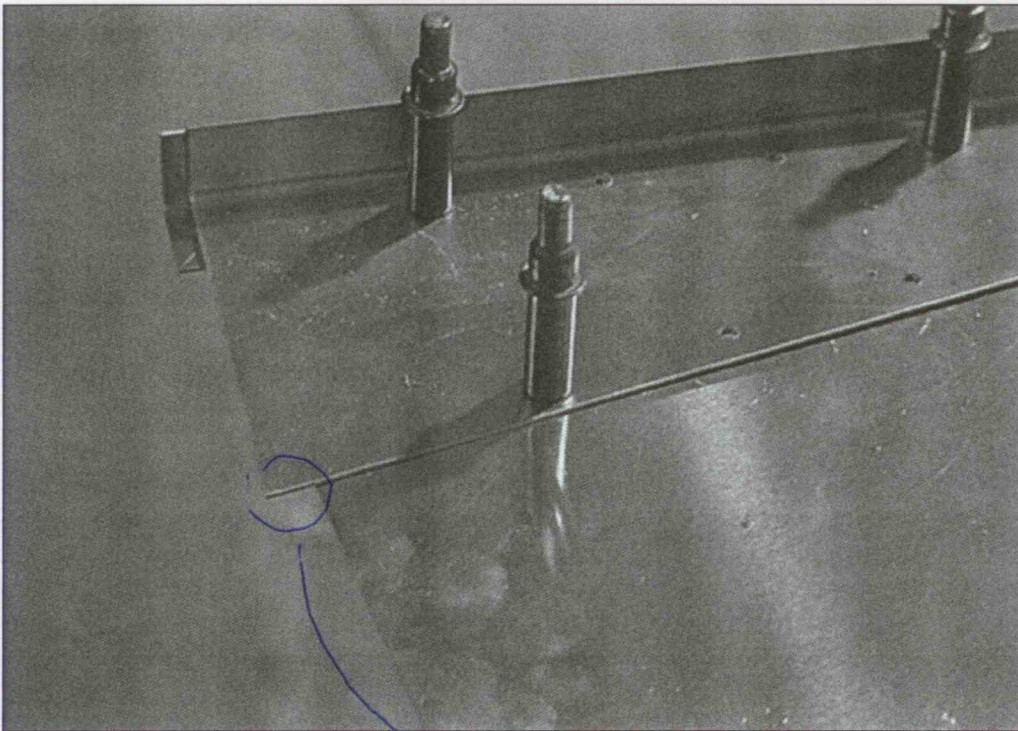




7F3-2 BOTTOM LONGERON DOUBLER

SUGGESTION: Before installing the Doubler 7F3-2. Cleco the Bottom Skin to the Doubler, along the bottom edge of the Doubler trace a **reference line**.

Position the Bottom Longeron Doubler 7F3-2 to the Bottom Skin; then slide a piece of .016" material between the Doubler 7F3-2 and the Longeron 7F3-1 (to represent the Fuselage Side Skin 7F2-2. CHECK that the .016" material is not pushed down too far or it will interfere with the bend radius of the Longeron).
Clamp the side flanges together.



Check the position with the above reference line. Be very careful that the Longeron 7F3-1 does not move when drilling. At this time don't worry about trimming the correct angle on 7F3-2. Drill and cleco #20.

The Longeron 7F3-1 & 7F3-2 will be trimmed later. The side flanges are trimmed flush with the front edge of the Fuselage Side Skins. *- later*
(Sec. 4 page 11)