

A4 PITCH 40
6B16-1 to L angles.

Layout the rivet lines for the 2 L angles on each side of the center seat back channel 6B16-2



Trim the overhang.

Clamp the L angles to the sides of the back channel.



1 RIVET A4
L angle to 6B16-2
(Left & right flange).

Drill and Cleco.



Front view.

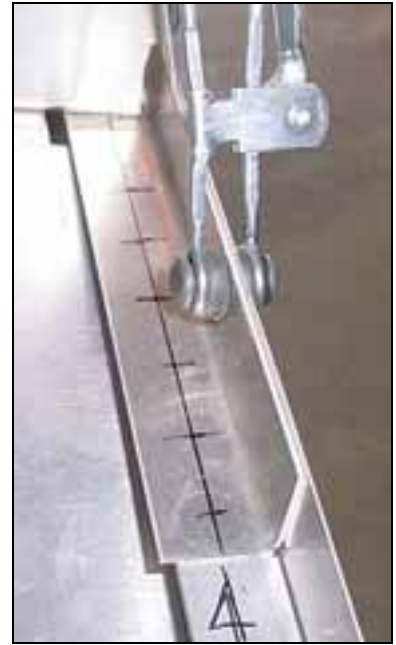
Drill the baggage floor to the L angles.



Layout the 8 rivets through the middle of the top flange of the extrusion 6B11-1. The last hole is through the bulkhead.

CHECK overlap = 150mm

TRIM: make a note to trim the end of the longeron 6B11-1 10mm from the last hole (even with the aft edge of the bottom flange of the bulkhead).



Longeron splice, Ref. top left diagram on drawing 6-B-14



Drill & cleco the longerons together. Wait to drill through the side flange until the top skins are installed.



Top view.



8 RIVETS A5
6B2-1 to 6B11-1

Left side.



Right side.



**UPPER FUSELAGE
LONGERON DOUBLER
6B16-4**

Width = 35mm

ORIENTATION: Short flange is inboard.



Ref Bottom left diagram on
drawing 6-B-16

Layout and cut off 55mm off the short flange.
ORIENTATION: Cut-off is towards the rear.

Note: Left and Rights required.



Trim parallel to the front flange of the baggage floor support 6B16-1.



Aft overlap on top of gusset 6B15-1



Position the front I/B flange of the doubler against the longeron, then adjust the doubler to bring the outer edge flush with the side of the fuselage and clamp in place.



Trim back side flange to the same angle as the upper seat & baggage floor support 6B16-6



Photo of right side, looking forward (Gusset 6B15-1 is at the bottom).

Note: Lengthwise: the doubler overlaps the gusset for 2 rivets A5.
 Widthwise: measured from the edge of the fuselage along the front of the gusset, the doubler overlaps on 20mm. If necessary make the cutout deeper to make room for the gusset 6B21-8.



Front end, overlaps underneath panel gusset 6B12-5



At the instrument panel, the **Panel Gusset 6B12-5** overlaps on top of the doubler **3 RIVETS A5**

Photo of right side.



Mark the overhang.



Cut-line.



Detail of aft end.

Trim.



Locate the no rivet zone for the striker stud 6C2-1



A4 PITCH 40
6B16-4 to 6B11-1

Drill and cleco.



See section 6-B-21B page 9.



Detail of left side (rear) gusset 6B15-1



Detail of panel gusset 6B12-5 (front)



Doubler extends underneath instrument panel



Left side: viewed from rear.



Left side: view from front.