



**UPRIGHT CHANNELS
6B5-6**

Top and bottom outboard flange is joggle to overlap the .093" extrusion 6B2-3 and 6B11-1

Length: fits between the bottom and top longerons.



Clamp the upright channel to the rear frame channel.

Trace around the channel.
Also trace the inboard side of the channel on the plate 6B5-4.



Remove the channel.



Layout 2 rivet lines 10mm from the sides of the channel.
For now, leave the area for flap control bearing 6B19-5 as a no rivet zone.

Pre-drill with pilot holes.



Remove the attach Plate 6B5-4
Position the channel on top of the plate, trace along the outboard flange.



Re-install, back drill into the rear frame channel 6B5-2.



Re-clamp the upright channels 6B5-6 to the rear frame channel 6B5-2.
Back drill though into the upright channel 6B5-6.



Turn the template over to check the backside of the channel (first check that the top and bottom of the template is level).

Set the channel at 77.5-degree, use the rear channel plywood template.



Detail of left side.

COMMENT: Wait to drill the side skins into the Upright channel until after the top skin 6B21-7 is installed.

Clamp the top of the channel to the longeron.
LAYOUT: Trace the front and aft edge of the channel on the skin; for future reference (see page 10).



SEAT BACK SIDE CHANNEL 6B16-3

Cut the side flange to install the seat back side channel:

Top I/B flange: snip off the corner to fit inside the top flange of the Baggage Floor Support.

Top O/B flange: Corner cutout to make room for the Longeron 6B11-1

With a round rat-tail file, radius a corner relief hole in the corner of the cutout.



Clamp an extrusion or other straight edge on the rear seat panel 6B16-3 and the upper seat & baggage floor support 6B16-6



Detail of top end (overlaps behind top flange of floor support 6B16-6)



Bottom flanges: Corner cutout for the web to overlap the Seat Panel.



2 RIVETS A4
 6B15-1 to 6B16-3
 Ref: bottom left diagram
6-B-16

Drill the 2 top holes.

Detail of right side.
 Clamp the channel to the rear seat panel 6B5-1



Detail of left side.
 Wait to drill the bottom of the side channel 6B16-3 to the Seat panel. It will be easier to drill through the flap mount gusset 6B19-9



A4 PITCH 40
6B11-2 to 6B16-3

Drill & Cleco the side flange to the side skin.



A4 PITCH 40
6B11-2 to 6B16-3

Photo of left side.



Installation of baggage floor.

Looking at sloped rivet line in fuselage side skin 6B3-1 into corner L angle with the baggage floor 6B16-1



End of diagonal L angle even with aft edge of vertical L angle.

Sloped L ANGLE to support side of baggage floor 6B16-1



Clamp the L angle to the bottom flange of the floor support 6B16-6



Note the gap between the fuselage side skin and the L angle.



Crimp the L angle to close the gap.



Crimp the top flange of the L Angle to close the gap between the angle and the fuselage side skin.

Detail of front left end of L Angle



3 crimps
First crimp 60mm from the front, next two 40mm apart.

Photo of Hand Crimper (also see section 6-B-14 page 4)



**BAGGAGE FLOOR
6B16-1**

Lay a piece of extrusion across the fuselage to support the front edge of the baggage floor skin.



Clamp the aft edge of the baggage floor skin flush to the aft edge of the bulkhead flange.



From underneath, trace the along the edge of the fuselage skin.
Remove and trim.



Reposition the skin to fit inside the fuselage.



Front edge of the baggage skin is resting on the bottom flange of the floor support
6B16-6