



**GUSSET  
6B15-3**

Orientation: flange points to the back.



Left side, looking forward.  
Trim the outboard side to fit the curvature of the fuselage side.  
Gusset overlaps on the backside of the Heel Support and the Vertical L Angle.



**5 RIVETS A4**  
6B15-3 to 6B8-8 (3 rivets)  
6B15-3 between crimps on L angle.

Photo of left side.



**ROLLED GUSSET  
6B15-2**

The wider side is towards the front; the 90 degrees side is up.

Photo of right side: viewed from the front.  
Start by drilling the gusset to the Heel support, then to the side skin.



Right side

Layout the rivet lines 10mm from the edge of the gusset.

Right side, viewed looking back.



Photo of right side (looking back).



**8 RIVETS A4**  
6B15-2 to 6B8-8 (4 rivets)  
6B15-2 to 6B11-2



Left side.





**LOWER ENGINE MOUNT  
FITTING  
6B6-5**

**OBSERVATION:** The front AN3 bolt is 13mm from the front, in this location it will not be centered on the bottom flange.

Orientation: the bent is O/B Ref. Drawing 6-B-10  
Photo of right side.



SHIM T=.040"  
Ref bottom right diagram on 6-B-7





**LOWER ENGINE MOUNT  
FITTING  
6B6-5  
Qty: 1L + 1R**



**CHECK: The bolts are  
centered on the lower front  
longeron 6B10-3**



Right side.



Bolt to the longerons, then open up the 3/8" hole through firewall and front flange of the lower engine mount fitting.

**CHECK: The bolts are centered on the lower front longeron 6B10-3**



**FRONT SEAT PANEL  
6B15-4**

Qty: 1L + 1R

Orientation: the flange along the bottom, the 90-degree side is inboard.

Layout and cut the access cutout.



Mark the location of the Gear Upright 6B11-4 on the Seat Panel.



Layout the cutout.





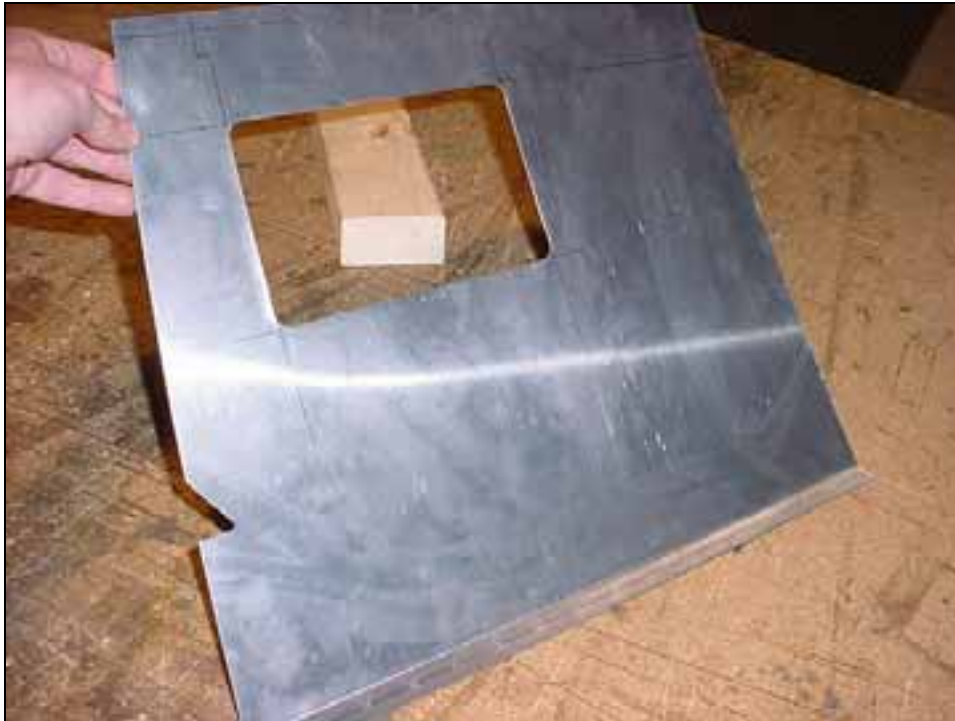
Cutout in the Seat Panel to make room for the Gear Upright 6B11-3

The cutout can be made L shaped as shown in this photo or triangular as shown on drawing 6-B-15



Left side.

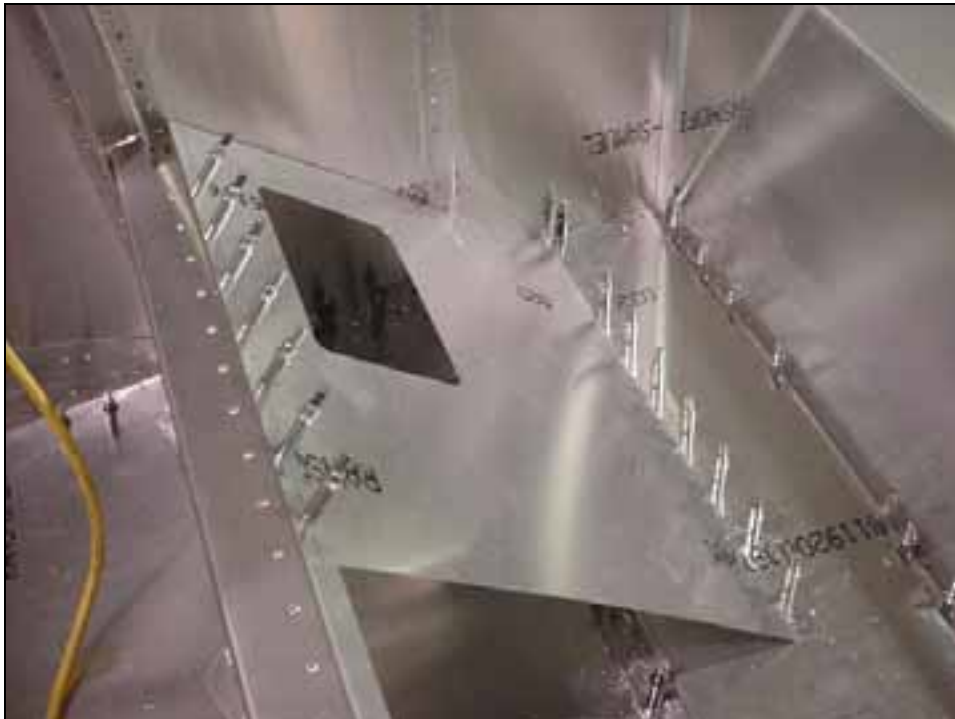




**A5 PITCH 30**  
6B15 -4 to spar 6W4-1

Layout and pre-drill.

#### FRONT SEAT PANEL



**CAUTION:** Use a drill stop on the drill bit. Do not let the drill bit touch the spar web.

Drill & Cleco the top rivet line to the spar first, then drill the bottom flange of the seat panel to the gear channel.

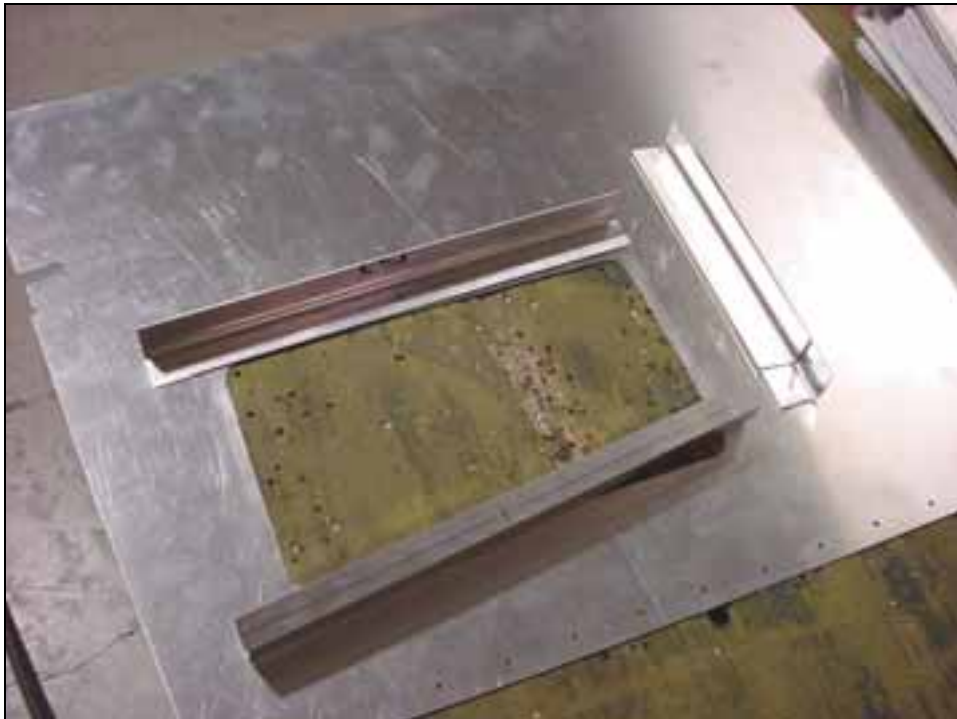


**A5 PITCH 30**  
6B15 -4 to 6B8-8

NOTE: The rivets in the bottom flange will be set from the bottom up.

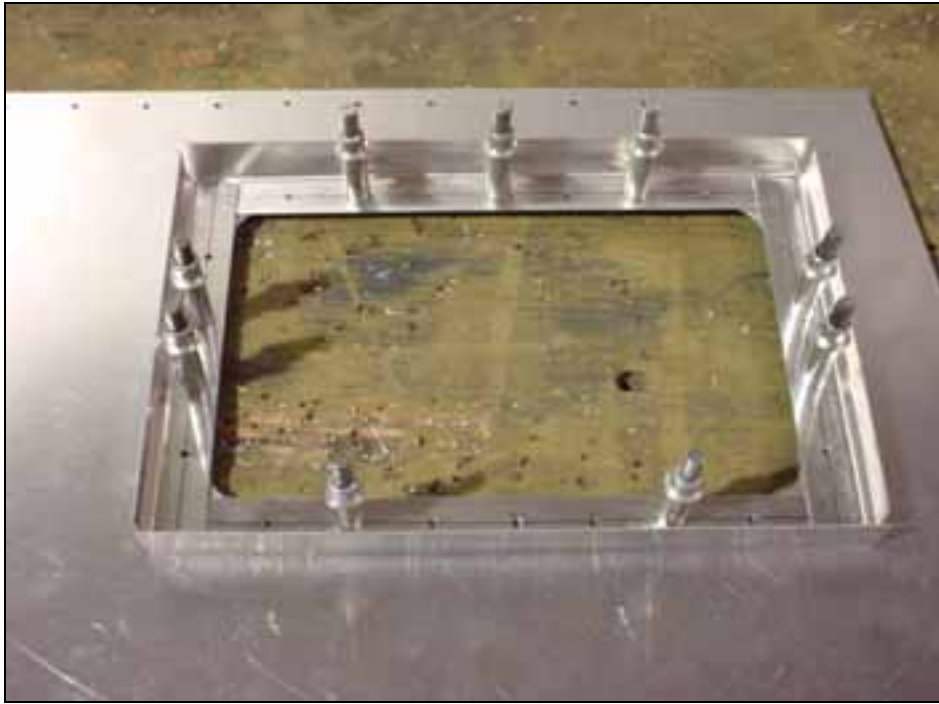
NO RIVET ZONE: Wait to drill the last holes on inboard end of the rivet line. Hole will be drill through the L angle, see section 6-B-18 page 8 Ref. drawing 6-B-18

Install the left and right seat panels.  
Drill the bottom flange to the top of the gear channel 6B8-8



Ref: 6-B-18  
Nutplates with A3 rivets  
MS21075-L3

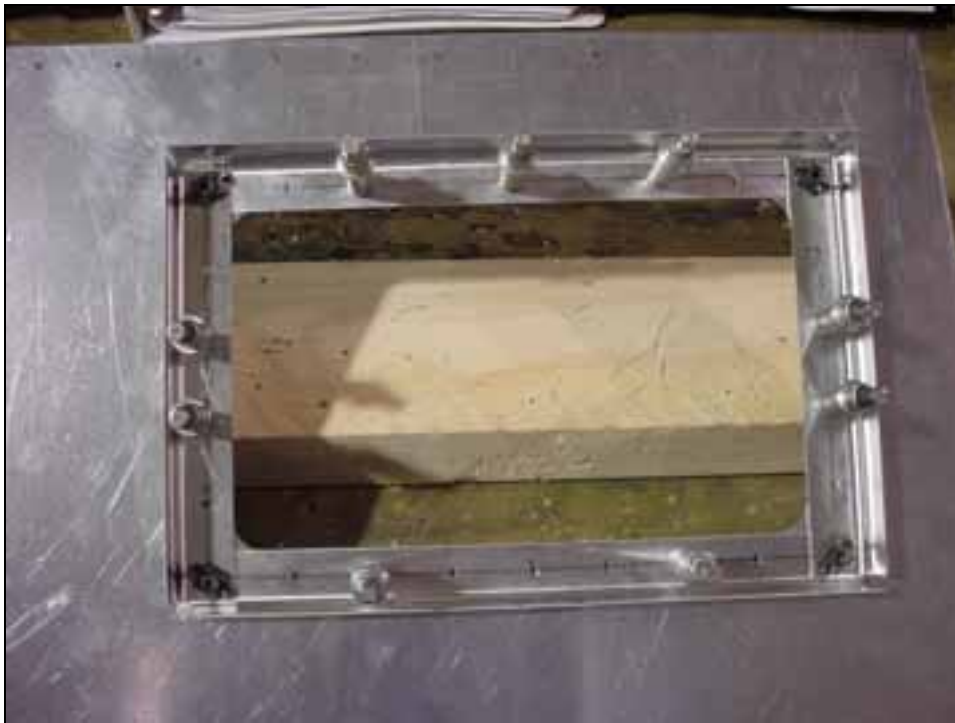
L angles around cutout



L Angles overlap in the corners.



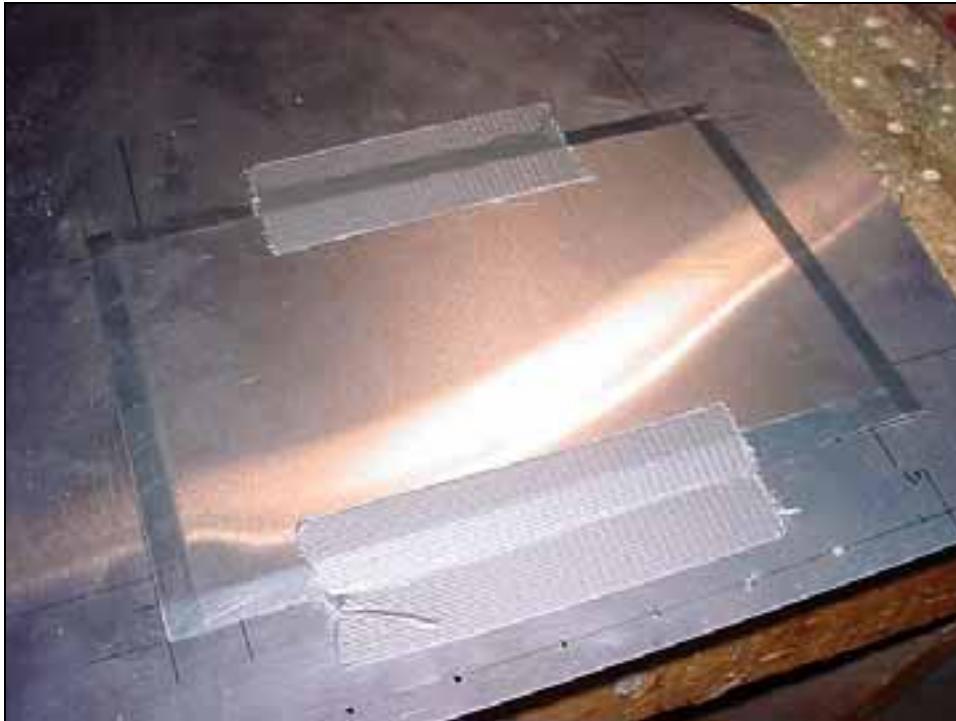
Before riveting the nutplate, drill the middle hole for the screw to  $\frac{1}{4}$ "



Nutplates in the 4 corners.

View of the underside.





**SPAR ACCESS COVER  
6B18-5**

Turn the seat over and drill  
the 4 corner hole.

Center the spar access cover 6B18-5 over the cutout. Hold in place with a couple of pieces of duct tape.



Note: The beveled edges of  
the cover plate cover up the  
rivets for the L angles.

Spar access cover 6B18-5