



**7F19-12D Door Sill**

Position the Door Sill on the upper Cabin Frame. The Door Sill will have to be trimmed to fit around the Cabin Frame. The rear of the Sill will extend to position between the Side Skin and Side Channel (7F5-2SP) and riveted together. The front will wrap around the Cabin Frame and will be screwed in with the Formed Windshield.



**7F19-12D Door Sill**

The front of the Door Sill on the inside is riveted to the Cabin Frame with two A4 Rivets.



7F19-12D Door Sill

Cutting a slot in the Door Sill is needed at the rear inside section to allow room for 7F12-4 Gusset.



7F19-12D Door Sill

The Door Sill is riveted to Cabin Frame with A4 Rivets.



**7F19-12D Door Sill  
7F19-13D Door Piano  
Hinge**

Position the Piano Hinge to the Door Sill. The Hinge is mounted on the under side of the Door Sill. It is helpful to rivet the Hinge in place at this time to the Door Sill (A4 pitch 40).



**3/8" Plywood Template**

Place a piece of 3/8" thick plywood against the opening of each door and hold it in place while an assistant accurately traces the opening on it. The template can be used for both sides, check to see how it fits in both openings.



After cutting the wood door template. Check to make sure it fits in the door area. Notice that the template is position under the Door Sill.



**7F19-7D Door Side**

Laying out the Door Side.



**7F19-7D Door Side**

Place the template board on top of the skin. Using a piece of 3/4" wood makes an excellent gauge to layout the 20mm distance. At this time don't worry about the height of the door side.



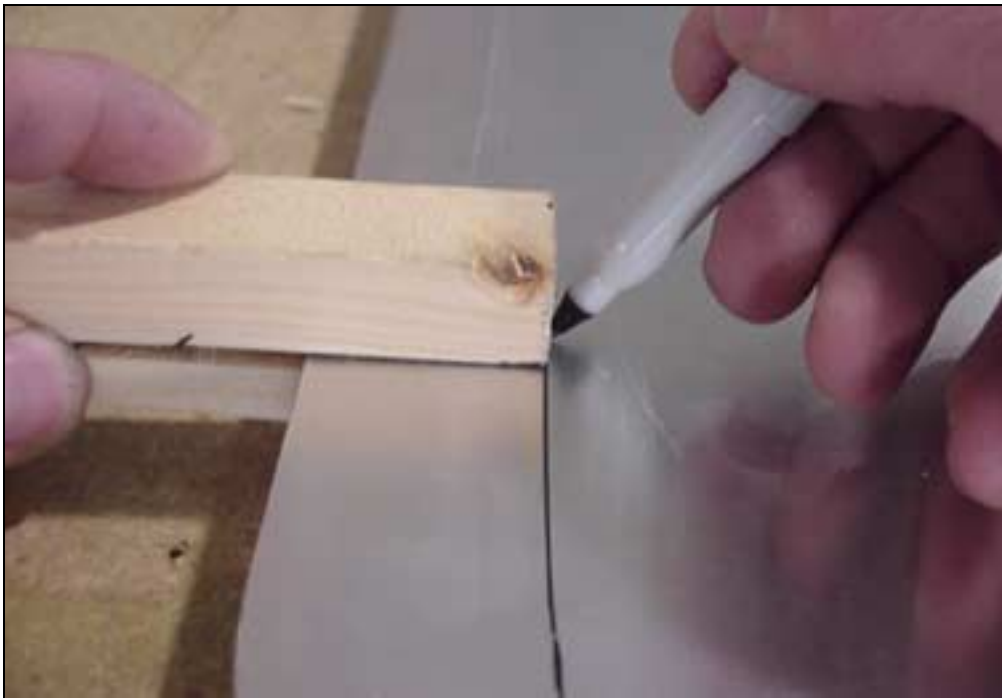
**Left Side Door**

- 7F19-2 Bent Door Frame**
- 7F19-3 Upper Tube**
- 7F19-4 Central Tube**
- 7F19-6 Door Gussets**

The frames of the doors are to be constructed smaller than the actual opening size. Layout a construction line 5mm back from the edge on the front, rear and bottom. The top is flush with the Door Sill. Along the construction lines drive finishing nails to act as stops. Position the Door Frame and place nails on the inside to hold the frame in place. This will be the outside of the door. The nails need to be lower than the tube to allow for the position of the Door Skin.



The Door Frame tube will have to be trimmed at the top flush with the template. Install the Upper Tube (7F19-3) to the Piano Hinge. Know position Gusset (7F19-6) to the Door Frame. To position the Central Tube, the front is located in line with the bottom corner of the Windshield and the back is 530mm down from the top. If the Windshield has not been installed using 560mm will work.



Gauge Block  
1" X 2" by cutting a slot  
and cutting back 6mm on  
the top edge. This will  
allow for the mark to be in  
the center of the tube.

Center the Door Side 7F19-7D on the Door Frame. Making a gauge block to locate the center of the Door Frame. This will be the rivet centerline. Before drilling make sure to double check center on the tube.



**7F19-6 Door Gussets**

Using a hole finder to locate the Gusset on the Door Side is very helpful. The Door Side is A4 pitch 40. Do not take the Door Frame off the wood template to drill the Door Side.



Cleco the Door Sill and Door Frame back on the Cabin Frame and install the inside Gusset.



**7F19-5 Short Tube**

Locate the Door Latch center hole. It is 25mm up from the center of the Door Frame and 40mm back from the lower bend. Use a Step Drill (Unibit) to enlarge the hole for the Door Latch. Two screws will secure the latch to the Door Skin. Drill the two small screw holes with #20 drill bit.



**7F19-5 Short Tube**  
Plate t= .040"

Position the .040" reinforcement plate. The plate is center on the Door Latch. Mark and drill the Door Latch holes in the plate. Position the Short Tube behind the Door Latch and in the middle of the lower Gussets. Drill and cleco using A4 Pitch 40.





**7F19-1A Door Window**

Position the Door Window on the Door. Let the Window overhang on the front and rear. This will be trimmed later to match the Windshield and back edge, drill and cleco. It can be riveted later after painting is done.



**7F15-3D Striker Plate**

Position the Striker Plate on the Cabin Side (7F9-6). Drill and rivet three A4 Rivets.



**7F15-4D Interior Handle  
7F15-3D Striker Plate**

Position the Interior Handle to the Exterior Door Handle. For tight fit between the Interior Handle and the Striker Plate, either add a washer or file down the interior Tube Bushing (14613). The Interior Handle is secured with MS24693-S275 Screw.



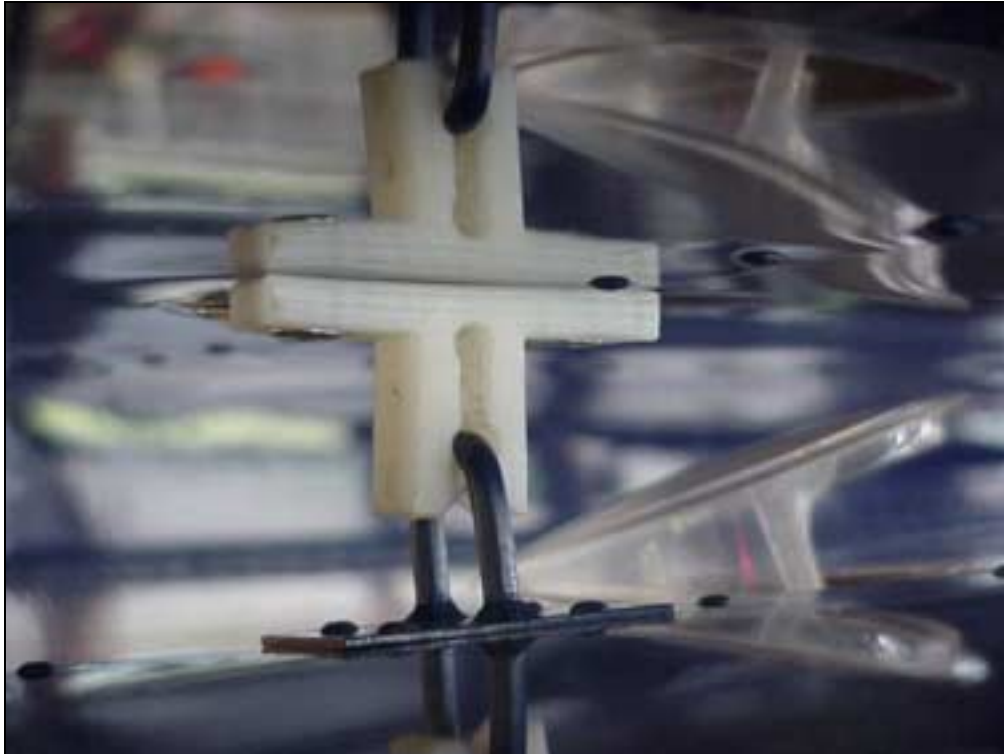
**Exterior Door Handle**

There is left and right side Handle. The Handle will open to top of the Door see drawing 7-F-15.



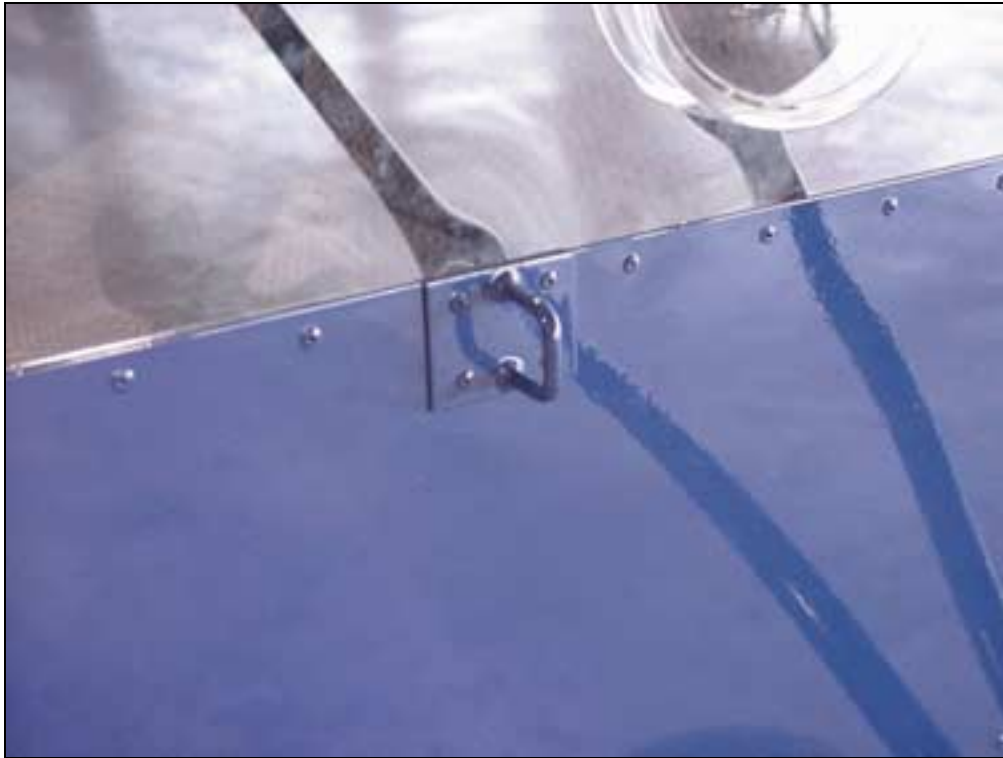
**7F19-10D Door Clasp**

Position the Door Clasp to the Wing. The Clasp is riveted on Spar centerline and one rivet on the Leading Edge Skin. It may be necessary to use A6 rivets to hold the Clasp to the Wing.



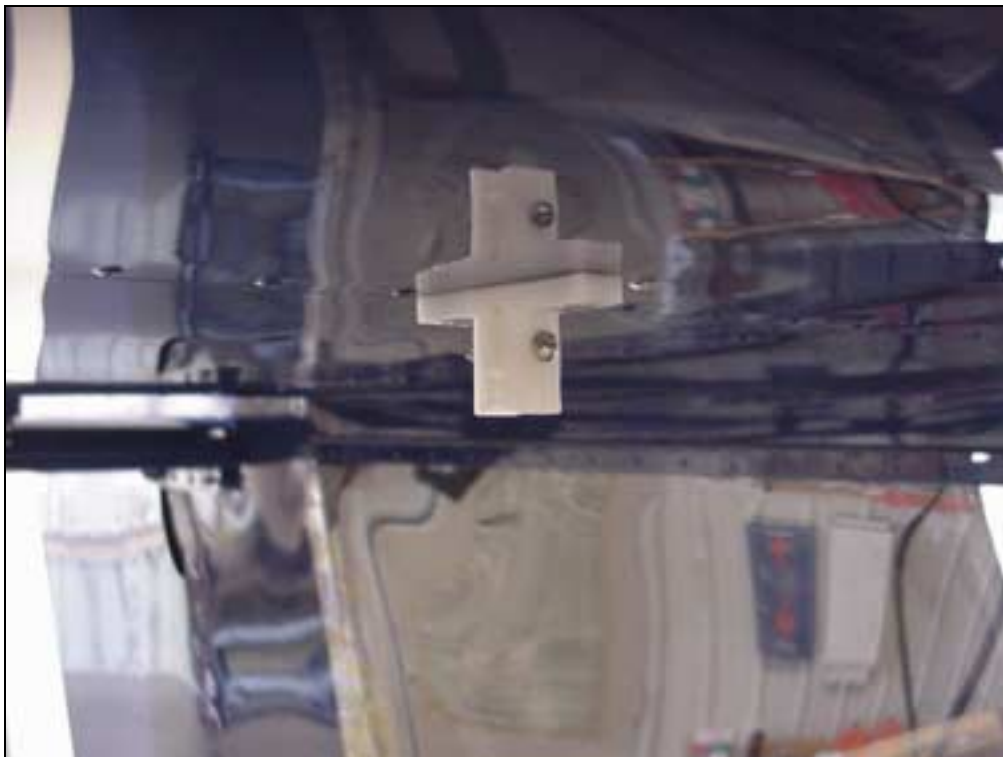
**7F19-10D Door Clasp  
7F19-14D Door Retainer**

When positioning the Door Clasp and Door Retainer attach together for the correct location.



**7F19-14D Door Retainer**

Drill and rivet four A4.



**7F19-10D Door Clasp**

If the Door does not stay up, add a bolt to tighten the Clasp.