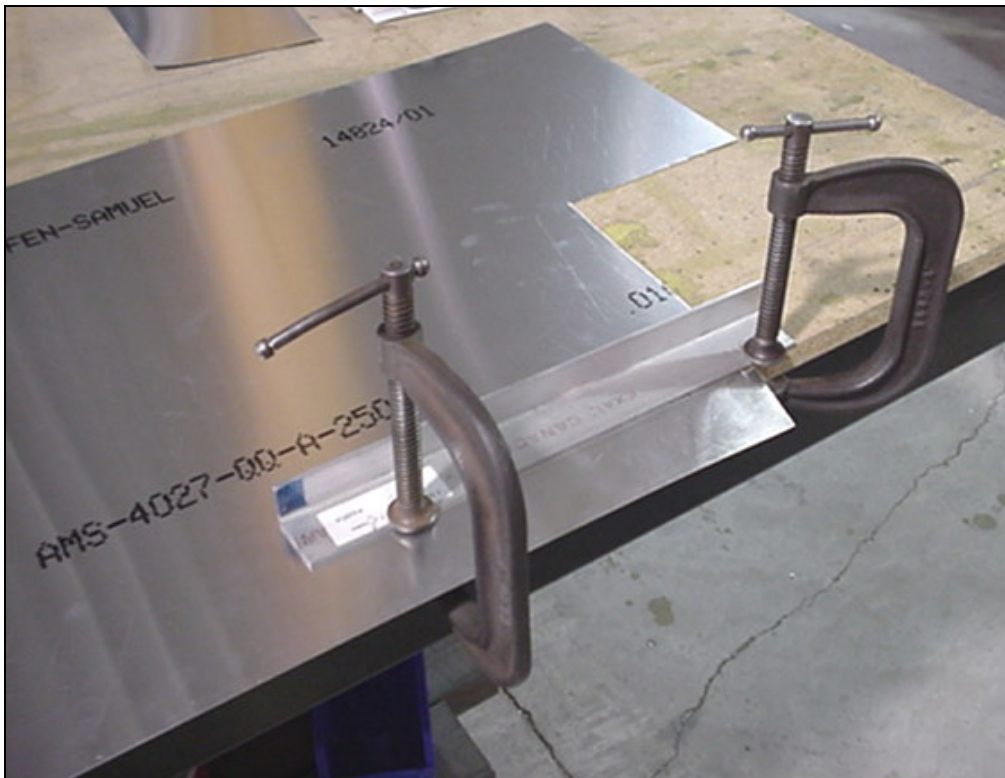


7F14-3 Front Side Skin

Layout the measurement for the Front Side Skin. Only cut the lower corner section and file where the 10mm notch is located.



7F14-3 Front Side Skin

Locate the notch and bend 10mm to 90deg. After the bend, the lower section will need to be rolled to follow the curve of the Firewall.
(DWG 7-F-14).



7F14-3 Front Side Skin

Layout the rivet line on the Cabin Side Assembly A4 Pitch 30. The first rivet is 10mm from the lower corner of the Cabin Side. Position the Side Skin, with the bent corner with bend of the Cabin Side. The Side Skin Bottom edge is on the inside of the Fuselage, which is on the top of 7F8-7.



7F14-3 Front Side Skin

Layout the bottom edge rivet pattern A4 Pitch 30.



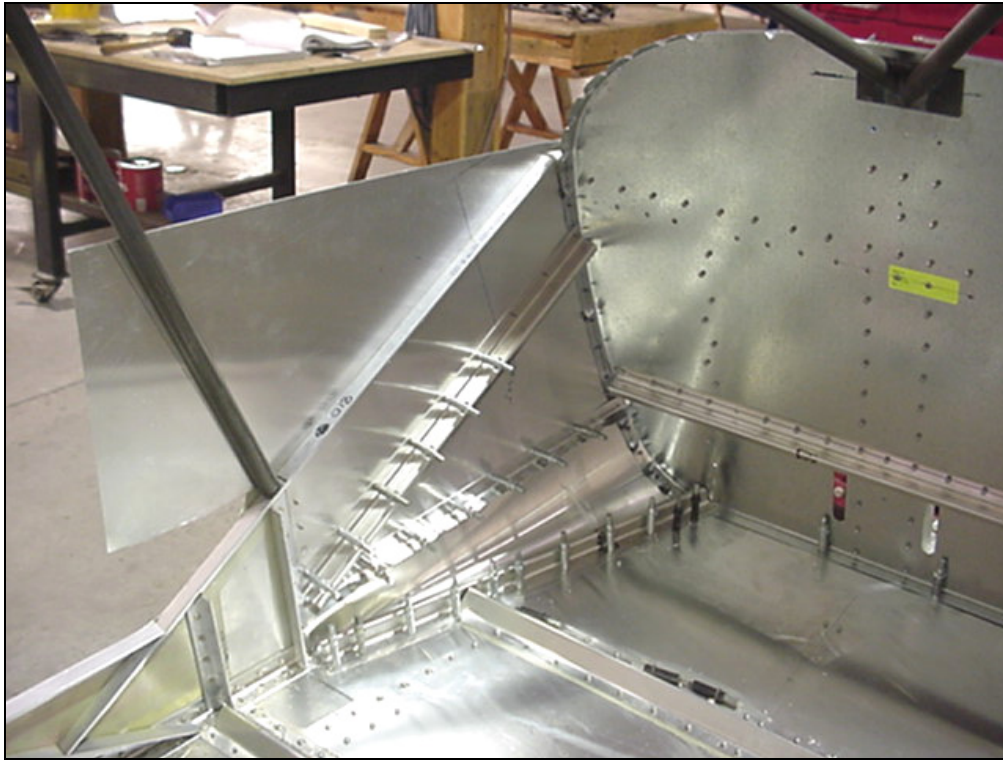
7F14-3 Front Side Skin

For the best results drill the lower corner where the bend in the Side Skin and the Cabin Side meet. Using a small wood block to push the Side Skin lower corner tight against the Cabin side lower corner.



7F14-3 Front Side Skin

Drill and cleco the bottom edge and the Cabin Frame to the Side Skin.



7F14-3 Front Side Skin

Position the 'Z' Angle and 'L' to the Side Skin. When drilling the Side Skin to the Firewall, the best way to avoid the crimps in the Firewall is to layout the rivet line and drill from the inside.



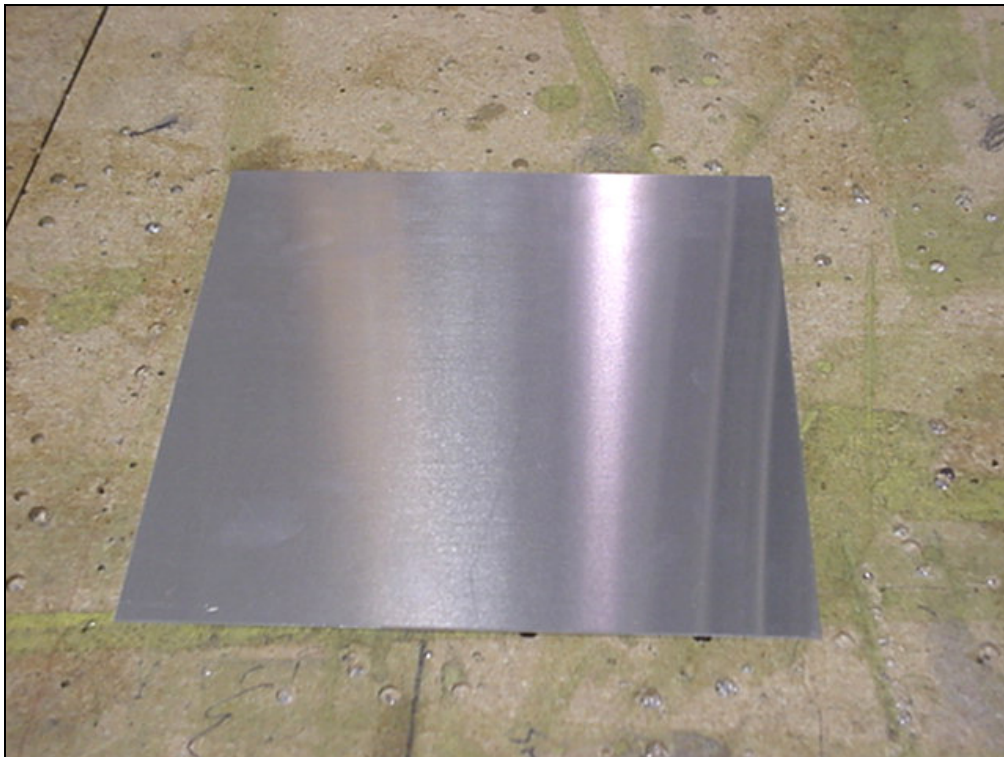
7F14-3 Front Side Skin

The 'L' Angle between the two 'Z' Angles will need to be crimped to close the gap between the skins.



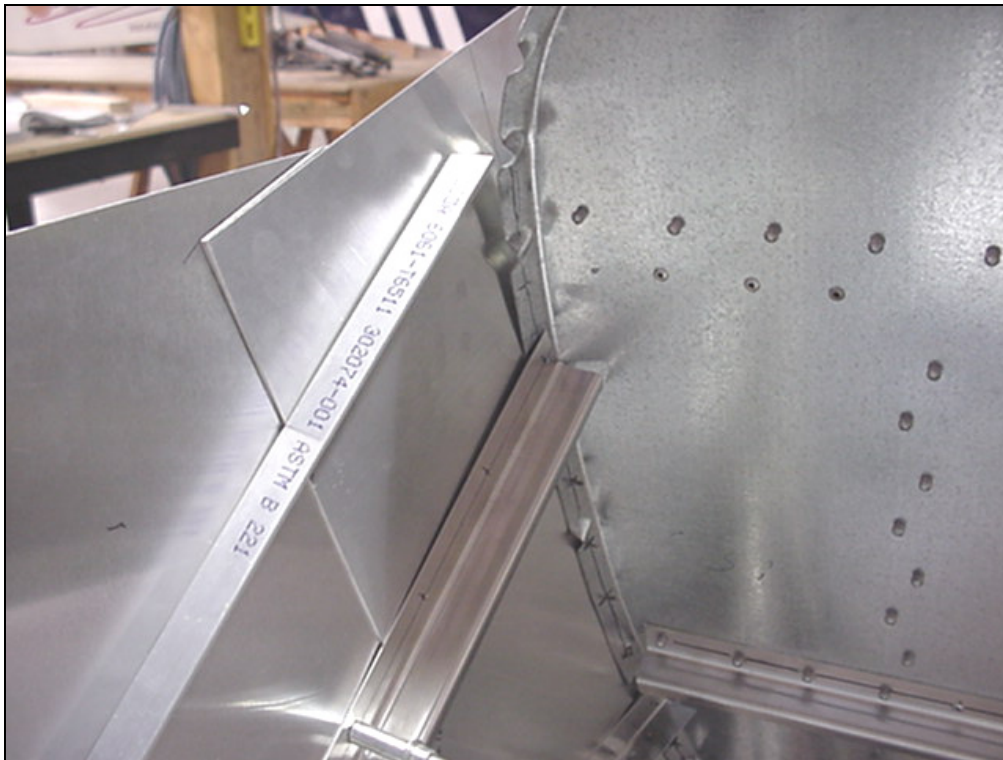
Hand Crimp

The use of a hand crimping tool will work very well to form the crimps.



**7F14-6R Aluminum
Plate**

Aluminum Plate 7F14-6R.



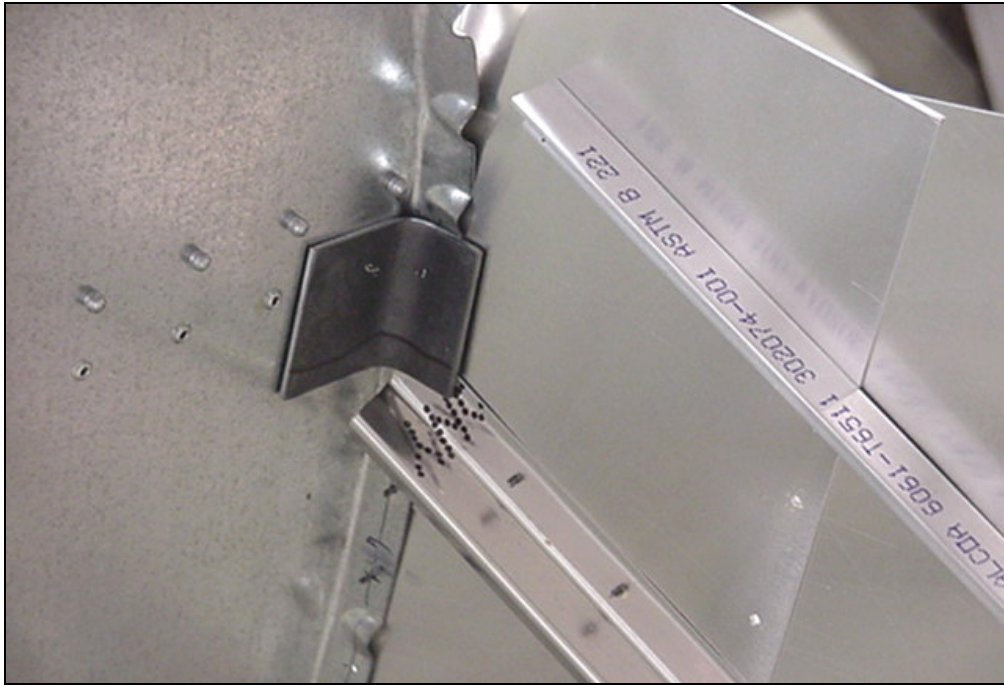
7F14-6R Aluminum Plate
(Aircraft Left Side View)

Position the 7F14-6R Aluminum Plate on the Front Side Skin and the Firewall. The Aluminum Plate will extend 50mm past the front of the Firewall.



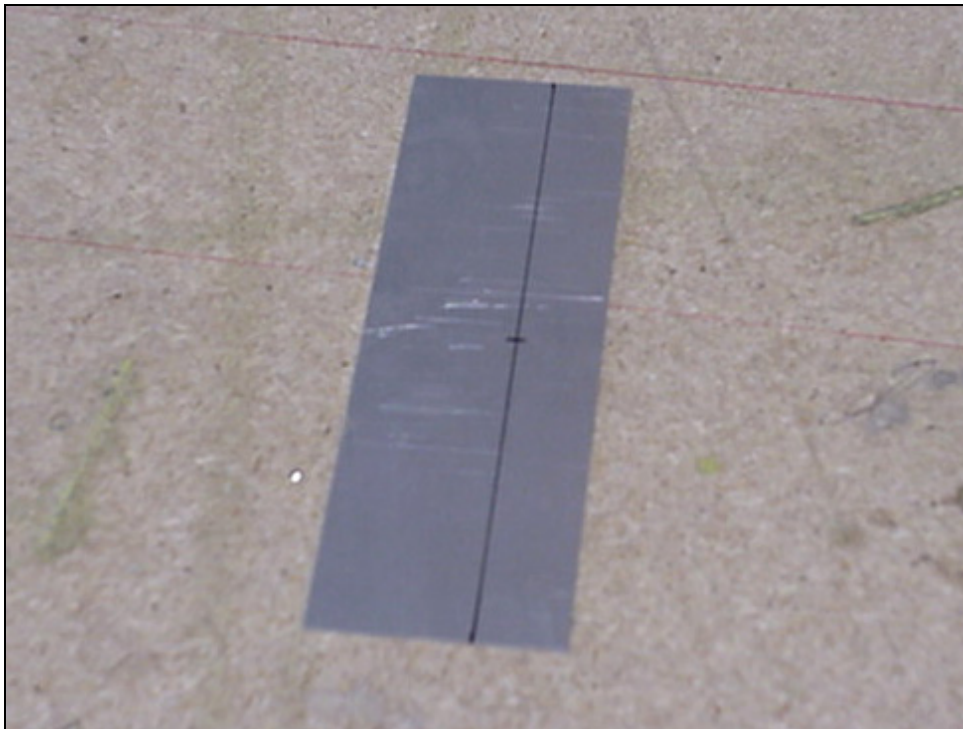
7F14-5R Steel Angle

Position 7F14-5R Steel Angle.



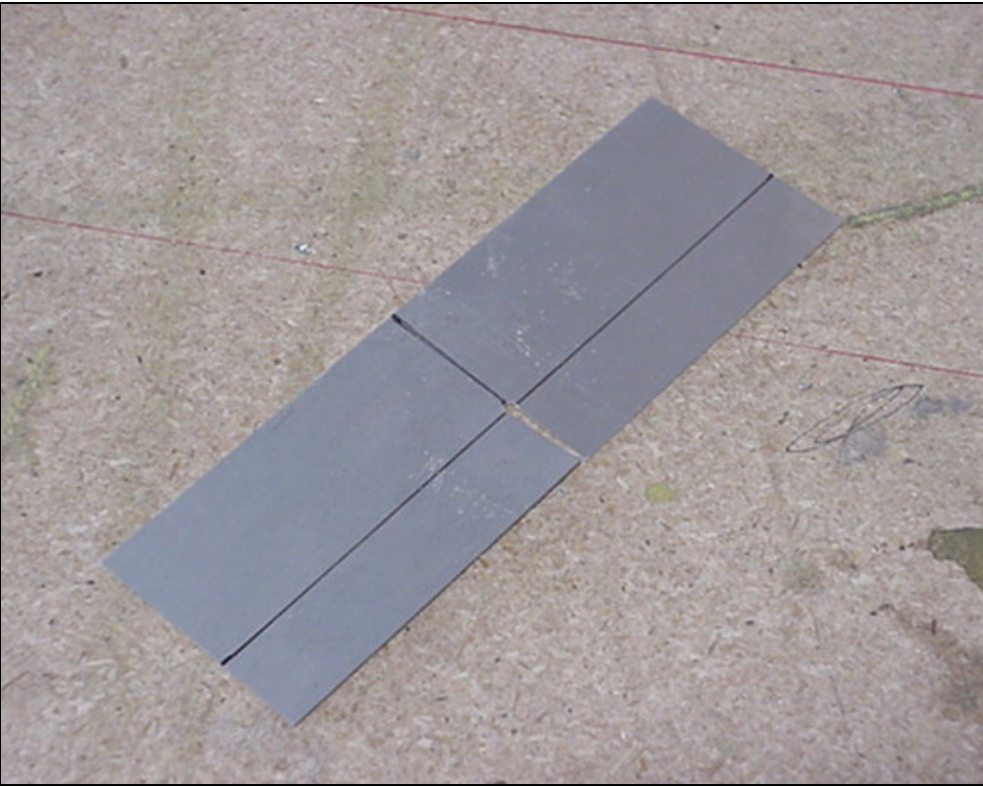
7F14-5R Steel Angle
(Aircraft Right Side)

The Steel Angle is positioned where the upper Engine Mount is located on 7F7-1SP. The Angle may need to be trimmed if the crimp from the Firewall is in the way. Drill and cleco and open up to an AN3-4A Bolt. Don't forget to paint before bolting to the Firewall.



7F15-2 Panel Side Gusset

Layout a line 18mm by 75mm on the Panel Side Gusset.



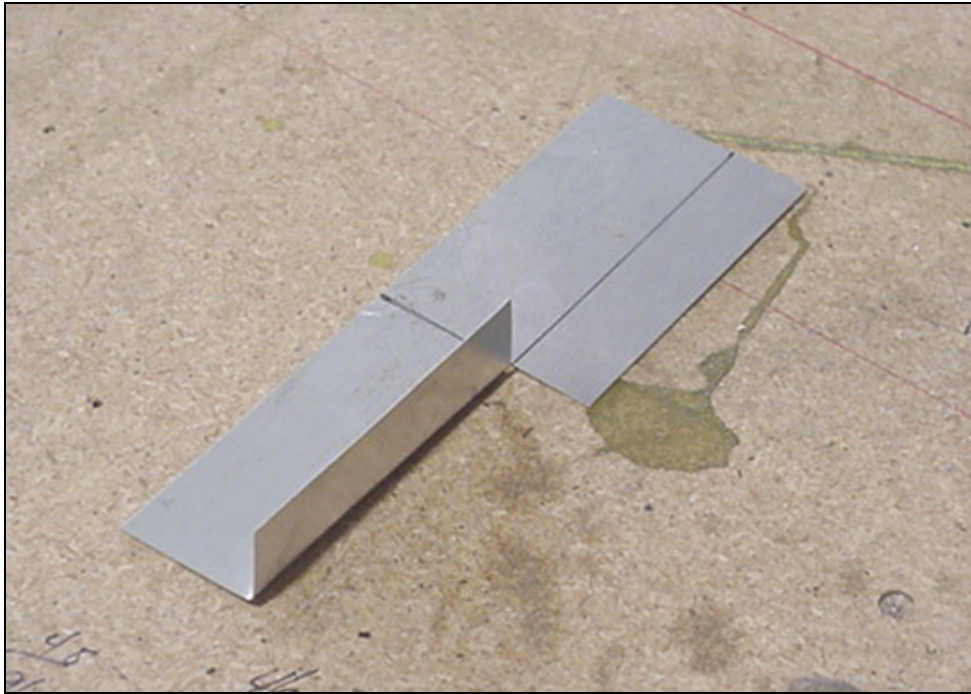
7F15-2 Panel Side Gusset

Make a small cut at the 75mm and file a relief hole.



7F15-2 Panel Side Gusset

The small flange will need to be bent 90 deg.



7F15-2 Panel Side Gusset
(Gusset for the right Side)

One left and one right is needed to install on the Instrument Panel.



7F15-2 Panel Side Gusset
7F1-2 Instrument Panel

Instrument Panel Right Side View

The Gusset is positioned on each side of the Instrument Panel. Drill and cleco two A4 rivets, on the lower corner of the Instrument Panel. Trace and cut the over hang on the Gusset to the Instrument Panel.



**7F15-2 Panel Side
Gusset
7F1-2 Instrument Panel**

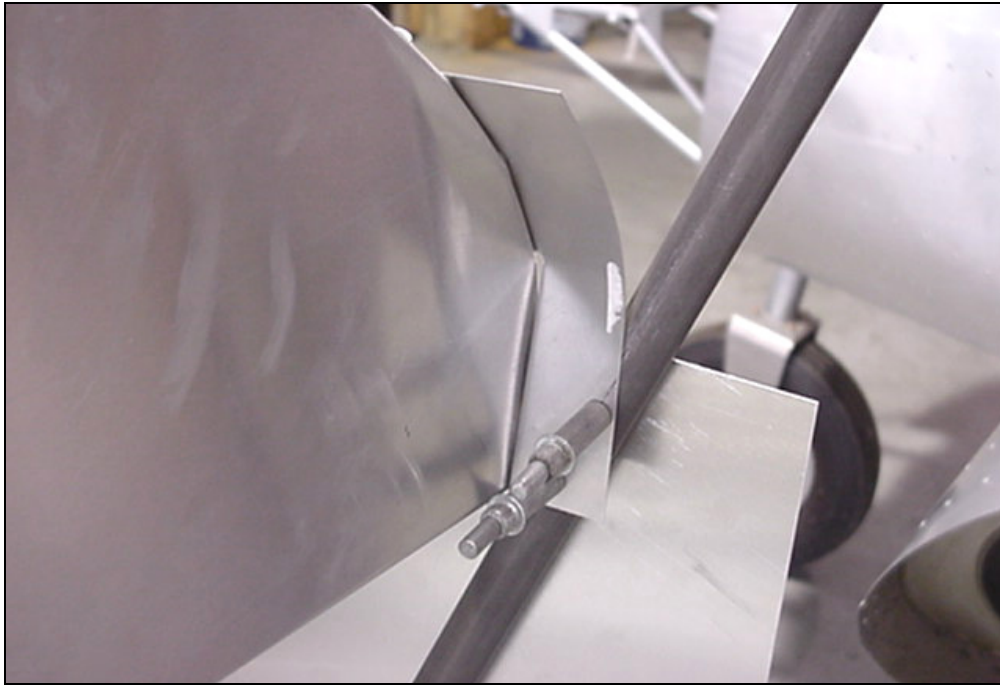
Instrument Panel Right
Side

After 7F15-2 has been trimmed, it can be riveted to the Instrument Panel with A4 rivets.



**7F1-2 Instrument Panel
7F15-2 Panel Side
Gusset**

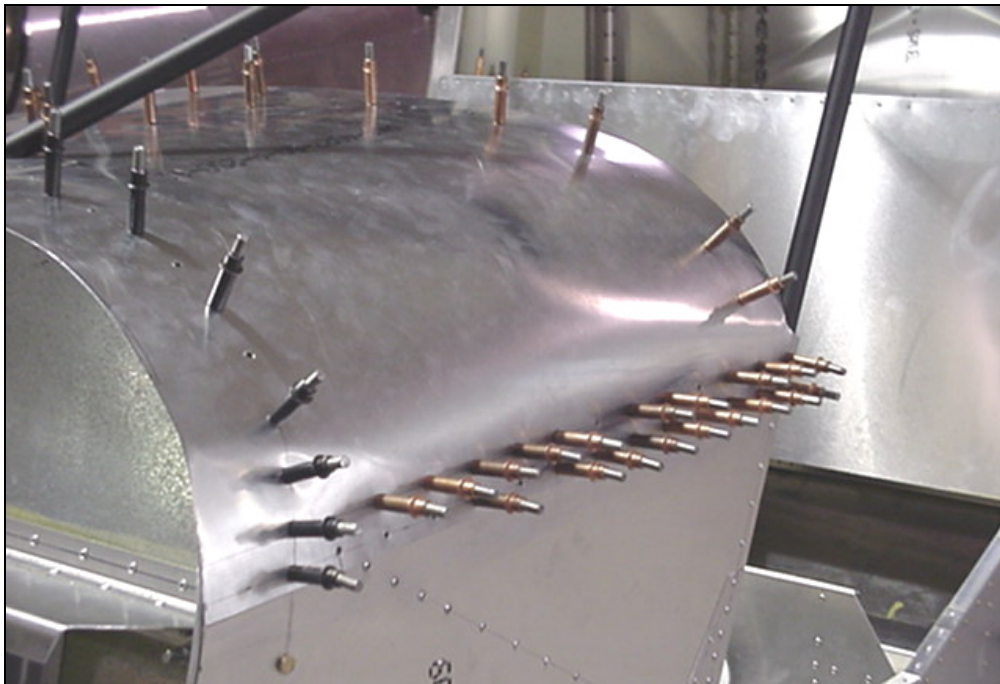
To position the Instrument Panel to the Cabin Frame refer to drawing 7F10. The Panel is 435mm from the Cabin Floor and 390mm from the Firewall. Clamping an 'L' Angle to the Firewall and Panel will hold the Panel in place.



7F15-2 Panel Side Gusset
7F1-2 Instrument Panel
7F18-1 Cabin Frame

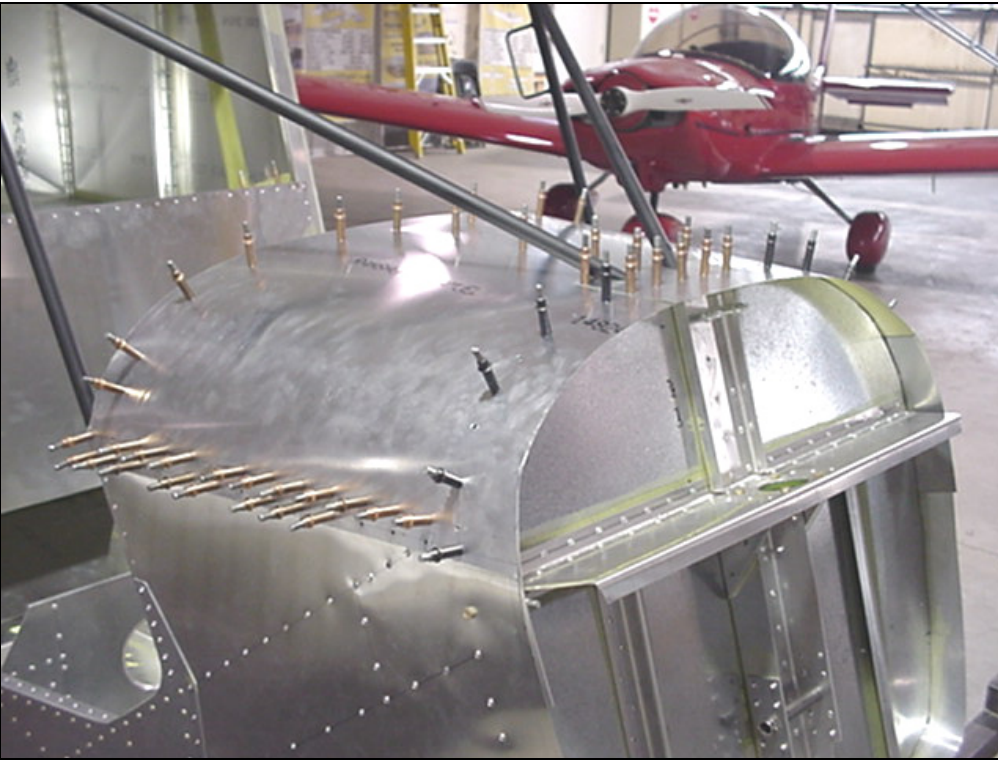
Aircraft Left Side

Once the Instrument Panel is positioned, drill and cleco to the Cabin Frame. Trim the corner off the Gusset.



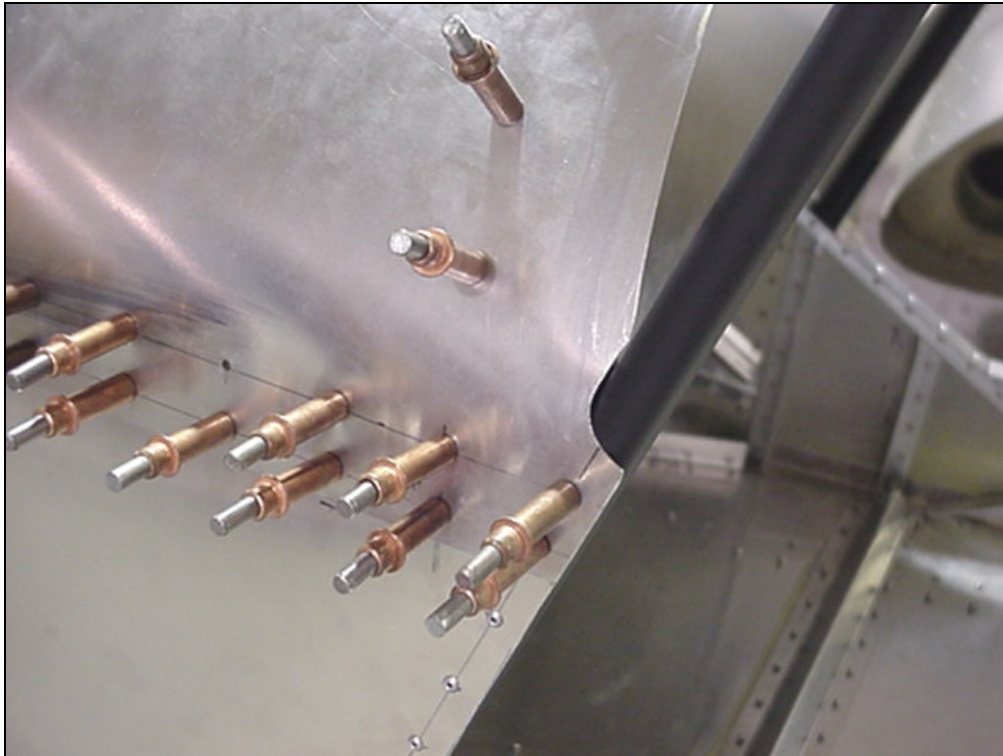
7F14-4 Front Top Skin

Mark a centerline on 7F14-4. Layout the cut out for the Cabin Frame front tubes. Best way to drill the Firewall and Instrument Panel to the Front Top Skin, is to pre-drill the Firewall and Instrument Panel, then back drill. This is done one side at a time from the inside. Don't worry about cutting the sides to the Front Top skin until after the rivet line has been drilled.



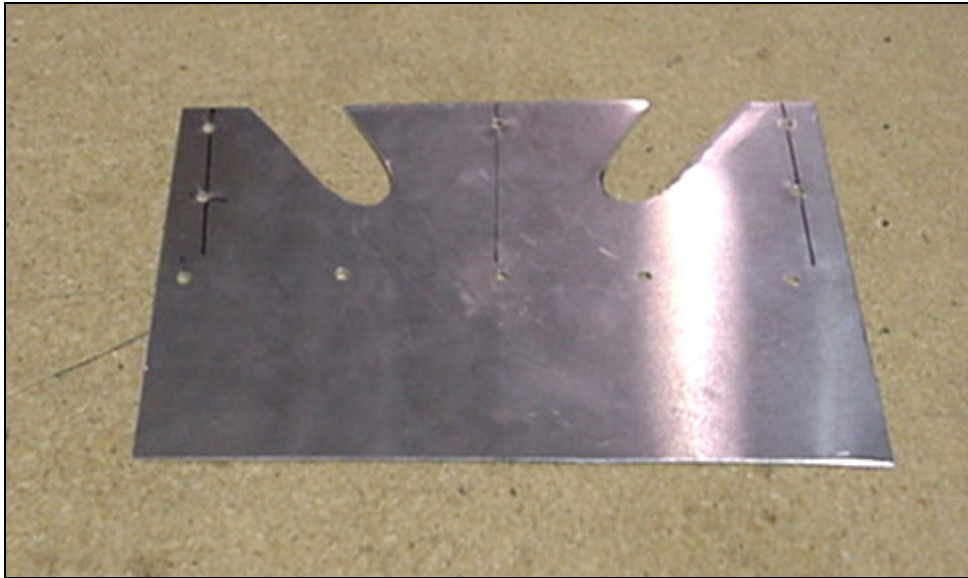
7F14-4 Front Top Skin

There are 'L' Angles on the top edge of 7F14-3 which attaches to the 7F14-4. Drill and cleco.



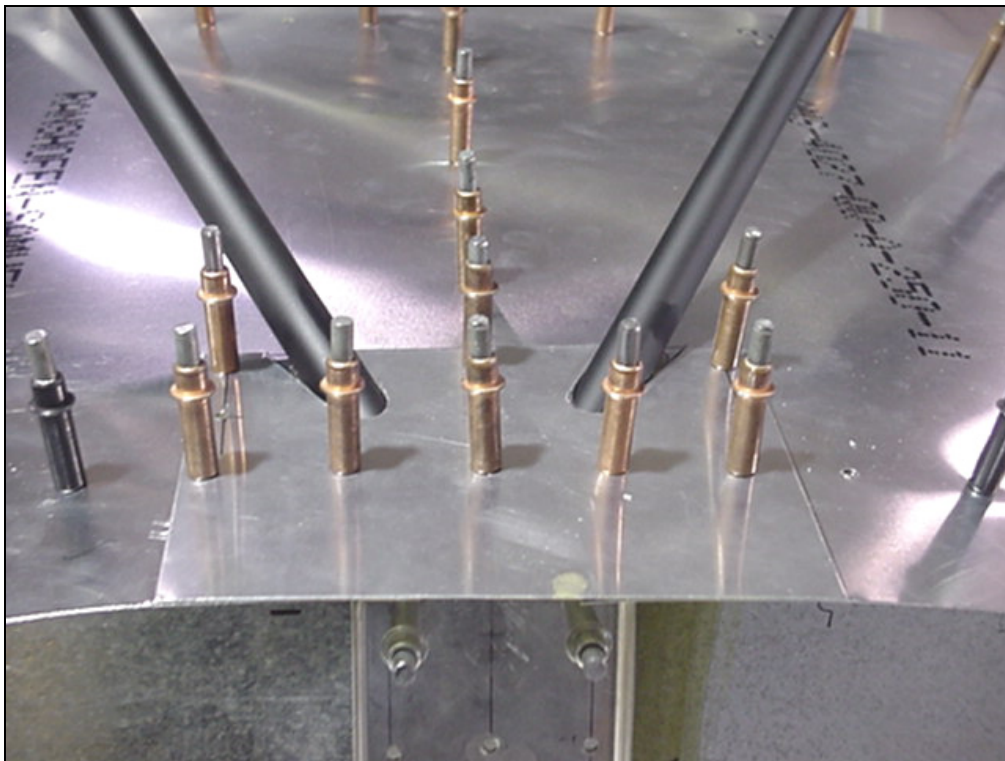
**7F14-4 Front Top Skin
7F18-1 Cabin Frame**

Trimming is required around the Cabin Frame.



**7F14-2 Instrument Panel
Top Cover Plate**

Mark the centerline and layout the cut out to go around the Cabin Frame.
Trim and position on the Front Top Skin.



**7F14-4 Front Top Skin
7F14-2 Instrument Panel
Top Cover Plate**

Position the Cover Plate, drill and cleco.



**7F1-2 Instrument Panel
7F15-1 Panel Bottom
Channel**

Position 7F15-1 Panel Bottom Channel on the bottom side of the Instrument Panel. Mark a centerline on the Channel and clamp it to the Instrument Panel centerline. The Bottom Channel will extend forward 8mm. Layout a rivet line with a pitch 60mm A4 rivets. Drill and Cleco.



**7F1-2 Instrument Panel
7F15-1 Panel Bottom
Channel**

At this time the Top Skin and Panel can be deburred. Just cleco the Front Top Skin, this will allow access to the Panel to install the instrument and wiring.