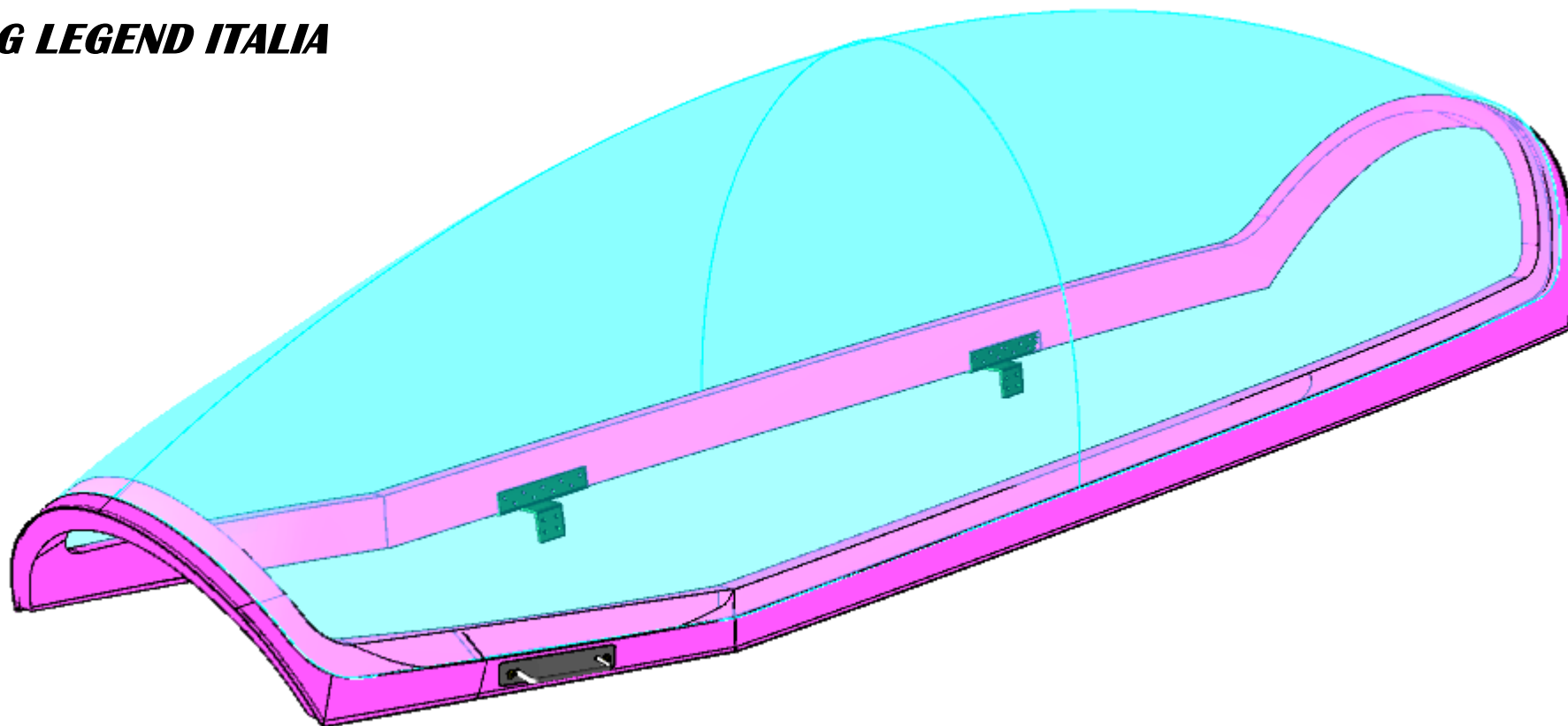




FLYING LEGEND ITALIA



FUSELAGE-CANOPY

FUSOLIERA - CANOPY

TUCANO REPLICA

REV. 0

N° PAGINE: 32

11/06/2018

PARAFIAMMA

FIREWALL

CODA

TAIL

Measure taken from the inclination change to the centre of the hinge

150mm

CA-HA

Measure taken from the centre of the front hinge to the centre of the rear hinge

1000mm

CA-HP

MISURA PRESA DAL CENTRO DELLA CERNIERA ANTERIORE AL CENTRO DELLA CERNIERA POSTERIORE

LE MISURE VERTICALI DEI FORI VANNO PRESE DAI LABBRI DELLA GUIDA CANOPY

The vertical measures have to be taken from the lips of the canopy guide

10

10

10

10

PRODUZIONE:
FUSOLIERA - CANOPY

STEP:
MONTAGGIO CERNIERE

DISEGNATO DA:
D. CONIGLIONE

PROGETTO:
TUCANO REPLICA

DATA:
25/05/2018

REV.:

SCALA:
N.D

MODIFICATO IL: OPERATORE

CONTROLLATO IL: OPERATORE

MODELLO:
TR-

NOTE:



FLYING LEGEND ITALIA
C.DA CAUDARELLA
95041 CALTAGIRONE (CT)

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DISEGNO
01

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Drill the holes from the hinge to the fuselage at $\varnothing 3,2$

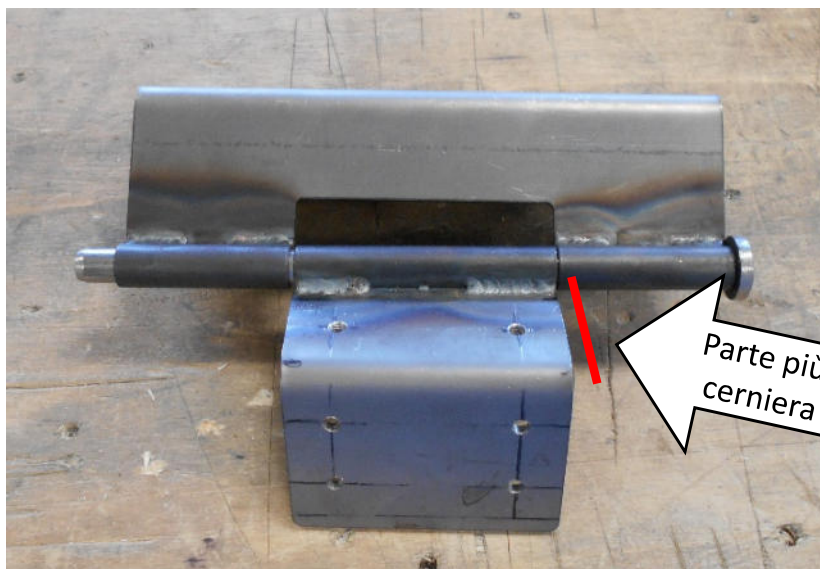
Ripassare i fori dalla cerniera alla fusoliera a $\varnothing 3,2$.

Drill to the final size $\varnothing 4$ and rivet the lower half -hinge, if this is painted, with rivet $\varnothing 4 \times 12,5$

Si consiglia di passare a misura definitiva ($\varnothing 4$) e rivettare la semi-cerniera inferiore, se questa risulta già verniciata, con rivetti $\varnothing 4 \times 12,5$

Front hinge

Cerniera anteriore
(CA-HA)



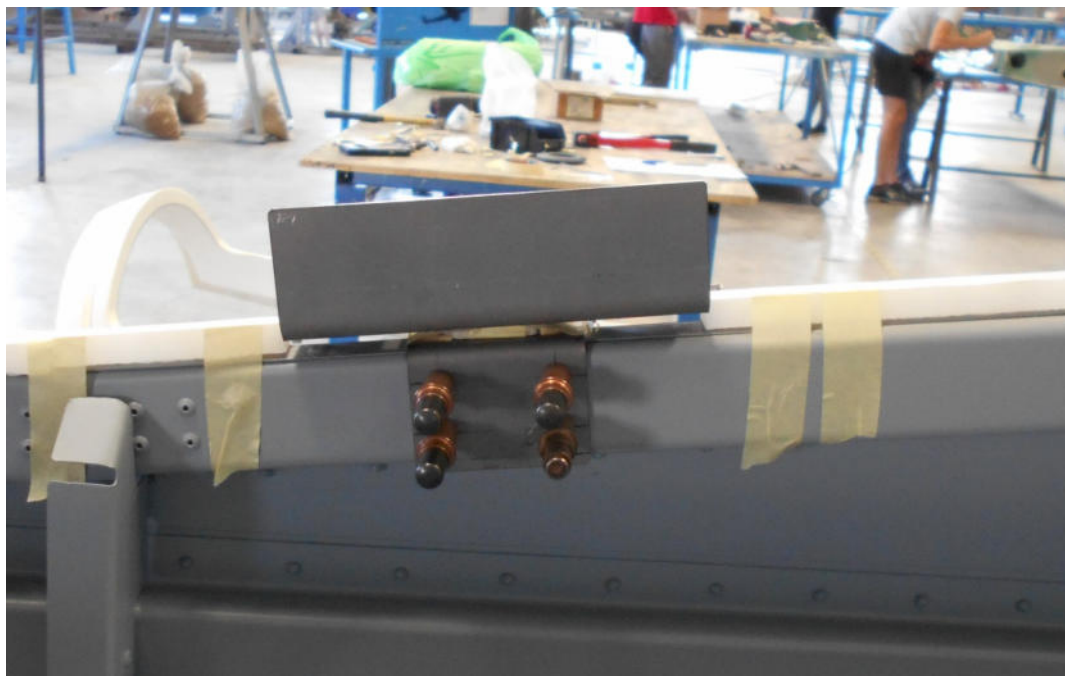
Fare attenzione: la cerniera posteriore è più lunga di quella anteriore

Pay attention: the rear hinge is longer than the front one

Longest part of the rear hinge

Back hinge

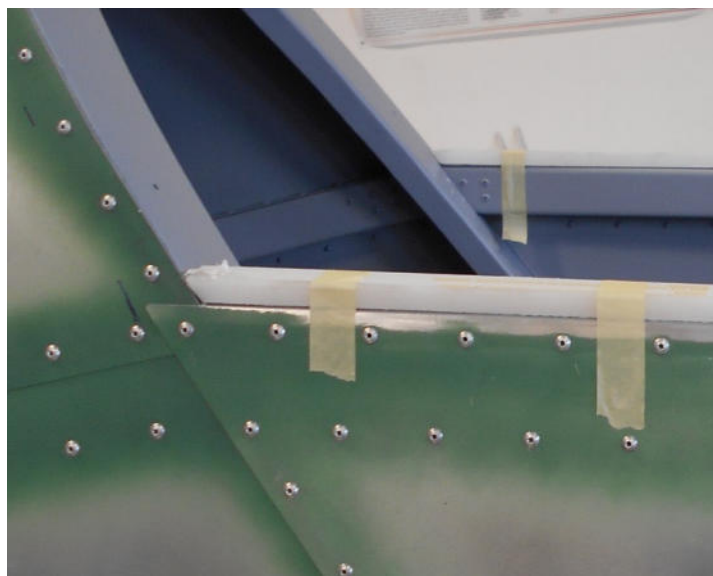
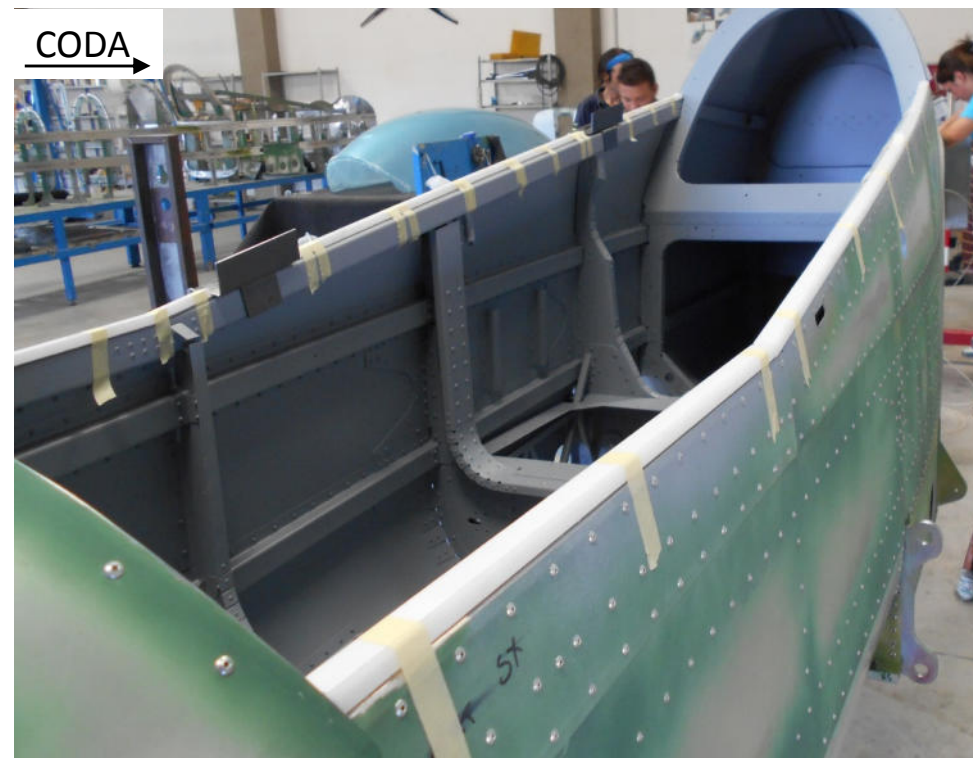
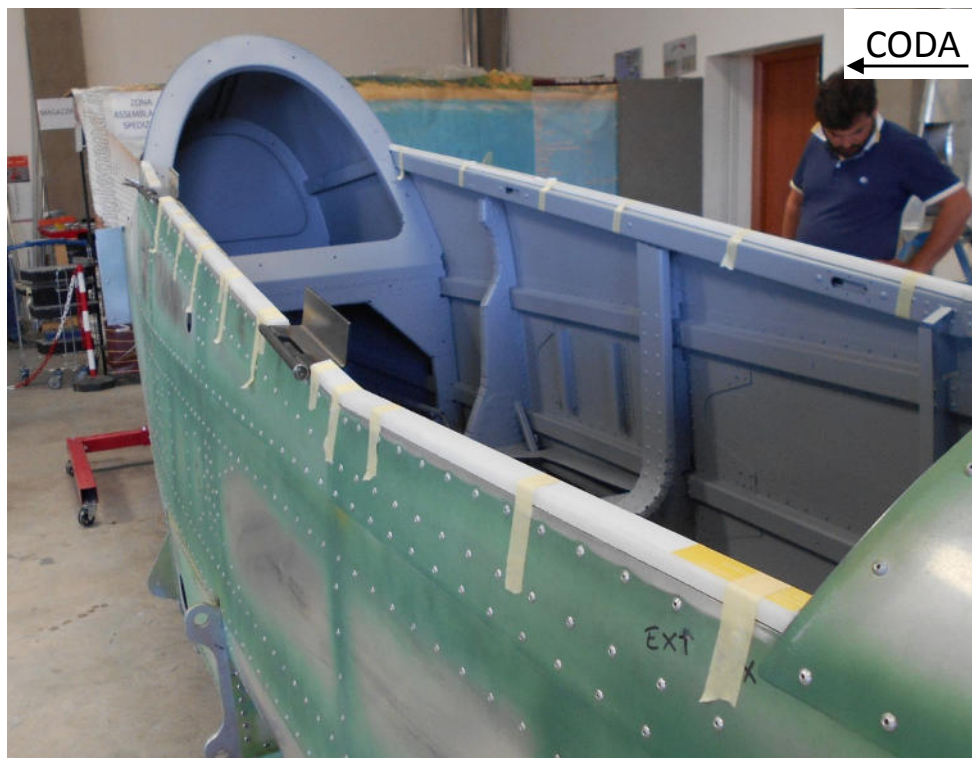
Cerniera posteriore
(CA-HP)



↑ ORDINATA 3
BULKHEAD 3



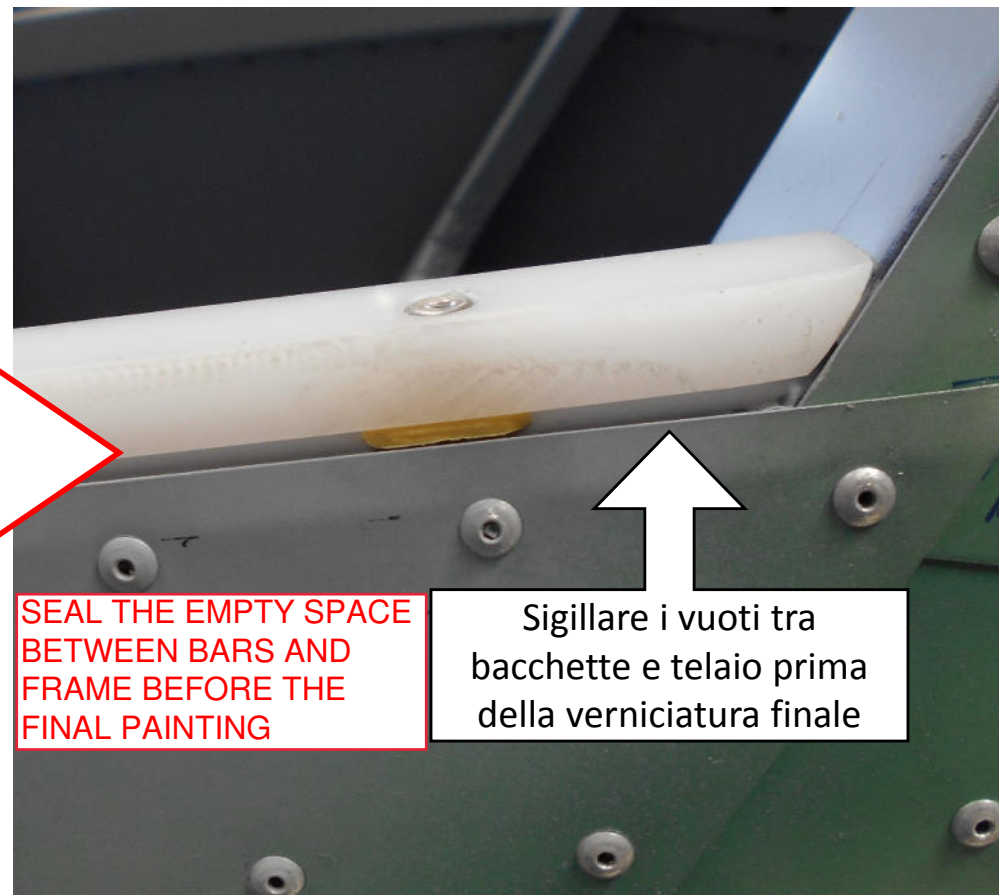
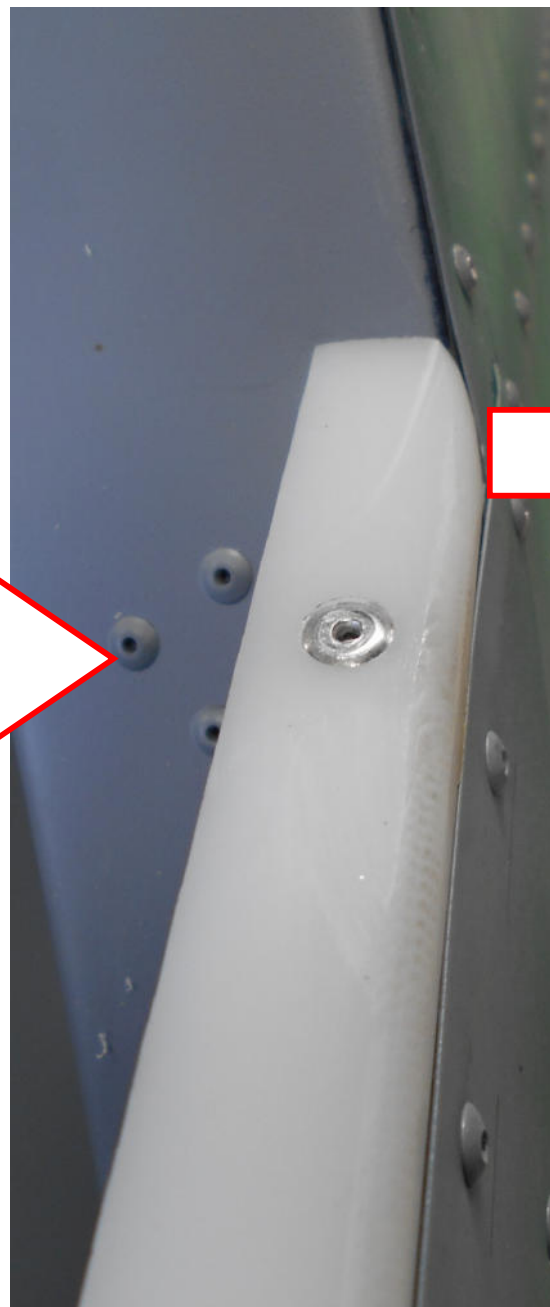
↑ ORDINATA 5
BULKHEAD 5



SHAPE ADEQUATELY THE PLEXIGLASS BARS TO THE
EDGES AND IN THE INCLINATION CHANGE OF THE CANOPY
GUIDE

SAGOMARE
OPPORTUNAMENTE LE
BACCHETTE IN PLEXIGLASS
ALLE ESTREMITÀ E NEL
CAMBIO DI INCLINAZIONE
DELLA GUIDA CANOPY

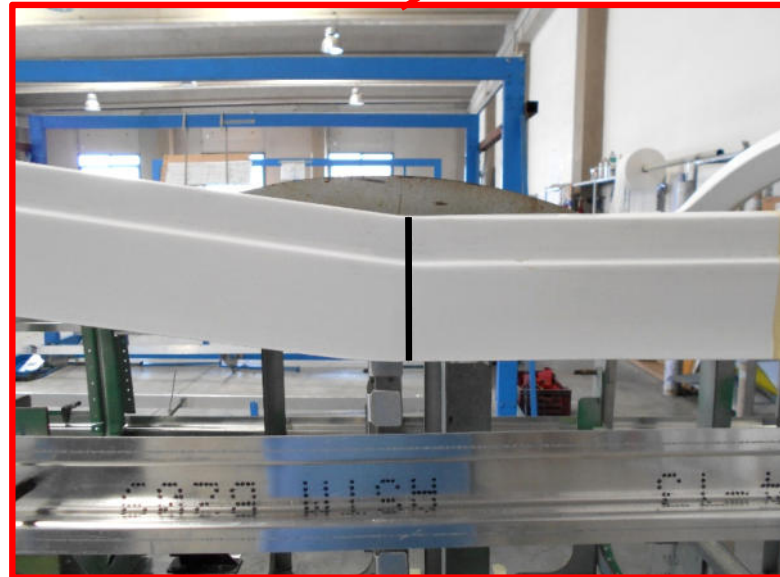
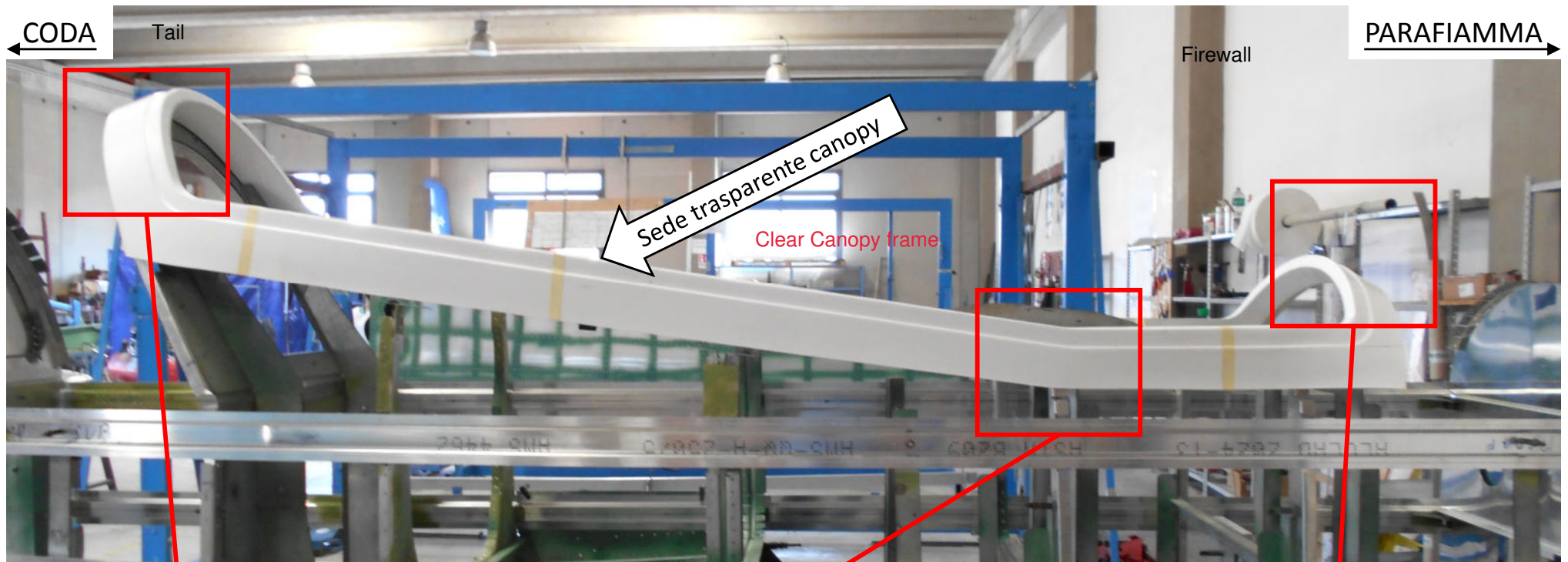


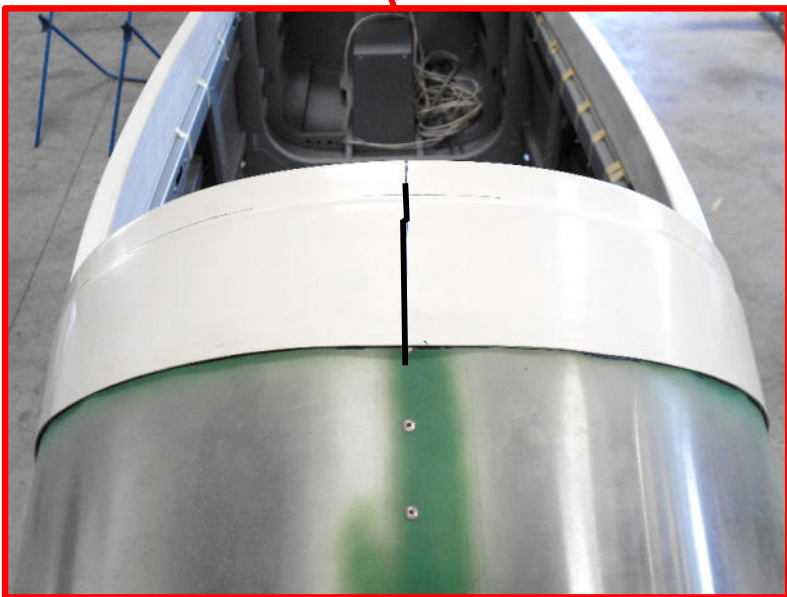


Effettuare alcuni fori per lato facendo in modo che le bacchette tengano la sagoma (circa una decina di fori per lato)

Applicare spessori di 2mm, forare, svasare e rivettare con rivetti Ø4x16 multigrip.

DO SOME HOLES FOR EACH SIDE IN THIS WAY THE BARS WILL MAINTAIN THE SHAPE (AT LEAST 10 HOLES PER SIDE)
APPLY THICKNESS OF 2MM, DRILL, COUNTERSUNK AND RIVET WITH RIVETS Ø4X16 MULTIGRIP



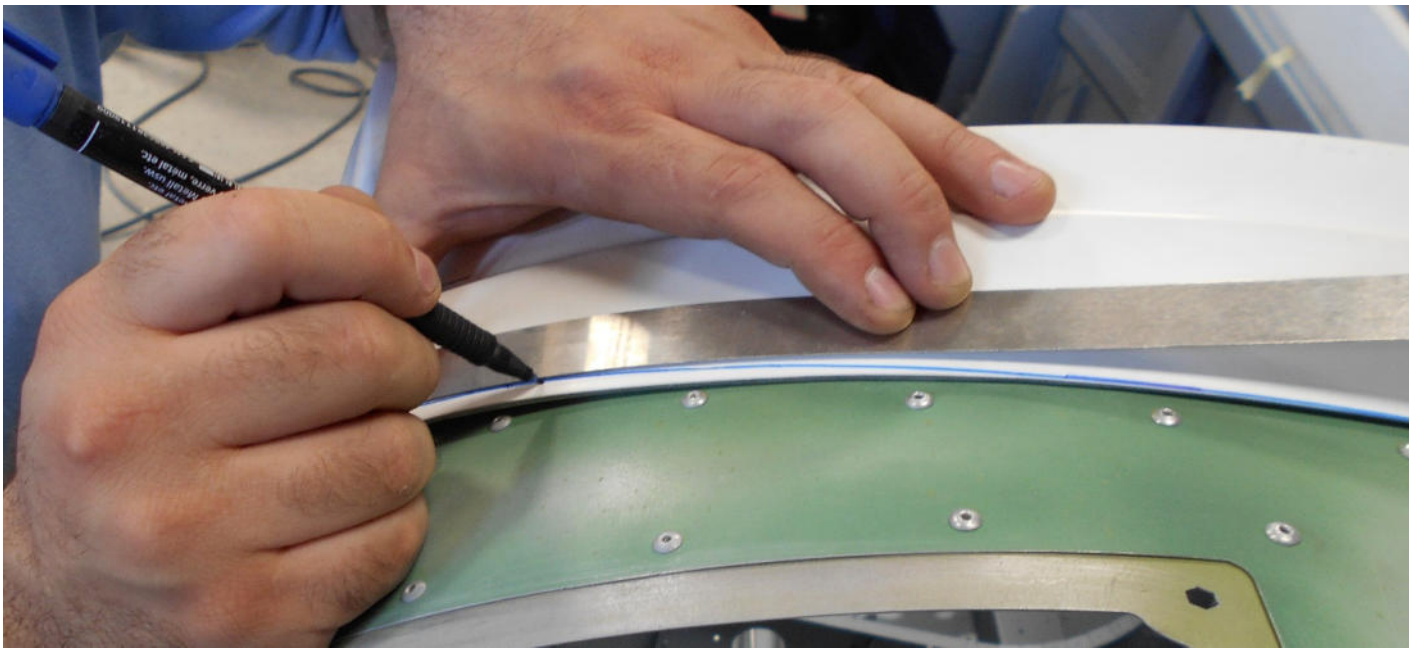


ALLINEARE I CENTRI DEL
TELAIO CANOPY CON LE
FILE DI RIVETTI PRESENTI
SULLA FUSOLIERA

Align the centres of the canopy
frame helping yourself with
the rivet lines



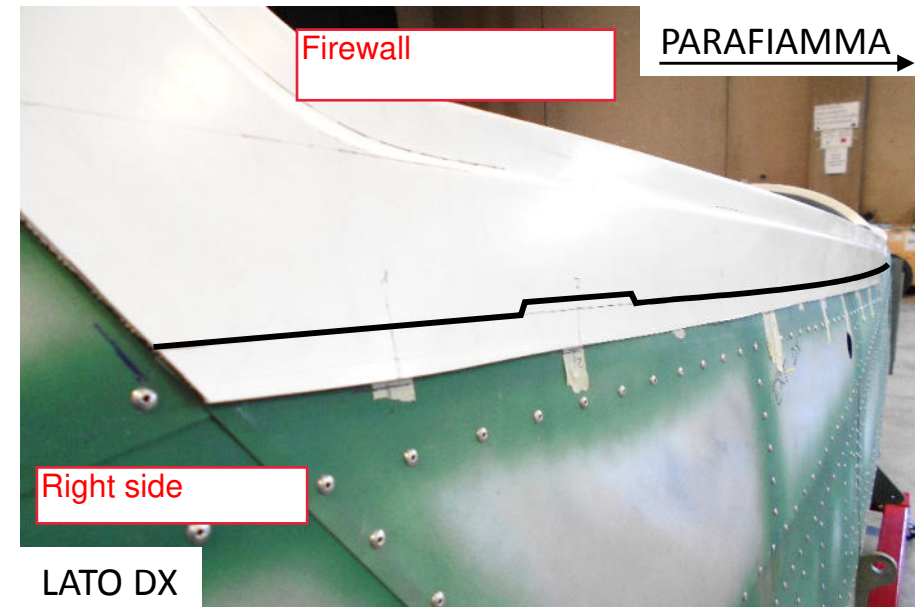
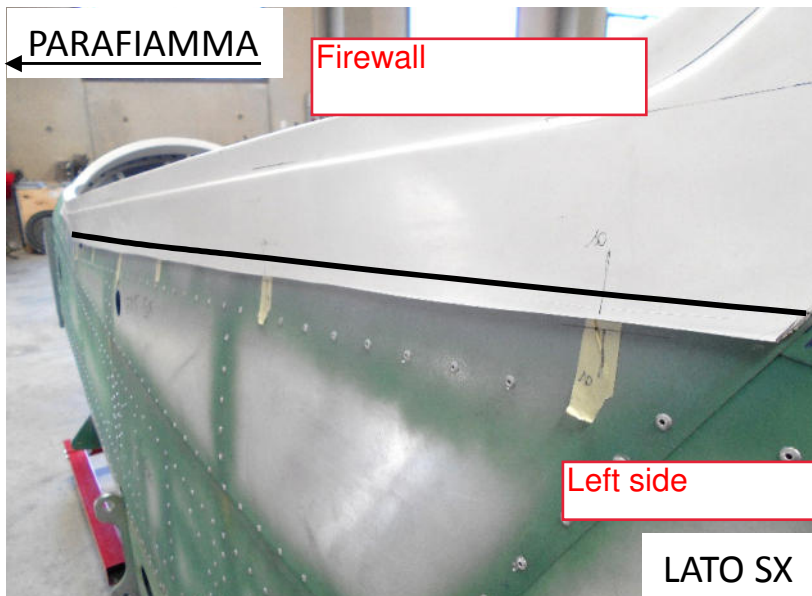
Left side cut line:
close to the rivet line
so that it overlaps
on the fuselage
when the canopy is
closed

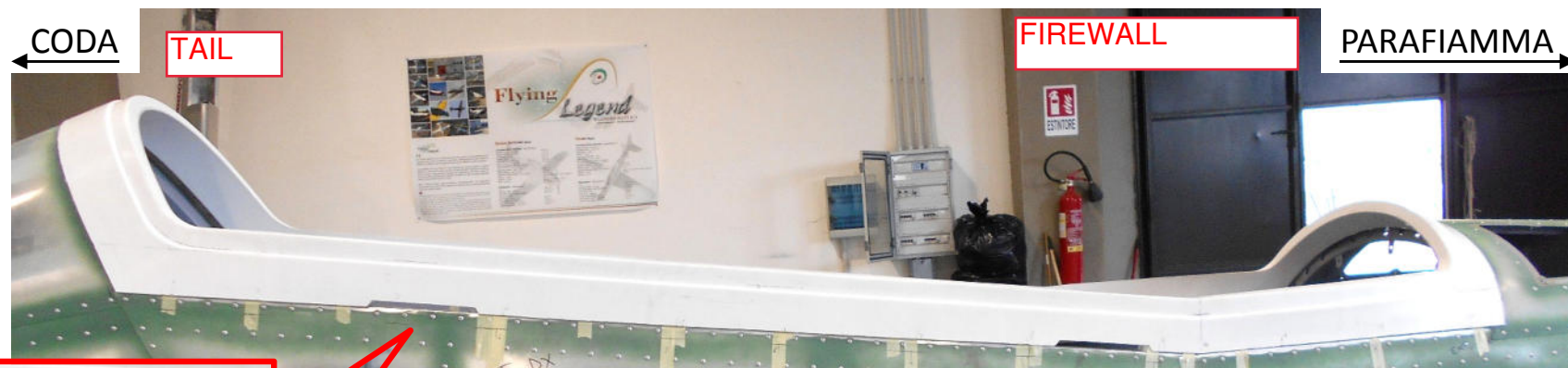


Right side cut line:
close to the canopy
guide to allow a correct
opening operation.
Take into consideration
also the hinges

Traccia di taglio lato sinistro: rasente alla
fila di rivetti in modo da accavallarsi sulla
fusoliera quando il canopy è chiuso

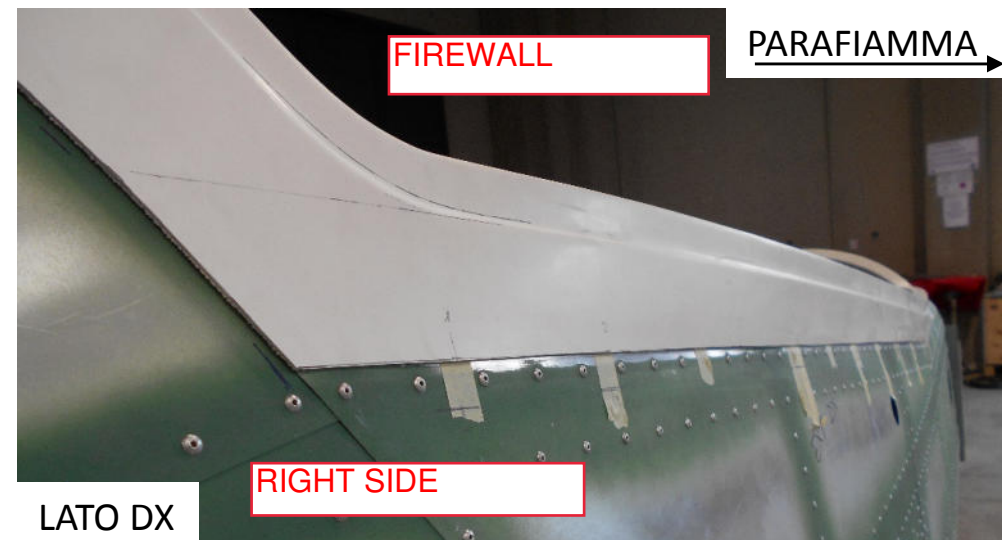
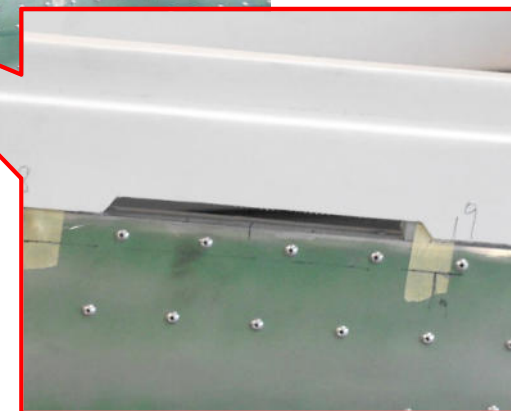
Traccia di taglio lato destro: rasente alla
guida canopy per consentirne una corretta
apertura. Considerare anche le cerniere

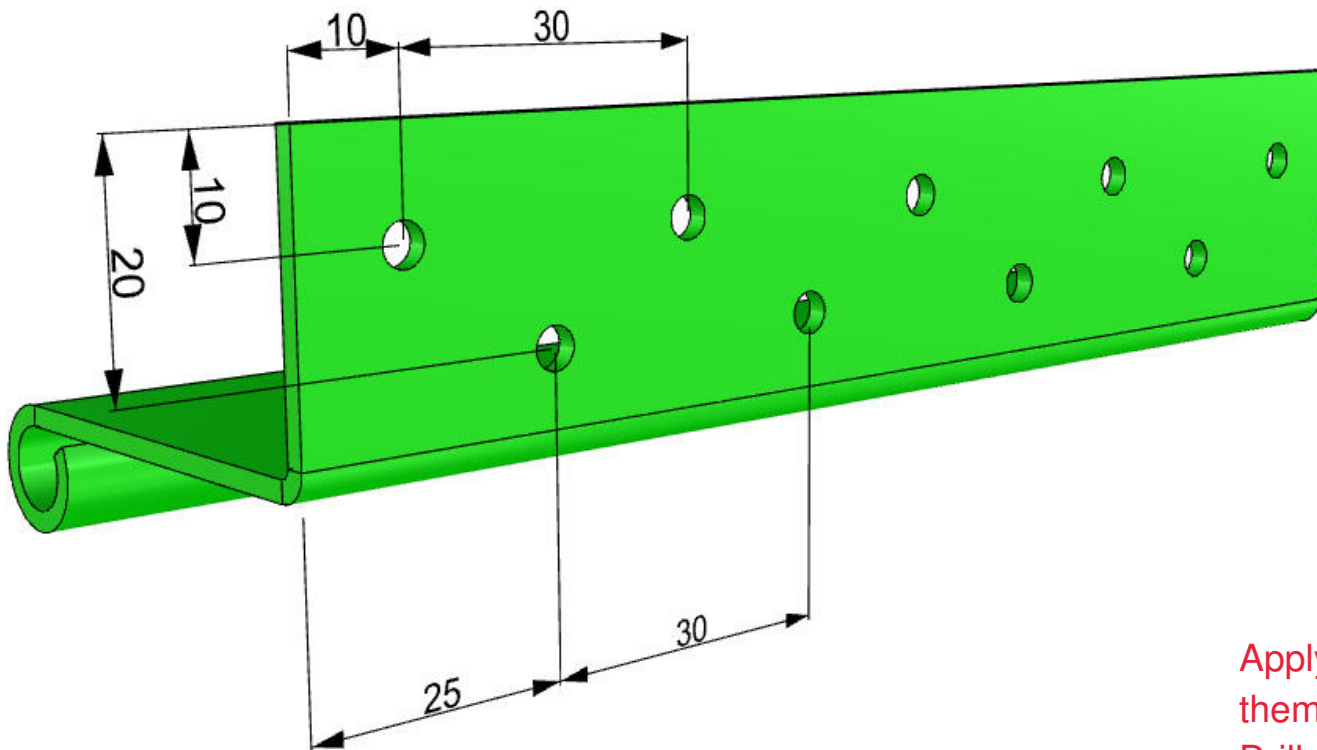




LATO DESTRO: SCASSI PER CERNIERE

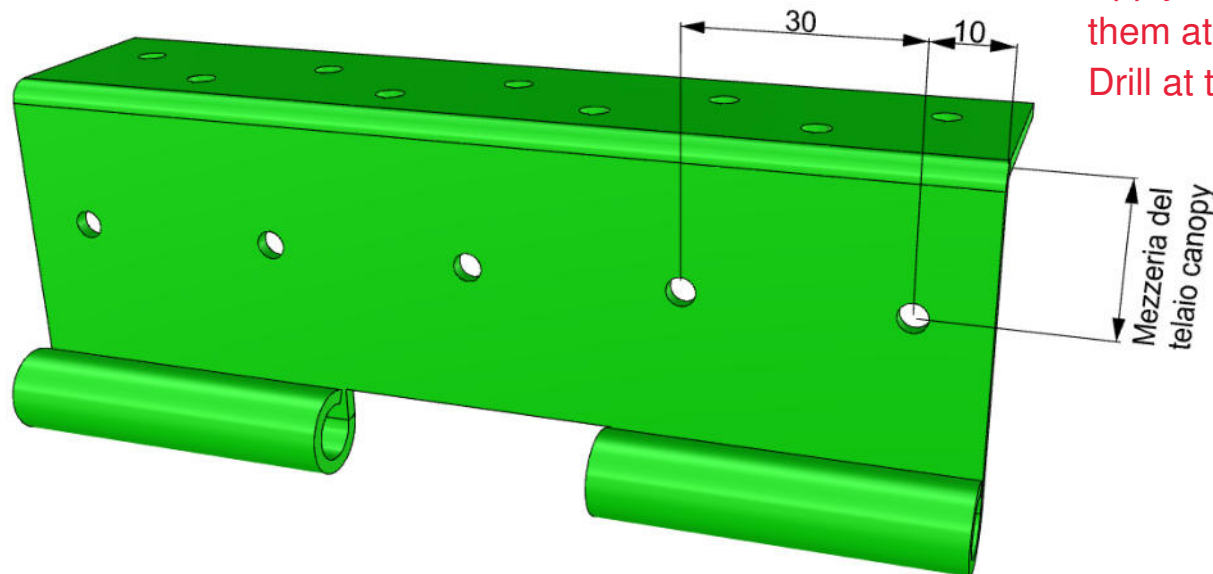
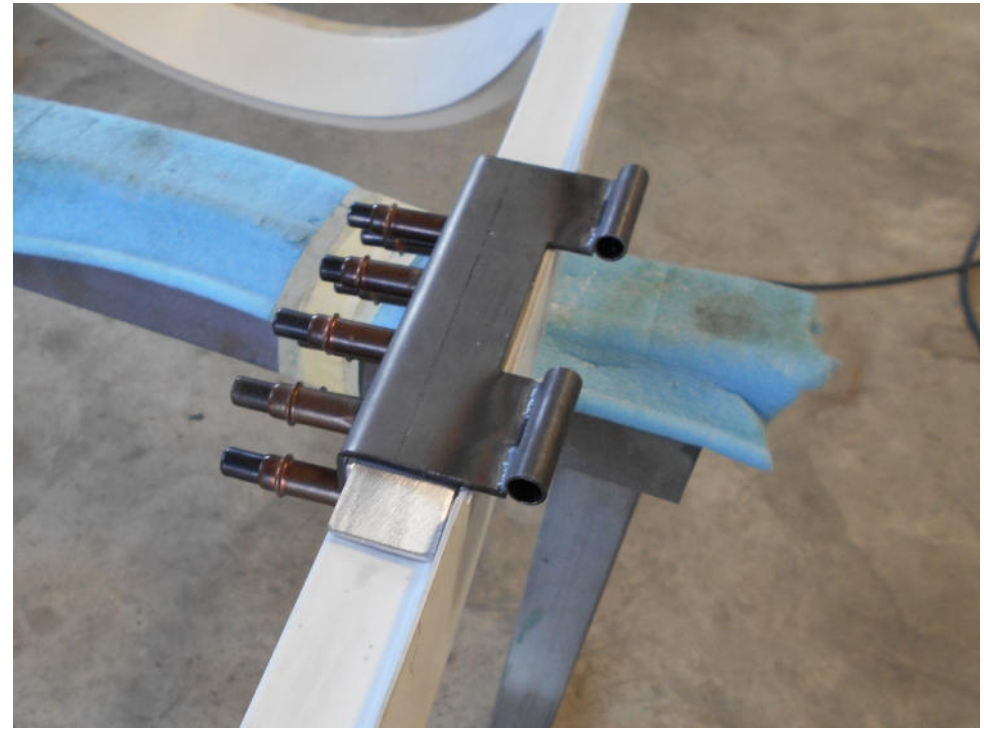
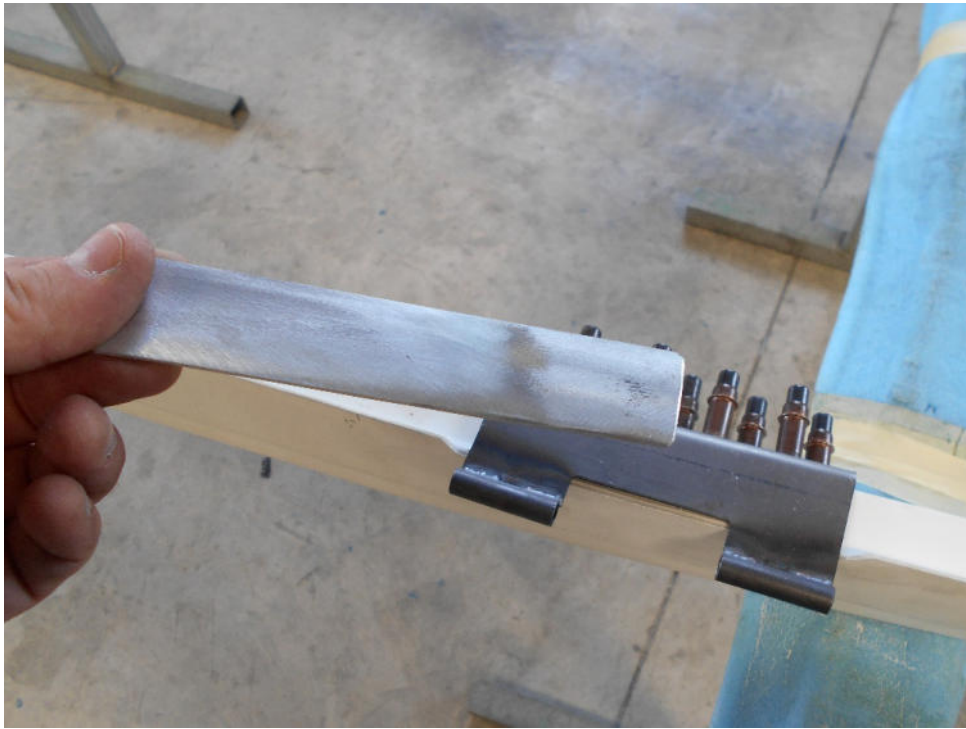
RIGHT SIDE: NOTCHES FOR THE HINGES





Applicare spessori verticali,
sagomarli, bloccarli sulla
cerniera e forare il tutto a $\varnothing 3,2$.
Si consiglia di passare a misura
definitiva ($\varnothing 4$) solo dopo
l'applicazione del trasparente.

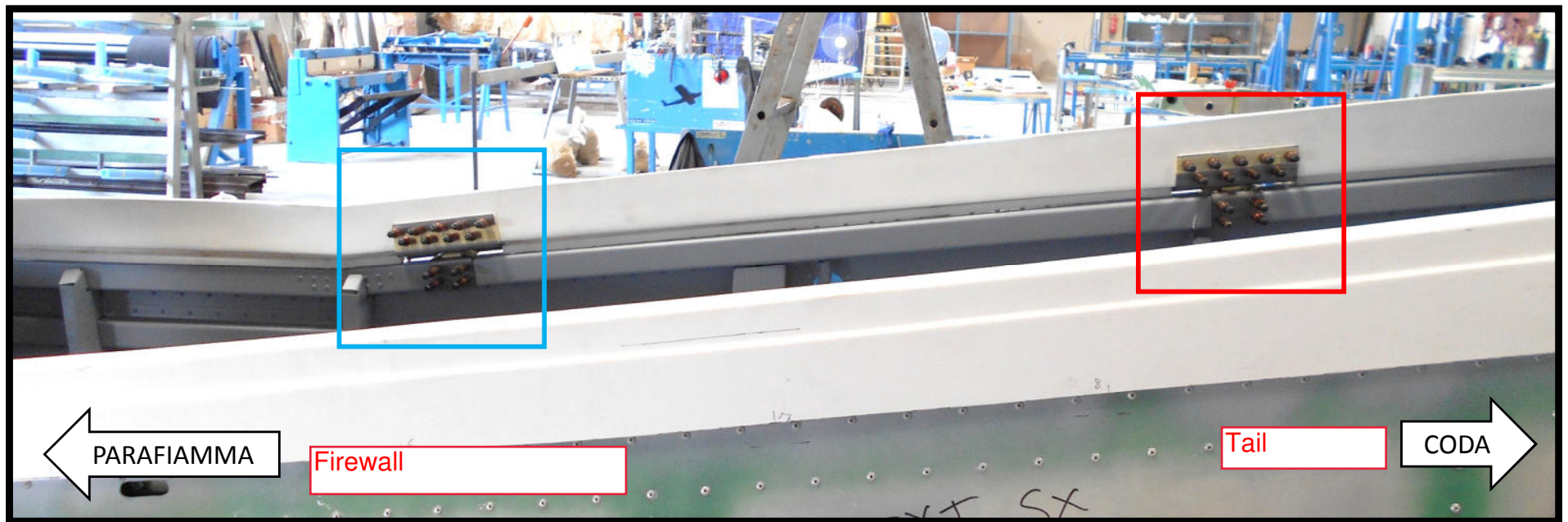
Apply vertical thicknesses, shape them, and stop
them on the hinge and drill everything at $\varnothing 3,2$.
Drill at the final size only once the clear is applied 9



Apply the horizontal thicknesses, shape them and drill them at $\varnothing 3,2$.

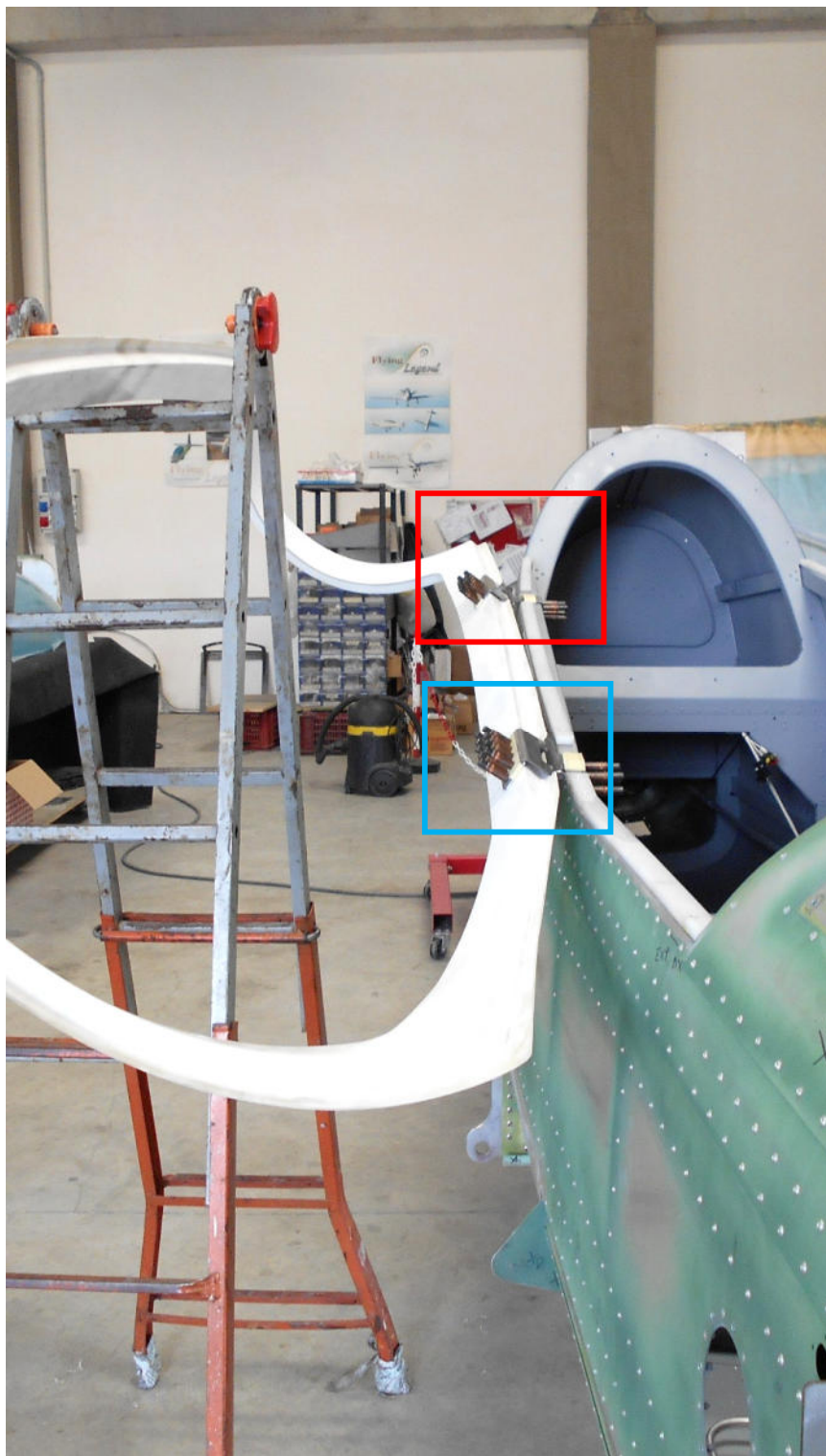
Drill at the final size $\varnothing 4$ only once the clear is applied

Applicare spessori orizzontali, sagomarli e forare il tutto a $\varnothing 3,2$.
Si consiglia di passare a misura definitiva ($\varnothing 4$) solo dopo l'applicazione del trasparente.



Before riveting the hinges, evaluate the painting status
Prima di rivettare le cerniere valutare la verniciatura

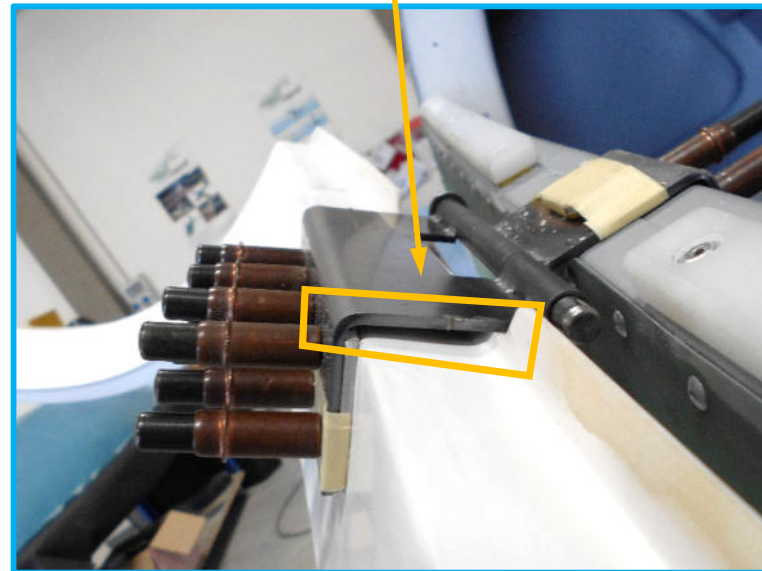


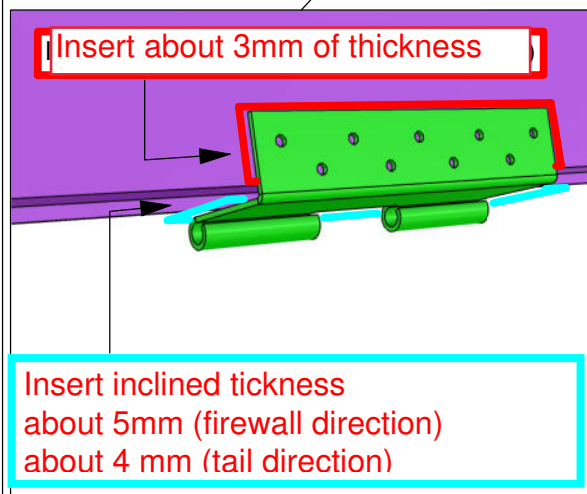
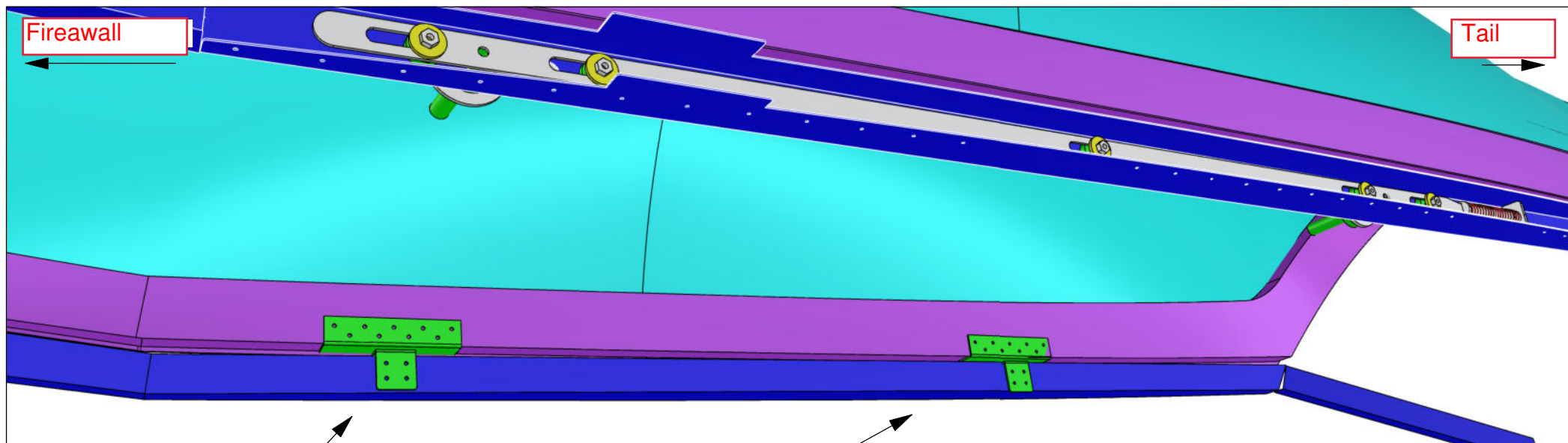


Insert compensation vertical thickness to shape

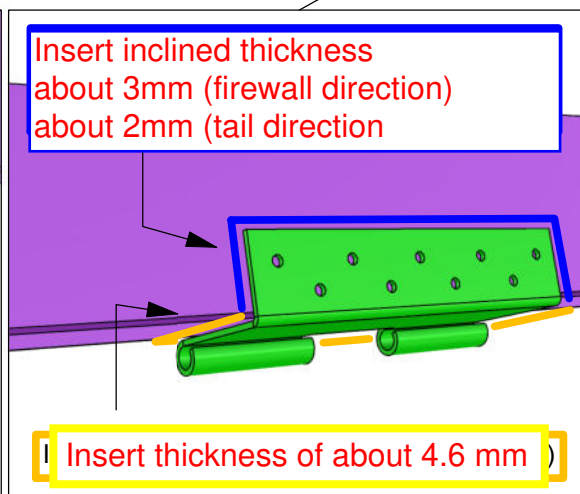


Inserire spessore di compensazione
verticale da sagomare opportunamente





CERNIERA ANTERIORE Front hinge



CERNIERA POSTERIORE Back hinge

Rivet to stop the hinges on the resin canopy: Multigrip $\varnothing 4 \times 16.5$
(GRIP: 6.00mm-13.0mm)

Vertical Thickness

Vertical Thickness

Horizontal thickness

Horizontal thicknesses

ATTENTION

The sizes of the compensation thicknesses here at the side are just suggestions. An assembly test of the canopy frame will guide you how to shape the thickness properly

PRODUZIONE:
QBK-RTF - CANOPY

DISEGNATO DA:
D. CONIGLIONE

SCALA: **N.D**

MODIFICATO IL: OPERATORE

CONTROLLATO IL: OPERATORE

MODELLO:
TR-

STEP:
MONTAGGIO CERNIERE

PROGETTO:
TUCANO REPLICA

DATA:

REV.:

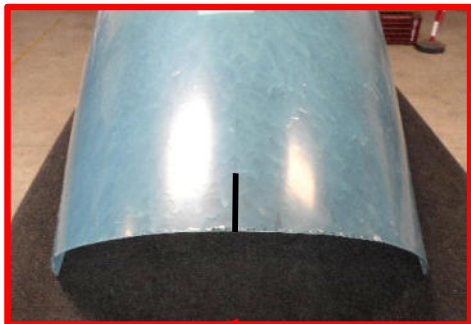


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DISEGNO
13

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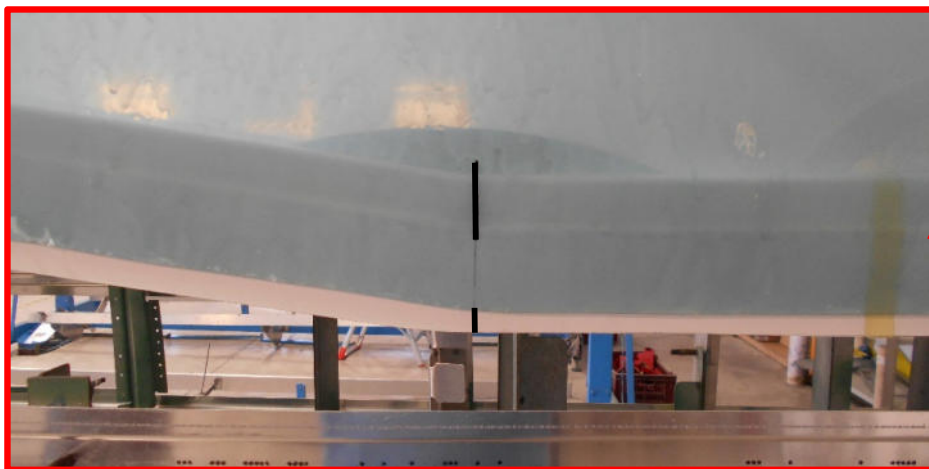
FIREWALL

PARAFIAMMA →



← CODA

TAIL



CODA

PARAFIAMMA

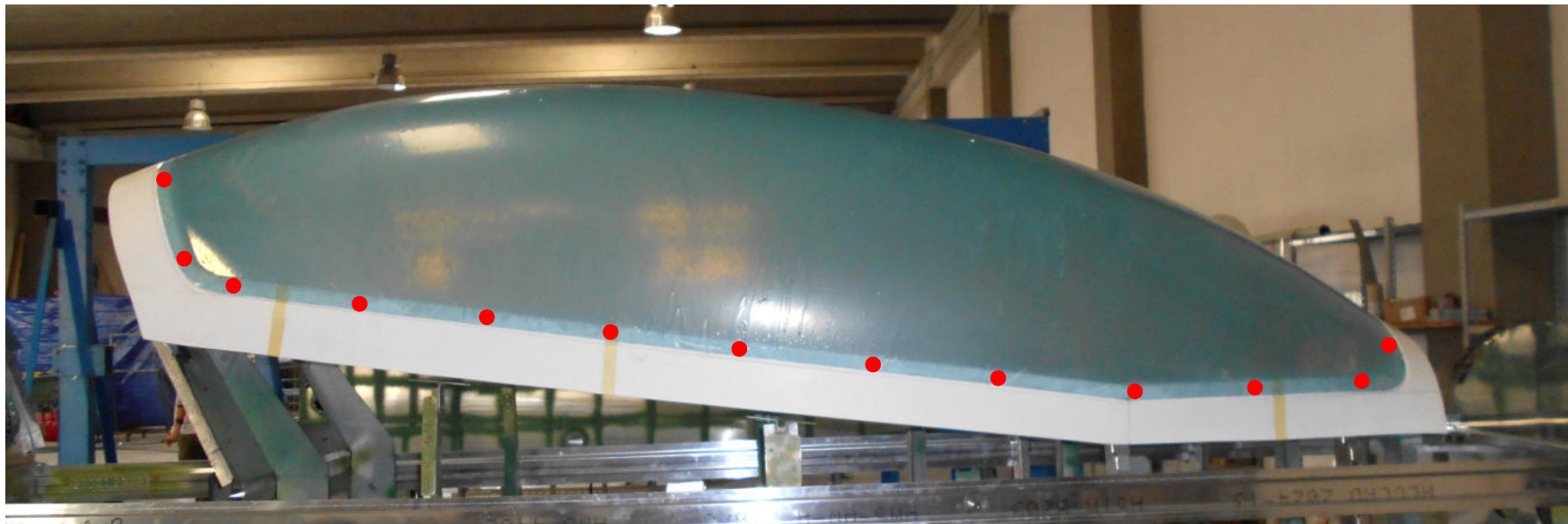
TAIL

FIREWALL



MARK THE CANOPY SIDES AND CUT FIRST THE SHORT ONES AND THEN THE LONG ONES, SMOOTH THE EDGES

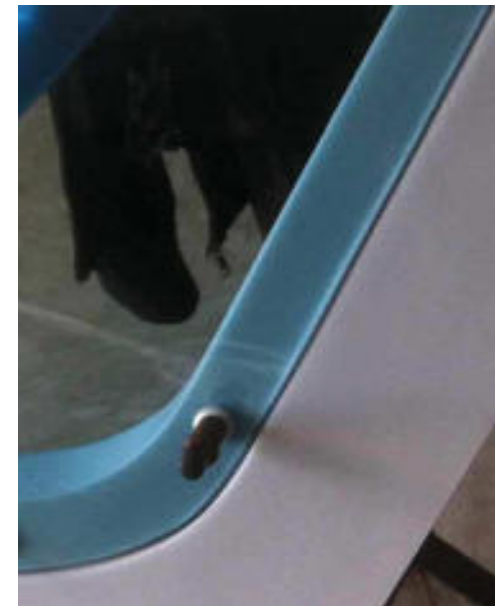




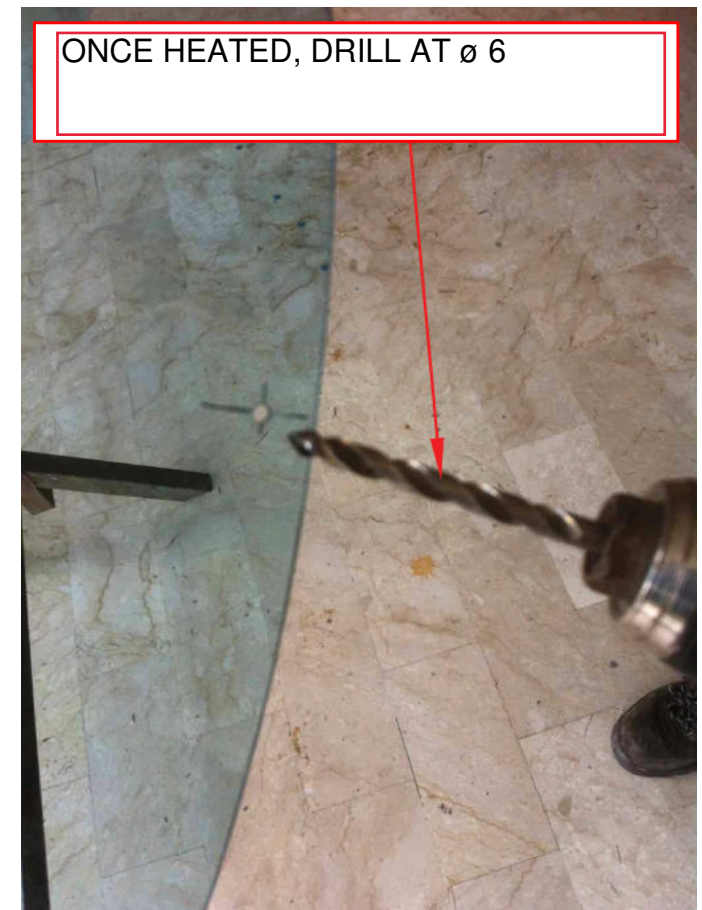
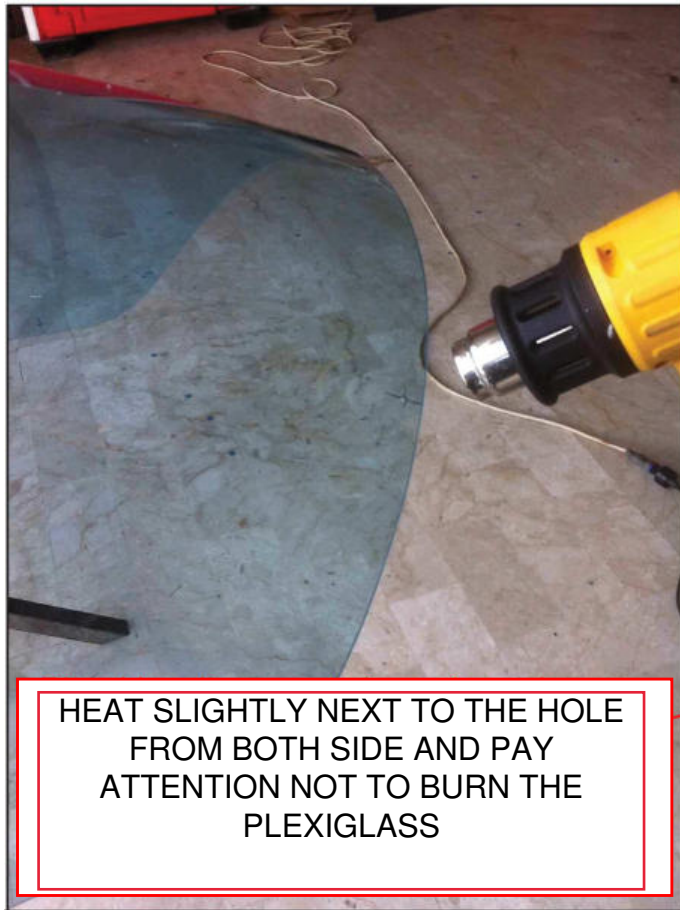
Drill the clear canopy and the frame at $\varnothing 2,4$ and cleco and make sure that adheres between the two parts



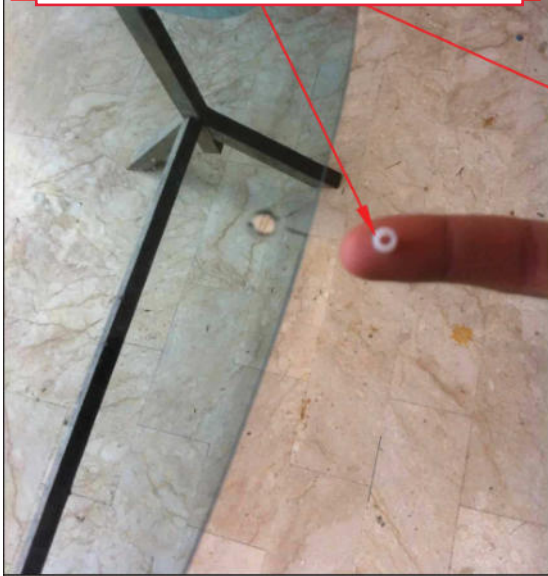
Drill the canopy starting from the centre to the edges



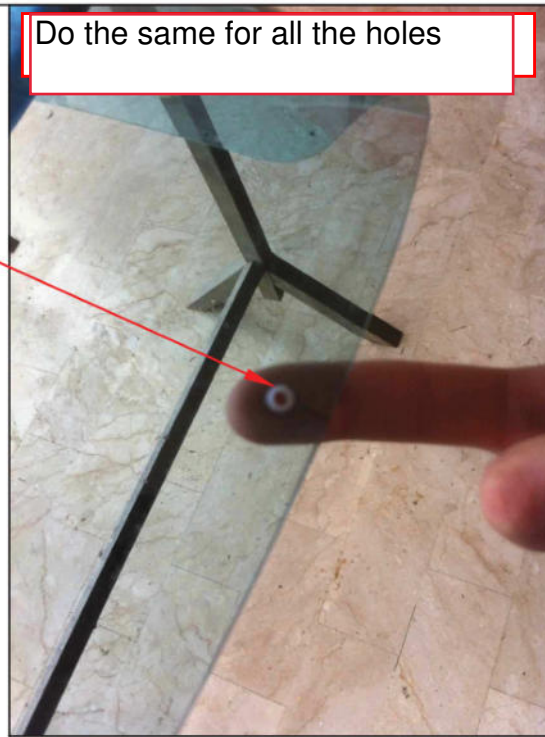
REMOVE THE CANOPY FROM THE RESIN FRAME AND ENLARGE THE HOLES
OF IT AT $\varnothing 3,2$



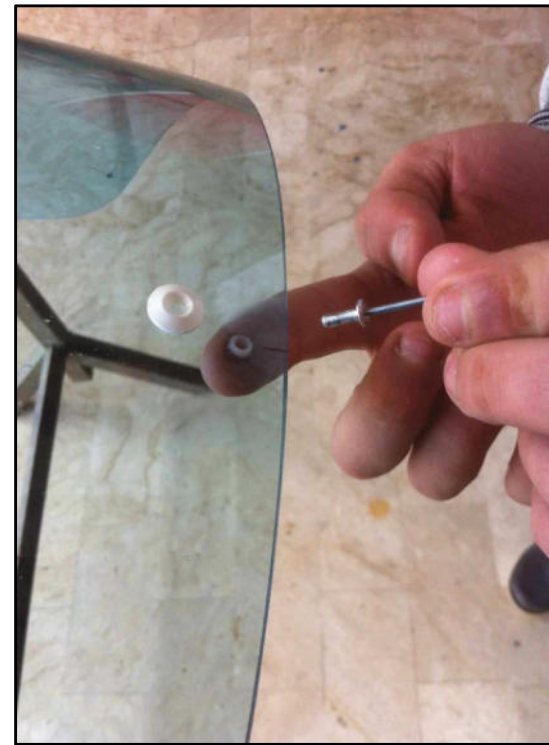
Insert inside the hole the protection rubber which will avoid that the rivets ruins the plexiglass



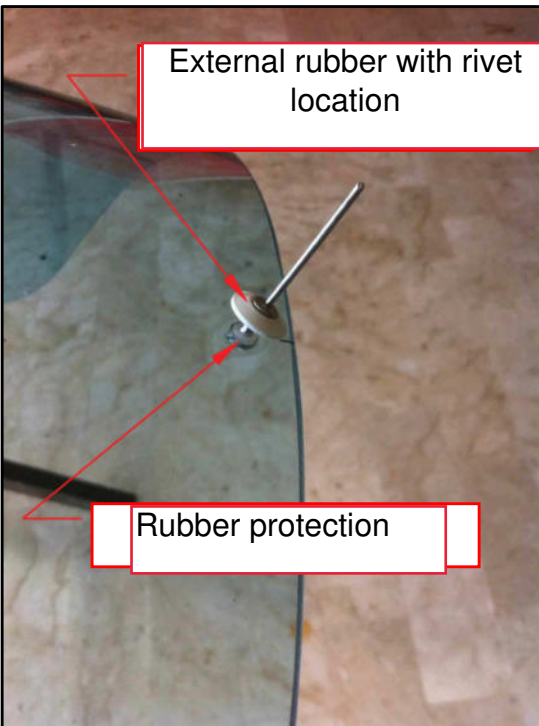
Do the same for all the holes



Insert the canopy on its resin frame being sure that it adheres perfectly and does not exit. Use rivet $\varnothing 3,2$ to rivet definitively



External rubber with rivet location

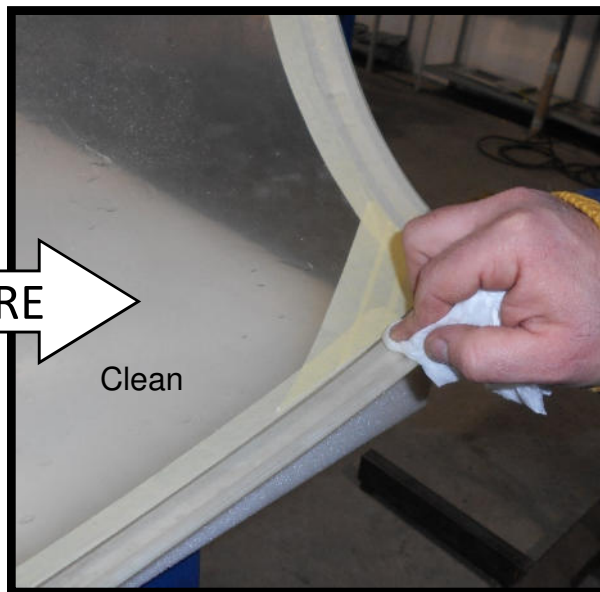
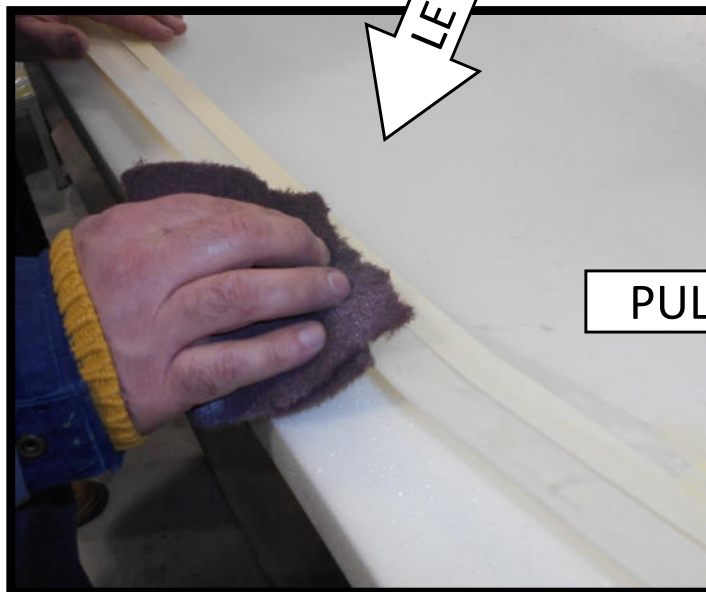
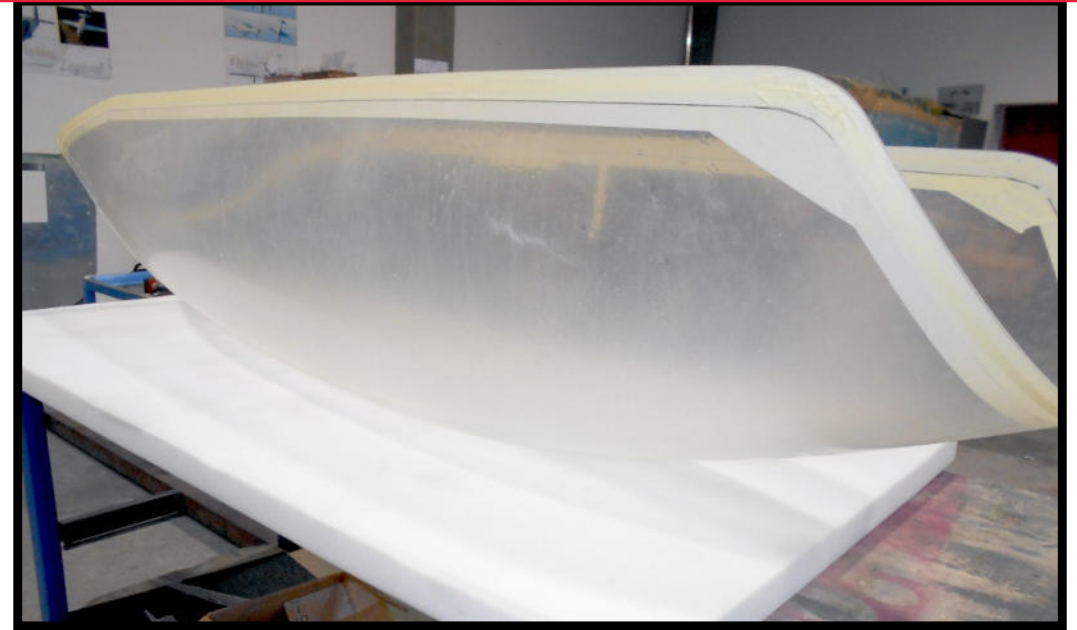
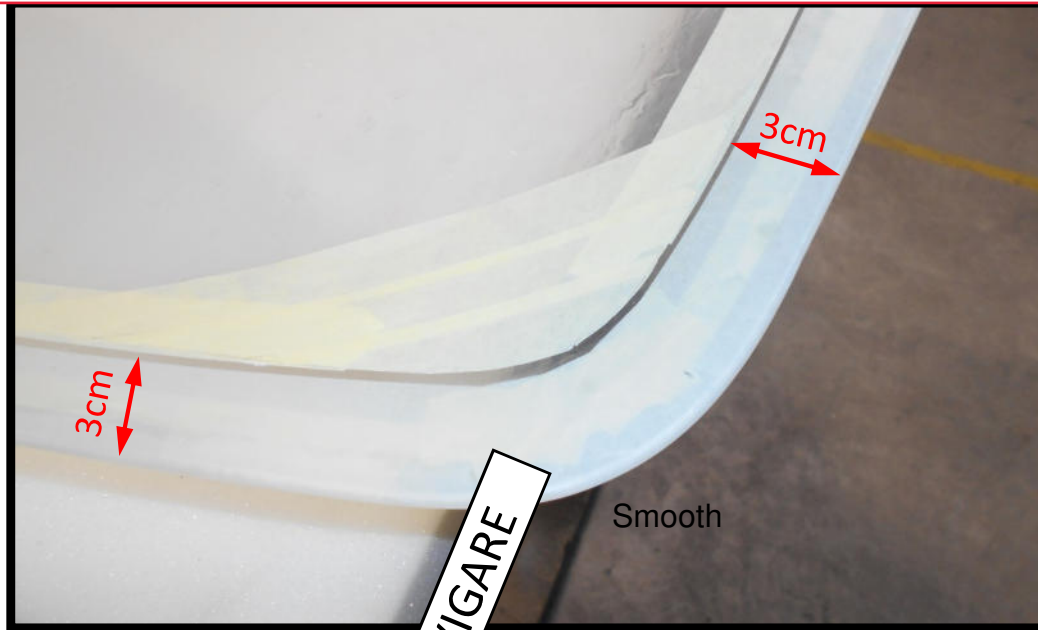


Rubber protection



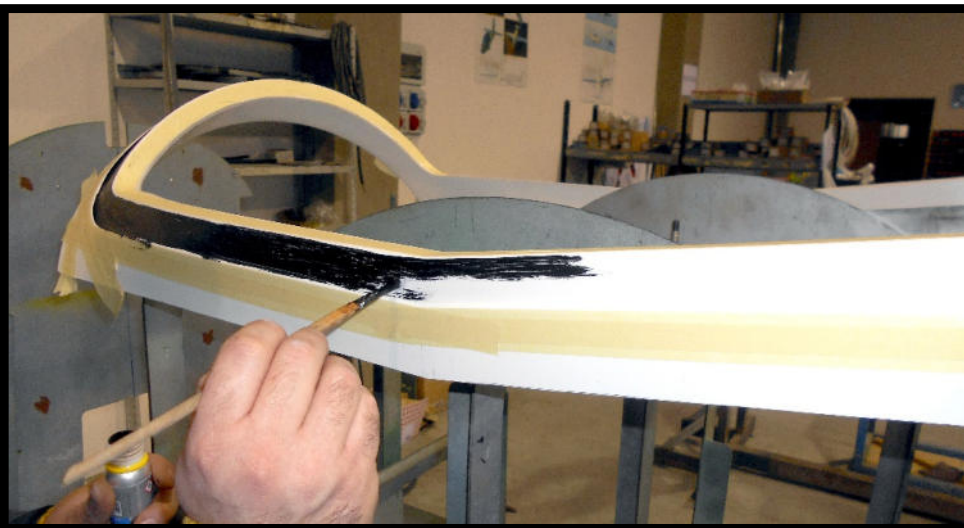
EVALUATE TO
PAINT THE
FRAME BEFORE
STARTING TO
RIVET THE
CANOPY

Protect with some paper tape the parts which have to be treated with the primer to limit the smears. The tape applied on the inner side has to be about 3 cm from the edge (apply the canopy on the frame and check that the tape can be easily removed once it is glue), while on the outer side it has to be applied on the edge.

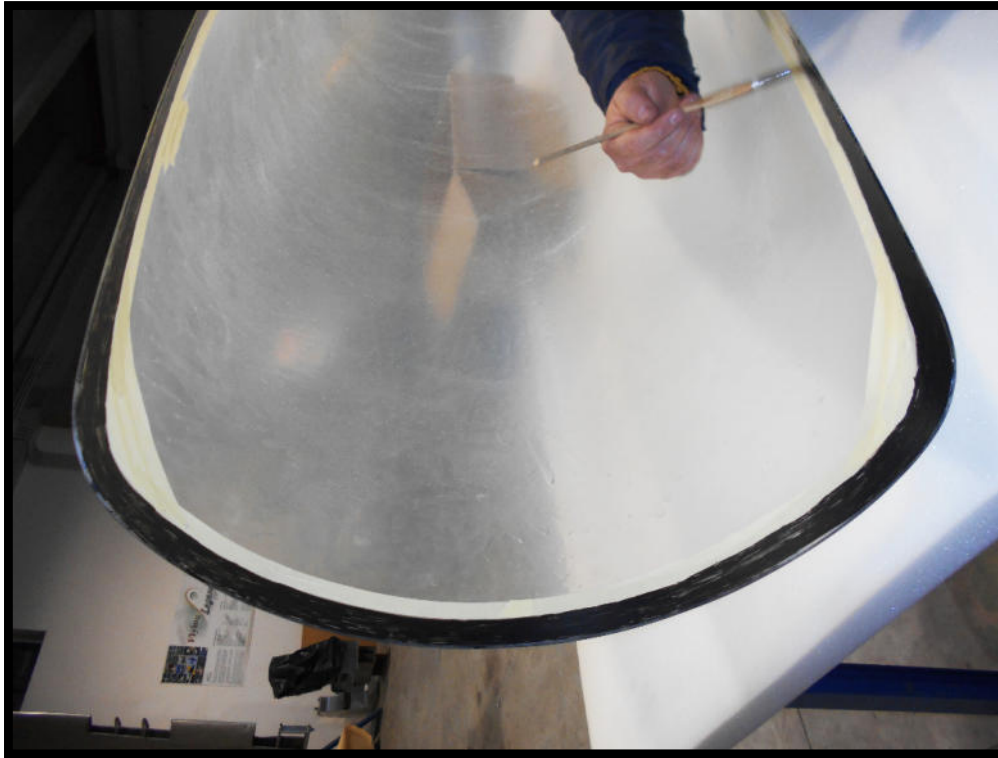


Smooth the inner side of the canopy which will be glued with the frame. We suggest to use brite tape or sandpaper. Clean the surface once the operation is finished

EVALUATE THE POSSIBILITY TO PAINT THE FRAME OF THE CANOPY BEFORE PROCEEDING TO GLUE THE CANOPY



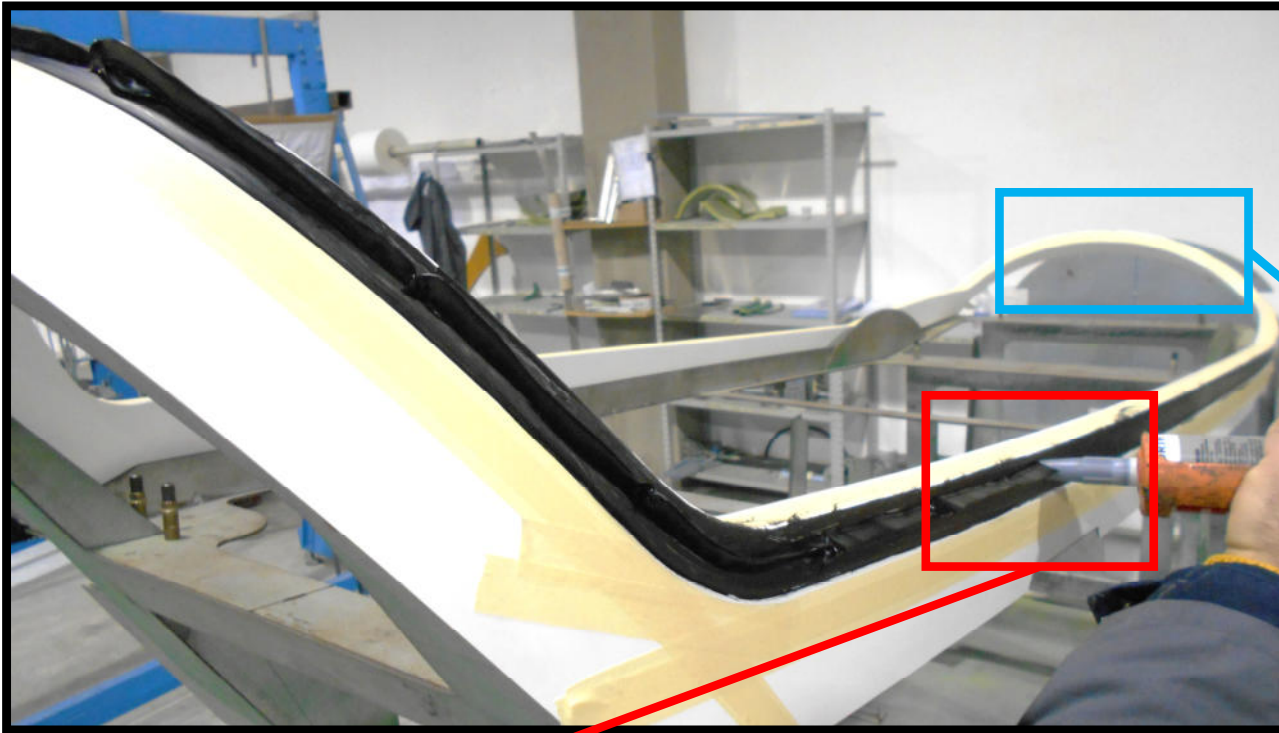
Before gluing the canopy, protect with some tape the parts which have to be treated with the primer to limit the smears. Apply the primer on the surface to be glued and make sure you do not leave parts uncovered



Passare primer sul bordo interno del trasparente ed assicurarsi che questo sia tinto in maniera uniforme in modo da non lasciare parti scoperte.

Prima di procedere all'incollaggio assicurarsi che il primer sia completamente asciutto. Allo scopo, si consultino le specifiche indicazioni fornite dal produttore dello stesso

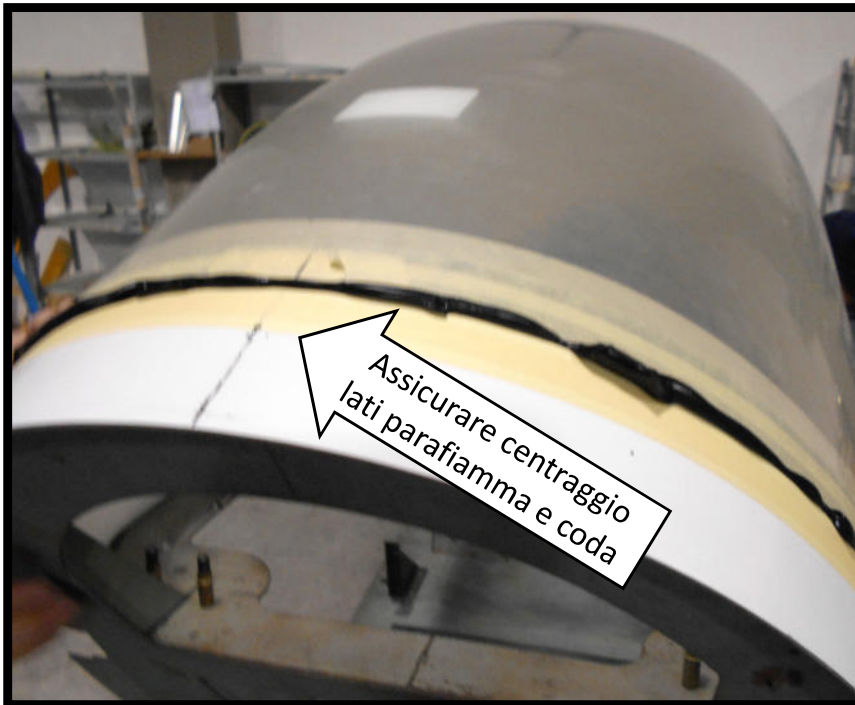
Apply the primer on the inner part of the canopy and make sure the painting is uniform and not leave parts uncovered
Before starting the glue operation, make sure that the primer is perfectly dry. Check the indication of the product about it



Apply a glue line around the frame where you have applied the primer. Make sure that you are not exceeding or lacking with the quantity of the glue.

Please check the indication on the product used.

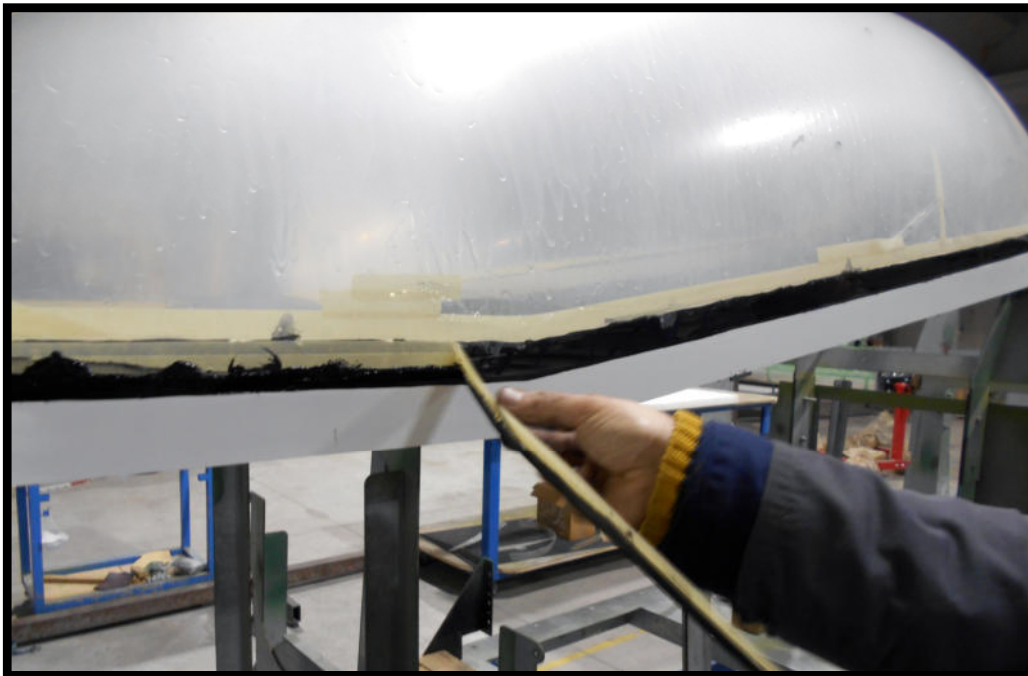
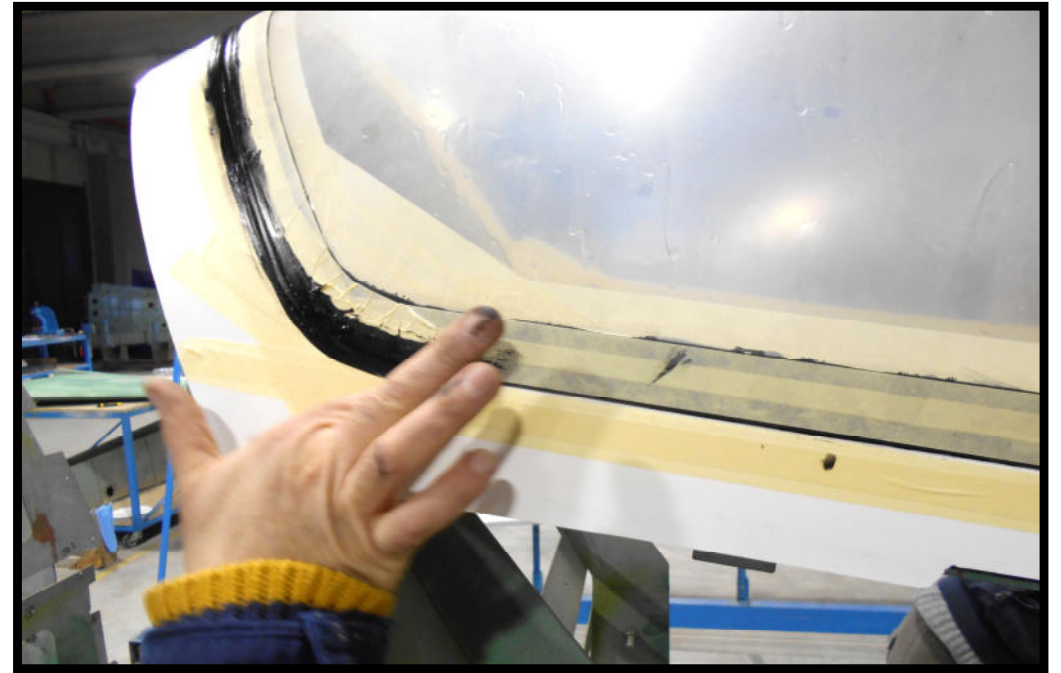
ATTENTION: IN THIS STEP IT WOULD BE USEFUL IF THE OPERATION IS PERFORMED BY FOUR PEOPLE



Lean the canopy on the frame and enlarge slightly the sides to ease the insertion.

Make sure the elements are centered one to the other.

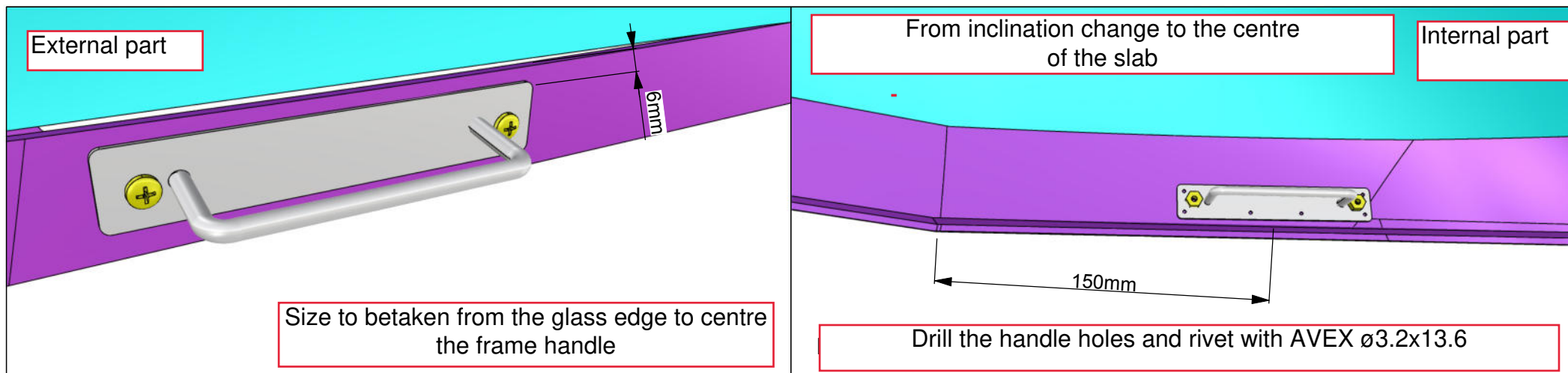
Check the centrage between the firewall sides and the tail



Once the canopy is positioned, press between them the canopy and the frame. Use clams only if necessary, and pay attention not to damage the canopy.

The empty space between canopy and frame and spread the glue which does exit from the inner and outer side.

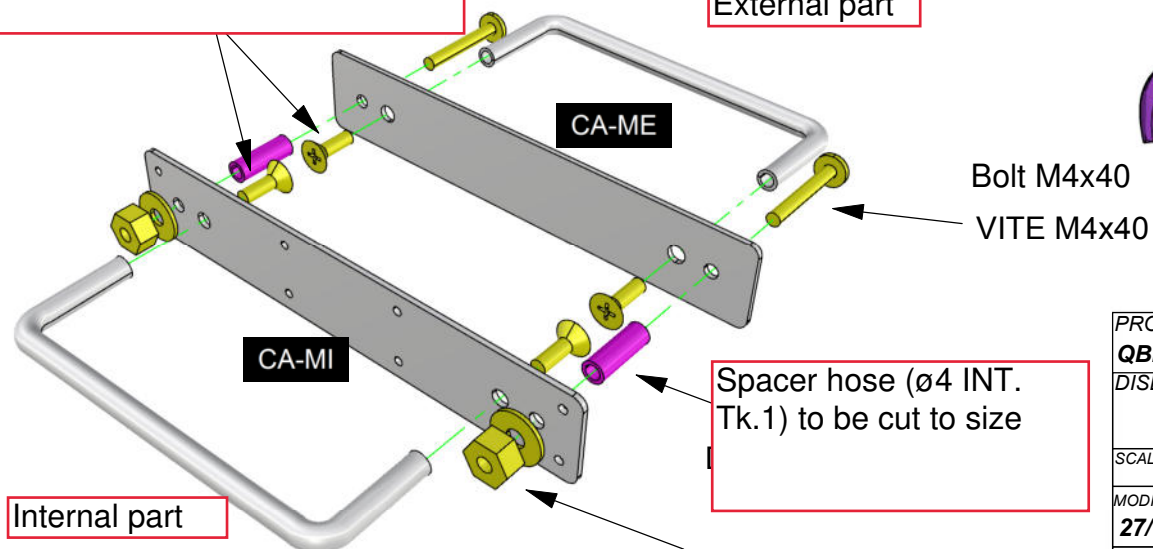
Remove the tape before the glue dries



Trim the exceeding part of the bolt shaft once bolted

Countersunk head rivet M4x10

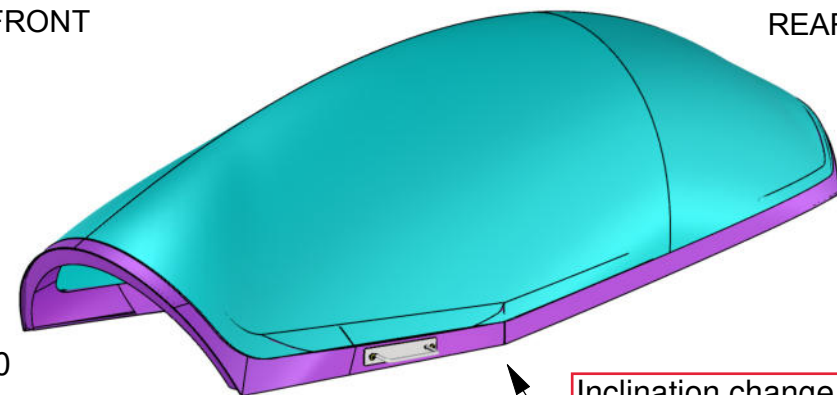
External part



Internal part

FRONT

REAR



PRODUZIONE:
QBK-RTF - CANOPY

STEP:
MONTAGGIO MANIGLIE

DISEGNATO DA:
D. CONIGLIONE

PROGETTO:
TUCANO REPLICA

DATA:
16/07/2018

REV.:

SCALA:
N.D

MODIFICATO IL:
27/07/2018

CONTROLLATO IL:



FLYING LEGEND ITALIA
C.DA CAUDARELLA
95041 CALTAGIRONE (CT)

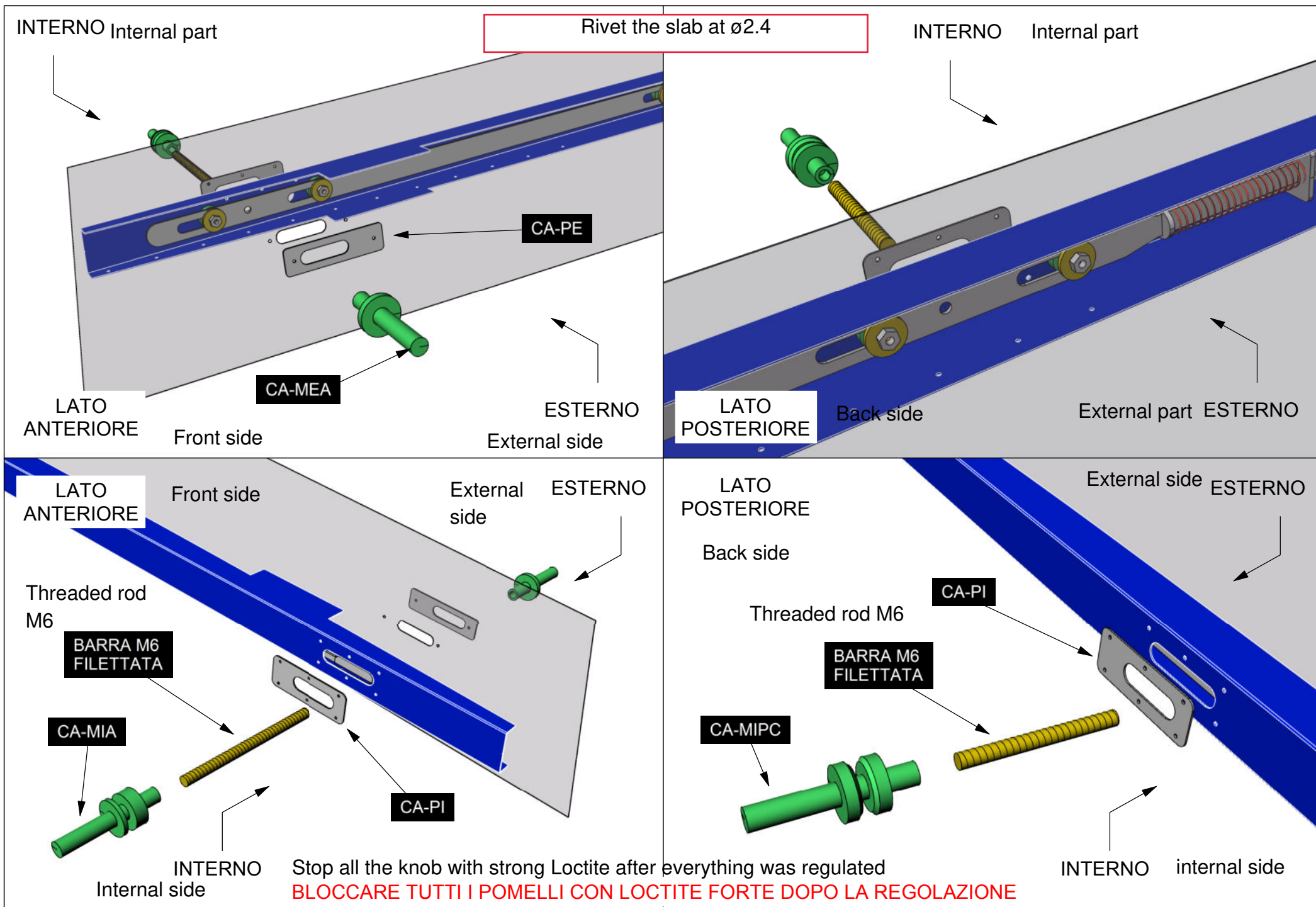
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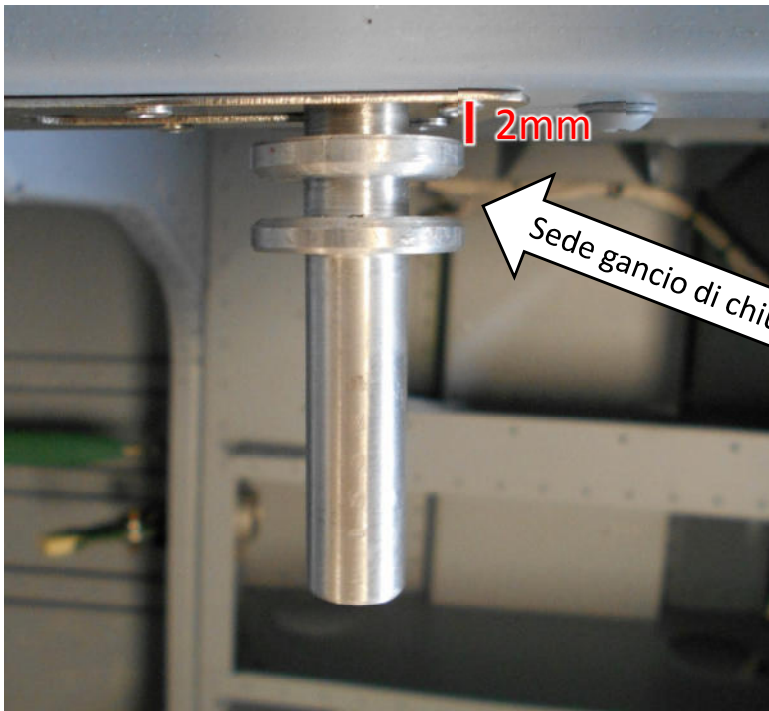
MODELLO:
TR-

NOTE:

DISEGNO
25

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Pomello posteriore Back knob

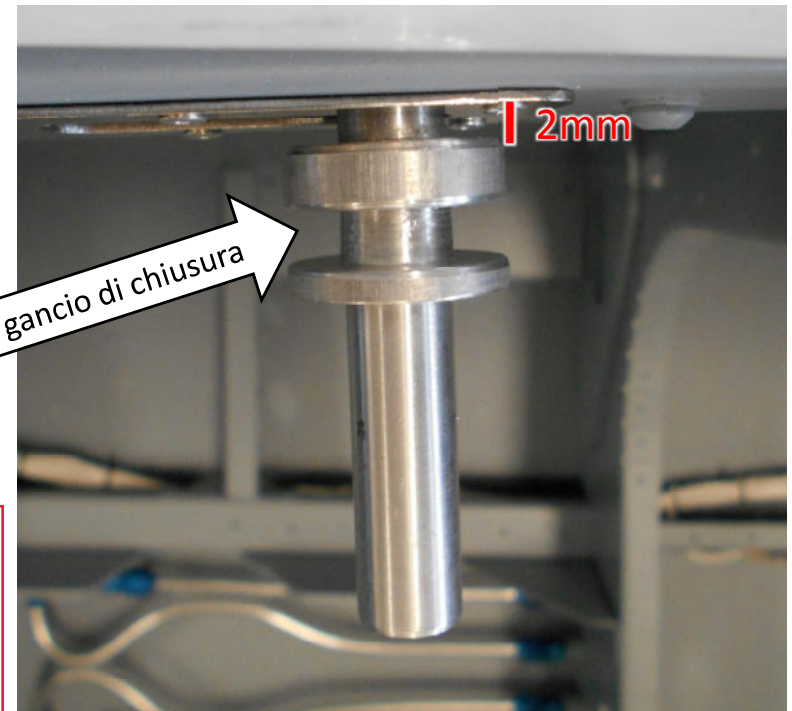
Leave about 2 mm
between the slab and
the opening knobs

Sede gancio di chiusura

Closing hook place

Closing hook
place

Pay attention to the
difference of the two
knobs : the front one
has a thicker flange
than the other one while
the back knob has the
flanges of equal
thickness.



Pomello anteriore Front knob

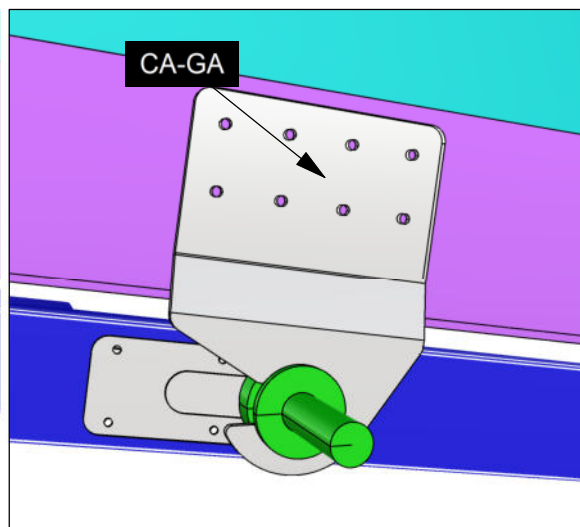
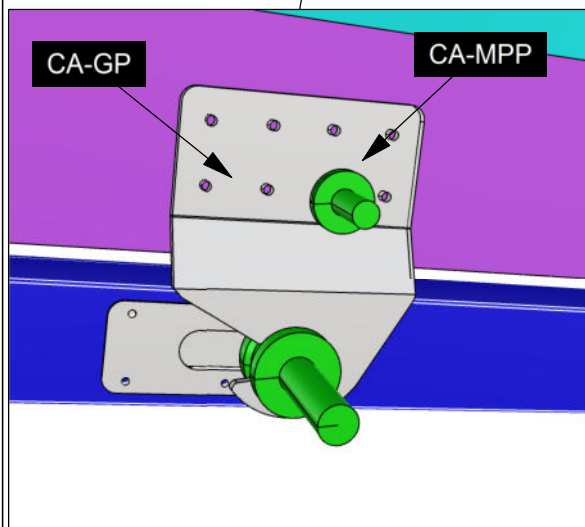
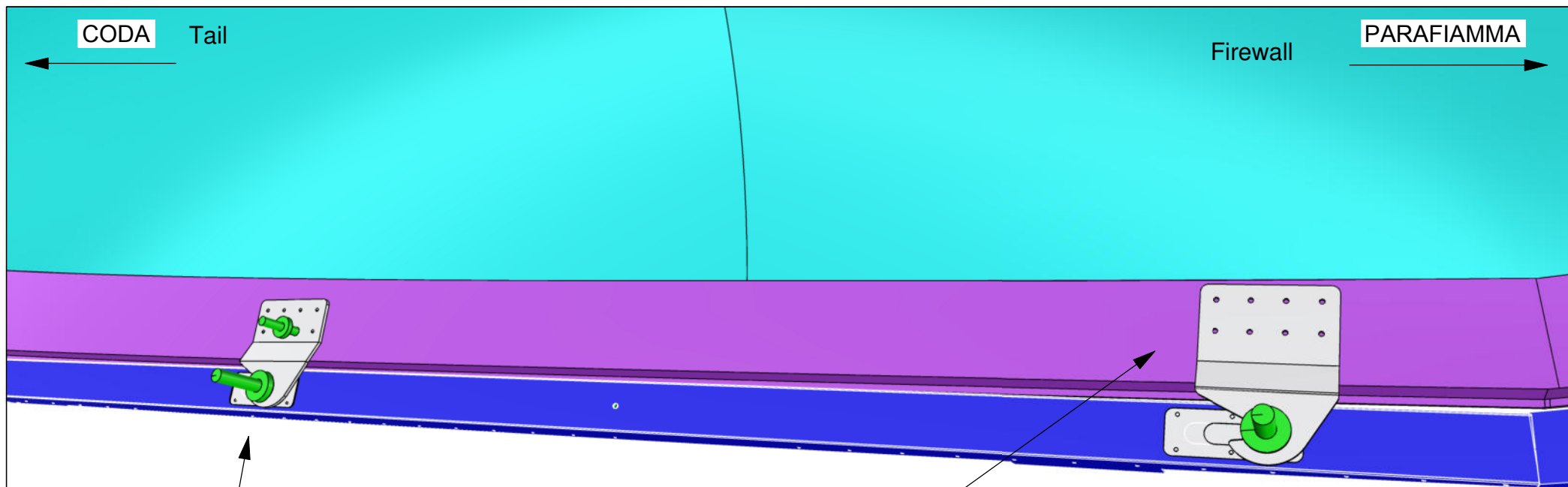
Sede gancio di chiusura



Rivet the slabs at $\varnothing 2,4$

Rivettare le piastrine
a $\varnothing 2,4$





The holes of the slabs have to be drilled at $\varnothing 3.2$ on the canopy frame (final size $\varnothing 4$)

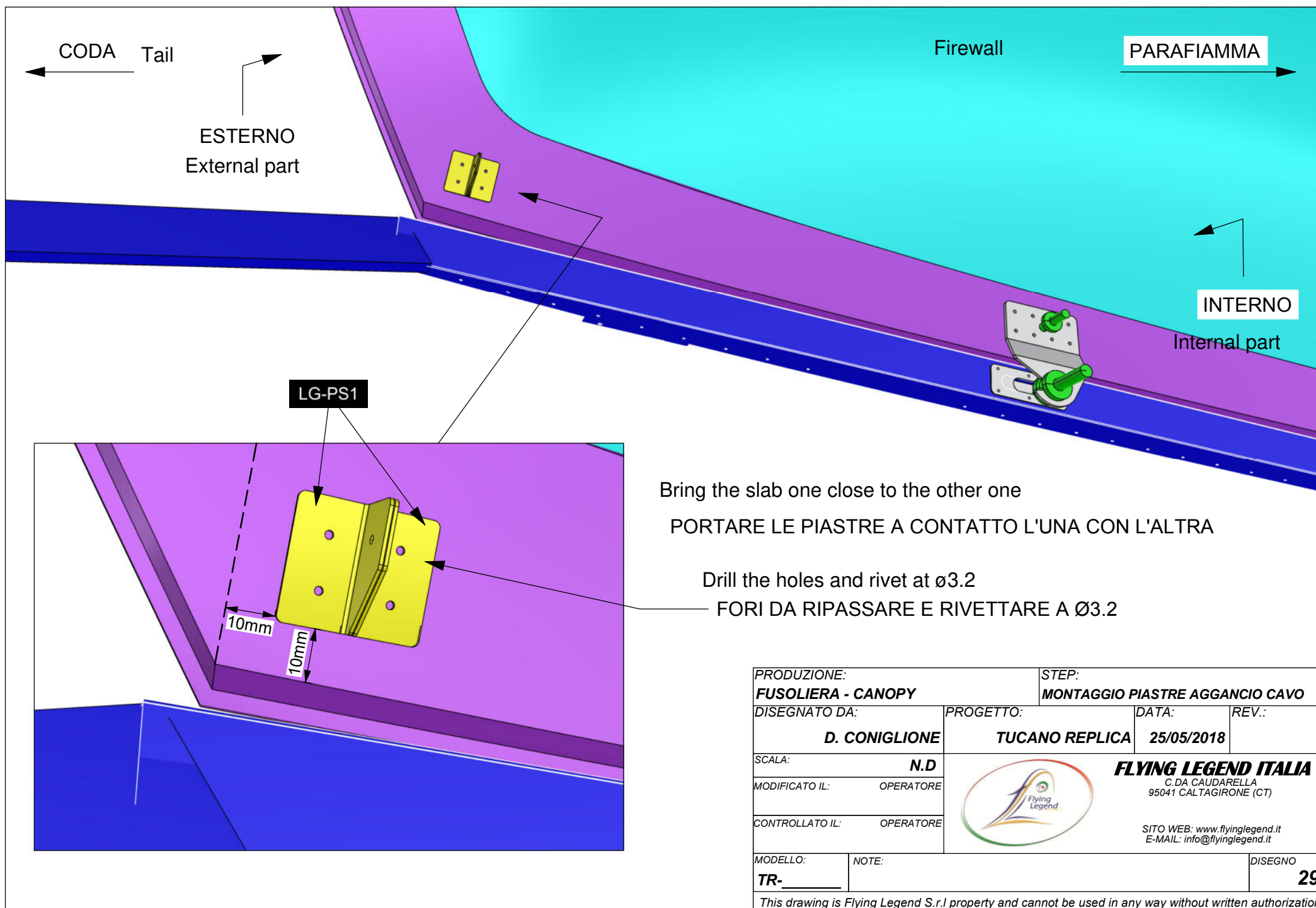
ATTENTION

The bends of the closing slab have to be attentioned every time

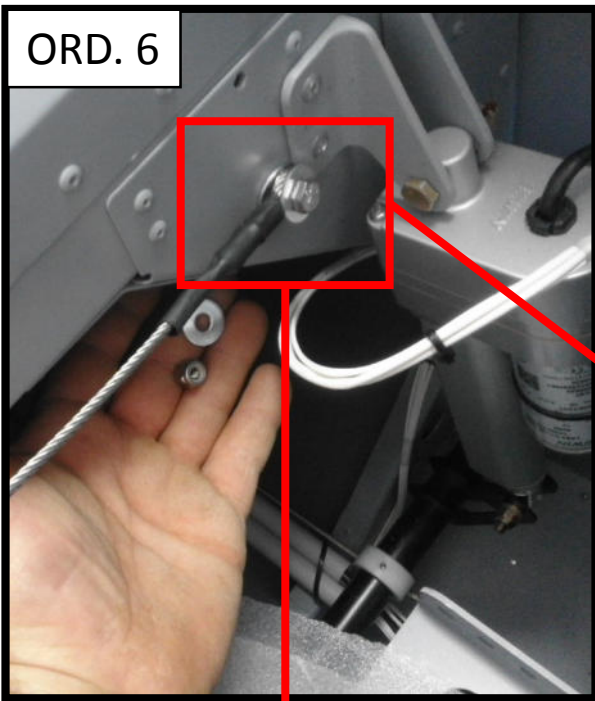
At the third lower rivet place of the slab CA-GP, do not apply the rivet, but realize a tread hole (with a thread equal to a M6) without passing the canopy. Cut to size the knob rod CA-MPP. Stop with strong Loctite.

PRODUZIONE: QBK-RTF - CANOPY		STEP: MONTAGGIO CHIUSURE	
DISEGNATO DA: D. CONIGLIONE		PROGETTO: TUCANO REPLICA	
		DATA: 16/07/2018	
		REV.: 	
SCALA: N.D		 FLYING LEGEND ITALIA C.DA CAUDARELLA 95041 CALTAGIRONE (CT)	
MODIFICATO IL: 27/07/2018			
CONTROLLATO IL: OPERATORE			
MODELLO: TR-		SITO WEB: www.flyinglegend.it E-MAIL: info@flyinglegend.it	
NOTE: 		DISEGNO 28	
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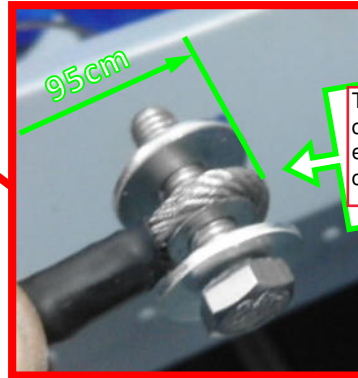
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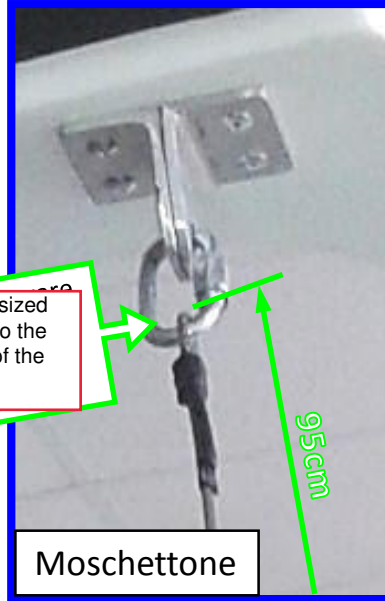
ORD. 6



Bolt M6x25+
3 washer ø6x25+
self locking nut M6



To be sized
close to the
edge of the
circles



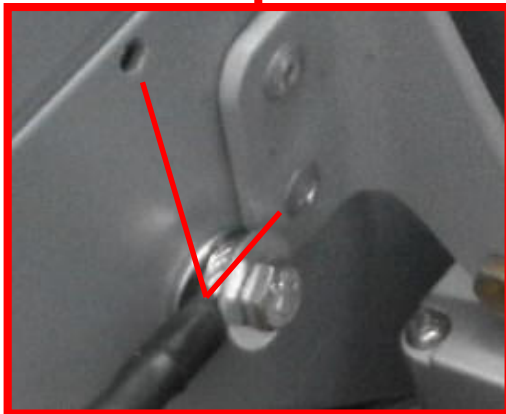
Moschettone

Cut a $\varnothing 3$ SS cable to the opening size that you would like to achieve. Insert two portion of heat shrink gasket, do two circles at the cable and crimp with zip ties. Heat the gasket to cover the zip ties and the free end of the cable.

Realize also a cable of 95 cm. The size to be taken from the edge of the two centers.

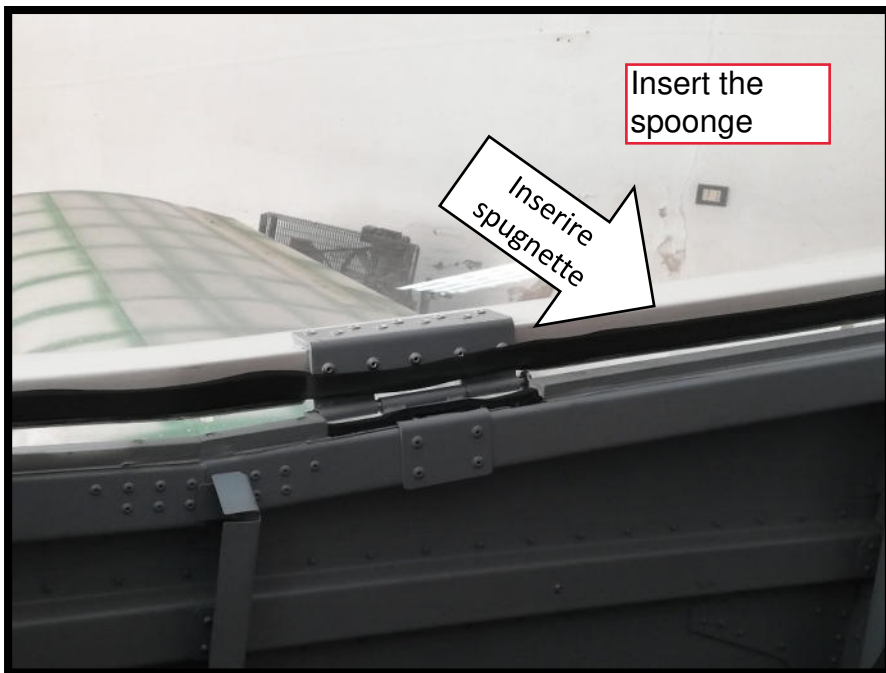
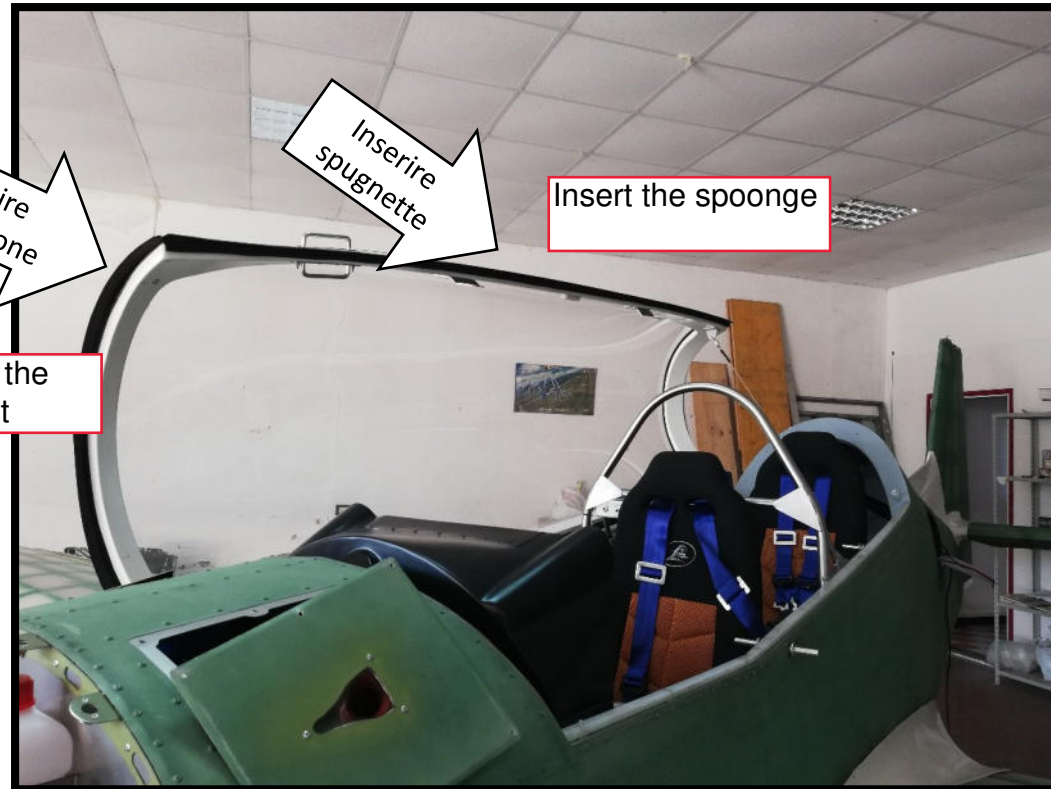
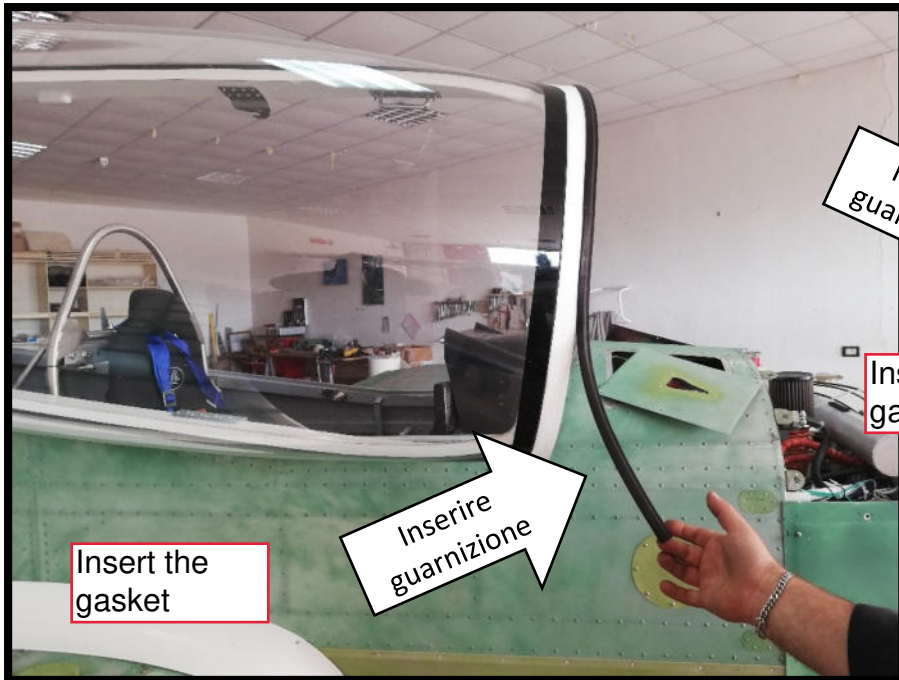
Attach one end of the cable on the reinf. of the flap actuator and the other one to the carabiner which will be inserted in the L's close to the rear angle of the canopy

It is suggested to pass the cable which stops the canopy behind the rear seat, between the two harness



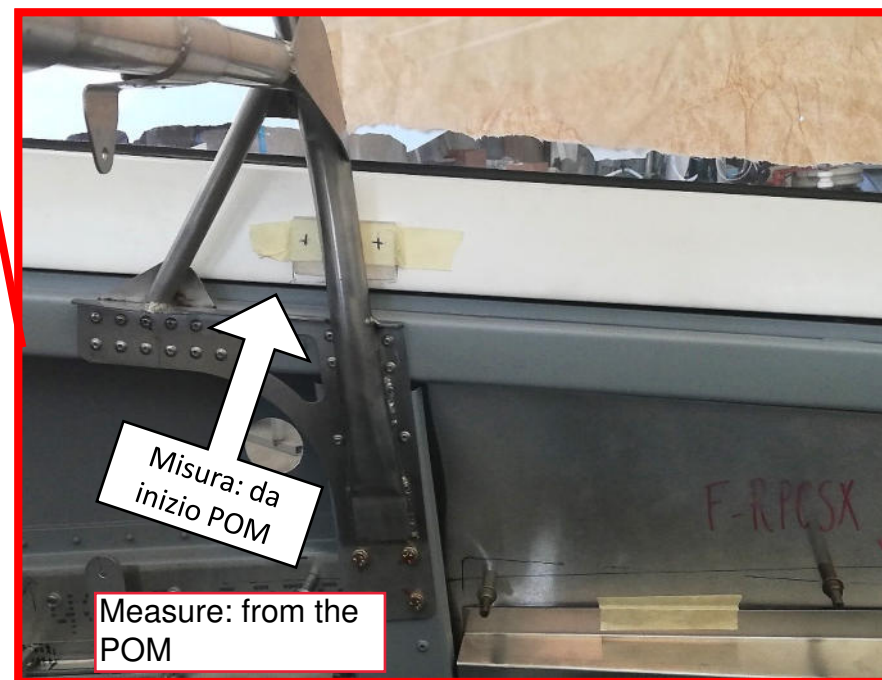
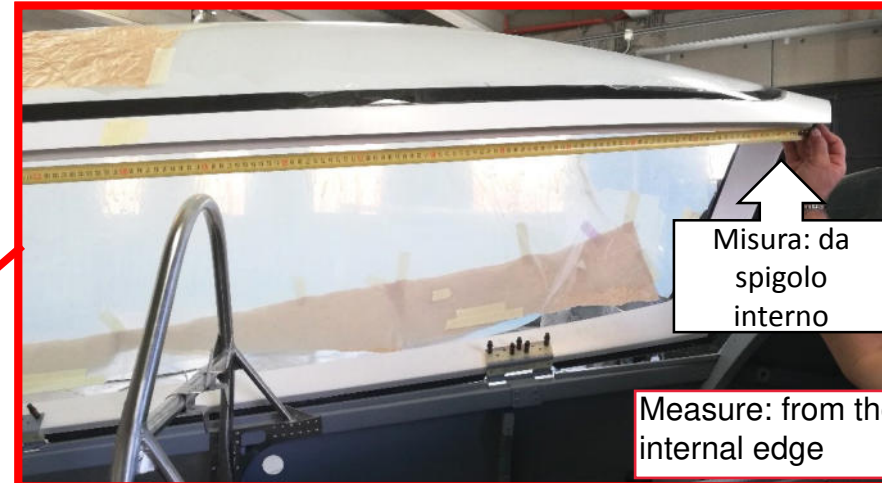
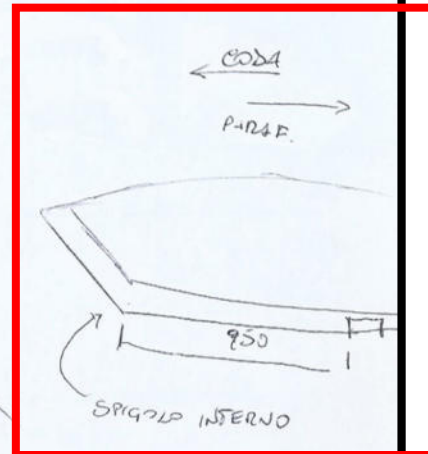
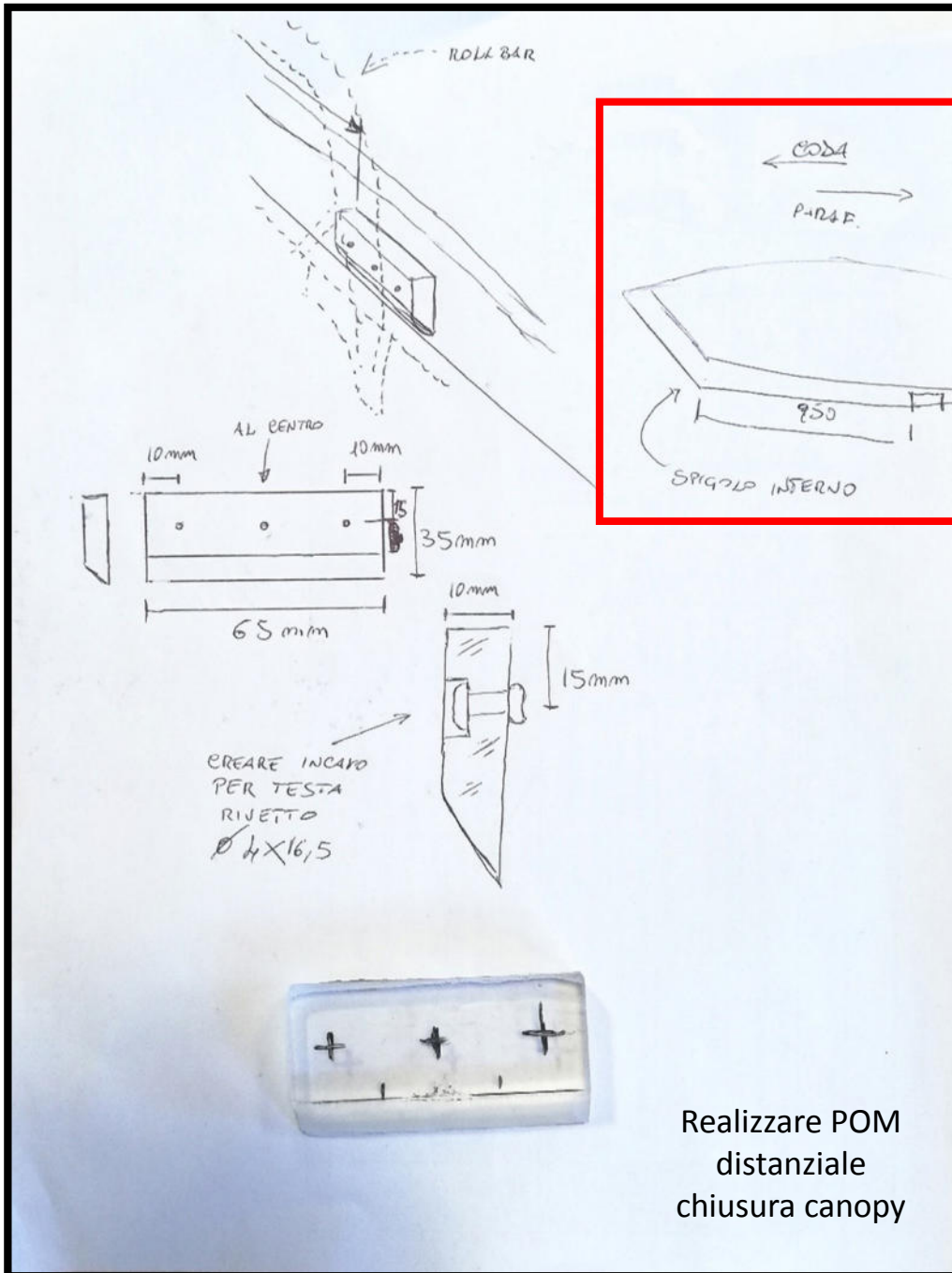
Align the stop bolt with the lower rivet of the support slab of the flap actuator and with the exiting hole which is just above





Attach some sponge where the canopy leans on the frame
(including the parts related to the hinge closing)

Insert the gaskets around the front and rear
bend



Realize with the POM material a spacer for the canopy closure

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For any doubt in the execution of these operations of this cycle production, please refer to the manual "General construction information".



START PRODUCTION DATE ____/____/____

PRODUCTION CYCLE: FUSELAGE - CANOPY

REV. 0 – 11/06/2018

END PRODUCTION DATE ____/____/____

MODEL

TR -

REFERENCE
DRAWING

REV. 0 – 11/06/2018

CONTROLLED

DATE

SIGNATURE

____/____/____

APPROVED

DATE

SIGNATURE

____/____/____

M	STEP	DESCRIPTION	PAG	✓	WORKED HOURS	OPERATOR
	1	Place the two lower half hinges on the canopy guide to take the reference points to do 4 holes in the internal part (Ø3,2). Cleco on the canopy guide and do other two holes on the lip guide following the centre line of this last one. Re drill to the final size all the holes of the lower half-hinges paint and rivet.	1, 2			
	2	Cut to size and place the plexiglass rods on the canopy guide of the fuselage and shape the edges. Jump over the part of the occupied by the hinges and stop on the fuselage with some soft tape (paper tape).	2, 3, 4			
	3	Place thickness of 2mm under the plexiglass rods, drill, dimple the holes and rivet.	3, 4			
	4	Mark the centers of the front and rear bends and the grade change on the canopy resin frame. Place this last one on the fuselage and trim the edges to allow a perfect bond.	Da 5 a 8			
	5	Drill the upper hinges and assembly these together with the ones already in the fuselage. Place the resin frame on these and shape some thicknesses between it and the hinges. Forare le cerniere superiori e assemblarle insieme a quelle già presenti in fusoliera. Re-drill the holes on the thicknesses and canopy frame and check the correct opening of the resin frame.	2, da 9 a 13			
	6	Mark the positions of the centers of the rear and front bends and the grade change on the clear canopy, place it on the resin frame and adhere it correctly. Make sure that the reference points previously taken coincide with these already on the resin frame.	5, 14			

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M	STEP	DESCRIPTION	PAG	✓	WORKED HOURS	OPERATOR
	7	Trim the clear canopy taking as reference its location where it should stay and clean any burrs from the cutted edges.	5, 14, 15			
	8	<i>Call the supervisor to evaluate if it was glued/rivet properly. Mark one of the following option:</i> ☐ <i>Riveted canopy</i> ☐ <i>Glued canopy</i>	-			
	9	Rivet/glue the clear canopy	Riveting: from 16 to 18. Glue option: from 19 to 24			
	10	Assembly front handle on the resin frame	25			
	11	Rivet the slabs (CA-PI) e (CA-PE) and place the closing knobs front and rear.	26, 27			
	12	Once the frame is closed, place the closing slabs (CA-GP) and (CA-GA) and check the correct system hook with the knobs. Adjust the threaded bar of the knobs and re-drill the holes of these slabs on the resin frame.	27, 28			
	13	Insert the knob(CA-MPP) on the back slab (CA-GP) and, after having rechecked again the opening system, rivet the closing slabs (CA-GP) and (CA-GA)	28			
	14	Install on the canopy and on the fuselage the cable which avoid the overturning and the L shape slabs.	29, 30			
	15	Install the sponge and the seal and the POM of closing (NOTE 1)	31, 32			

NOTE 1 – Evaluate to insert the rear seal, as it might be necessary.

CHECKLIST – FUSOLIERA – CANOPY

TR - _____

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