail of top flange.

Clamp top flange to stiffener
6B7-1

Clamp side flange to channel
6B8-7

Make sure that the top stiffener is square to the firewall before drilling the gear gusset.



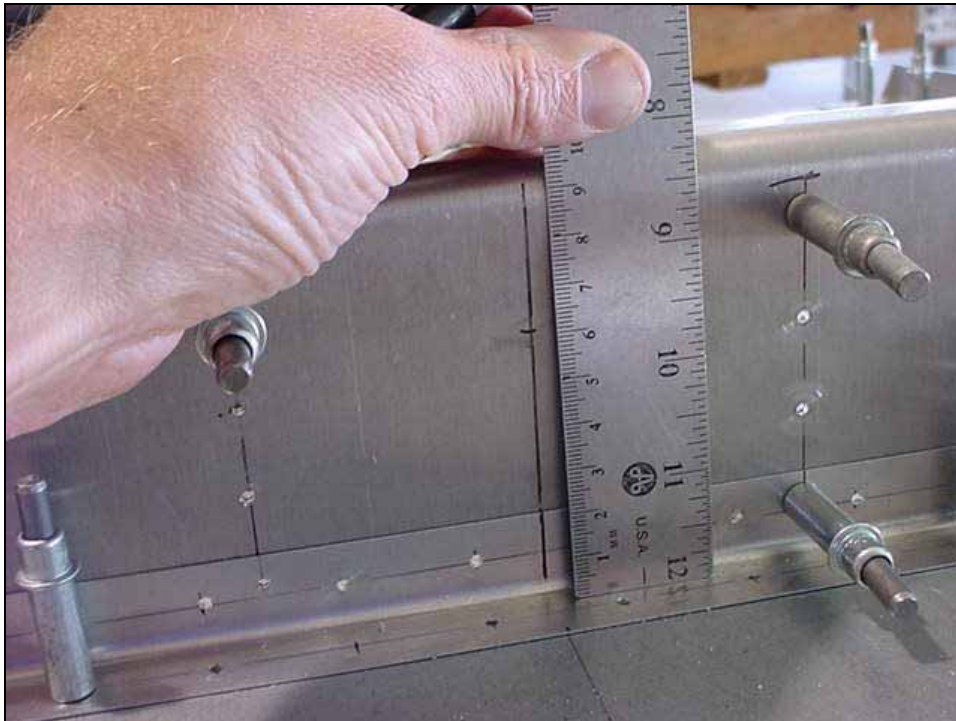
Check that the aft edge of the top flange is not pushed up inside the radius of the stiffener.



SUGGESTION: For maximum edge distance lengthen the corner relief hole with a round file, bend the aft edge of the top flange down to make room for the radius.

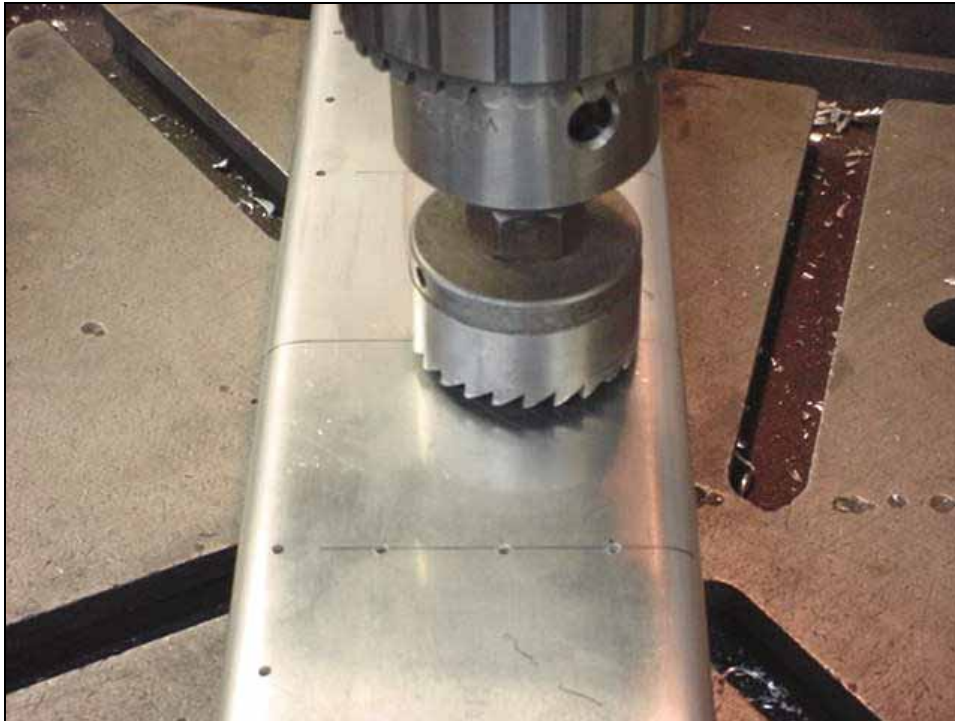


A5 PITCH 30
6B8-1 to 6B8-7
Edge distance 10mm from edge



Layout aircraft center line.

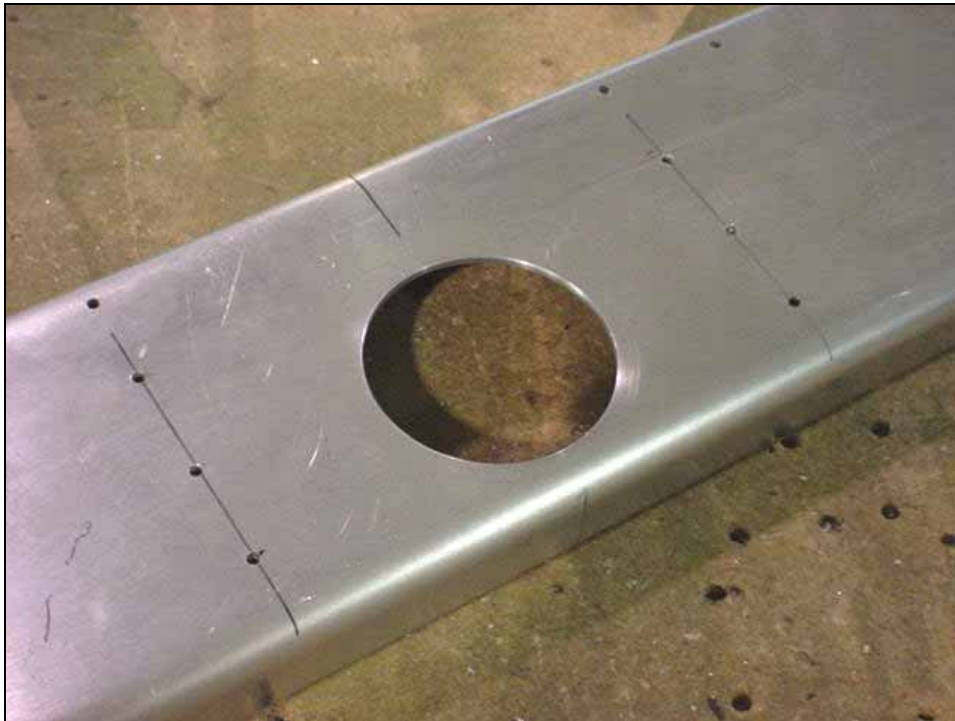
Layout the center of the nose gear leg 6G1-1, 60mm from the firewall.



Ref. 6B7-1 Firewall Top Stiffener (also see 6-B-10 & 6-G-2)

It is a good idea to do a test hole in scrap material to familiarize yourself with the tool and to evaluate the quality of the 2" hole.

Location of the 2" hole for the Nose Gear Strut 6G1-1 is 60mm from the Firewall



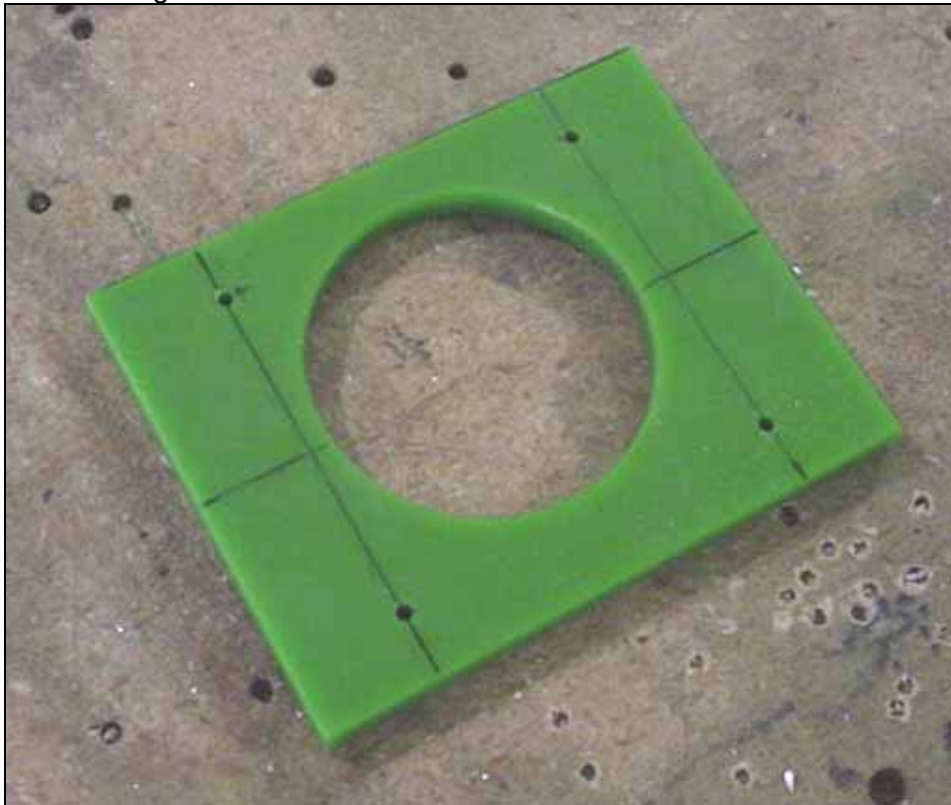
Detail of the 2" hole in the Firewall Top Stiffener 6B7-1

Check for proper fit with a 2" pipe or the Gear Leg 6G1-1.



**UPPER BEARING
6B8-6**

The Upper Bearing will need to be trimmed down; the cut line is 8mm to the front edge of the 2" hole.

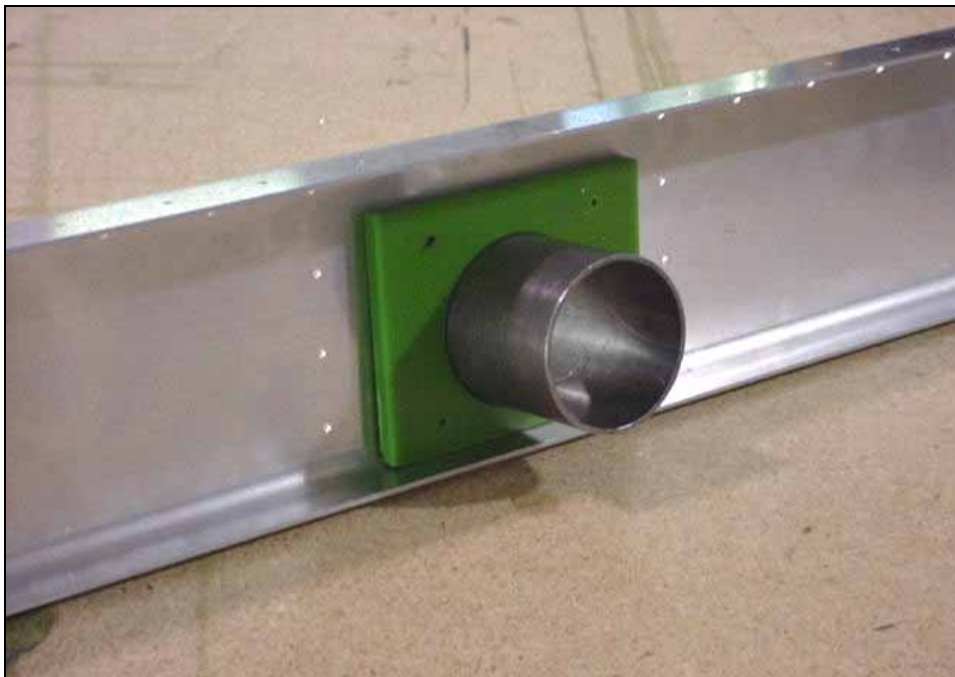


Layout the 4 bolt holes.

Mark the top side. With a file, radius the top edge along the side that was cut. (radius to fit inside the firewall top stiffener).

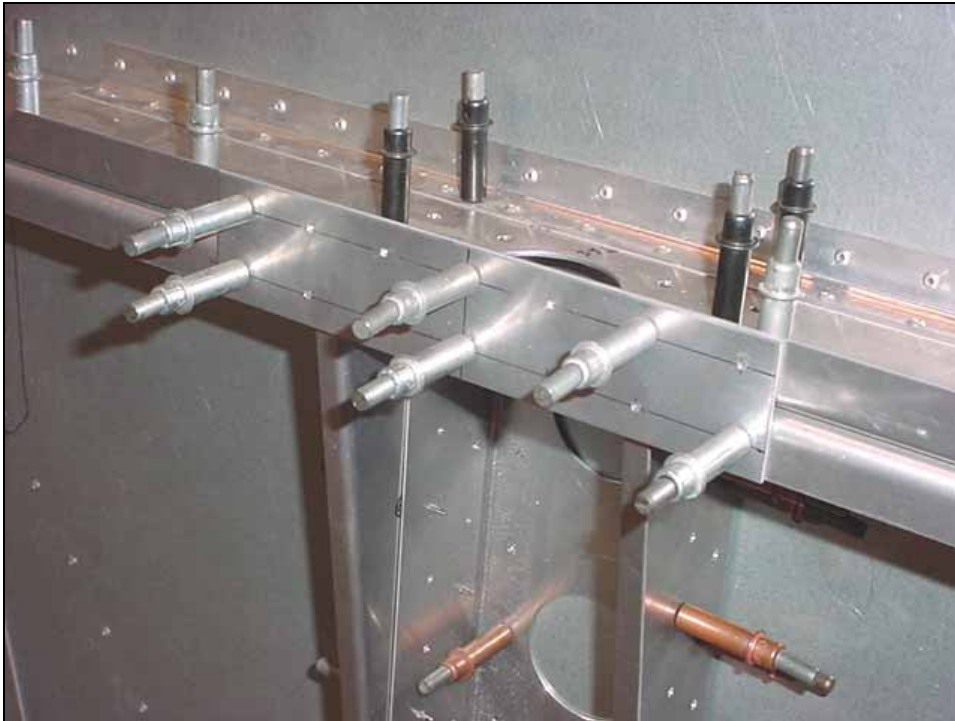


Looking ahead: The stop plate 6G2-3 fits between the bolts.

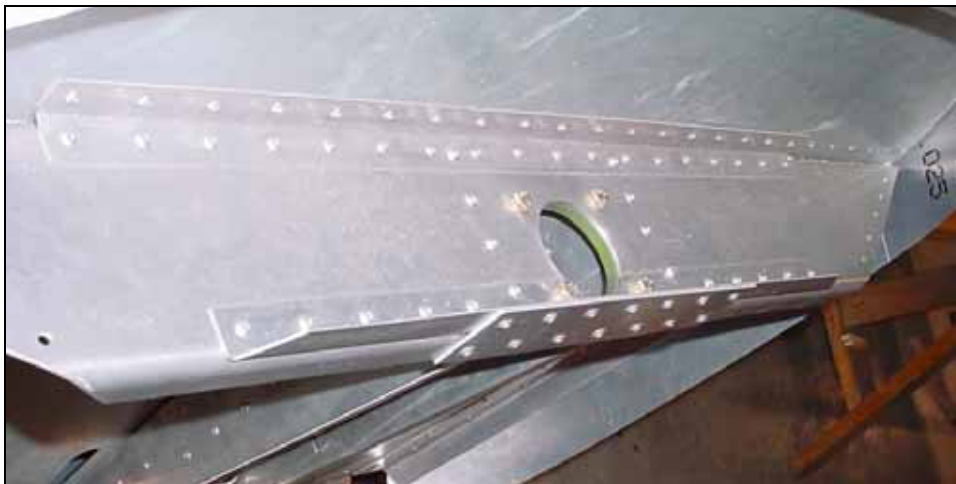


Bottom view:
The bearing fits inside the
Top channel.

Use a 2" tube or the nose gear leg 6G1-1 to align the 2" hole in the upper bearing with the 2" hole in the top firewall stiffener. Back drill and cleco.



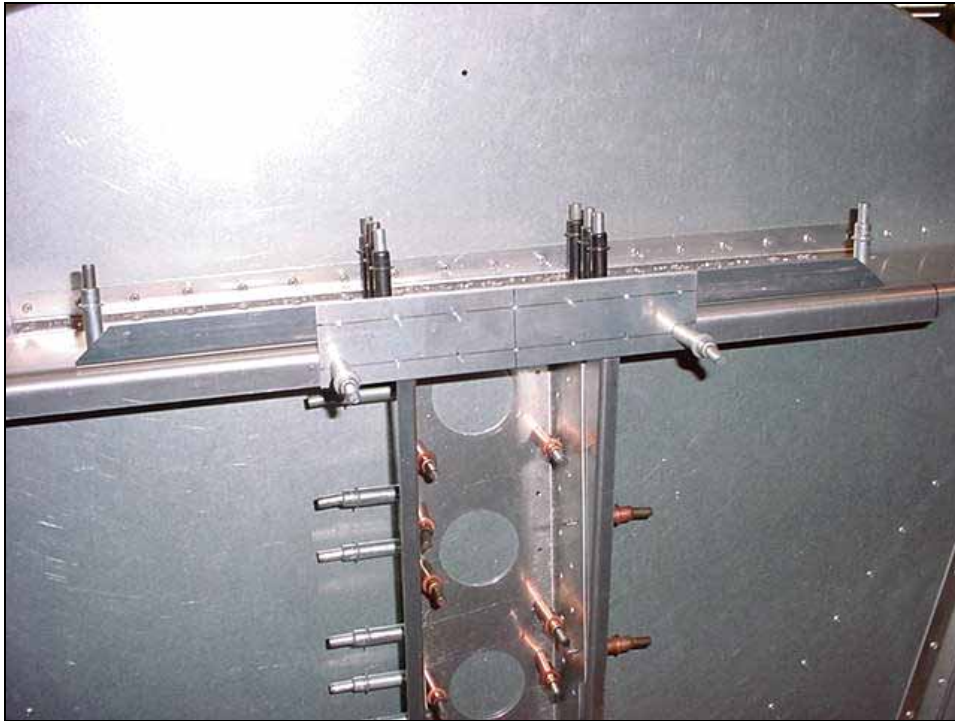
Clamp the upper angle 6B8-11 and the forward gusset 6B8-10 to the firewall top stiffener 6B7-1



UPPER ANGLE
6B8-11

Layout the rivet line in the upper angle 6B8-11 to firewall top stiffener 6B7-1

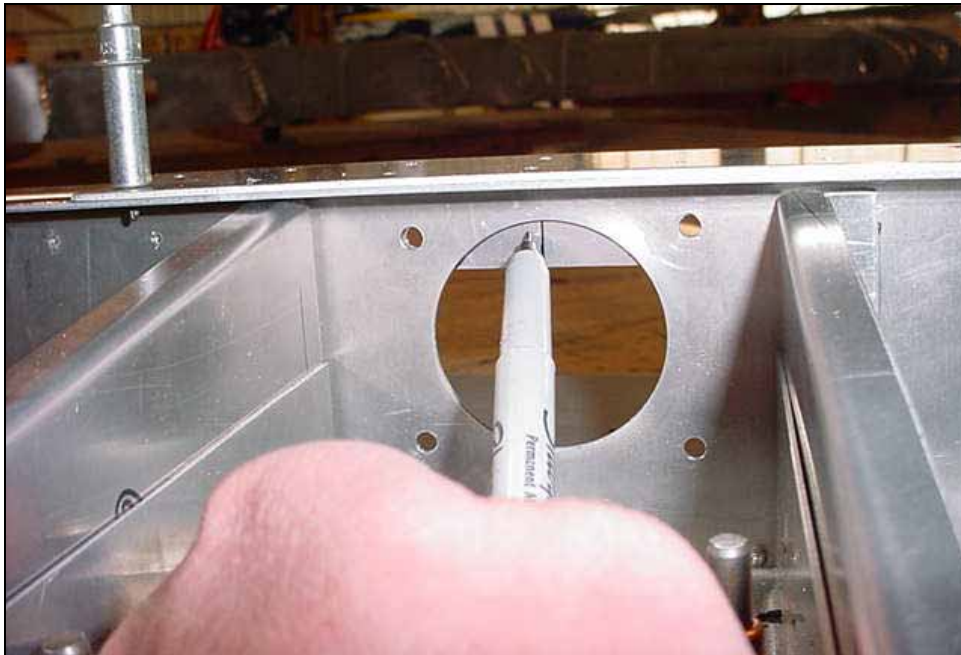
A5 PITCH 30 Ref. bottom right diagram on drawing 6-B-8



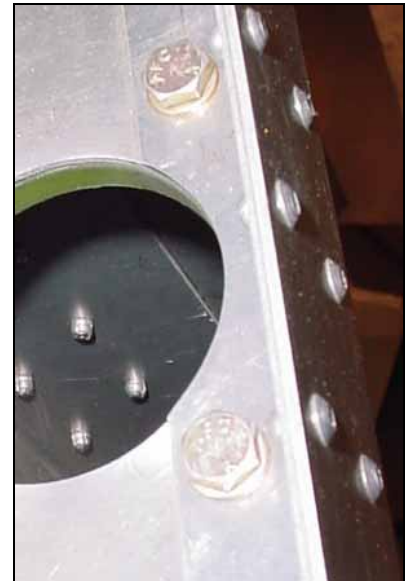
**FORWARD GUSSET
6B8-10**

7 RIVETS A5
in each row

Layout the rivet lines.



Trace around the 2" hole.
Trim.



Upper angle 6B8-11 is cut to
make room for the 2" hole.



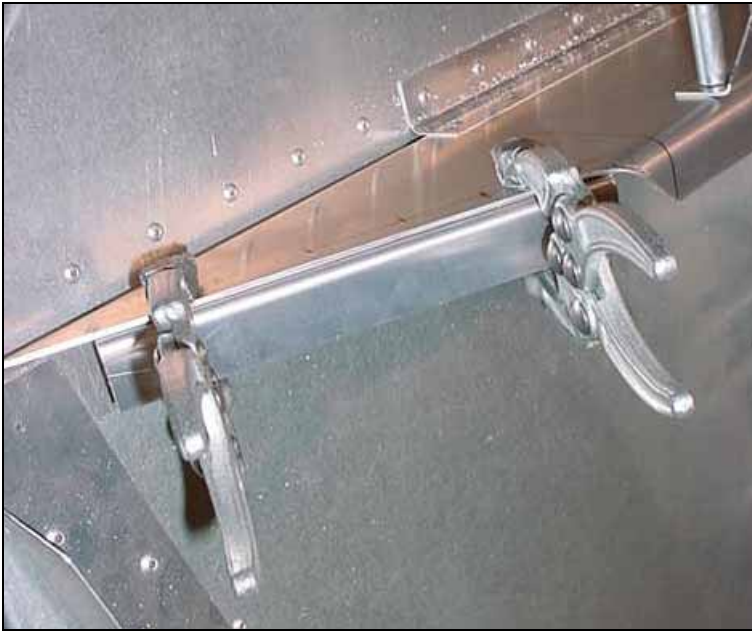
4 BOLTS AN3-6A



Corrosion proof and Rivet the firewall together.

Nylon self locking nuts and washer.
Looking up at the upper bearing 6B8-6

**SIDE BRACE
6B7-3**



Clamp. Drill and cleco.

Ref. Bottom right diagram on drawing 6-B-8

SUGGESTION: Wait to rivet in place until after the engine mount is installed, the aft corner may have to be trimmed.