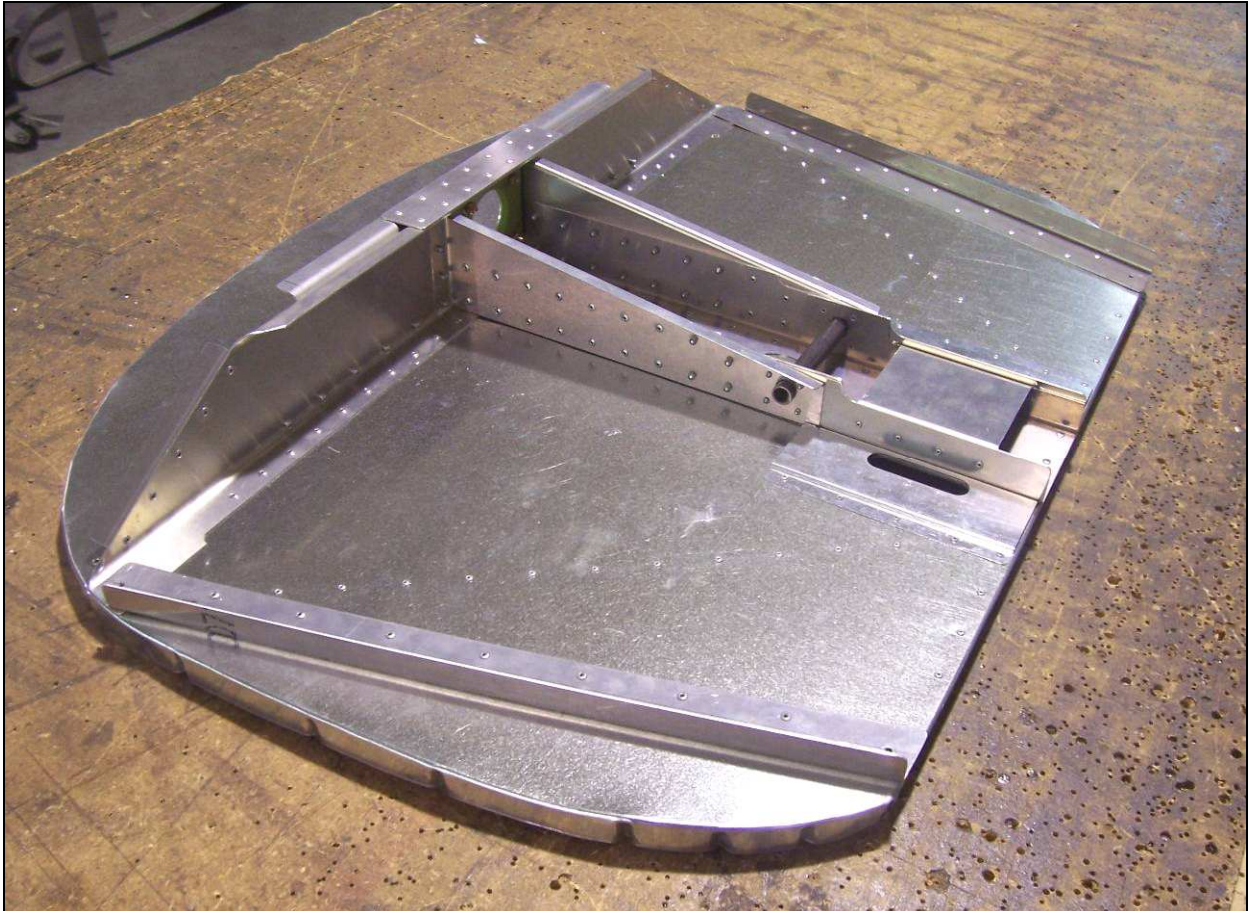


Section C75-FA-5 Firewall Assembly



This manual has been prepared for assembly of the firewall supplied with match drilled parts. This photo assembly manual is intended as a supplement to the drawings. If there is any discrepancy between this manual and the drawings, the drawings supersede this manual. For more information on building standards and allowable tolerances see "Construction Standards for Zenair Light Aircraft" available from Zenith Aircraft Co.



P/N: C75F8-1
Firewall

P/N: C75F8-2
Firewall Bottom
Stiffener

Deburr and corrosion proof all Firewall Part before assembly of the Firewall.



Cleco the Firewall Bottom Stiffener to the bottom flange of the Firewall. The 22mm flange belongs on the bottom flange of the Firewall.



P/N: C75F8-4
Firewall Top Stiffener

Cleco the Firewall Top Stiffener to the Firewall with 5/32 Cleco.



Cut a piece of L angle 520mm long. Position the L angle on top of the Top Firewall Stiffener. Position the L angle so there is 10mm edge distance for the holes at each end of the L angle on the Firewall Top Stiffener. With a #40 drill bit, back drill through the Firewall Top Stiffener into the L angle and Cleco. Expand the holes with a #20 drill bit and Cleco.

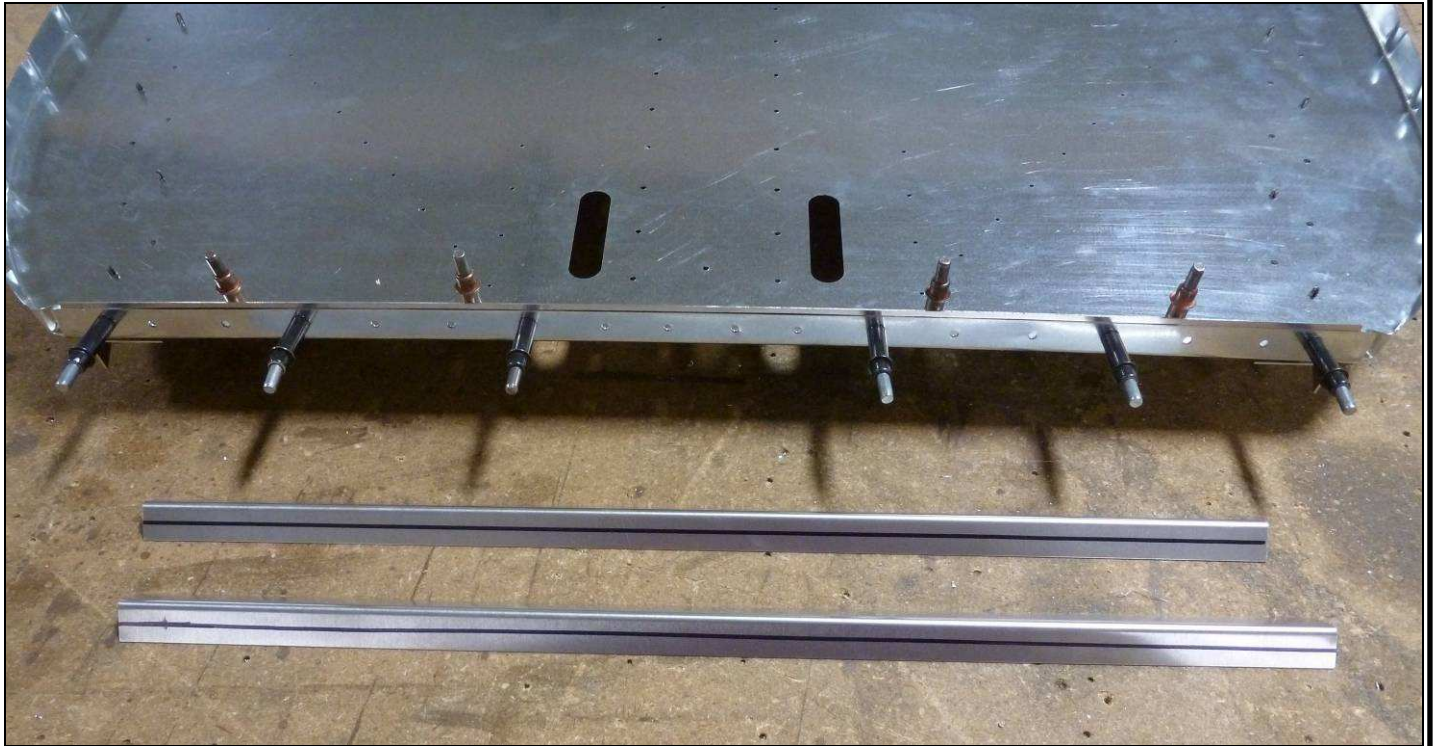


Flip the Firewall over to drill the other flange of the L angle. With a #40 drill bit, back drill through the Firewall into the L angle and Cleco. Then expand the holes to #20 in the firewall thru to the L angle.



P/N: C75F8-3
 Firewall Side
 Stiffener

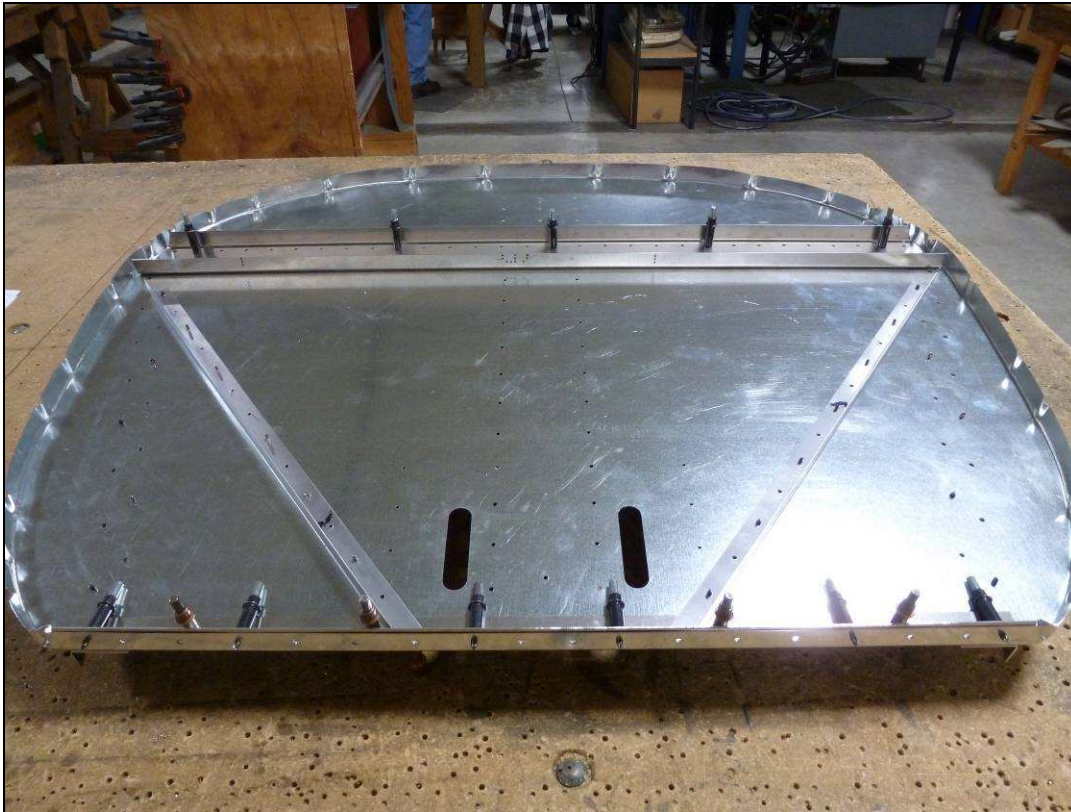
Cleco the Firewall Side Stiffener on each side of the Firewall using 5/32 clecos.



Cut a piece of L angle 543mm long and draw a center line down one flange. On the unmarked flange, measure up 15mm and place a mark.



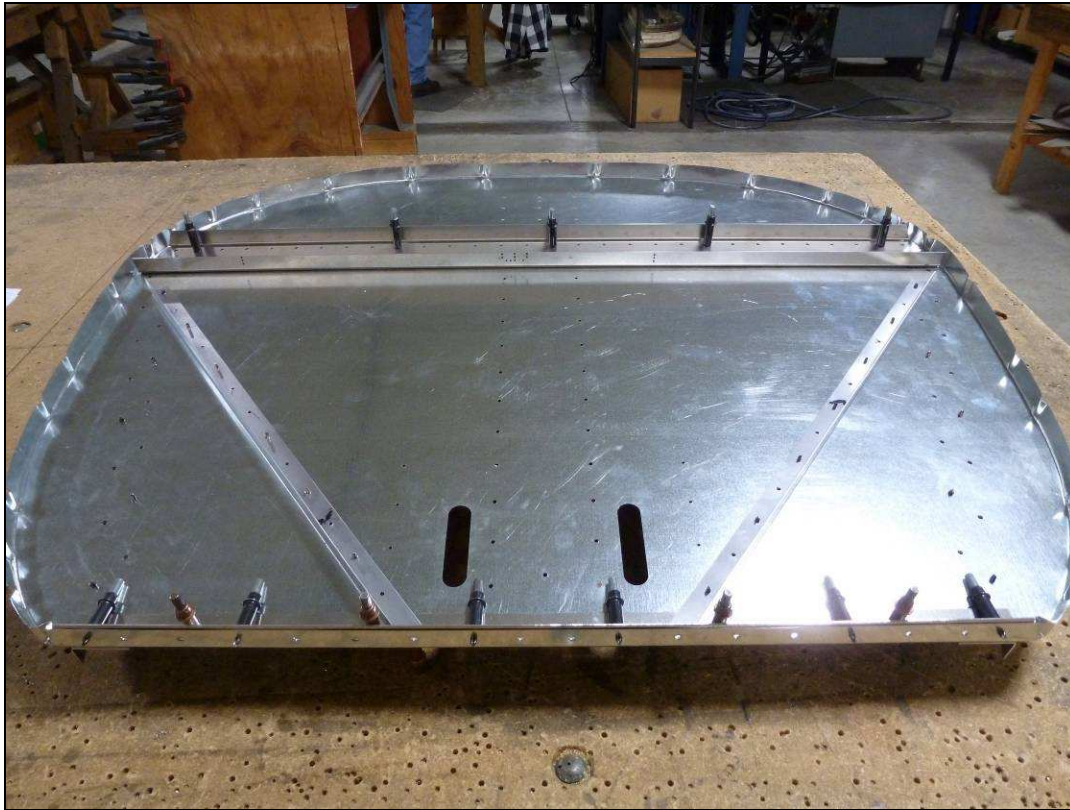
Trim the L angle along the mark so the L angle clears the bottom of the Firewall.



Position the L angles on the aft side of the Firewall. When the center line is visible through the predrilled holes in the Firewall, clamp the L angle to the Firewall. With a #40 drill bit, back drill through the Firewall into the L angle and Cleco. With a #30 drill bit, expand the holes and Cleco.



With a #30 drill bit, back drill the remaining holes through the Firewall into the Firewall Side Stiffener and Cleco. With a #20 drill bit, expand the holes and Cleco.

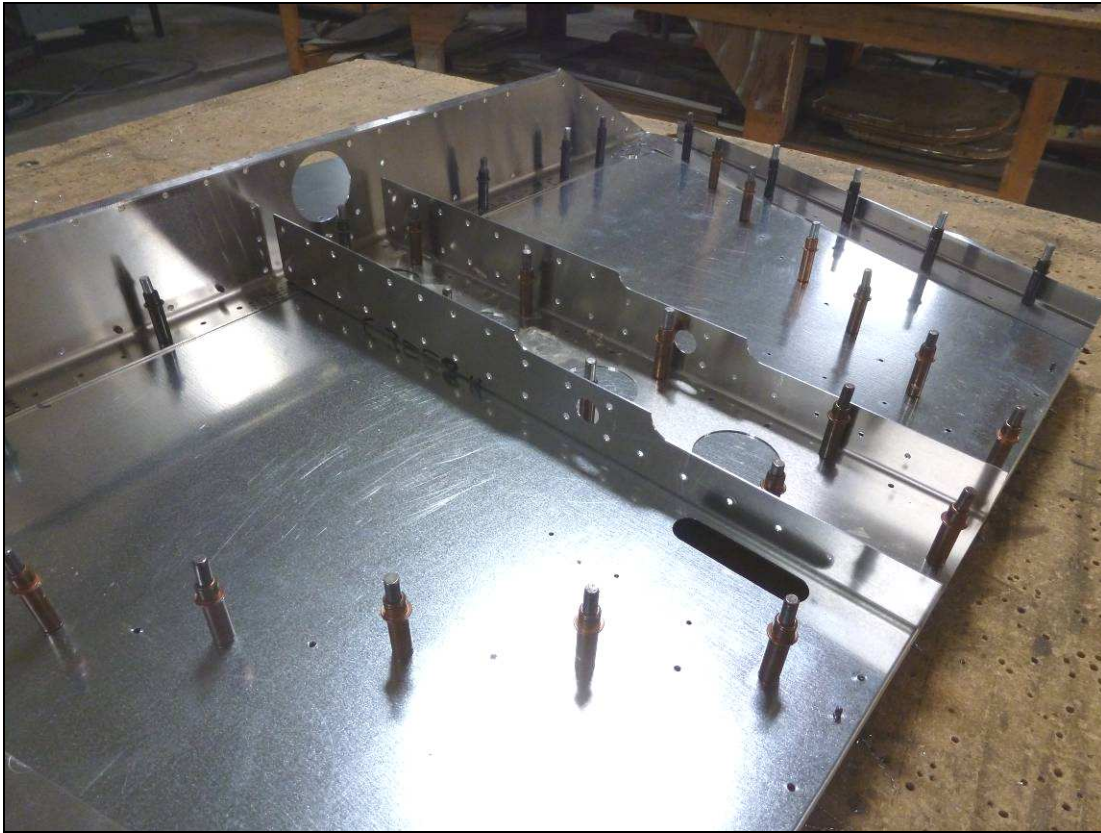


P/N: C75F8-5
Firewall Rear
Reinforcement

Cleco the Firewall Rear Reinforcement to the Firewall using 5/32 clecos.



The rivets are common for the Firewall Top Stiffener and the L angle attached to it.

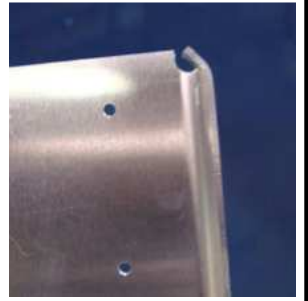
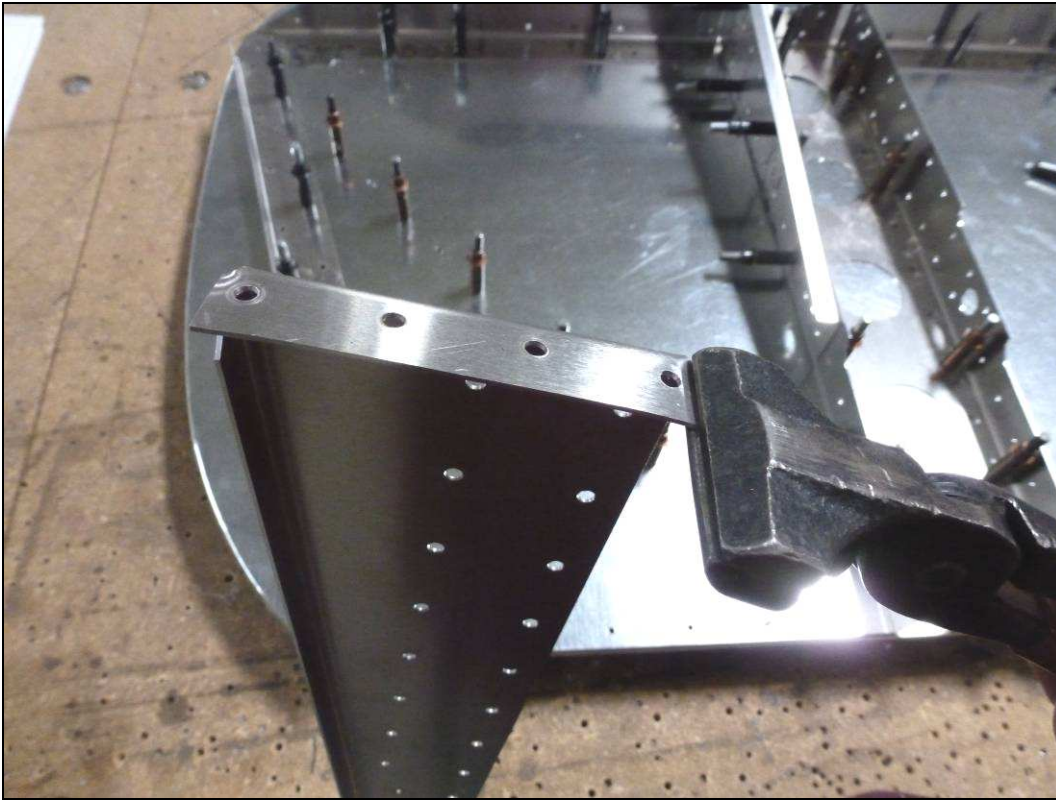


P/N: C75F9-4
Center Firewall
Stiffener

Cleco the Center Firewall Stiffner to the Firewall with 1/8 clecos.



P/N: C75F9-3
Gear Gusset



Slightly bend **BOTH** ends of the top flange. This is so the flange of the Gear Gusset will set in the radius of the Top Firewall Stiffener.



Cleco the Gear Gusset to the Top Stiffener with 5/32 clecos.



P/N: C75F9-1
Forward Gusset

Cleco the Forward Gusset to the Top Stiffener.



P/N: C75F9-2
Upper Angle

The Upper Angle has a circle hole cut in the middle. This is positioned on the Firewall Top Stiffener at the location of the Nose Gear Leg hole. Cleco the Upper Angle to the Firewall Top Stiffener.



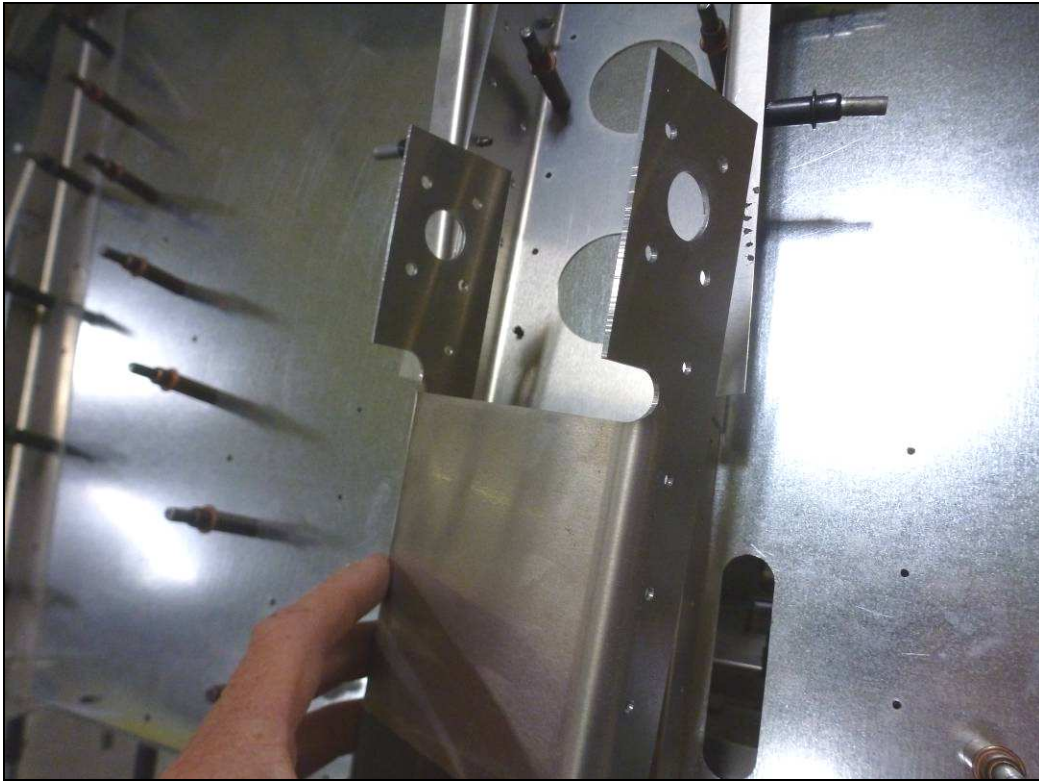
P/N: C75F9-6
Upper Bearing

Cleco the Upper Bearing to the Top Stiffener using 3/16 clecos. It will be bolted together using AN3-6A Bolts.



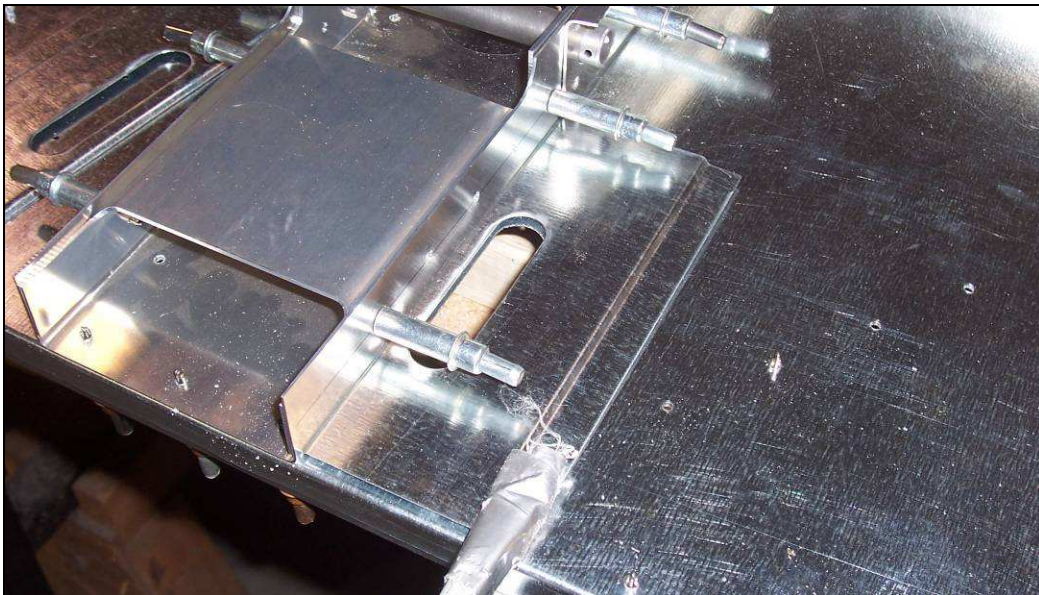
P/N: C75F8-6
Side Brace

Cleco the Side Braces to the Firewall Top Stiffener.



P/N: C75F9-5
Center Firewall
Doubler

Position the Center Firewall Doubler inside the Center Firewall Stiffener and cleco the Center Firewall Doubler using 1/8" clecos.

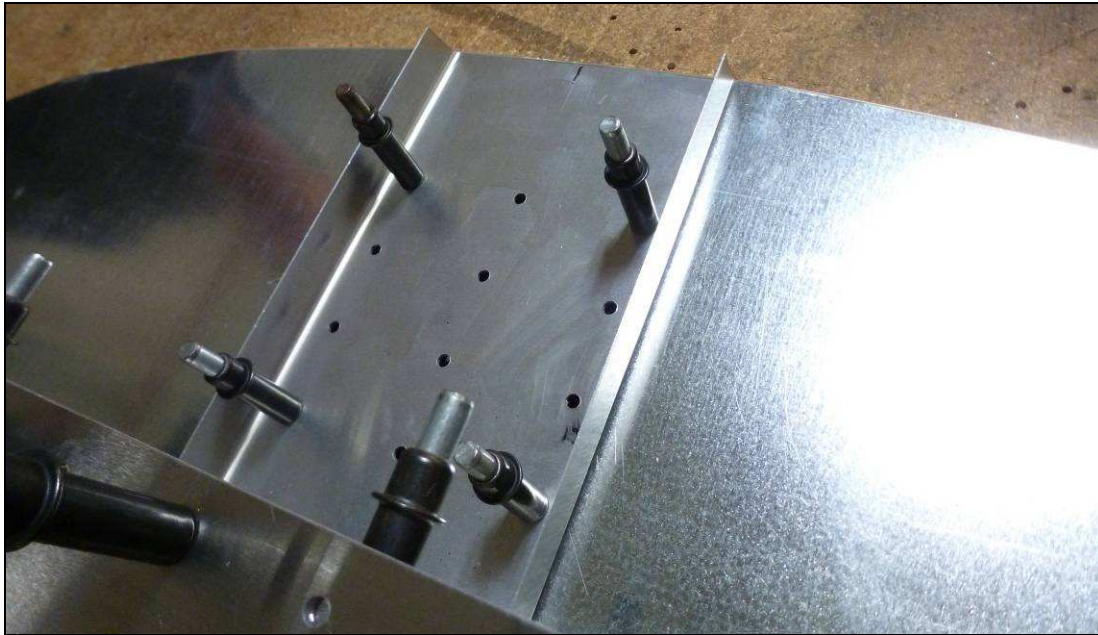


P/N: C75F8-8
Slide Cover

Position the Slide Cover on the Firewall against the Center Firewall Stiffener and clamp the Slide Cover to the Firewall.

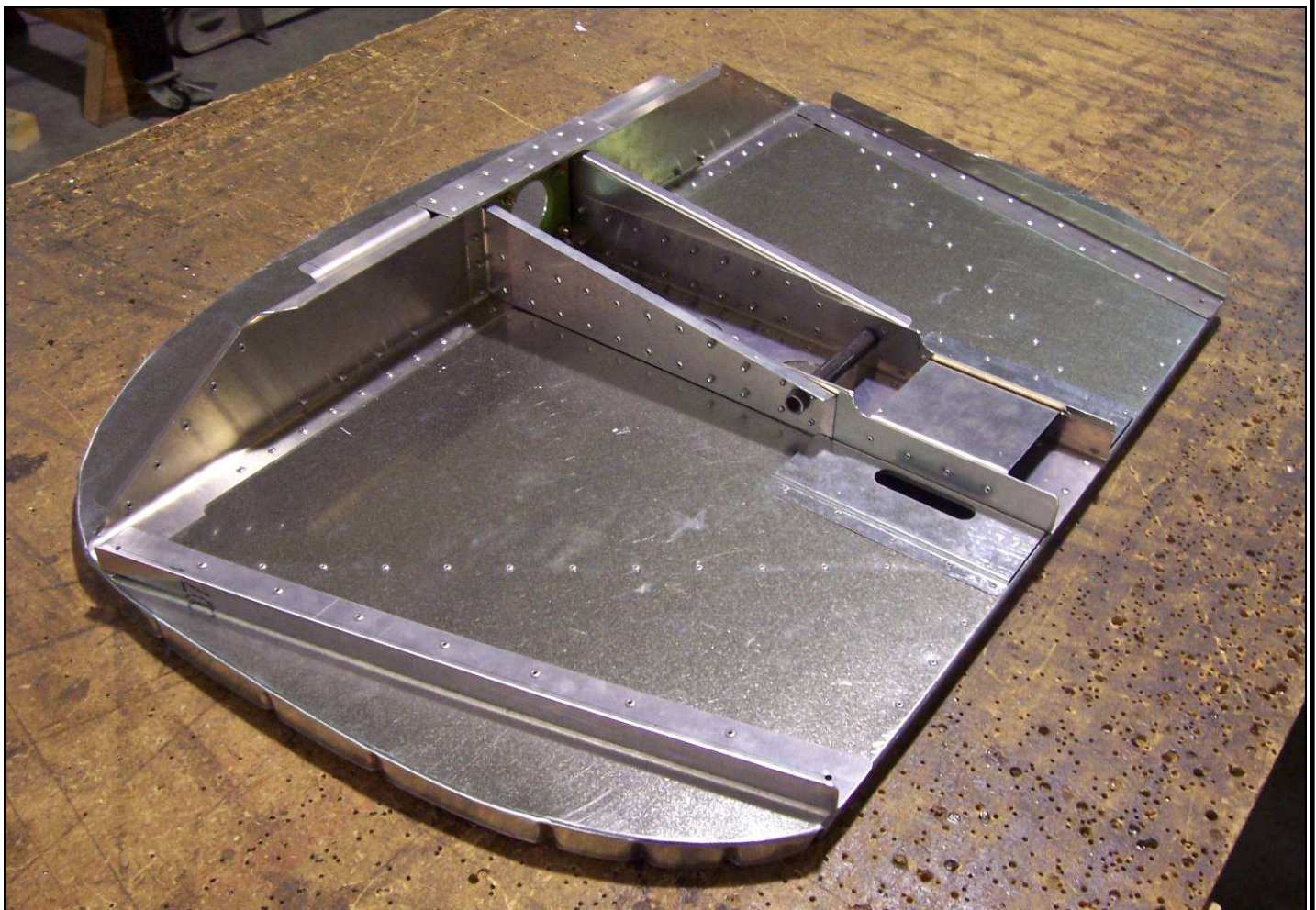
Check: Be sure there is adequate edge distance for the holes in the Slide Cover before drilling.

With a #40 drill bit, back drill through the holes in the Firewall into the Slide Cover and Cleco. With a #30 drill bit, expand the holes and Cleco.



P/N: C75F9-7
Upper Firewall
Channel

Cleco the Upper Firewall Channel to the Firewall.



Disassemble the Firewall, deburr the parts, reassemble, and rivet the Firewall together.