



**Join the cabin floor
6B10-1 to the gear
channel 6B5-5**

Pull a chalk line (straight line) on the middle of the workbench or on the floor.

Overlap the Gear Channel 6B5-5 on top of the Cabin Floor skin, line up aircraft center lines and clamp together.

Note: the Longeron 6B10-3 overlaps on the underside of the Gear Channel.



Joining the cabin floor to the rear fuselage.



Check: The aircraft centerline is in line with a chalk line on the workbench.

Detail of chalk line and aircraft center along front edge of cabin floor.



Drill and cleco the cabin floor skin 6B10-1 to the gear channel 6B5-5

A5 pitch 30

Detail of chalk line and aircraft center at the rear of the fuselage (tie down ring 6B4-1).



Mark the center line on Center wing spar.



Center wing spar: 6-W-4



Spar insert: 6-B-13



Insert the spar insert in the wing center section.

See **section 11A** for where to drill the middle holes in the spar insert.
Bolt the spar insert to the spar (through the middle holes).



Mark the spar rivet line on the underside of the bottom flange of the wing center spar.

Clamp the spar on the cabin floor skin.



200mm from the aft edge of the skin to the rivet line.

Note: if the skin is not pre-drilled, layout the rivet line and drill with pilot holes.

Ref. 6-B-10 middle diagram.

CHECK: The spar is parallel to the aft edge of the cabin floor skin.



Position assembly over the workbench.



CHECK: Spar rivet line is visible through the pre-drilled holes in the cabin floor skin.



Back drill and cleco.



Wood backing block on top side.



Front side.



Aft side of spar.
Finish drilling the rivet line.



The side flange of the cabin floor makes a transition from the spar to the bottom curvature of the firewall.

The sides of the cabin floor skin are 90-degrees at the spar.



Remove the Spar from the cabin floor before bending the sides of the cabin floor skin.

Clamp a board along the bend radius. With a rubber mallet bend the sides in.



Rubber mallet.

Bring the sides to 90 degrees on approximately 50mm



Side flange on the cabin floor skin 6B10-1 (area in front of spar).



Flat face pliers can also be used to bend the flange.