



Start by drawing a forward centerline along the bottom flange of WD-716A-L/R.

Next bend stiffening flanges around the 9 large lightening holes using a notched wooden block (See SEC A-A). This method is similar to the method used in pre-bending the edges of overlapping skins to make them lay down properly. Bend tabs on F-7128B side reinf. brace to make F-7128B-L and F-7128B-R (See SEC B-B). Test fit F-7128A center brace and F-7128B-L/R side reinf. braces. Some trimming or further bending of the tabs may be required for a proper fit.

Remove the parts and using proper edge distance drill the attach holes at the outboard and inboard ends of the flanges. These holes were omitted to allow greater flexibility when trimming the parts.

Make six F-7128C Clasps.

Align the forward reinf. brace with the drawn forward centerline. Clamp the braces then drill them to the C-702 canopy skin and WD-716 canopy frame. Use caution to be sure that the canopy frame is not twisted. Block up with equal sized blocks on a table.

With the braces clecoed in place, hold the F-7128C clasps to the outside surface of F-7128B-L/R (opposite side that they will be installed on), and match-drill them to the F-7128B-L/R side reinf. braces, using the clasps as a drill guide.

For the two most outboard aft tabs on F-7128B-L/R side reinf. brace (all F-7128B-L/R side reinf. brace to WD-716B-L/R canopy frame to C-702 canopy skin rivets) do the following. If the canopy skin is already installed, machine countersink the C-702 canopy skin and WD-716B-L/R canopy frame. If the C-702 canopy skin has not been installed dimple the skin and machine countersink WD-716B-L/R canopy frame. Dimple all remaining holes in the C-702 canopy skin and corresponding attach holes in the reinf. braces. Finish preparing all parts; deburring, priming, etc..

With the F-7128B-L/R side reinf. braces removed, rivet on the F-7128C clasps (to the inside surface of F-7128B-L/R side reinf. brace). Next rivet on the aft brace flanges and tabs to C-702 canopy skin and WD-716B-L/R. Rivet the forward brace flanges to WD-716A-L/R.

BILL OF MATERIAL

QTY	DESCRIPTION
1	F-7128A CENTER REINF. BRACE
2	F-7128B SIDE REINF. BRACE
45	LP4-3 BLIND RIVETS
41	AN426AD3-3.5 RIVETS
8	AN426AD3-4.5 RIVETS
12	AN470AD4-4 RIVETS

NOTE:

1) THE DRAWING AND INSTRUCTIONS ARE REPRESENTED FOR INSTALLATION OF REINFORCEMENT BRACES ON A RV-7 OR RV-8. RV-6 INSTALLATION IS SIMILAR.



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DATE DRAWN: 07/25/01

DRAWN BY: RIAN JOHNSON

TOLERANCES: NONE

(UNLESS OTHERWISE SPECIFIED)

PATH: \P\PARTS\OPTIONAL\PLANS\OP-25.DWG

UNITS:

INCHES

SCALE: AS NOTED

D-SIZE ORIGINAL

RV-6,7,9

OP-25