Overlaps on top of the rear seat panel 6B5-1

Remove the center seat back channel 6B16-2 to install the bearing support 6B17-1.

Clamp.
Layout the rivet line.

Drill and cleco.
Layout the rivet line and pre-drill with pilot holes. Wait to drill the bottom flange until after the torque tube is installed, see page 9.

Bottom flange rests on bottom skin 6B1-4. Wait to drill in bottom skin, see page 9.
Center of the hole is located 20mm from the edge of the part (20mm square to the sides).

Clamp the rear torque tube bearing 6B17-3 to the back side of the bearing support.

155mm from the bottom flange to center of 1-1/8” hole (Revision July 2005).
Cleco the bearing support assembly to the fuselage.

Locate the center.
1-1/8" flat face drill bit.

In a drill press, drill the 1-1/8" hole in the center of the Bearing.
Trim the sides.

Insert the Torque tube through the Rear Bearing 6B17-3.
Level the top of the torque tube.

CHECK: Approximately 4mm clearance between the front lightening hole on the center spar section and the top of the torque tube.

The forward torque tube bearings fits in between the upright extrusions on the center spar section.

Clamp the sides of the forward bearing to the center spar uprights 6W4-4
The bearing is square to the torque tube.

Rear view looking forwards.
Drill and cleco the bottom flange of the rear torque tube bearing support 6B17-1 to the bottom skin 6B1-4
Drill and Cleco, first with pilot holes than with 3/16" holes.

Stop ring is flush to the front end of the torque tube. Back drill the hole.

STOP RING 6B17-5
Use a V block in a drill press to drill the 3/16" hole.
Bolt the bearing to the spar.

Add the stainless still shim.

Ref. right middle diagram on drawing 6-B-17
Insert the ¼" OD x .028" wall 4130N tube inside the welded 3/8" tube on the torque tube 6B17-4.

Center stick 6B17-2.