



Position the front canopy on the fuselage. Line up the aft edge between the 2 tubes.



Mark the pre-drilled holes in the tube on the bubble. Use a #40 drill to drill a small impression over the existing holes - do NOT drill through.

Support the front edge on the strip across the fuselage. Check that the bottom edge is even with the top of the fuselage sides. If necessary mark a new tape line. Now that the canopy is cut, it is normal for the bubble to have shifted slightly.

Craftics Plas-Drill Bit
No chipping • No cracking
No grabbing • No melting

Flukes ground to 90-degree point with 0-degree rake for superior cutting quality in acrylic.

Drilling Procedure:
 Clamp material to be drilled securely to a bench or table. Place a backing block of scrap acrylic or plywood under drilling point to prevent chipping when bit breaks through.
 Chuck Plas-Drill bit firmly in hand drill or drill press and feed drill slowly into plastic. Use steady pressure, then reduce pressure just before drill breaks through.

NOTICE: To prevent dulling, do not use Plas-Drill Bits on non-plastic materials, and protect bit tips when storing.



5/32" drill



IMPORTANT: Use a wood block on the back-side to drill a clean, shatter-free hole.



Practice drilling holes in the cut-off piece.



Drill shatter free holes (the shatter is generally located on the back side of the hole)



Remove the bubble to drill the 5/32" holes in the rear tubes.

De-burr both sides of each hole.



Scuff the sides



Cleco the bubble in place (3/32" clecos)



Mark and drill the sides.



Start at the back and cleco towards the front



Cleco the left and right side.

Install the front tube. It is easy to get the tube behind the instrument panel with the front skin removed.

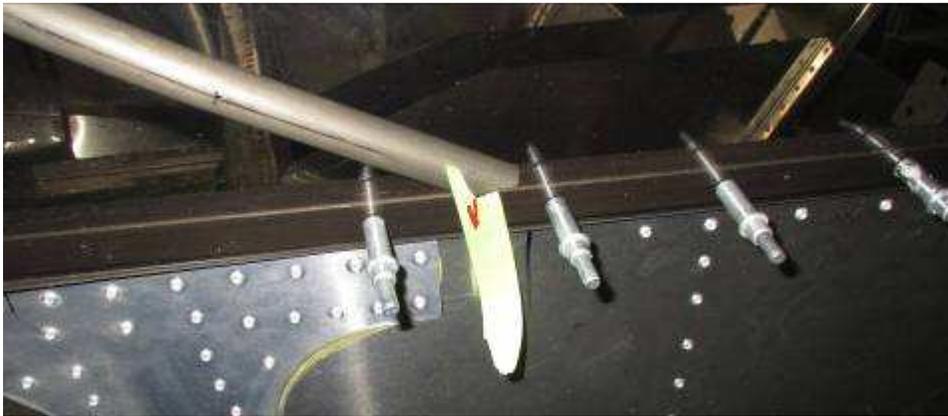
Position the 2x4 to set the minimum height (see next page).

Drawing the tube tight against the bubble.

Look from behind to make sure looks level



Check that the tube is centered over the instrument panel (left and right sides are equal)



Ends of front tube rest on top of the canopy side frame.

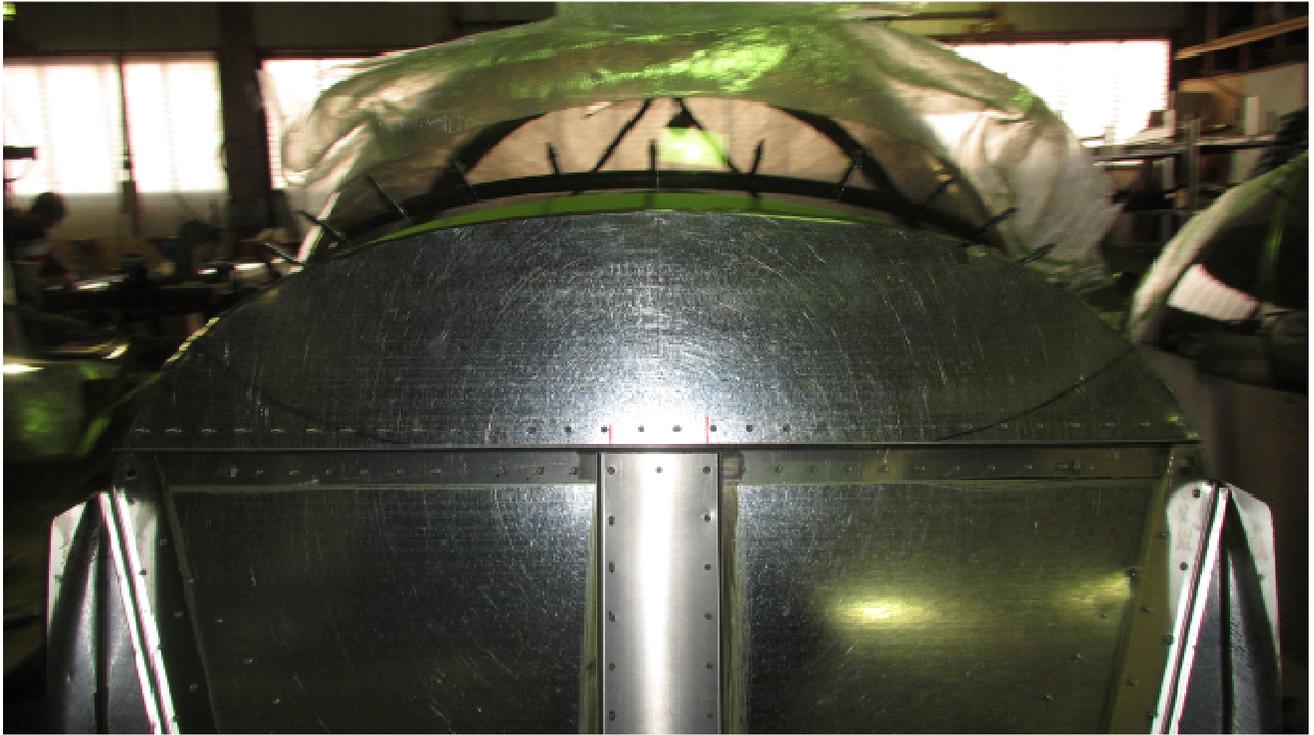
Draw the tube tight against front of the bubble.



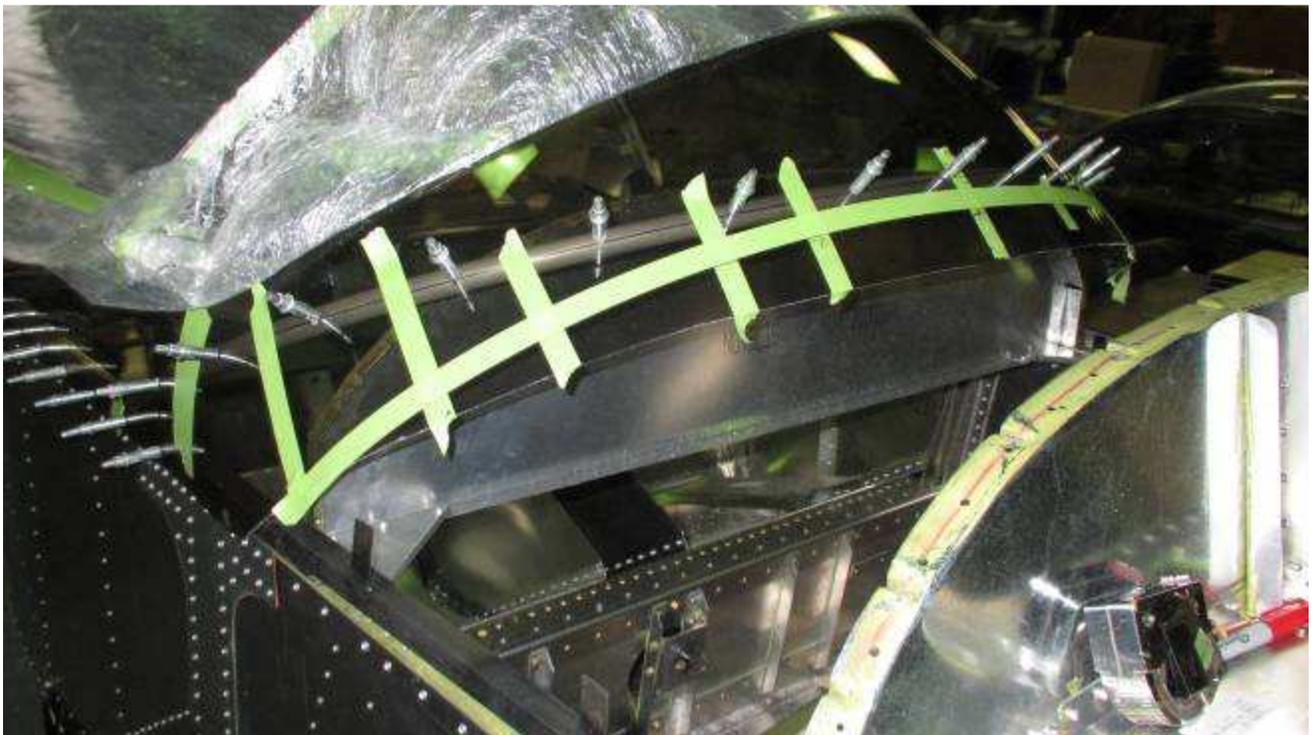
Using the drill to mark the holes with a shallow dimple.



2x4 lumber to set the height of the front tube above the top skin.



Remove the tube and drill the holes in the plexiglass.



Sight across the firewall and instrument panel to make a mark on the piece of tape. Use a flexible edge to connect the points and trim.



Flexible edge between instrument panel and firewall.



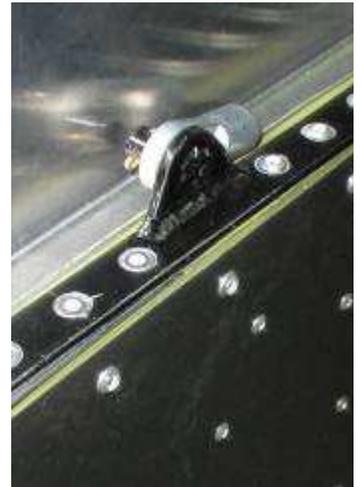
Keep trimming the front edge until it does not touch the strip.



Mark the aft edge of the FRONT CANOPY FRAME GUSSET 65C3-12 on the side frame (left and right side).

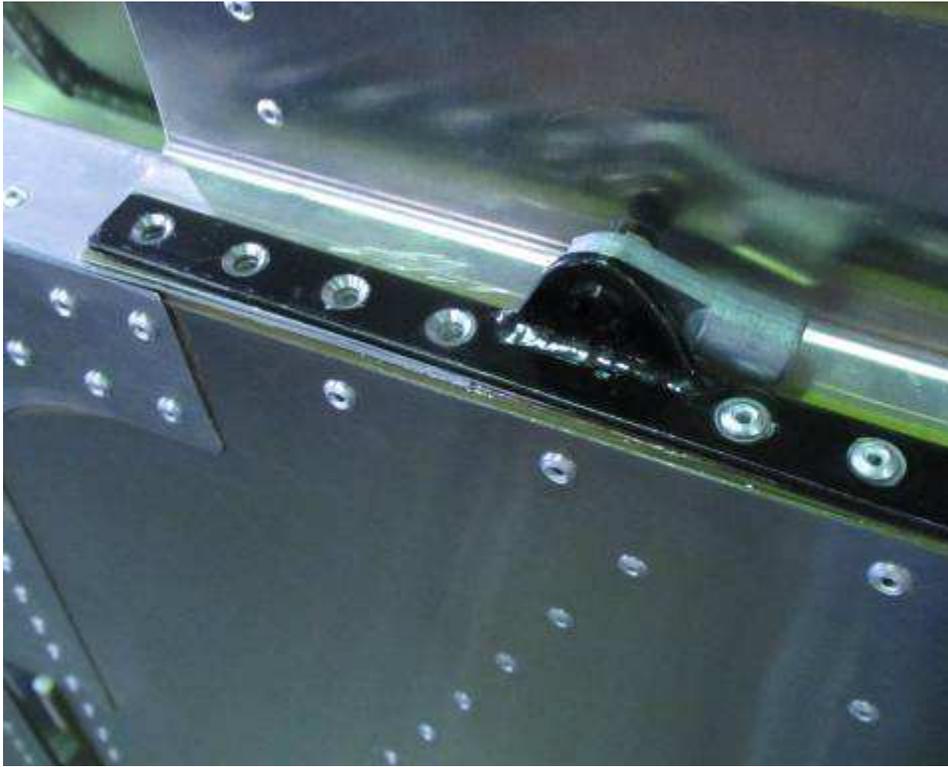


Remove the bubble to rivet the brackets to the side tubes.



Remember to install the eye 9426K94 before riveting

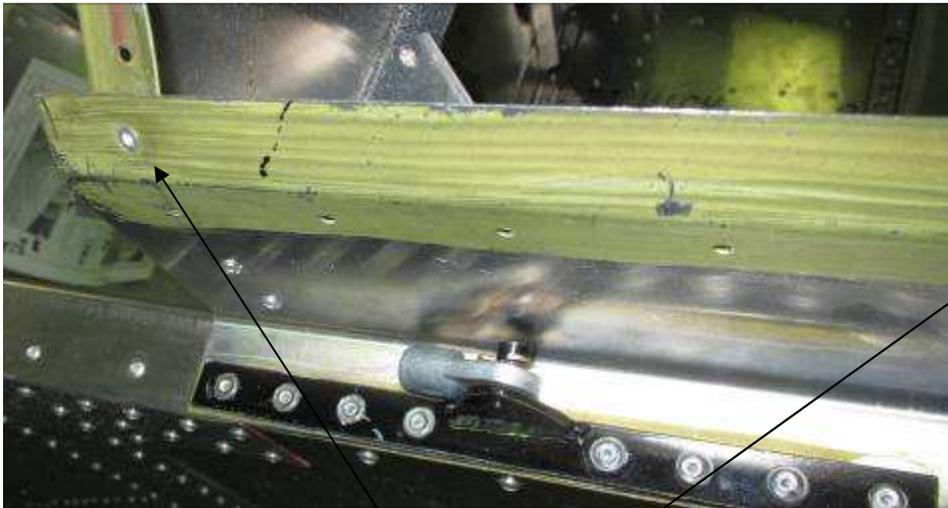
Reinstall the panel side angle 65C1-1 and the bottom bracket 65C2-2



Countersunk holes in the aft portion of the bottom bracket 65C2-2



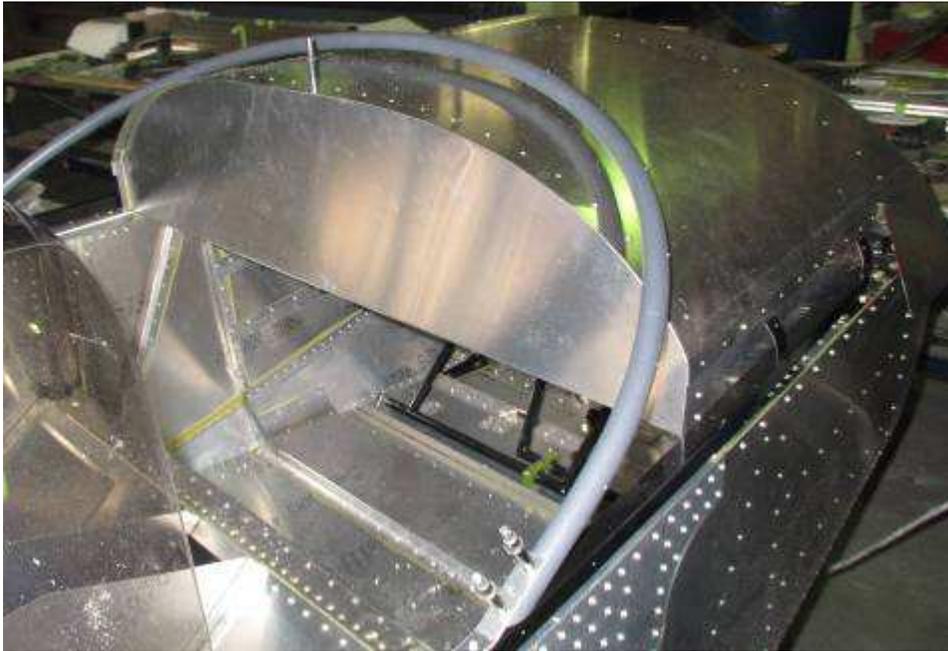
4 flush rivets in the rear portion.



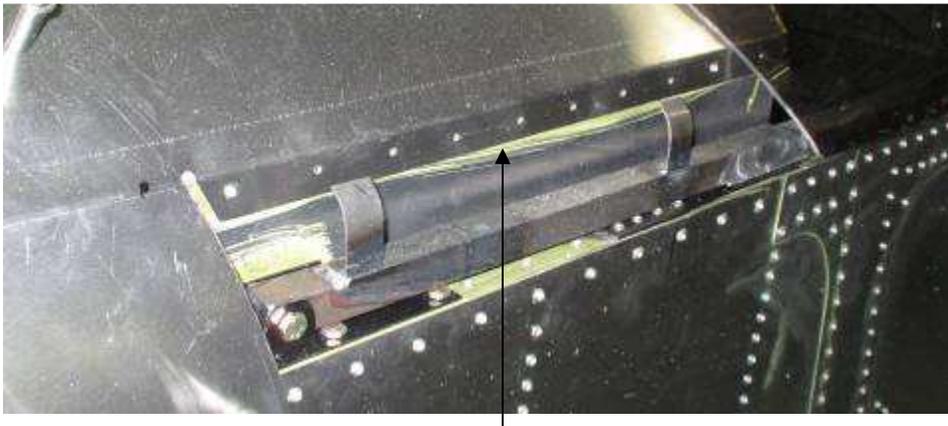
Flush rivets through the instrument panel and firewall.



Flush rivet at front through firewall flange



Cleco the forward top skin 65C1-4



To prevent the welded rod on the canopy side frame from catching and damaging the flange, add rivets in the middle as well as at the ends.



Canopy hinge bolt



Cleco the canopy to the frame.



Install the hold-open cylinders.

