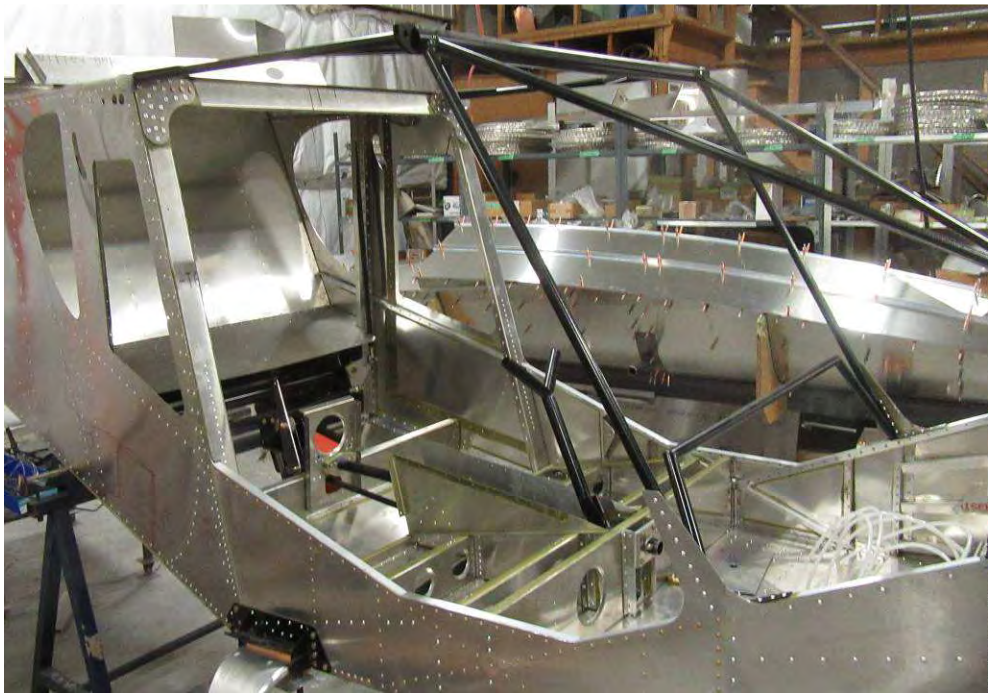
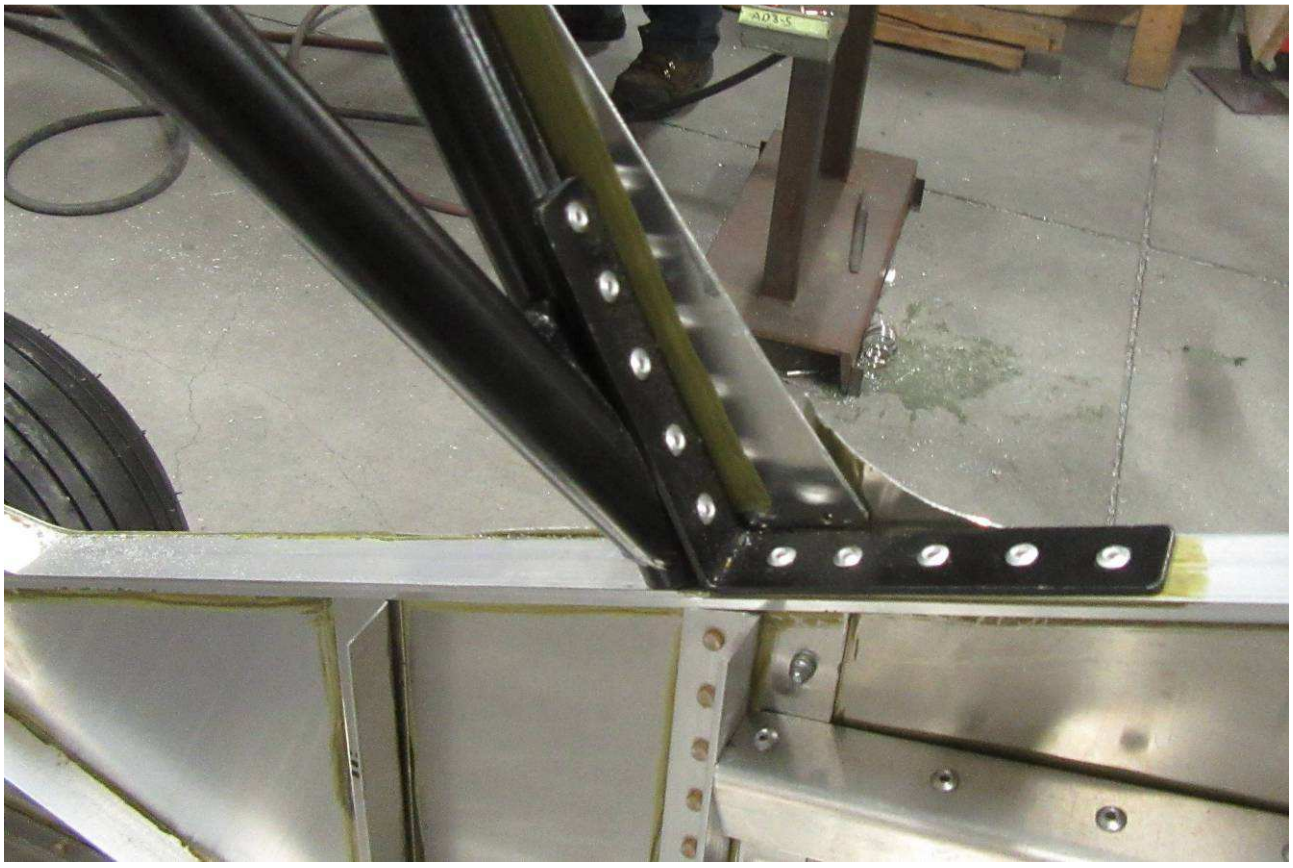


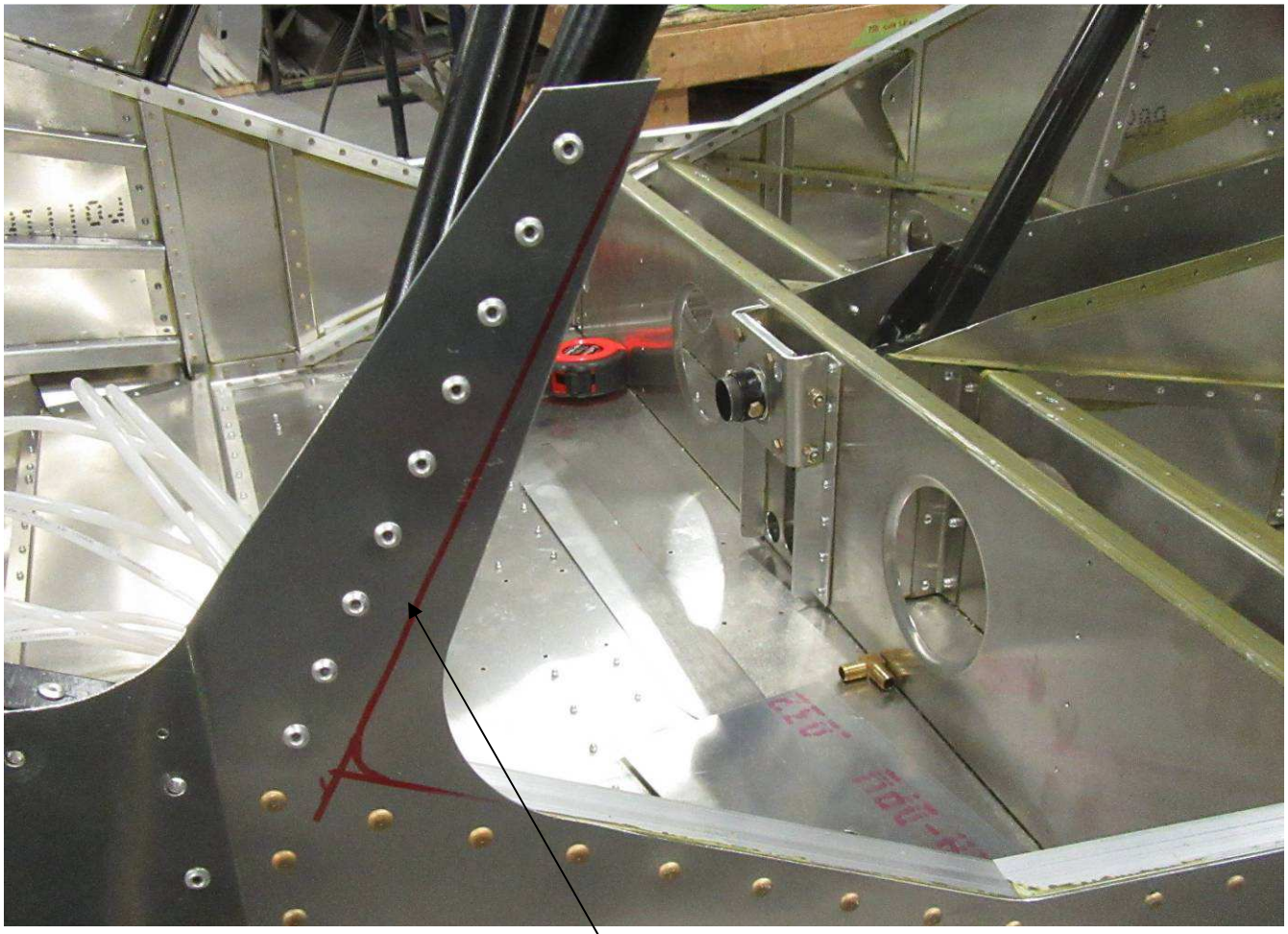
FRONT CABIN FRAME GUSSET

C75N1-2

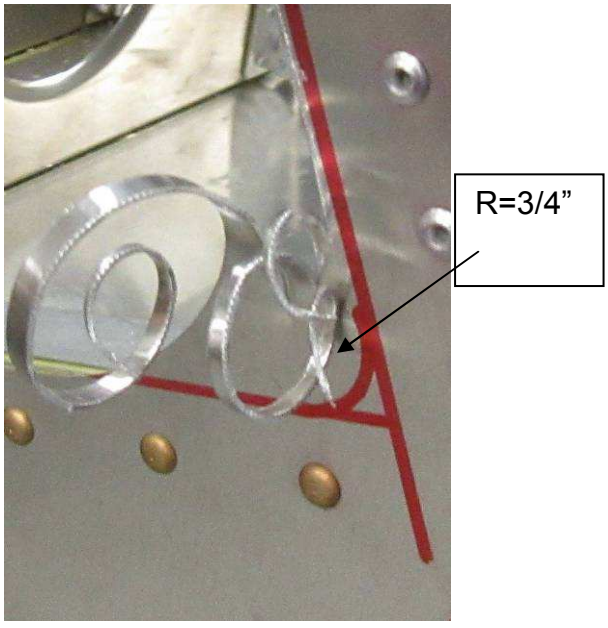
Front cabin frame gusset installed on the front side of the cabin frame.

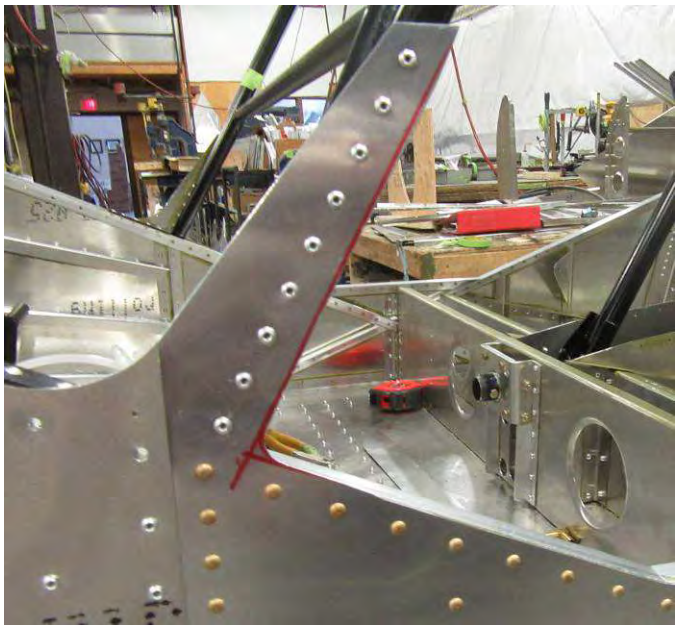


Rivets: 5 rivets AS-5 on each flange

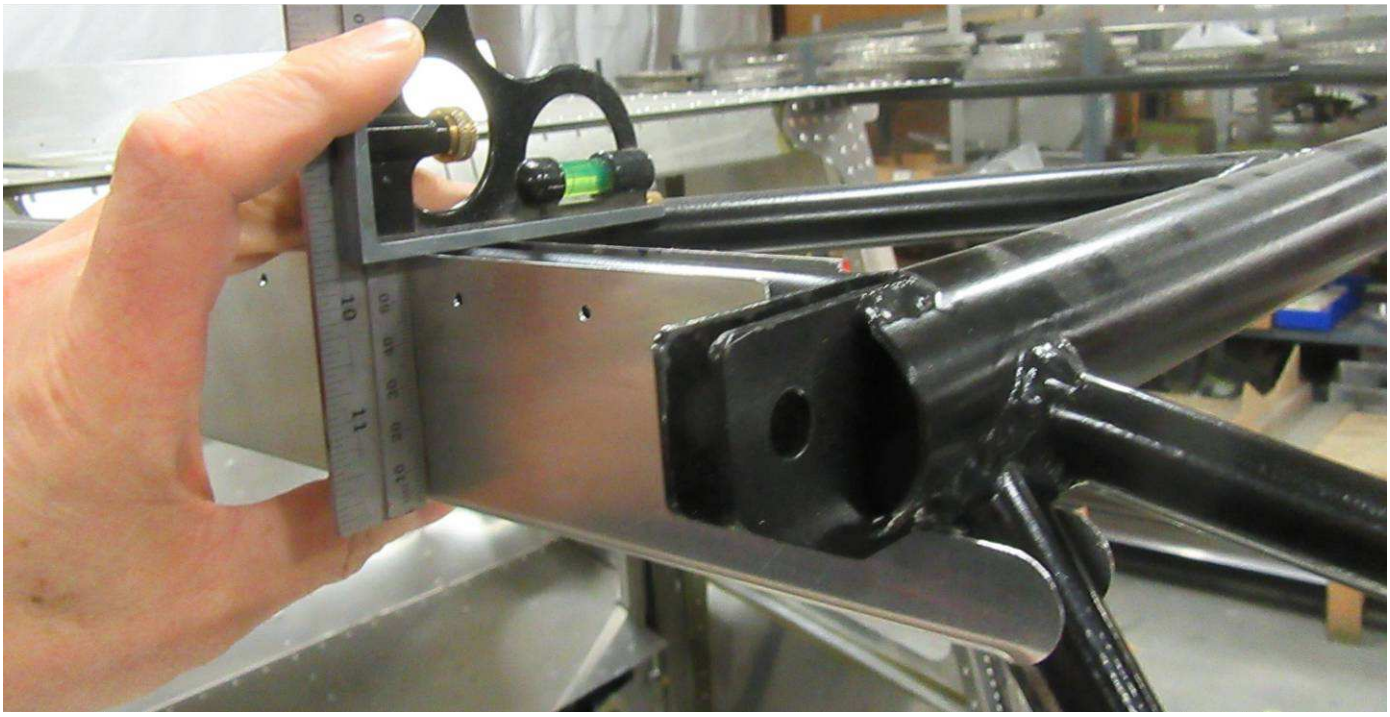


Trim the cabin side skin. Draw a line 12mm edge distance from the rivets.

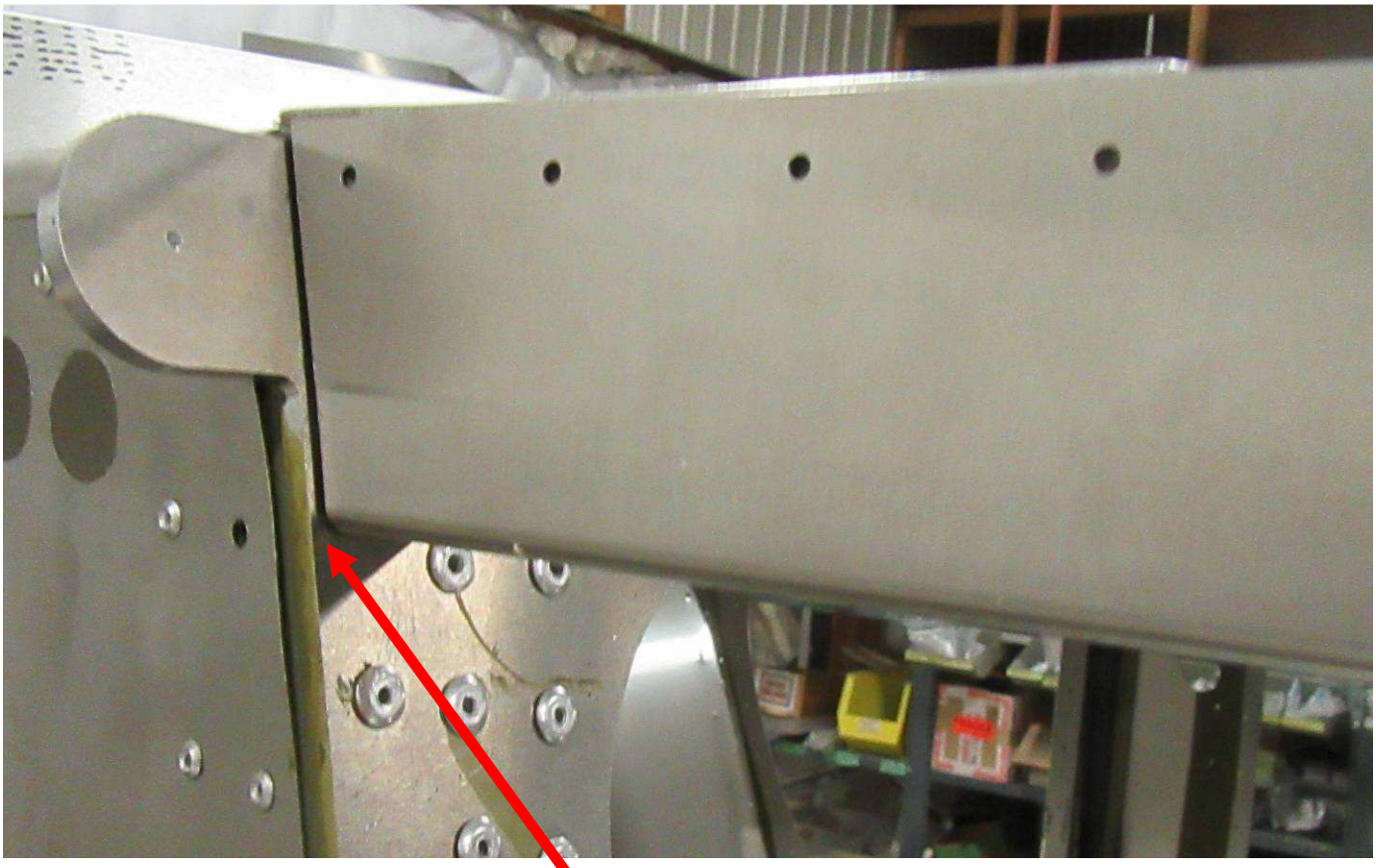




Use snips to cut along the straight line, and a half round file to finished the radius

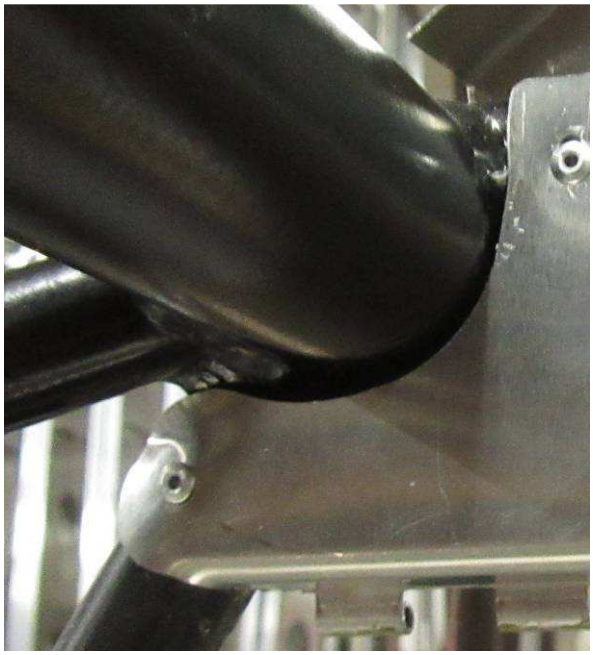


DOOR SILL C75F12-6/1(side flange = 60mm) The top is even with the side tubes of the cabin frame.

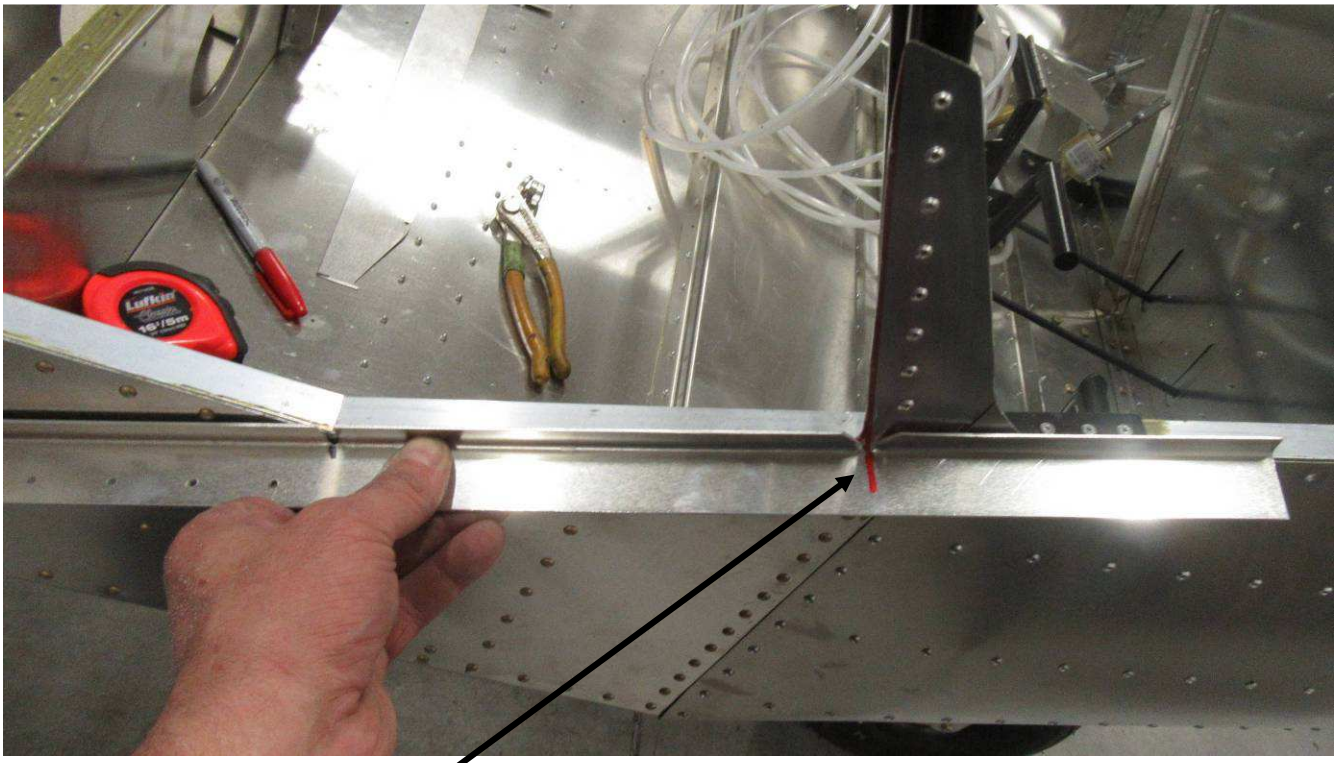


1/8” between the edge of the fuselage and the door sill.

TOP WINDOW RIB C75F17-6, riveted with A4 pitch 40 (both sides)



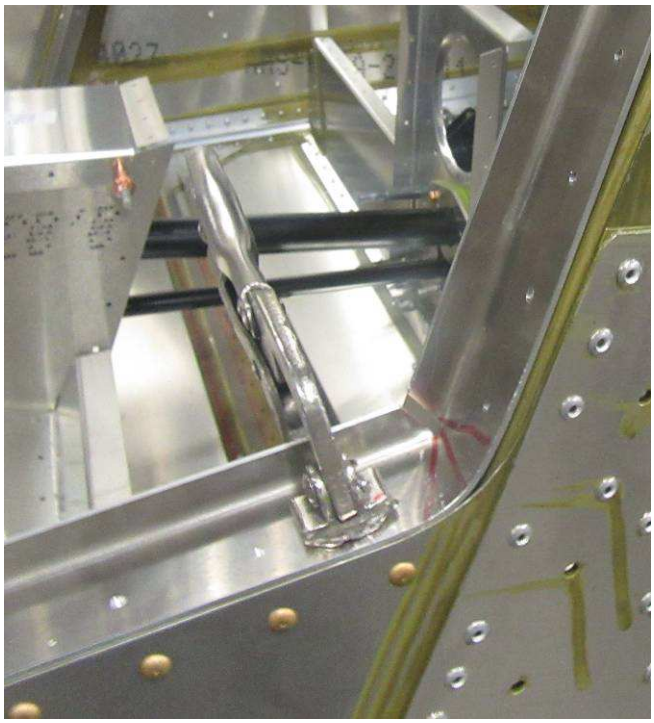
Bend the front around the tube. Add the inside rivet.



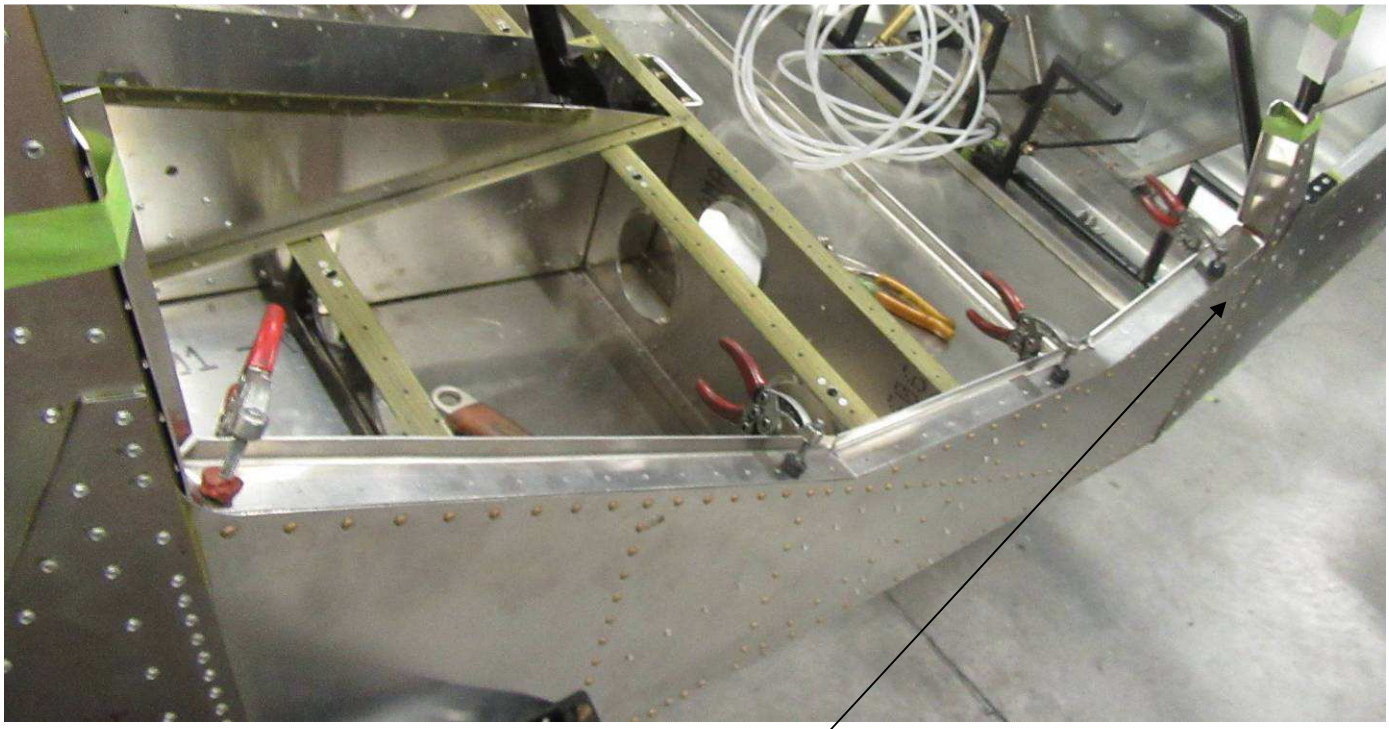
Position the doubler against the cabin side, mark the bend lines

Start with the middle bends, then the front – position the Cresent wrench on the bend line and rotate the wrench to bend the angle.

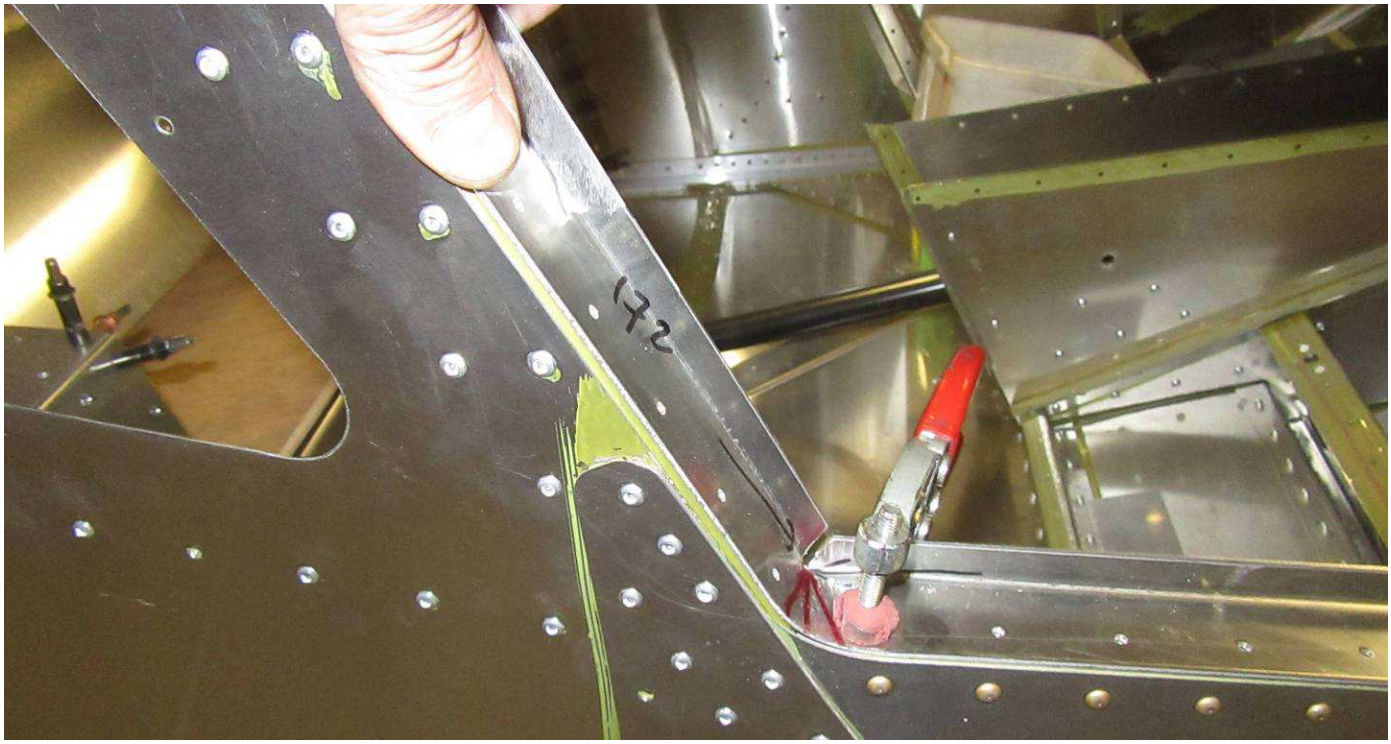
For the aft bend, mark 3 bend lines – for each bend, the tip of the wrench is centered on the corner relief hole.



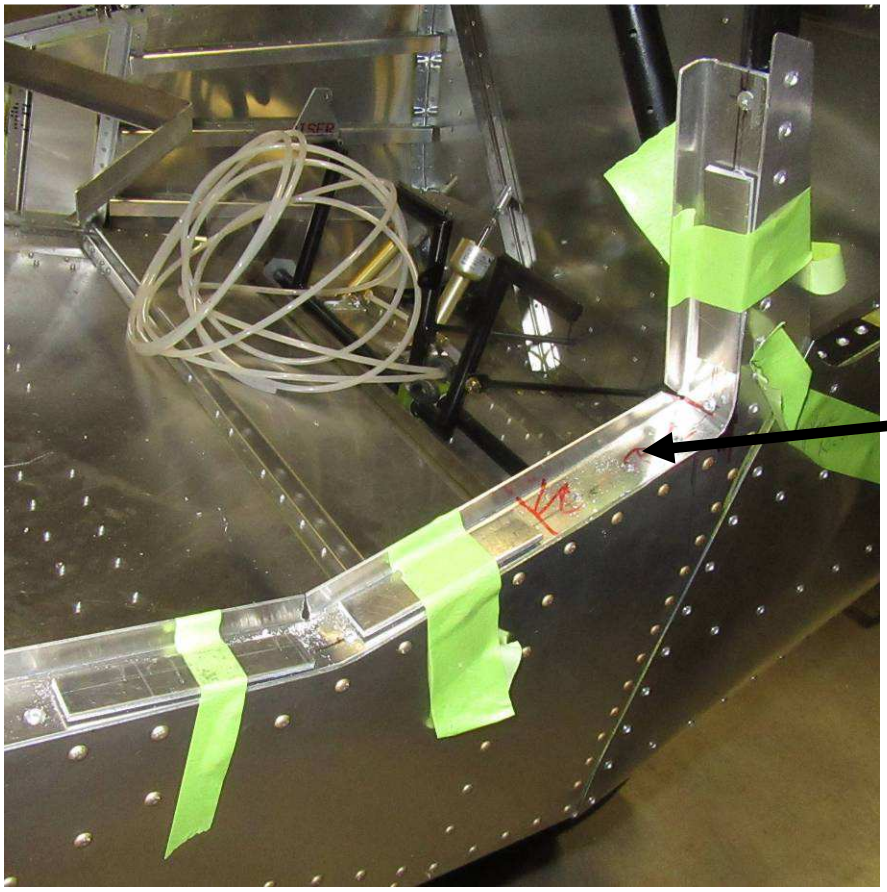
The larger radius will allow the flange to wrap against the side channel



Clamp the front first.



Position the clamp as close to the corner as possible. Hold the droubler even with the side channel, Drill and cleco



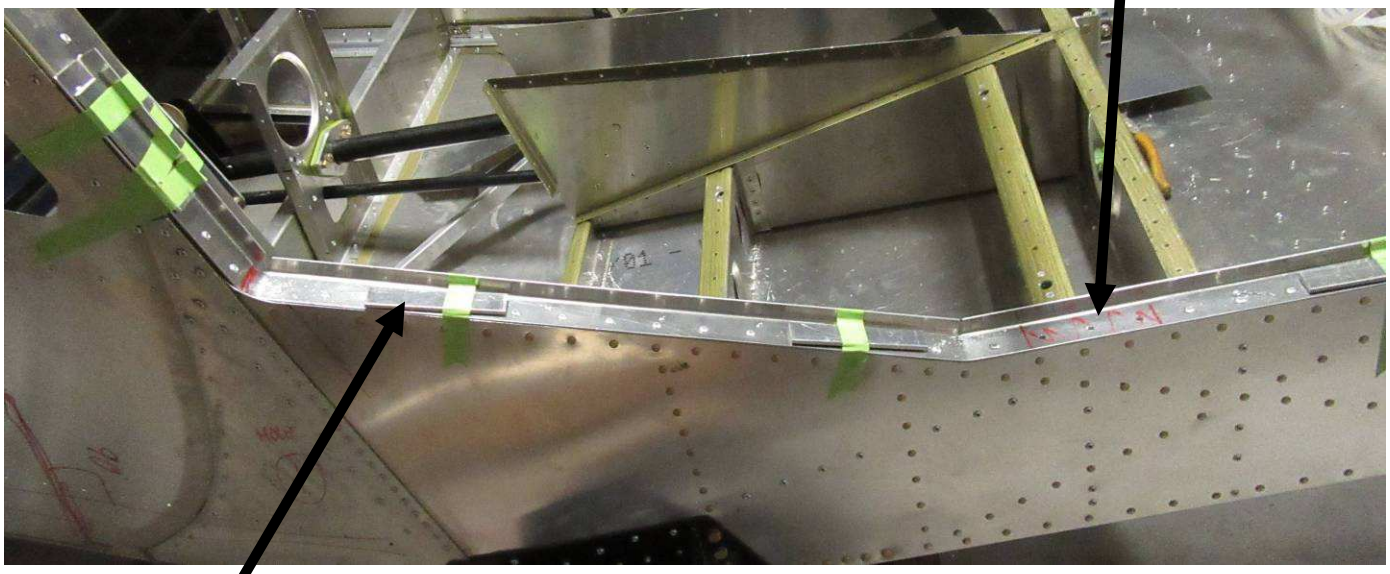
C75N2-11

"No rivet zone" for the 2 striker plate (Drill the holes but wait to set the 3 rivets pitch 30)

Front latch striker plate location

Location for the main striker plate

Rivet the double to the cabin side, also at the rear and front (pitch 30)



Tape 3/16" spacer on top of the rivets. (6 spacer)
The purpose of the spacer is to assure the door frame will fit inside the fuselage. When thinner spacers are used, the door frame may shift during construction and bind with the fuselage when opening and closing the door.

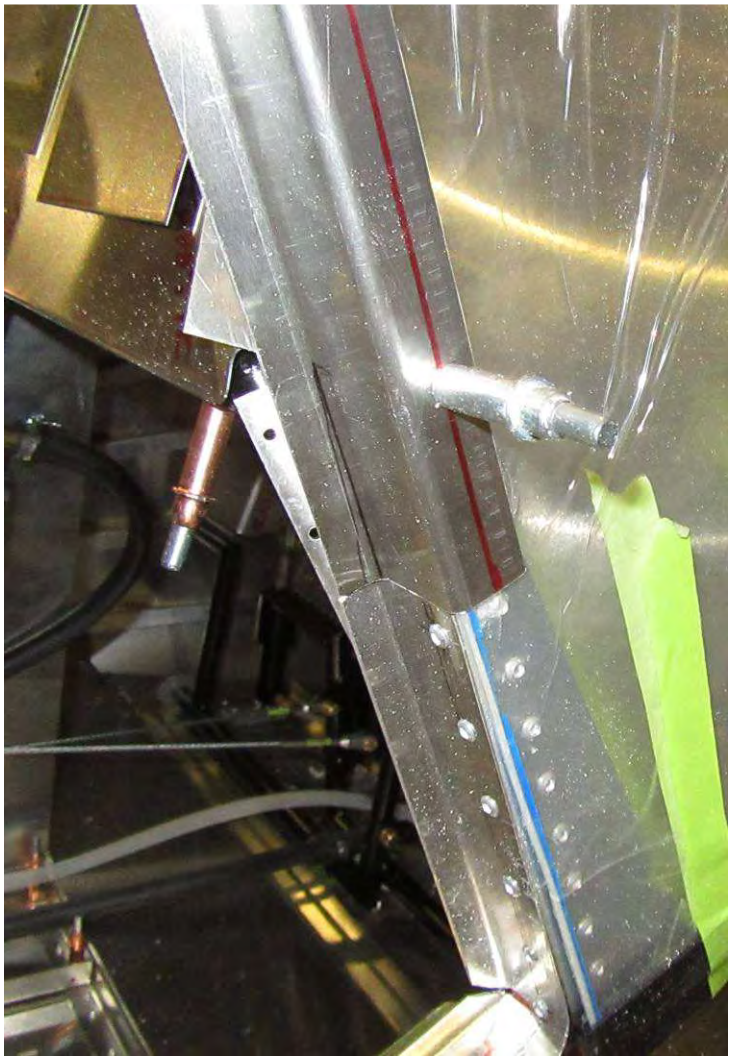
Stricker plate for the main latch: overlaps underneath the cabin side extrusion.

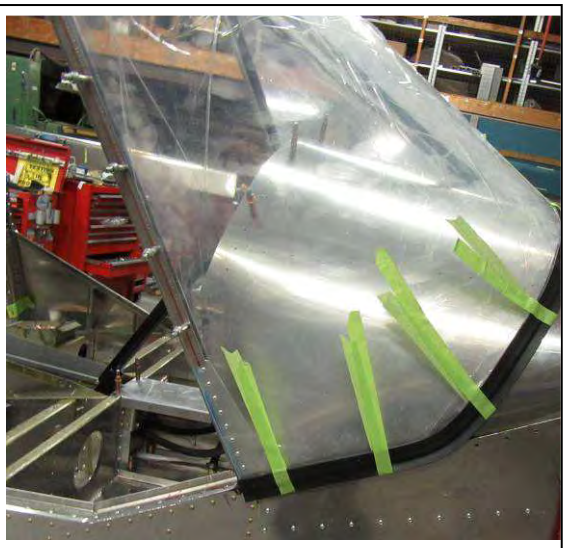
C75N2-11 & 11A

The sticker plates overlap underneath the cabin side extrusions.

The side flange is against the rubber trim.

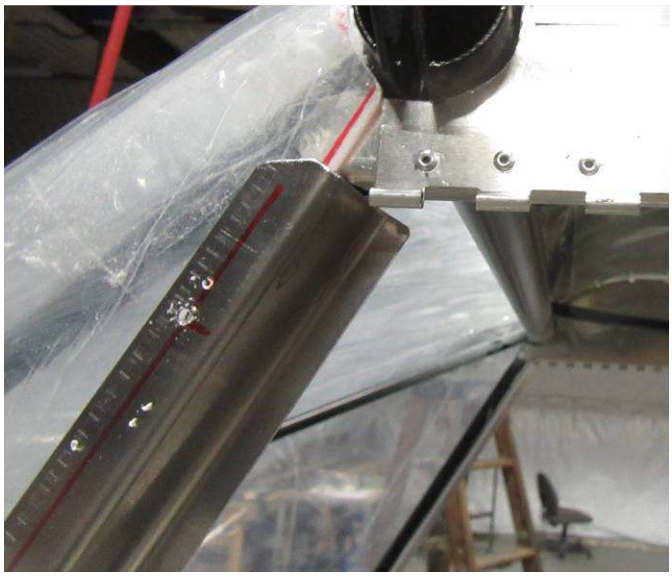
3 rivets A5



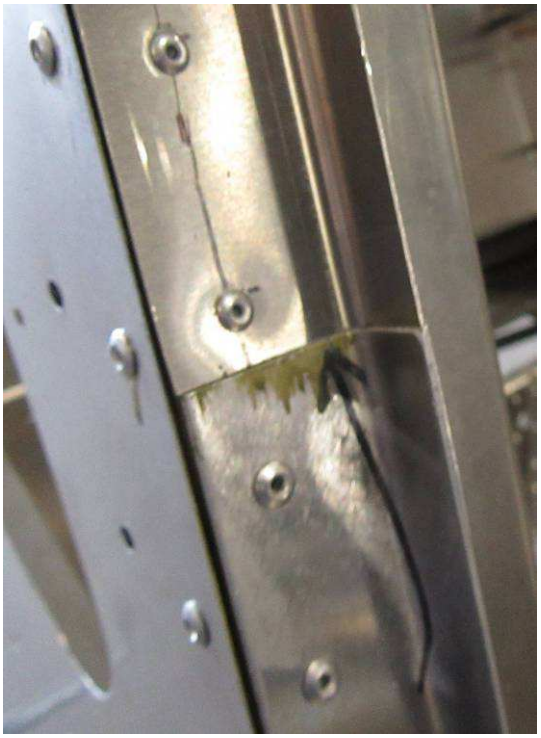


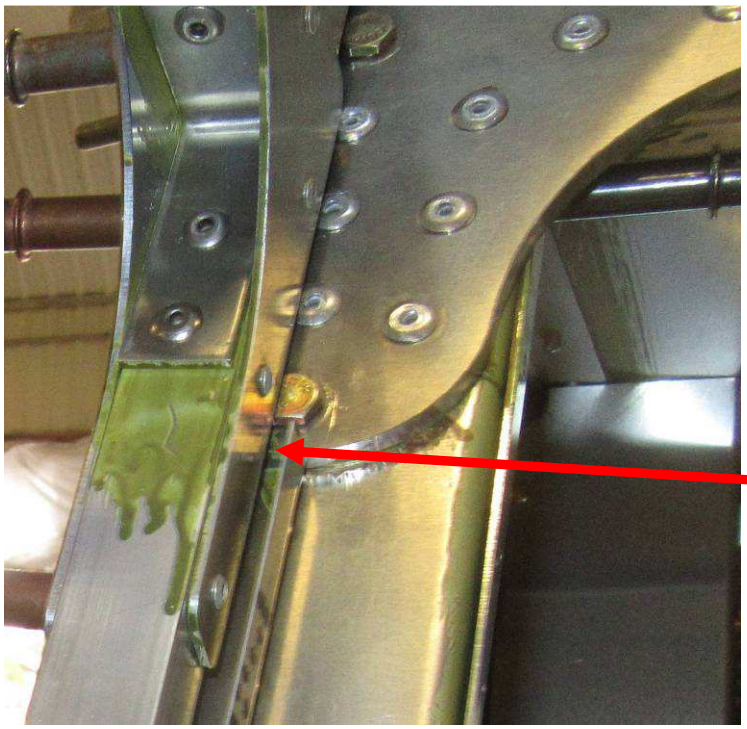
C75N1-5
WINDSHIELD SIDE TRM SUPPORT

Photo showing side trim riveted to the Door Sill.



NOTE: When the doors are installed before the windshield is installed – position the side trim without the windshield.

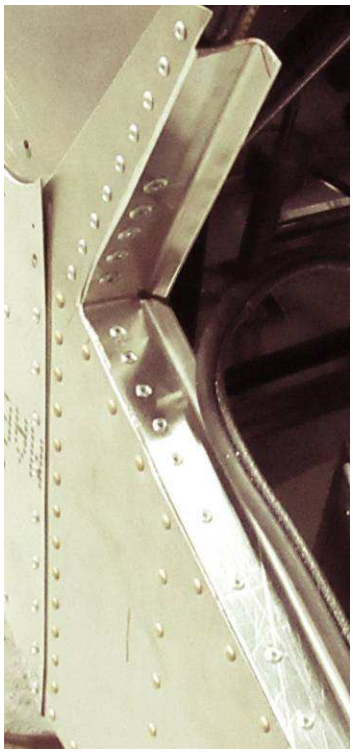




C75N1-4

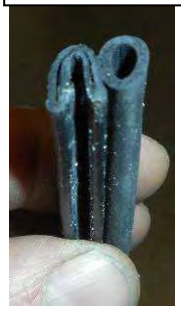
DOOR POST TRIM SUPPORT

Gap for rubber trim



When installing the rubber trim in the corners, simply push it in place. It is not necessary to cut the rubber trim to get a tigther radius. The rubber trim will make contact with the inside gusset.

Contact of the rubber trim with the inside gusset.



Rubber tim.

Note: It is easier to build the door frame if the rubber trim is not installed (when the door is closed, it will compress the rubber trim).