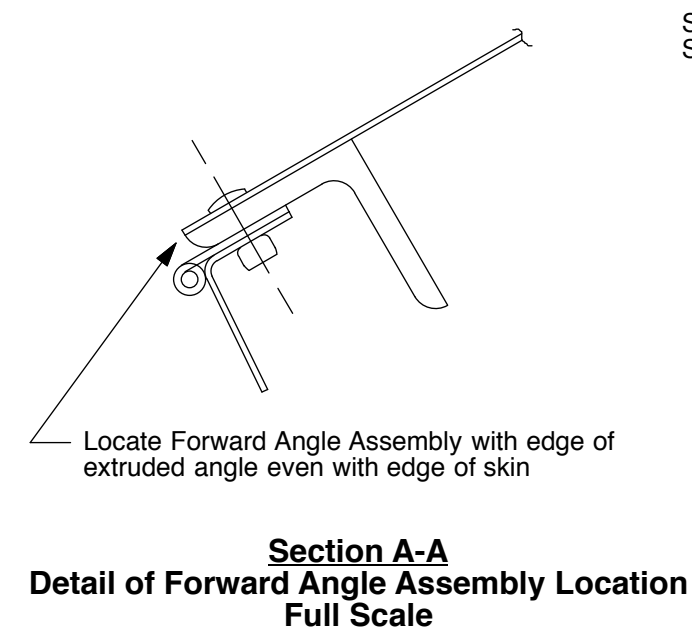
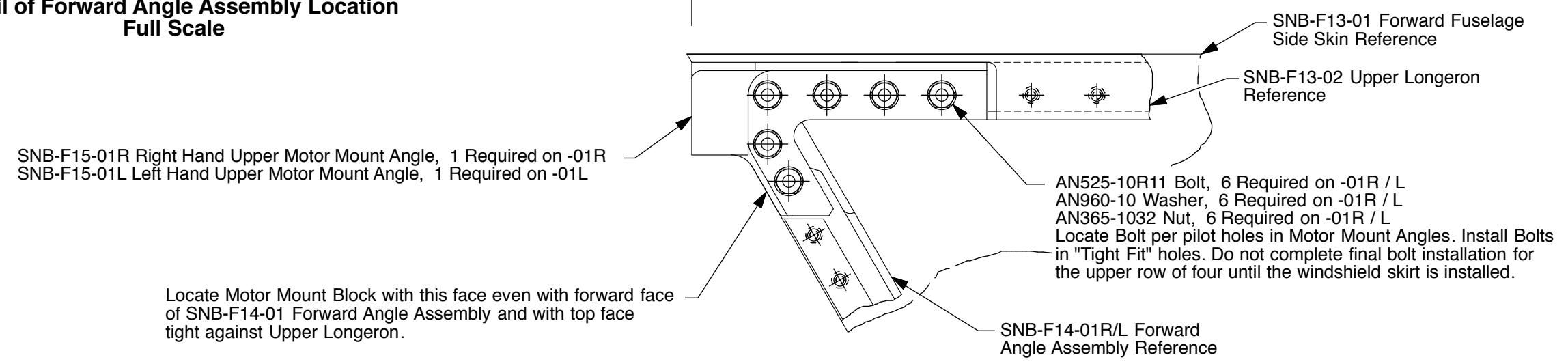


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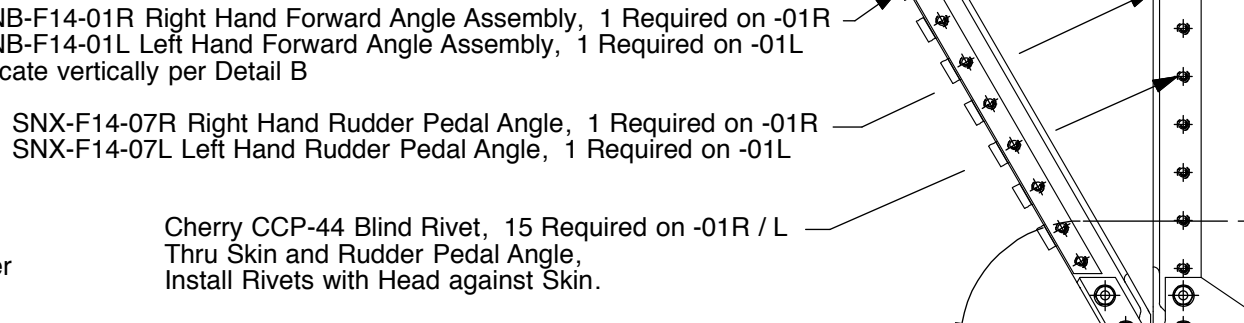
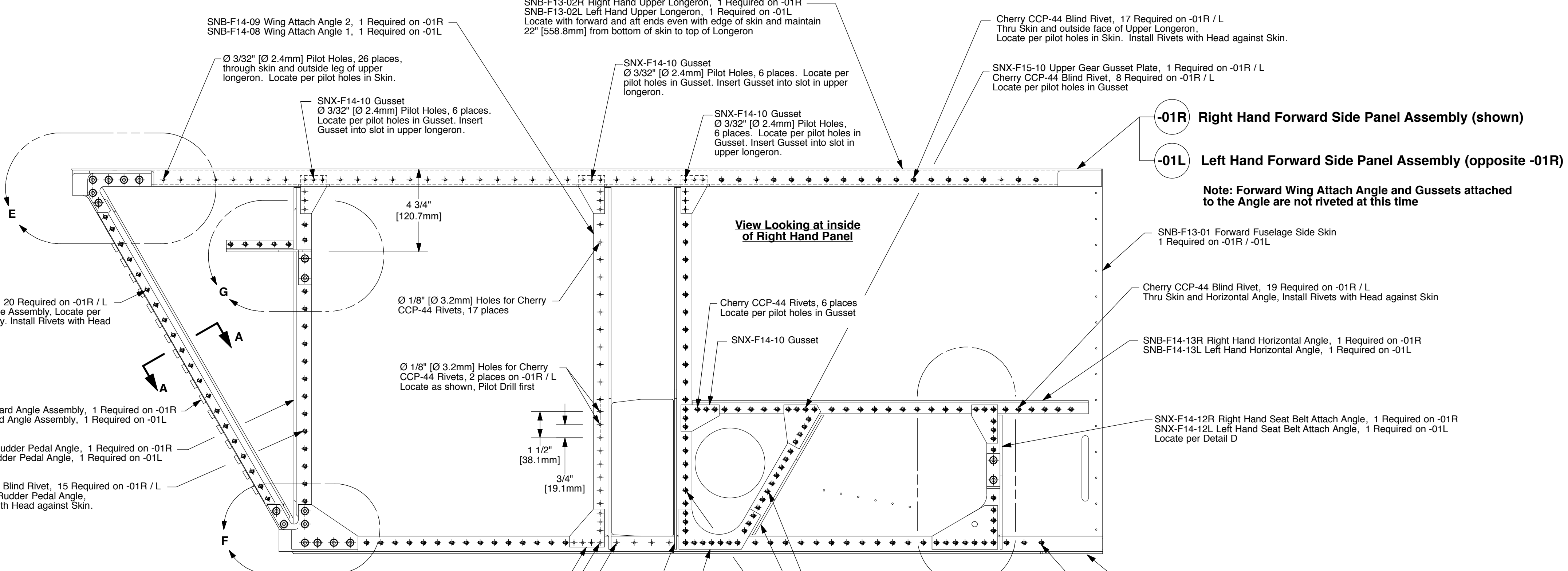
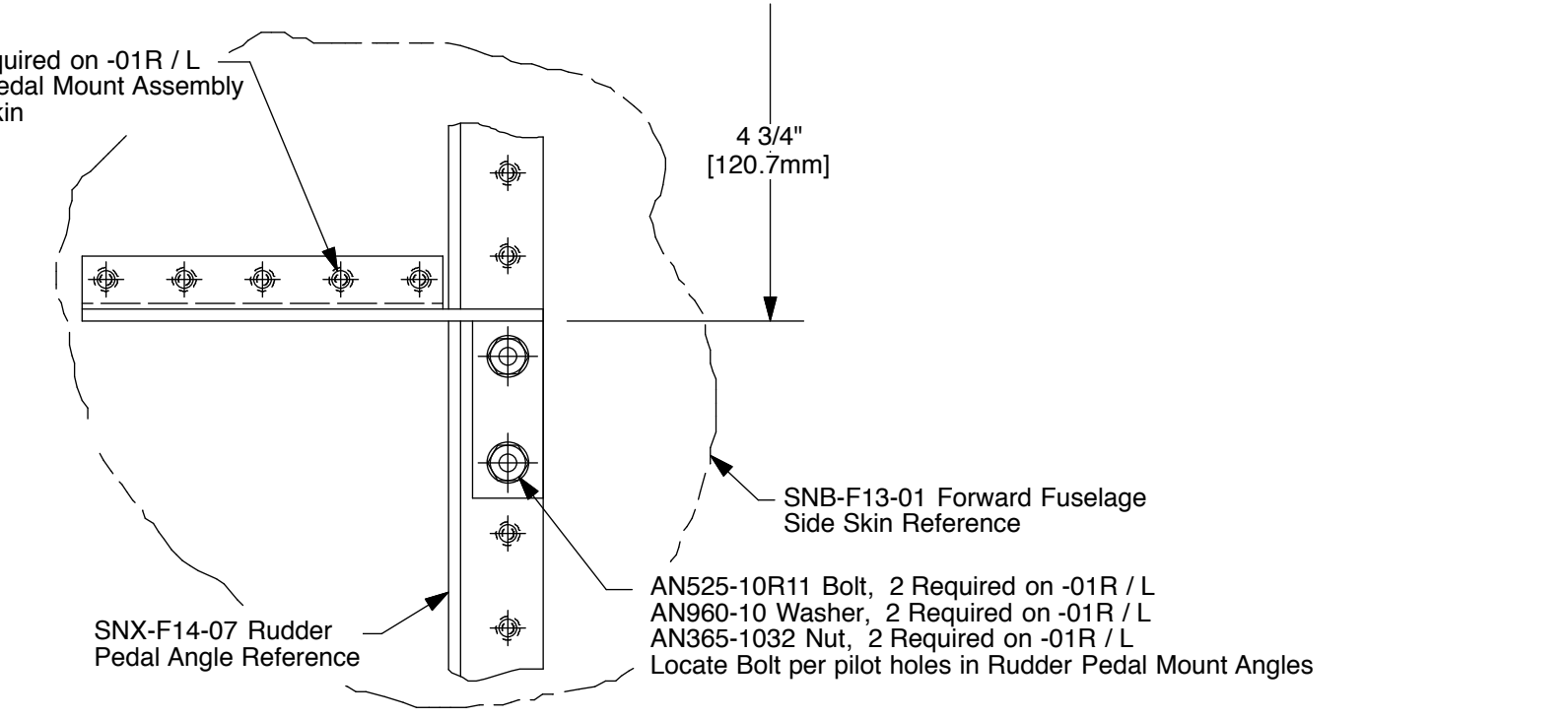
Revision Letter	Change Description	Date
A	Forward rivets through skin and upper longeron should be left to a later assembly after windshield skirt is installed, corrected here to pilot holes only. Changed AN525-10R11 bolts through motor mount angles, rudder pedal mount angles, and angle clips to AN365-1032. Four holes below spar tunnel cutout changed to 1/8" holes instead of rivets to allow for spar bumper install on F12.	08.24.16
B	Changed Part # SNX-F15-12R & -12L to SNB-F15-12R & -12L. Angle Clip.	10.23.16



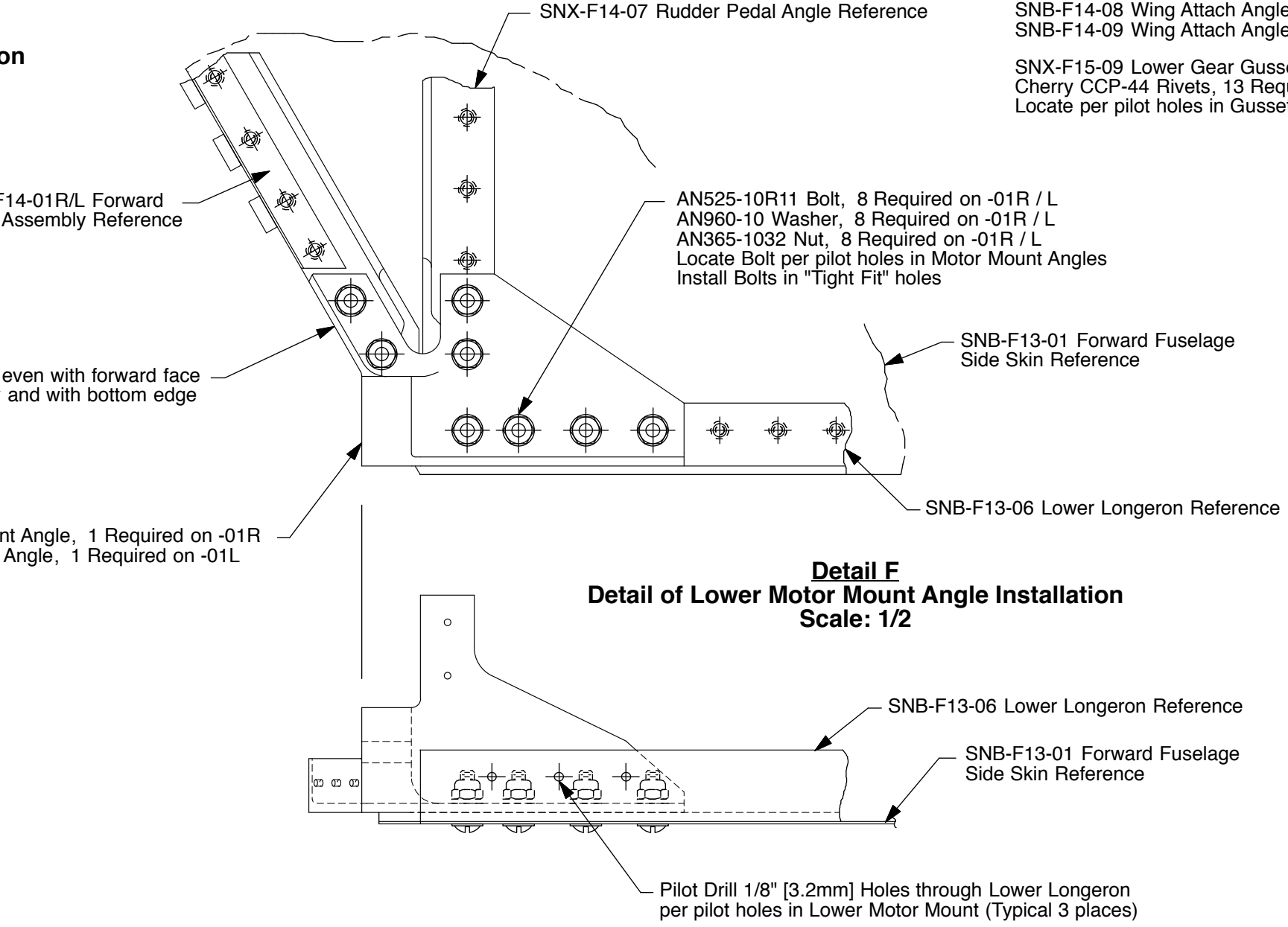
Detail E
Detail of Upper Motor Mount Angle Installation
Scale: 1/2



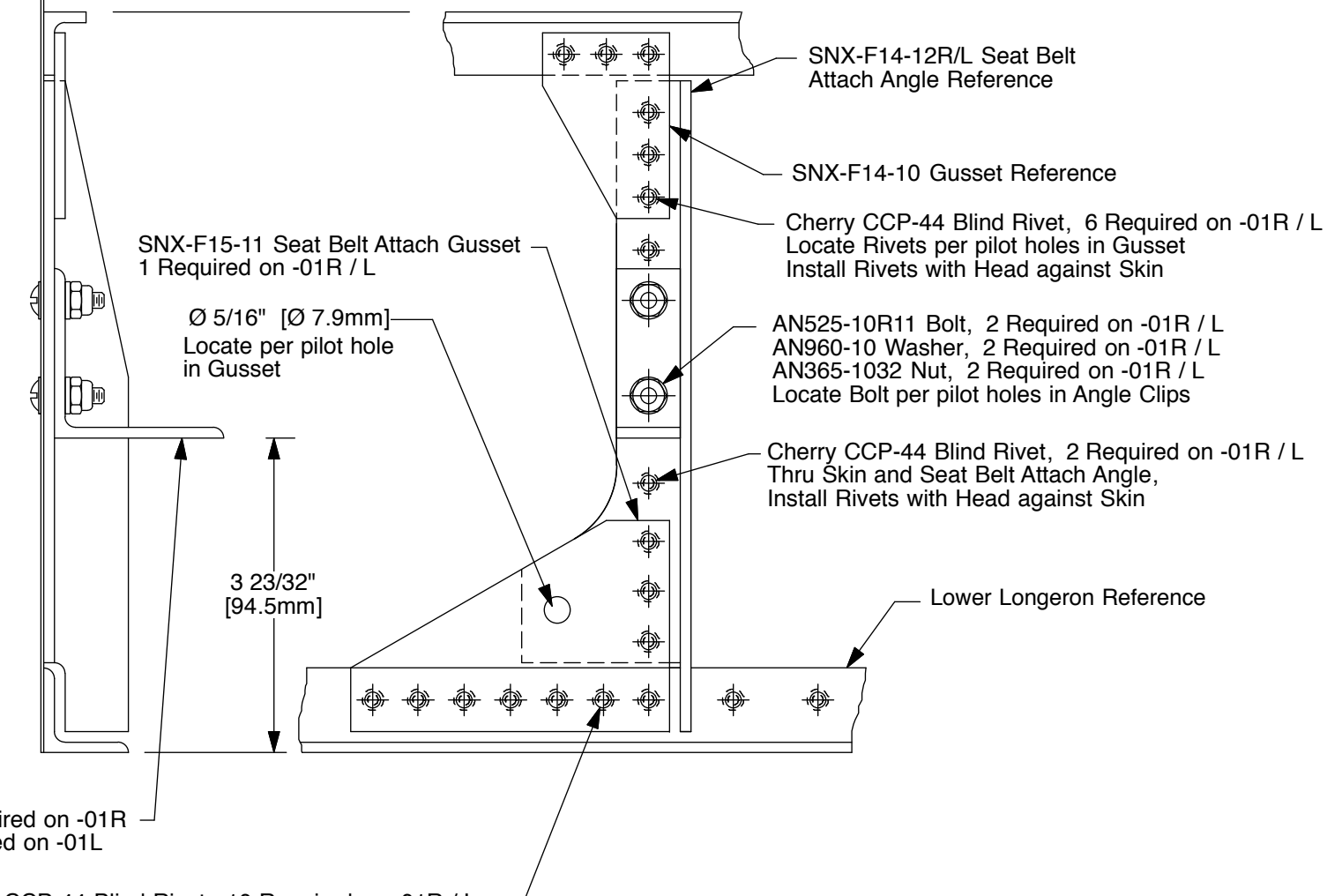
Detail G
Detail of Rudder Pedal Mount Assembly Installation
Scale: 1/2



Detail F
Detail of Lower Motor Mount Angle Installation
Scale: 1/2



Detail D
Detail of Seat Belt Attach Angle Location
Scale: 1/2



- Note: General Construction Order
- 1) Lay Lower Longeron Angle down on edge of flat building table.
 - 2) Lay Side Skin on table face down with bottom edge of Longeron even with bottom of Side Skin.
 - 3) Locate, pilot drill & cleco Lower Longeron in place using pilot holes in Side Skin
 - 4) Locate, pilot drill & cleco Upper Longeron in place using pilot holes in Side Skin.
 - 5) Locate, pilot drill & cleco SNB-F14-01 Fwd Angle Assembly using pilot holes in Angle Assy
 - 6) Cleco Forward Rudder Pedal Angle to Side Skin
 - 7) Cleco Wing Attach Angle 1 and 2 to Side Skin
 - 8) Cleco SNB-F14-13 Horizontal Angle to Side Skin
 - 9) Cleco Gear Attach Angle to Side Skin
 - 10) Cleco Seat Belt Attach Angle to Side Skin
 - 11) Locate, pilot drill & cleco Upper Motor Mount using pilot holes in Mount (see Detail "E")
 - 12) Locate, pilot drill & cleco Lower Motor Mount using pilot holes in Mount (see Detail "F")
 - 13) Locate, pilot drill & cleco SNX-F14-10 Gusset (5 places each side) using pilot holes in Gusset
 - 14) Locate, pilot drill & cleco Rudder Pedal Mount Assy using pilot holes in Mount.
 - 15) Cleco Lower Gear Gusset to Side Skin
 - 16) Cleco Upper Gear Gusset to Side Skin
 - 17) Locate, pilot drill & cleco Seat Belt Attach Angle Gusset using pilot holes in Gusset
 - 18) Locate, pilot drill & cleco SNB-F14-10 Gusset (5 places each side) using pilot holes in Gusset
 - 19) Drill all holes out to size for the Fasteners
 - 20) Disassemble, Deburr and Reassemble Side Panel
 - 21) Install Fasteners as called out (Note: make sure Side Panel remains flat, no twist, while installing fasteners)

SNB-F12-01L	1	Left Hand Forward Side Panel	SNB-F11
SNB-F12-01R	1	Right Hand Forward Side Panel	SNB-F11
Part / Assy Number	Qty. Req'd	Part Title	Next Assembly

Drawing Scale			Drawing Number			Revision		
1/4 & Noted			SNB-F12			B		