

HAT SECTIONS, BULKHEADS & COWLING STRINGER

****ALL SKINS SHOULD OVERLAP FROM FWD-AFT. THE TOP & BOTTOM SKINS SHOULD BE OVERLAPPED BY THE SIDE SKINS. ****

- Hat sections will need to be installed starting at station #2 thru station #14. (Refer to T51-03-INS-0963.)
- When installing the center stringers, use a SK32BS rivet in opposite corners of the stringers will help to prevent stringers from moving while drilling fuselage skins.
- Position all upper bulkheads in place using (1) flange hat sections in most places (stations #2 & #3 will need upper and lower bulkheads in place using regular hat sections).
- Build station #2 & #3 as shown on drawings (1041, 0820, 1053, 1487).
- When installing the upper cowling stringer (MF03-298) be sure bulkheads U5-U2 (MF03-163, 164, 165, & 166) are parallel.
- Bulkheads U2 (MF03-163) & L2 (MF03-173) will need the rivets drilled out prior to installing the firewall. (MF03-199)
- Remove the center of U5 (MF03-166) for instrument clearance before attaching the upper cowling. The instrument panel face (MF03-135) can then be used to keep (U5) straight while attaching cowling stringer. See T51-07-INS-1606
- Assemble & install the elevator/rudder bellcrank assembly as shown on T51-03-INS-0811.

By

Date

Checked

Date

Approved

Date