



Trace the upright channels 6B5-6 on the baggage floor 6B16-1



Transfer the marks from the side skin to the bottom skin.
Ref page 4 of 12 bottom photo section 6-B-16A



Detail of right side.



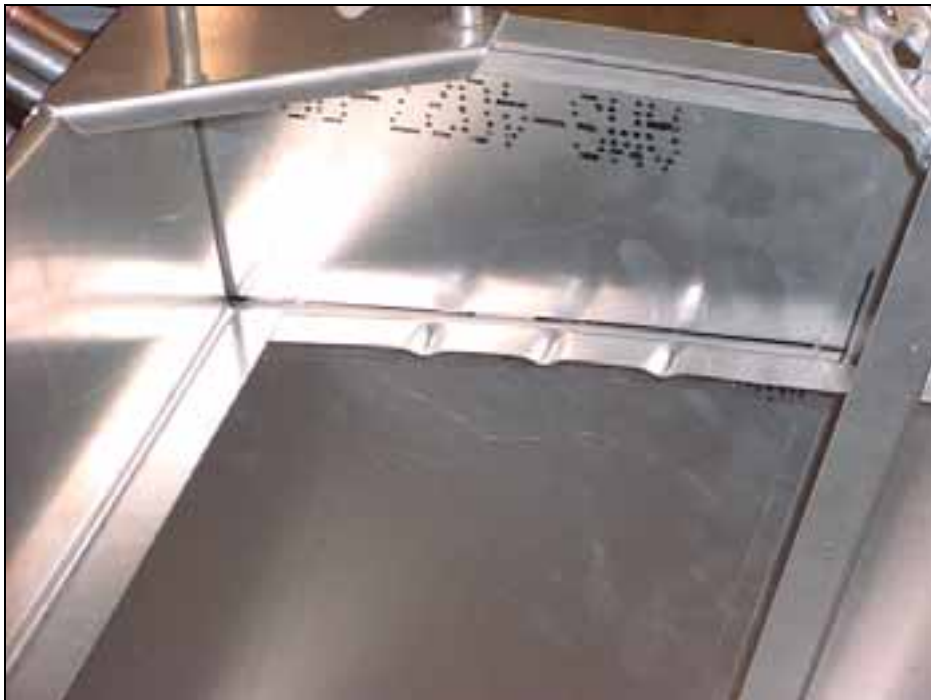
Remove the skin to make the cutouts.



A4 PITCH 100

NOTE: The end holes will intersect the L angle on the fuselage side skins.

Layout the 2 L angles. The bend is towards the front.
Ref. bottom middle diagram on 6-B-16
Drill and Cleco to the L angles, then trim the L angle approximately 3mm shorter than the edge of the baggage skin (to make room for the radius of the L angles on the fuselage).



The L angle is cut to make room for the 6B16-3

Mark the web (aft portion) of the upright on the L angle, remove the angle and cut the L angle in 2 at the mark.
Note: the front portion of the L angle will overlap the side flange of the upright channel 6B5-6



Drill and cleco the L angle to the side skin.

Rear view.
Re-install the vertical L angles on the side skin, flanges overlap.



**UPPER CHANNEL
6B5-3**

Rear view
Clamp the top flange of the channel to the L angle.



Front view.
With a marker, trace along the I/B side of the upright channel 6B5-6 to make the upper channel 6B5-3



Remove the upper channel 6B5-3 to layout the 4 holes. Pre-drill with #40 pilot holes.

4 RIVETS A5
6B5-3 to 6B5-6



Cleco left and right side: channel 6B5-3 to upright channels 6B5-6

Mark the rivet line on the top flange of the upper channel 6B5-3, extend the rivet line across the top flange of the L angles (left and right), transfer the rivet line to the side skin (to mark the rivet line on the baggage floor).



Clamp. Back drill & Cleco





CHECK: The cutout for the uprights is big enough.

Re-install the baggage floor skin 6B16-1 on the fuselage.



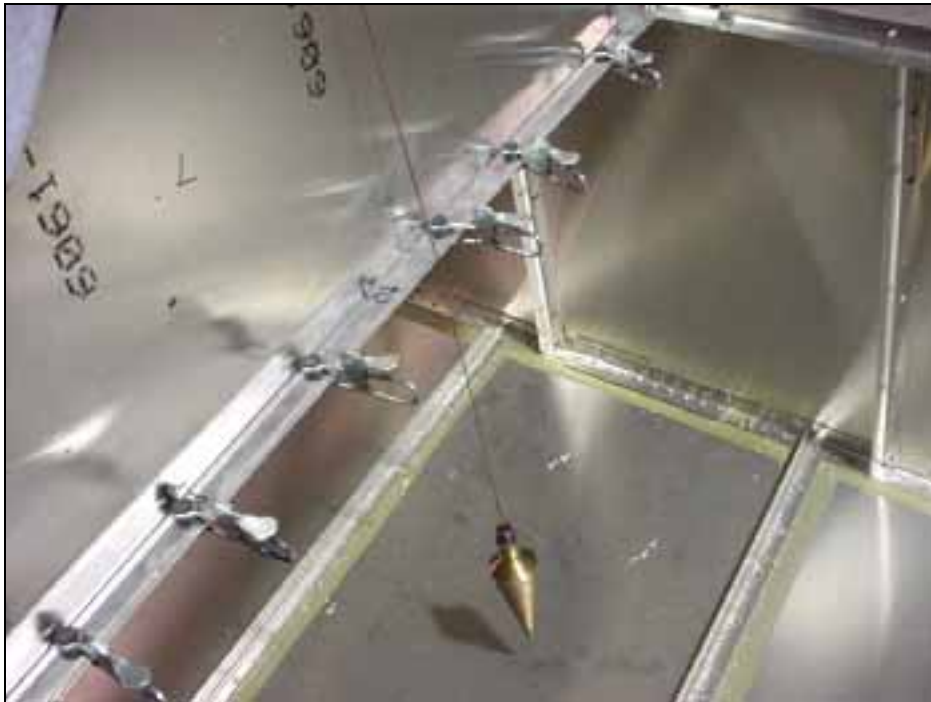
Ref. Clamp the aft edge of the skin flush with the aft flange of the bulkhead.

Use the reference line on the side skin to make the rivet line for the 6B5-3



Mark the location of the Upper Channel 6B5-2 on the Floor Skin.

Line up the center line of the baggage floor with the aircraft center line on the upper seat & baggage floor support 6B16-6



The fuselage is symmetrical about the aircraft center line.

CHECK: Use a plumb bob to check that the Bulkhead centerline is over the aircraft centerline on the bottom skin.

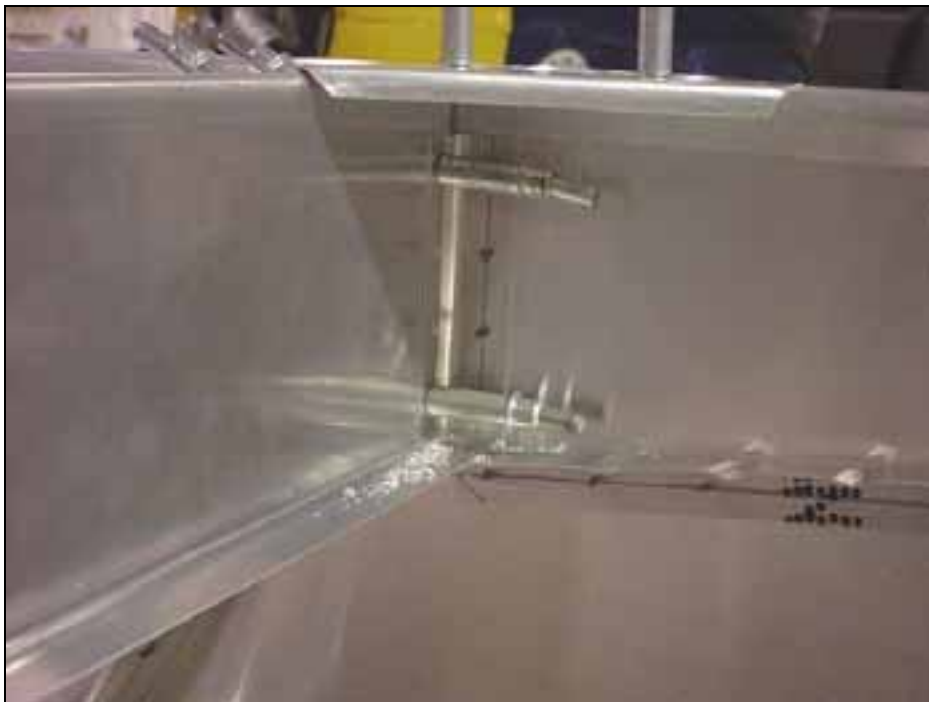
Plumb bob.



CHECK: Plumb line center lines.

A4 PITCH 40
6B16-1 to 6B5-3

Reposition the baggage floor, reach underneath and re-cleco the 2 L angles. Layout and drill the rivet line through the upper channel 6B5-3

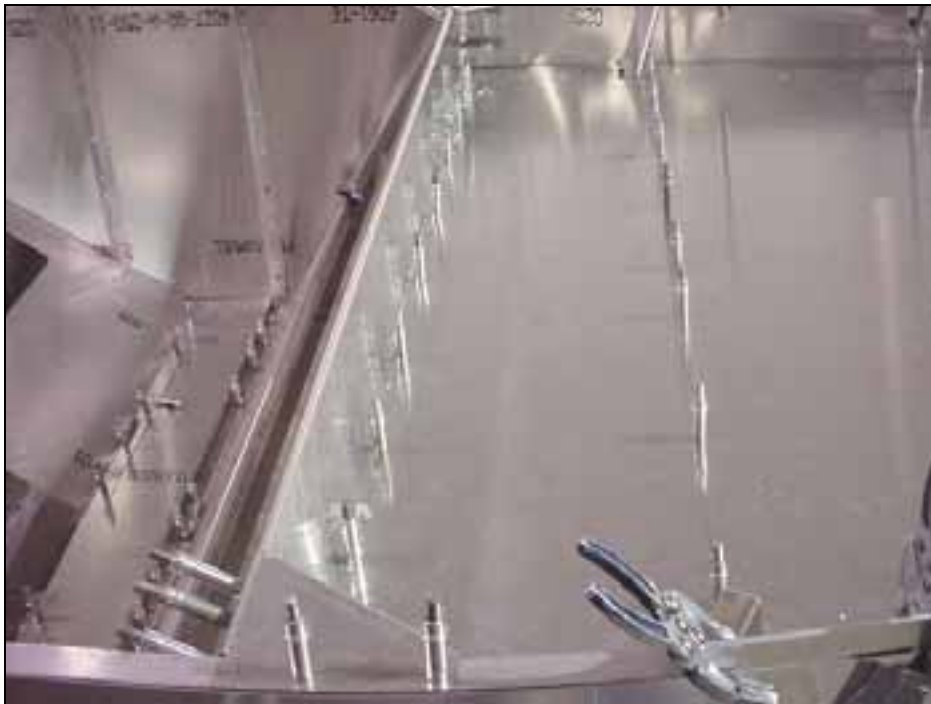


4 RIVETS A4
In each flange
L Angle to 6B5-2
L Angle to 6B3-1

Drill & cleco vertical L angle.



Detail of rivets lines on demo aircraft.



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

Plan for a no rivet zone for the L angles on each side of the center seat back channel 6B16-2. See section 6-B-16C page 1 and 2
Ref. top left diagram on drawing 6-B-16 baggage floor 6B16-1



**SEAT BACK ANGLE
6B16-5**

TRIM the flange of the Angle 6B16-5 to make room for the flanged lightening hole.

Clamp the seat back angle 6B16-5 to the back side of the top flange of the seat panel 6B5-1.



Plan for a no **rivet zone** for center seat back channel 6B16-2 and for the rear torque tube bearing support 6B17-1.

Also plan for a no rivet zone at the left and right end. Right end, no rivet zone for 3 RIVETS A5 for 6B16-3. Left side for the flap mount gusset 6B19-9. See setction 6-B-18 page 7

A5 PITCH 30
6B16-5 to 6B5-1
Two rivet lines, one in each flange.



No rivet zone for the rear torque tube bearing support 6B17-1



Layout the rivet line with 10mm edge distance up from the bottom edge of the Aangle 6B16-5 on the backside.



**CENTER SEAT BACK
CHANNEL
6B16-2**

Trim off the top corner of the side flange to overlap the front flange of the baggage floor support 6B16-6.



Trim the side flanges at the bottom for the web to overlap the seat panel.



Trim the web of the channel to expose the flange lightening hole.



11 RIVETS A5

Layout the rivets.



Drill and Cleco.