RECOMMEND: Lower fuselage off the workbench for easier reach and access inside.

Cleco the rear fuselage and cabin floor to the gear channel 6B5-5.

Make a suitable support out of saw horses approx. 580mm off the floor. Allow for a flat LEVEL surface (beams) from the firewall to the front edge of the fuselage side skin 6B3-1.

Rear fuselage support.

CHECK: The gear channel 6B5-5 must be level.

CHECK: Bottom skin is level span wise

Bottom skin support.
Place a 19mm furring strip between the level beams and the bottom fuselage in line with the front corner of the side skin.

Adjust the height of the rear fuselage to level the top edge of the side skins.
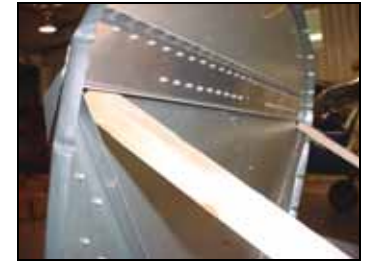
CHECK: The rear fuselage is level.

Clamp the side skin to the firewall flange to temporally hold the firewall.

Cleco the firewall to the front of the cabin floor.

Raise the front edge of the cabin floor **42 mm** off the level beams.

CHECK: Angle of the firewall is at 77 degrees.

Top fits underneath the reinforcement channel 6B7-2.

Firewall support.
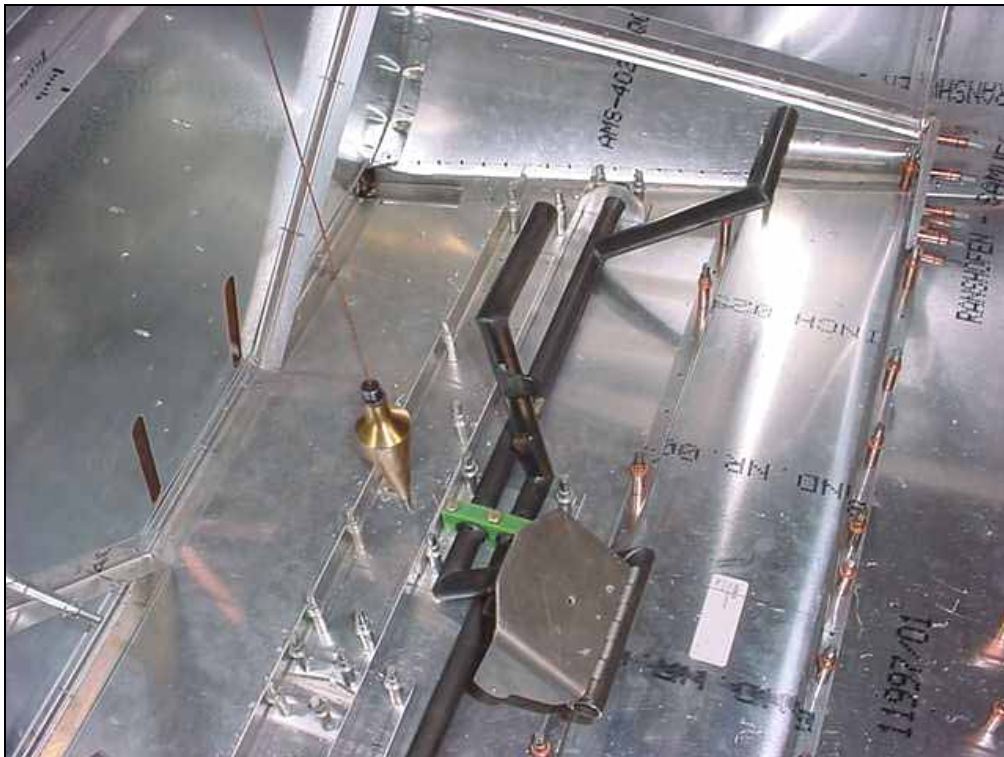Furring strip (1x2 board) approximately 780 mm long, 2 required.

Bottom detail.
Support in corner of spar with cabin floor.

Firewall support.

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CHECK: With a plumb bob, the centerline at the top of the firewall is in line with the aircraft centerline on the cabin floor skin.

REMINDER: Re-check the alignment of centerline before riveting the side skins to the firewall.

Plumb bob.

Ref. 6-B-7

5/16" holes in firewall for upper engine mount fittings.

UPPER ENGINE MOUNT FITTING 6B5-4
Qty: 1L + 1R

Insert washers on the bolt and tighten nut. Ref. bottom right diagram on drawing 6-B-7.

CHECK: The outboard edge of the upper engine mount fitting does not sit in the bend radius of the firewall flange. If necessary file the side of the fitting.

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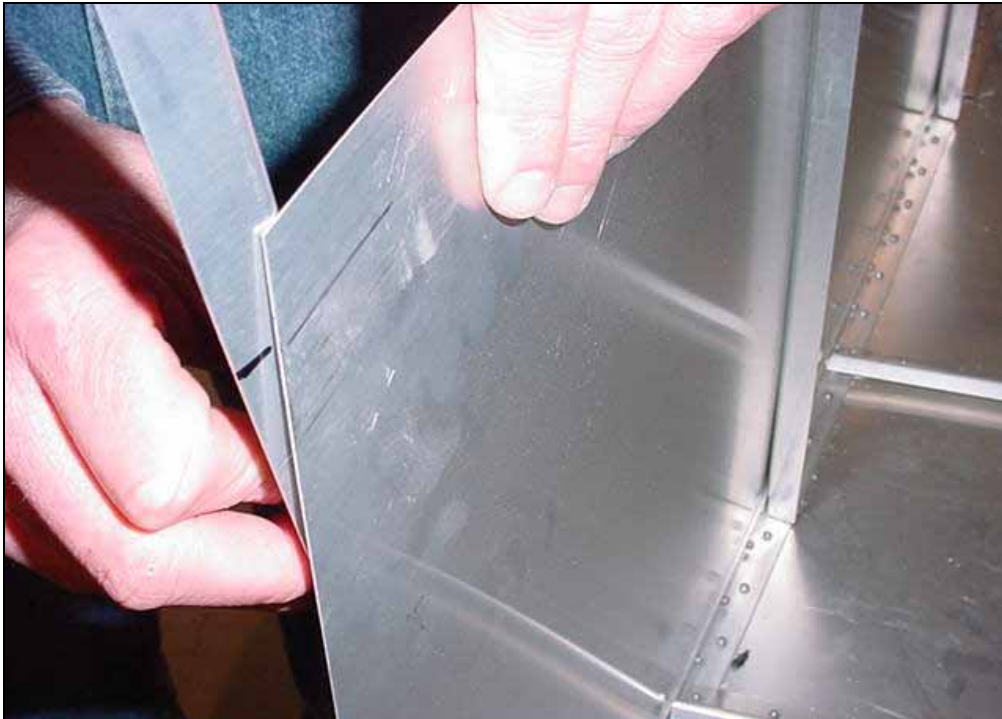**6-B-11B - Page 6 of 12**

If necessary, re-adjust the clamp on the side flange of the cabin floor and the firewall support 1x2 furring strips.

Check: The level on top of the 13 degree firewall template is level.

CHECK: Hold the side of the template square to the firewall.

NOTE: The front edge of the template is vertical (check with level or plumb bob).

Before installing the Longerons 6B11-1, check that the upper engine mount fittings, 6B6-4, are level with the rear fuselage reference line.

REFERENCE LINE: Mark a line 22mm down from the corner of the fuselage side skin 6B3-1 (left and right sides). These are the reference lines to level the fuselage. Ref middle diagram on drawing 6-B-14

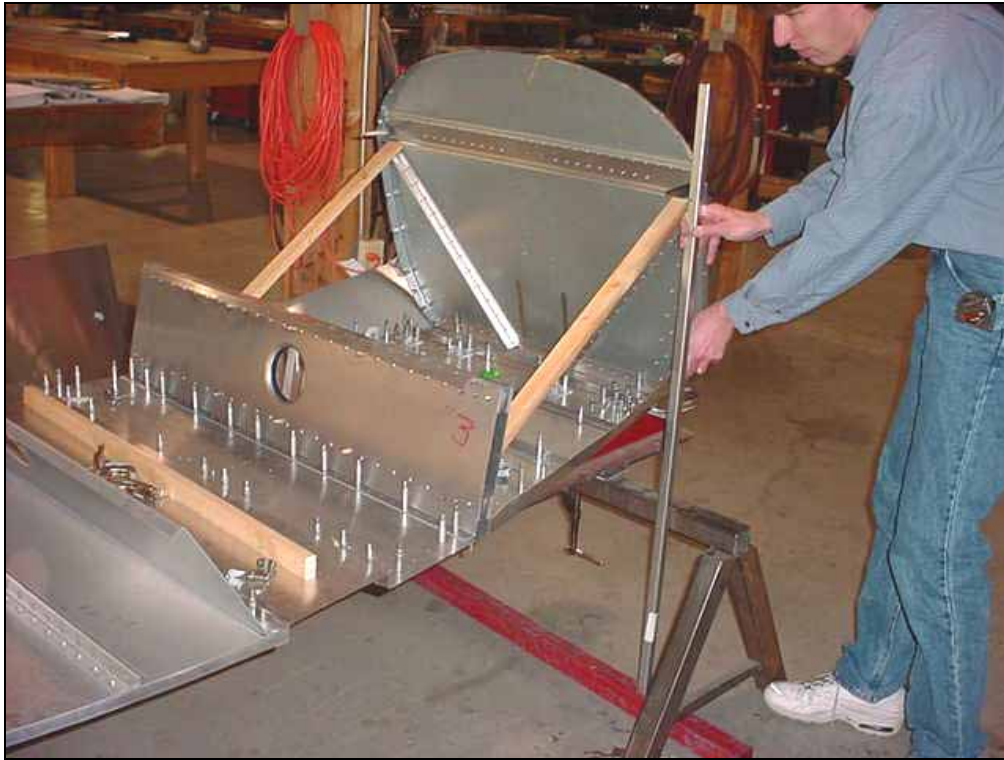Hold an "L" angle (or yard stick) on the floor, mark the reference line on the L angle.

If the floor is not level, lay a beam on the floor, level between beam.

Bring the "L" angle to the other side, the mark on the "L" angle should line up with the 22mm reference line.

Front edge of side skin.

Detail of right side.

If necessary adjust the height of the firewall by adding or removing spacer from under the firewall.

Bring the L angle to the firewall, the underside of the engine mount fitting 6F6-4 should be in line with the 22mm reference line on 6B3-1.

Detail of left side.

Keep using the "L" angle as a yard stick to check the height of the left upper engine mount fitting.

Note: Push in the sides of the cabin floor skin to bring the "L" angle close to the fuselage.

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Detail of the spacers underneath the front edge of the cabin floor.

Re-check the angle of the firewall, and plumb line.

Use firewall supports to keep the firewall parallel to the spar (top view).

Check that the firewall is parallel to the spar and that the firewall is not twisted.

When top edge of the side skin 6B3-1is level, the top aft corner of the side skin 6B3-1 should line up with the mark on the L angle.

Mark the height of the front top corner of the side skin 6B3-1 on the "L" or yard stick. Walk the "L" angle to the end of the fuselage.

The bottom skin 6B1-1 is level span wise.

Before installing the Longerons, 6B11-1, check that the upper engine mount fittings are level.

Detail of right side.

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