



Clamp a piece of extrusion along the center seat back channel 6B16-2 , this will set the front location of the rear tube 65C3-1



Let rear canopy tube **65C3-1** overlap the fuselage side skins.



Position the roll bar **65C3-10** underneath rear tube.



Top of roll bar against extrusions.



Center the rear tube over the center of the roll bar.





The welded plate rest along the I/B side of the fuselage side skins. Find the best fit - if necessary use some force to stretch the welded assembly so that it fits relaxed against the sides of the fuselage.



Check for equal distance between the left and right side to the front of the baggage floor.

Drill out any rivets that fall under the mounting plate.

Plan to bolt the roll bar using any existing pre-drilled holes. Adjust the position of the roll bar for proper edge distance. Mark the holes in the plate – remove the assembly and pre-drill the holes in the steel plate.

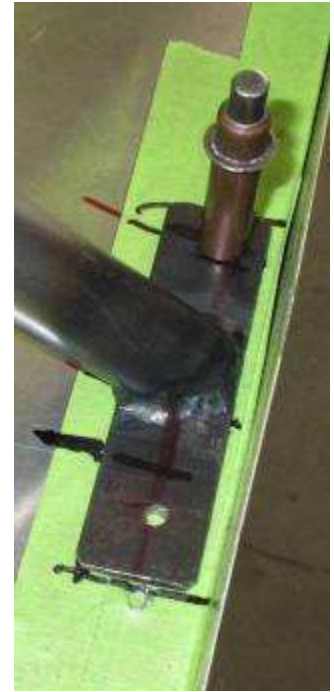


Pre-drill the 4 holes at the top. See top middle diagram on drawing 65-C-6





Reassemble and cleco the base of the roll bar to the fuselage.



IMPRTANT: The width across the ends of the tube is the same as the fuselage.



Mark the tubes flush with the top of the fuselage..



Tape the tube to the roll bar (wait to drill the tube until after the front canopy is installed).



Cut the ends to sit on top of the fuselage.



Mark the front end of the gusset and the front edge of the tube.



Leave a gap of approximately 5mm between the end of the side frame and the gusset

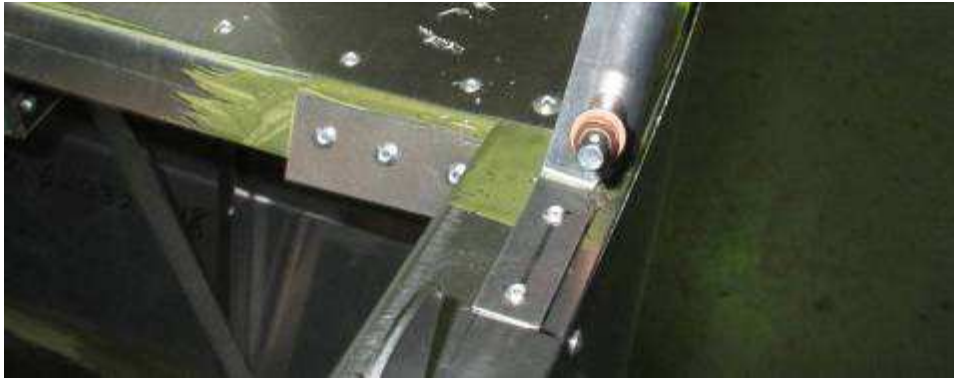


Hold a piece of 3/4" extrusion flush with the outside edge of the fuselage side skin and trace along the I/B edge – the line represents the edge of the longeron underneath the doubler 6B16-4



Rear canopy gusset
65C3-7

**Mark the rivet line
and pre-drill 3 holes.**



Line up the gusset with the mark and drill the front hole.
Rivet the gusset to the longeron.



Allow for a 1/8" gap
between the side of the
gusset and the outside
edge



Bend the gusset around the tube,
Center the hole to be in the middle of the longeron.



Wait to drill the gusset to
the tube. Wrap some
tape around the tube and
gusset to temporarily
hold them in place