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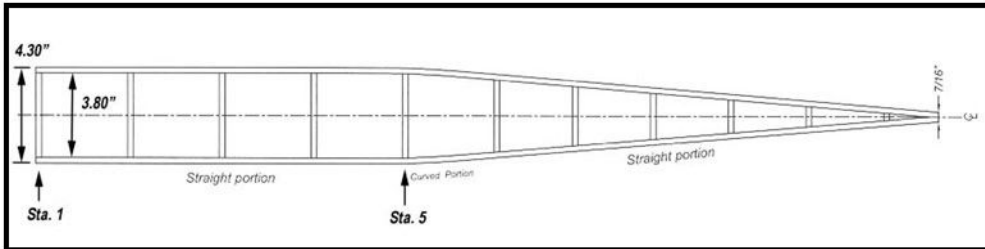
Date: 2/25/2018 3:51:45 PM

Subject: 72 Lancer 850 - Joining the Two Sides (Part 1)

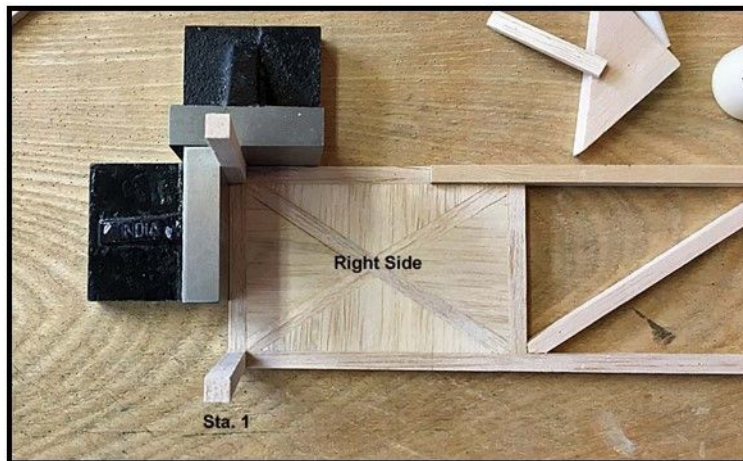
Report No. 72
New Cyclone Lancer 850
 February 25, 2018

This afternoon I started the process of joining the two sides of the fuselage's primary structural frame. I suppose there are any number of ways to go about this, but the following is what works best for me.

A top view drawing of the structural frame is shown below. The width of the fuselage is 4.30". The length of the 1/4" sq. cross members for the forward straight portion of the frame is determined by subtracting the thickness of the two 1/4" sides [$4.30 - (2 \times 1/4) = 3.80$ ". Four 1/4" sq. cross members were cut 3.80" long, two for Sta. 1 and two for Sta. 5. The ends were pre-glued with aliphatic glue.



Two 2" steel block squares were used as corner jigs to erect the cross members vertically at Sta. 1 on the right side as shown below.

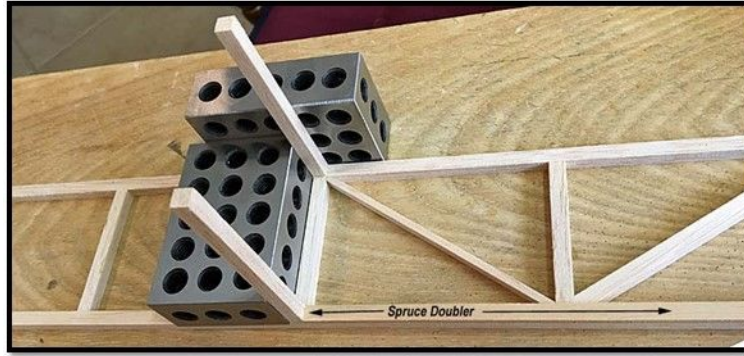


This close up shows the corner jig at Sta. 1.



Two precision 1-2-3 steel blocks were used as corner jigs to erect the cross members vertically at Sta. 5 on the right side

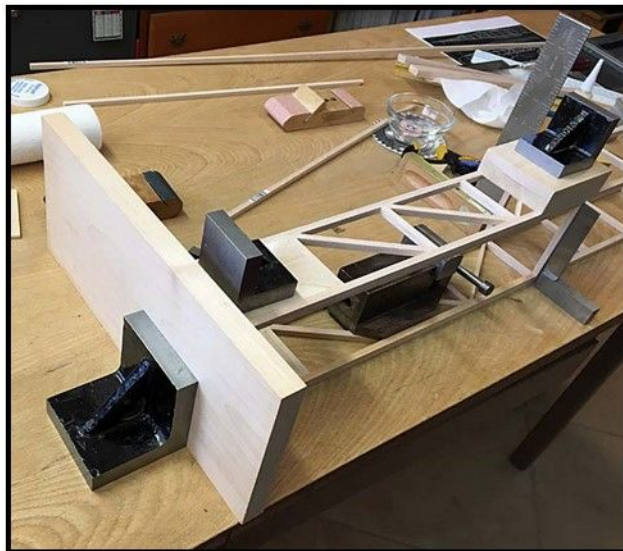
as shown below.



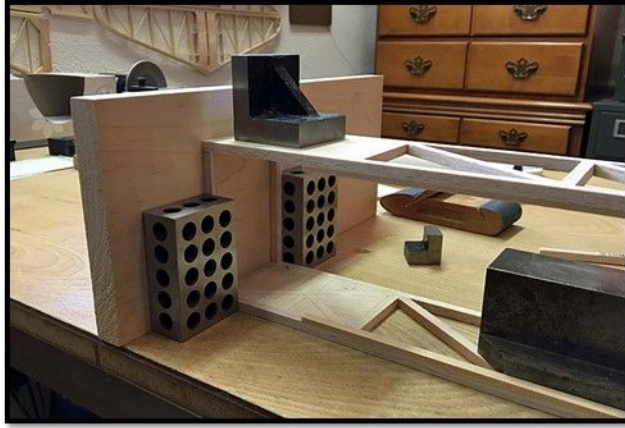
Once these four cross members had dried, the left side was placed down on the work table and weighted down with a small, but heavy steel vise. Glue was applied to the ends of the four cross member and the right side was placed down over the left side as shown below. A whole series of weights, squares, blocks, and planks were used to jig the two sides together as shown below. Notice the heavy tape dispenser pushing the maple plank against the ends of the two sides on the right side of the picture below.



A maple plank was placed in front of the sides with a 3" steel square block pushed against it.



On the back side, two precision 1-2-3 steel blocks were placed against the maple plank and up against the cross members to square the front of the frame. A 2" steel square block was placed on top to hold downward pressure on the two front uprights.



A balsa block was placed over Sta. 5 and a second 2" steel square block was placed on top to hold downward pressure on the two uprights at Sta. 5 as shown below. The maple plank pointed out earlier was placed at the far end of the two sides. This jig setup will be left to thoroughly dry overnight.....Tandy

