



When the door is on the workbench, always have the 30mm spacer under the front top corner of the door frame and the workbench.



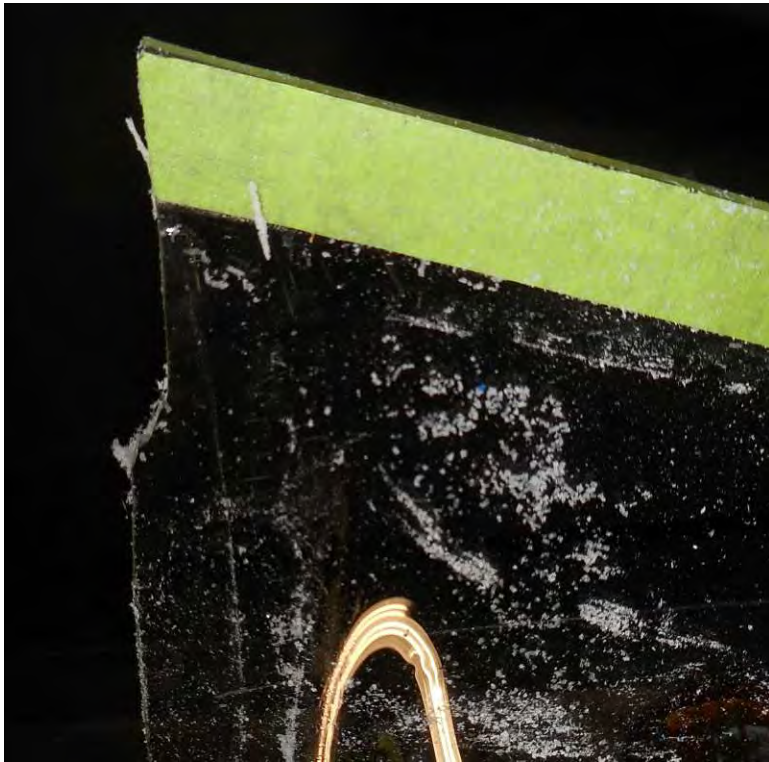
Use pieces of masking tape to mark the edge of the flange, this is the mark where the bubble begins to form. Line up the rear tape lines parallel with the rear tube. The critical edge is the front



Pull a tape line just below the hinge spline.



On a band saw, cut along the top edge on the tape line.



Top rear cutout to make room for the rear wing attachment



Cut the top rear edge of the bubble to make room for the rear wing attachment..  
2mm to the square tube, down 60mm



With a sanding disk, touch up the edge.



Sanding disk 80 grit



Layout the rivet lines on the door frame and pre-drill with #30 holes.

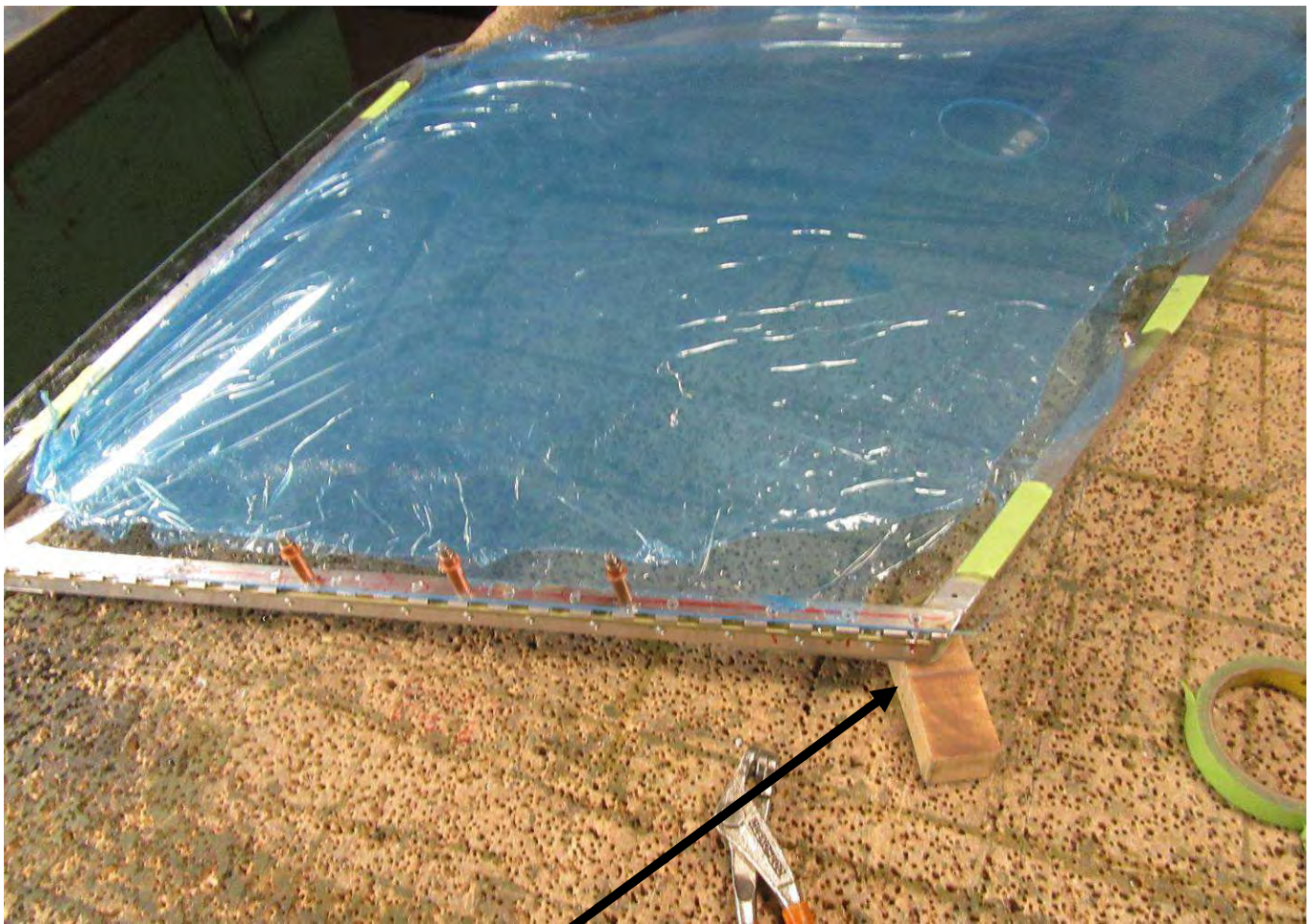


**When drilling the bubble, always use acrylic drill bits.**

The pre-drill holes in the frame are visible through the bubble.

Position the bubble on the frame.

It is normal for the aft corner of the bubble to be very close to the corner of the door frame.



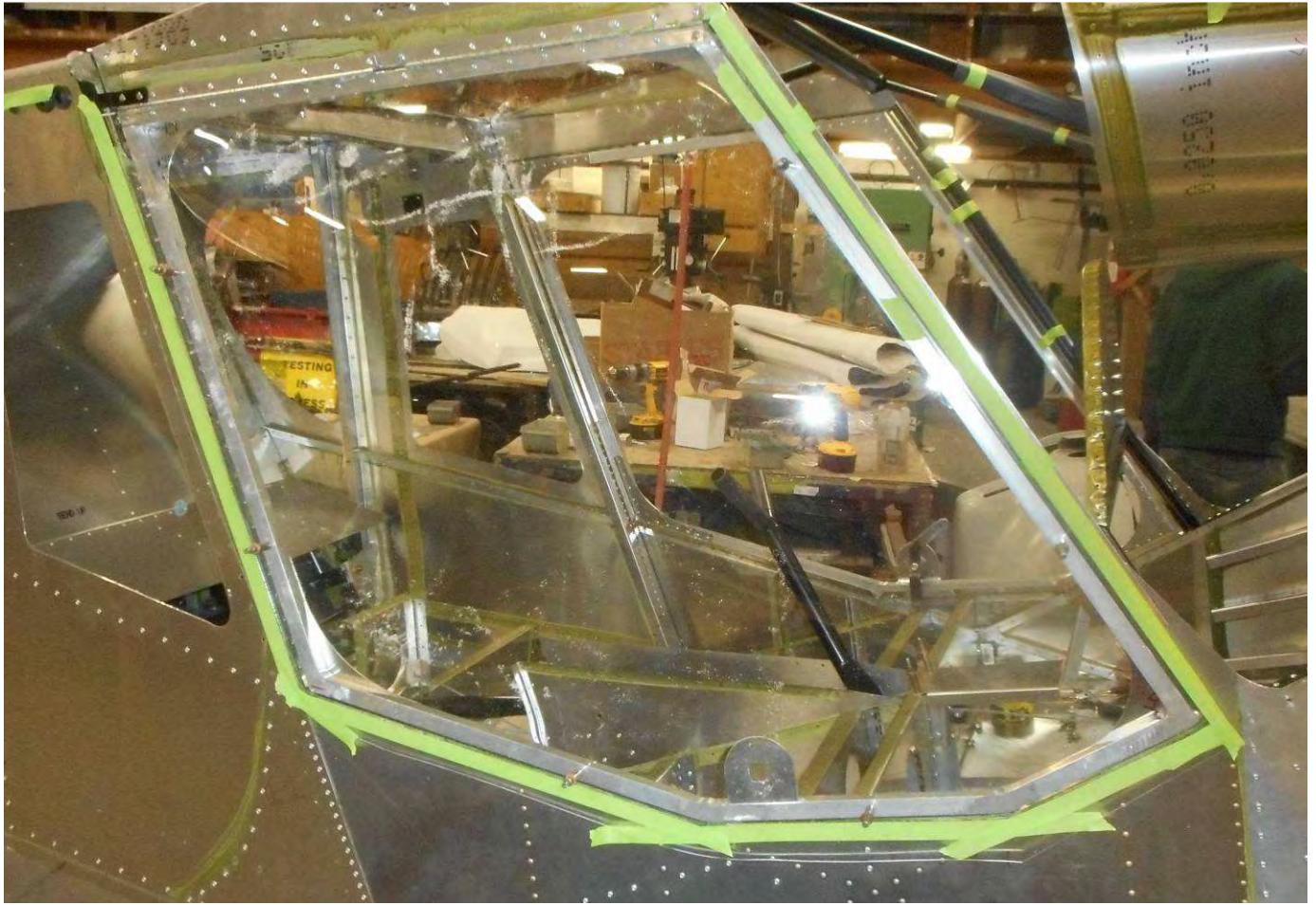
When the door is on the workbench, keep a 30mm block under the front top corner of the door frame. (30mm between the workbench and the door frame).



Position the bubble on the frame with the top edge flush with the hinge. Check the overlap with the front tube: slide the bubble forward, the tape is approximately 3 to 5mm past the edge of the frame.  
Drill and cleco



Drill and cleco the bubble to the frame.

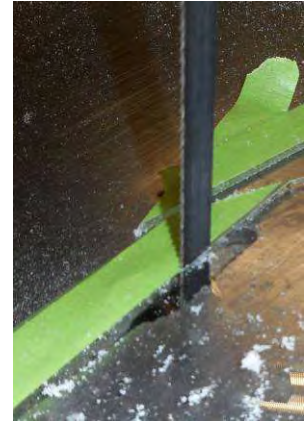
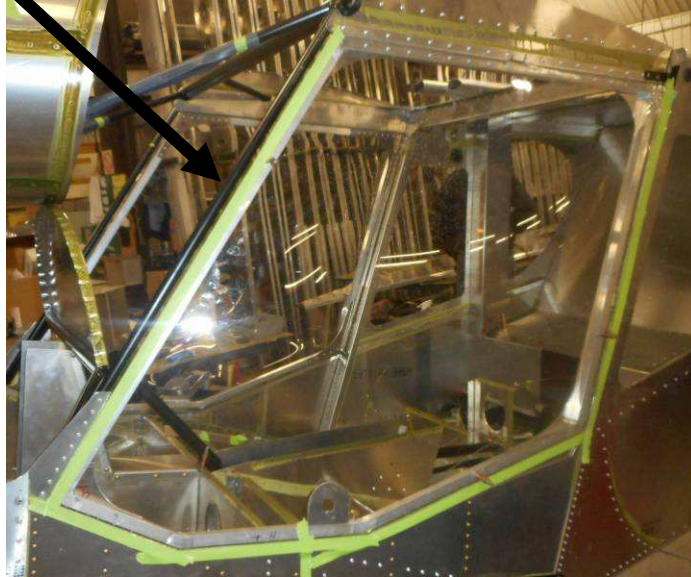


Re-install the door to the fuselage.



Use tape lines to mark the edge of the fuselage opening on the bubble.

Approximately 4mm to the side tubes.



Remove the bubble and use a band saw to cut along the tape line.



Deburr both sides of the holes. Slightly enlarge the holes with the #30 drill bit.





Sanding disk to clean up the edge and to trim the bubble to fit inside the fuselage.

Cleco the bubble to the door frame on the fuselage.  
Touch up the front edge after the windshield side trim support is installed.



Radius the corners and keep sanding until the bubble has approximately 2mm clearance with the fuselage.

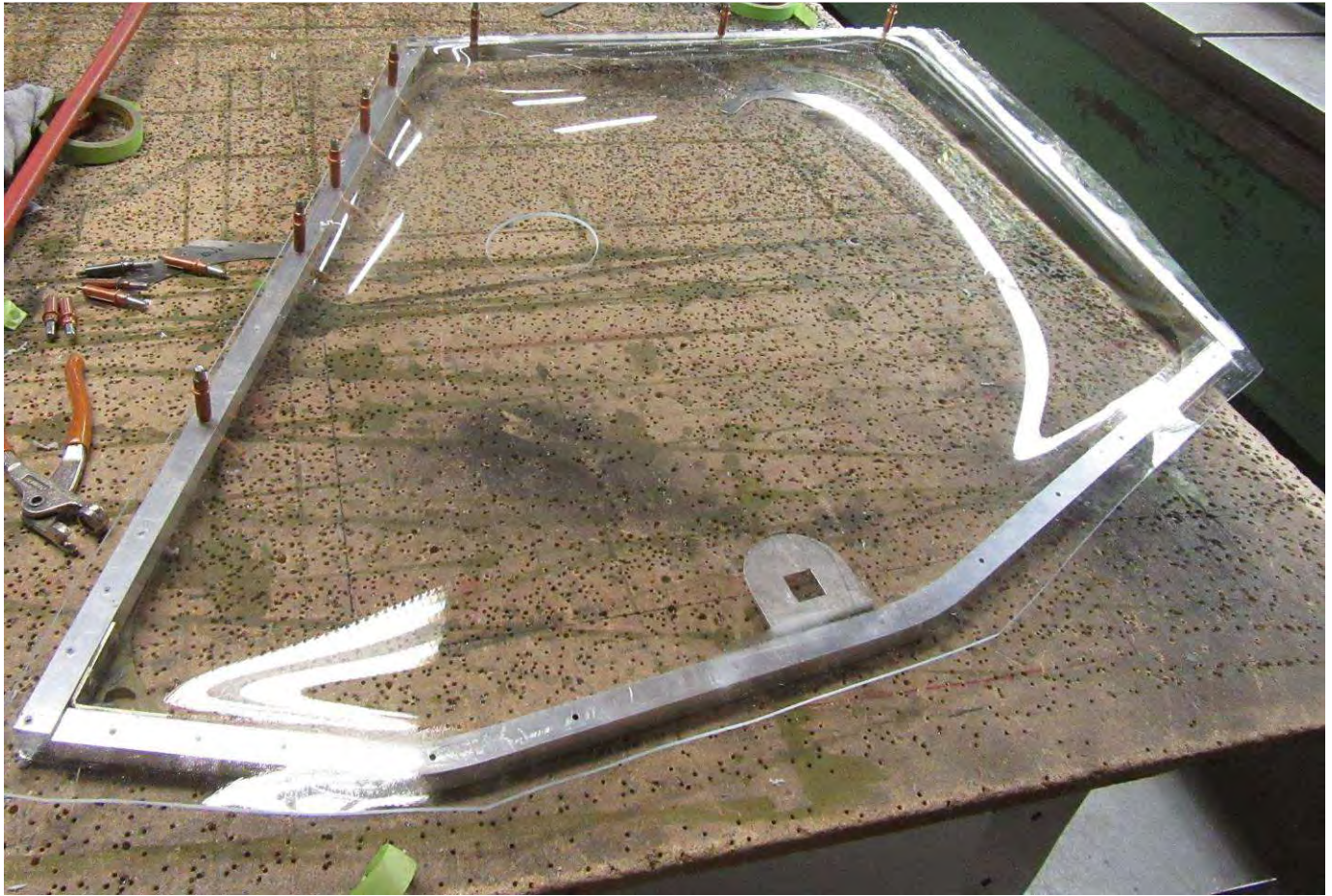


### C75N2-5 DOOR HANDLE MOUNTING PLATE

Position the plate on the recessed area of the bubble door. Check that the hole lines up with the striker plate.



Square hole to secure the outside handle assembly.



The door mounting plate lays flat on the bubble, riveted to the frame with 4 rivets AS-5



Mark the center of the square hole, drill a #40 pilot hole.



Remove the bubble from the frame to drill the hole. For a clean hole using a Hole saw, cut half way from both sides.

