

Start with the rear bulkhead 6B12-3



Position the bulkheads to the rear fuselage.



Check that the left and right side flange is flush with the fuselage side skin.

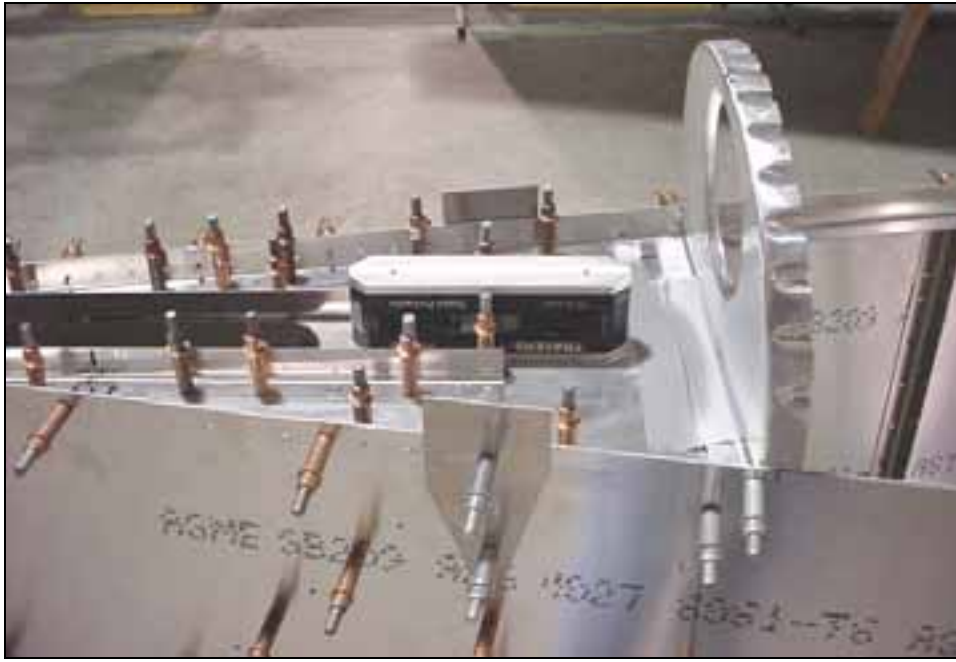
GENERAL: The bottom flange points towards the back.

The bulkheads overlap on top of the Longerons 6B2-1.

Trim the ends of the bottom flange to overlap parallel to the fuselage sides.



Check: Cutout in the bulkhead to make room for the side skins is



**AFT BULKHEAD
6B12-3**

A4 PITCH 40

Position the bulkhead flush with the front edge of the panel 6B3-6
SUGGESTION: Use a piece of duct tape to temporarily hold it in place.



**MIDDLE BULKHEAD
6B12-1**

Check that the corner cutout in the front flange of each bulkhead does not interfere with the top edge of the side skin.

Reference: distances measured along the top edge of the side skin.

CHECK: When the fuselage sides are straight, the middle bulkhead does not draw the fuselage in or bulge it out.



**N66
PLASTIC FAIRLEAD
2 RIVETS A5**

Fairlead is located on right side of centerline.
3/16" hole drilled for the upper elevator cable.



**BAGGAGE BACK
BULKHEAD
6B12-2**

A4 PITCH 50
L angles to bulkhead

Drill and cleco 2 pieces of L angles on the backside of the bulkhead.



2 RIVETS A5
 one in each Longeron (see splice detail, to left diagram on drawing 6-B-14)

Set 6B12-2 from 6B12-1, distance measured along the top of the fuselage side skins.



Remove the cleco and clamp the bulkhead to the Longerons.

Do not drill any holes in Longerons 6B11-1 (Splice detail ref upper right diagram on 6-B-14).

Remove the diagonal L angles to drill 6B12-2 to the Longeron 6B2-1.

The holes in the Longeron 6B11-1 are drilled after the cabin width has been set at 6B16-6



Baggage back bulkhead.



Bulkheads on fuselage.



19 PILOT HOLES IN 6B12-3

Drill pilot holes



Layout the rivet spacing between the crimps.



25 PILOT HOLES IN 6B12-1



Mark the rivet line. Layout the aircraft center line. Pre-drill the bulkheads with #40 pilot holes.



31 PILOT HOLES IN 6B12-2