

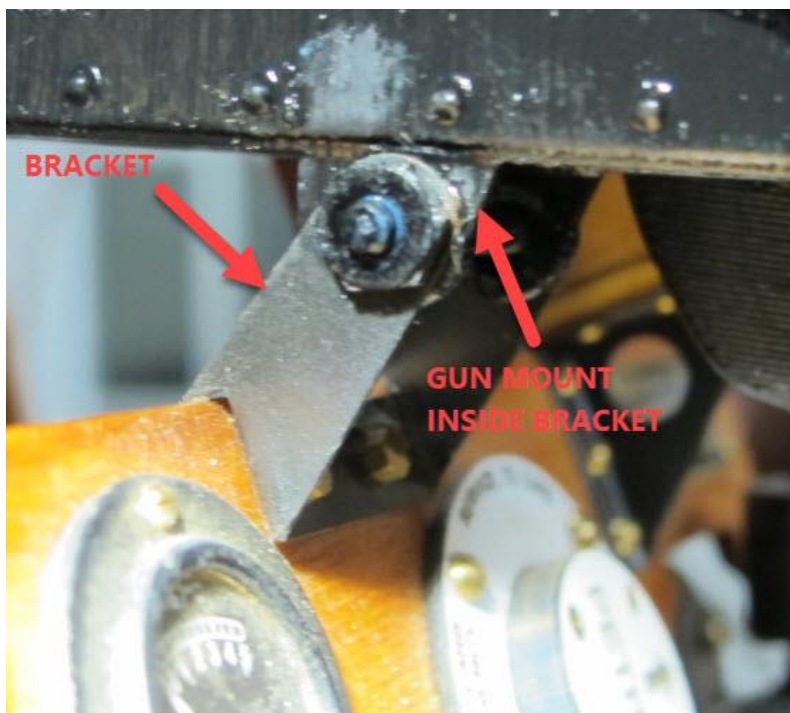
SE5a Vickers Gun

rev 1.0

The Vickers gun mounts to the instrument board and forward cross tubing. The Vickers gun will be slightly above the gas tank indentation. The instrument board and gas tank should be located and secured in place. The carlin 5.44 with plywood support 5.193 at STA 5.3 should be installed as well. You will custom fit the cross tubing to the Vickers gun.

Assemble the Vickers gun now. Follow the instructions included with the parts. Paint the gun semi-gloss or flat black. A gun metal paint also works well.

The gun has two mounting points. The rear attaches to the instrument board bracket and the front attaches to the two cross tubes. Using screw and hex nut 3.59, 3.58 attach the rear gun mount to the instrument board bracket 4.72. The bracket should be on the outside of gun mount. See photo below -



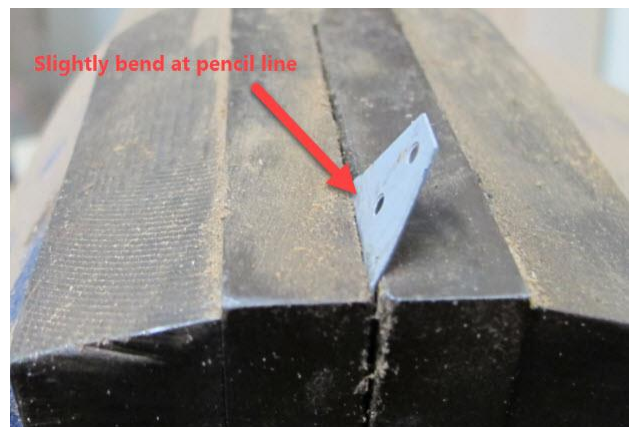
Mark and cut one 4-1/4-inch piece from the aluminum tube 4.111. See photo below -



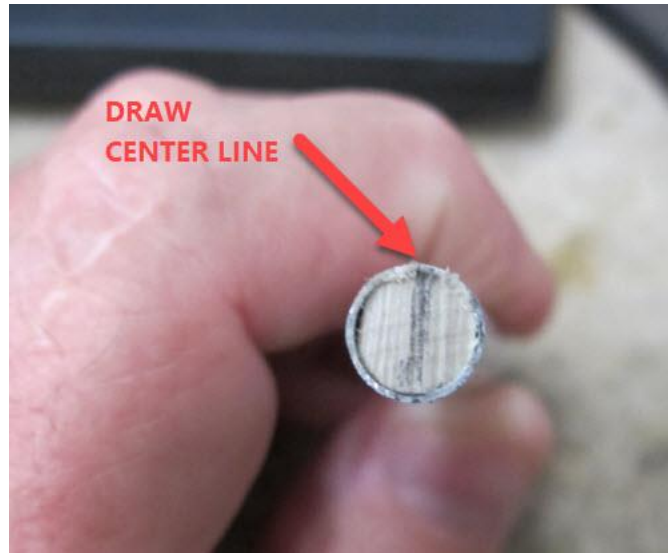
Cut a 2-inch long piece of dowel 5.49. This dowel will require some sanding so it can fit inside the above tube. You can put the dowel in your drill press sanding it. After you sand the dowel cut a 5/8-inch long piece gluing that inside the tube with wood glue. The dowel edge should be flush with the tube edge. See photos below -



Metal base plate 4.104 will go into this tube end with the dowel. The base plate needs to be bent prior to permanent installation. You can pencil a line on the base plate showing the bend area. Using a vice or something similar slightly bend the base plate. Try to keep the bend crisp and straight. The actual bend angle will be determined when you install the tubing. See photos below -



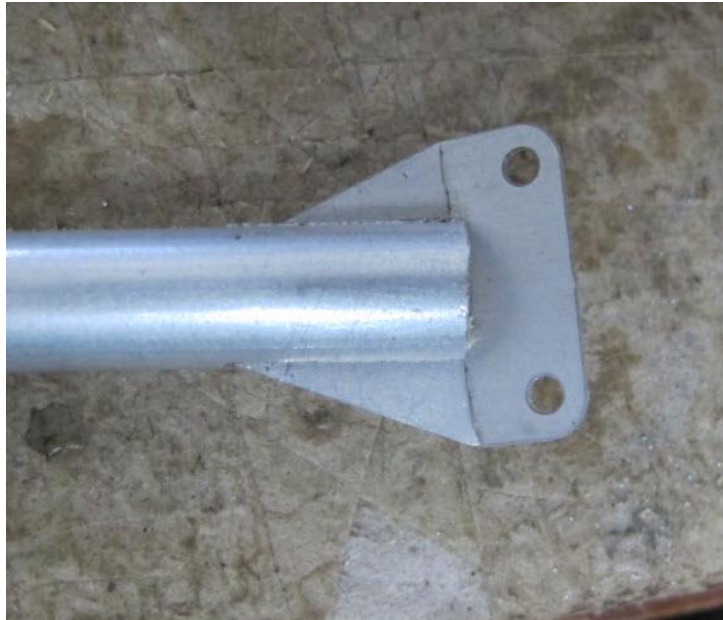
Using a pencil mark the tube end with the dowel the height of the fitting. Place the fitting so the bent edge is flush with the tube end then mark the tube. Draw a center line on the dowel end. See photos below -



Using a hand saw or a band saw a slot for the base plate. The slot should be about 1/2-inch long. See photos below -



Test fit the base plate into the slot. Using wood glue or similar secure the base plate into the slot keeping the bend straight against the tube as well as the base plate centered in the tube. See photo below -

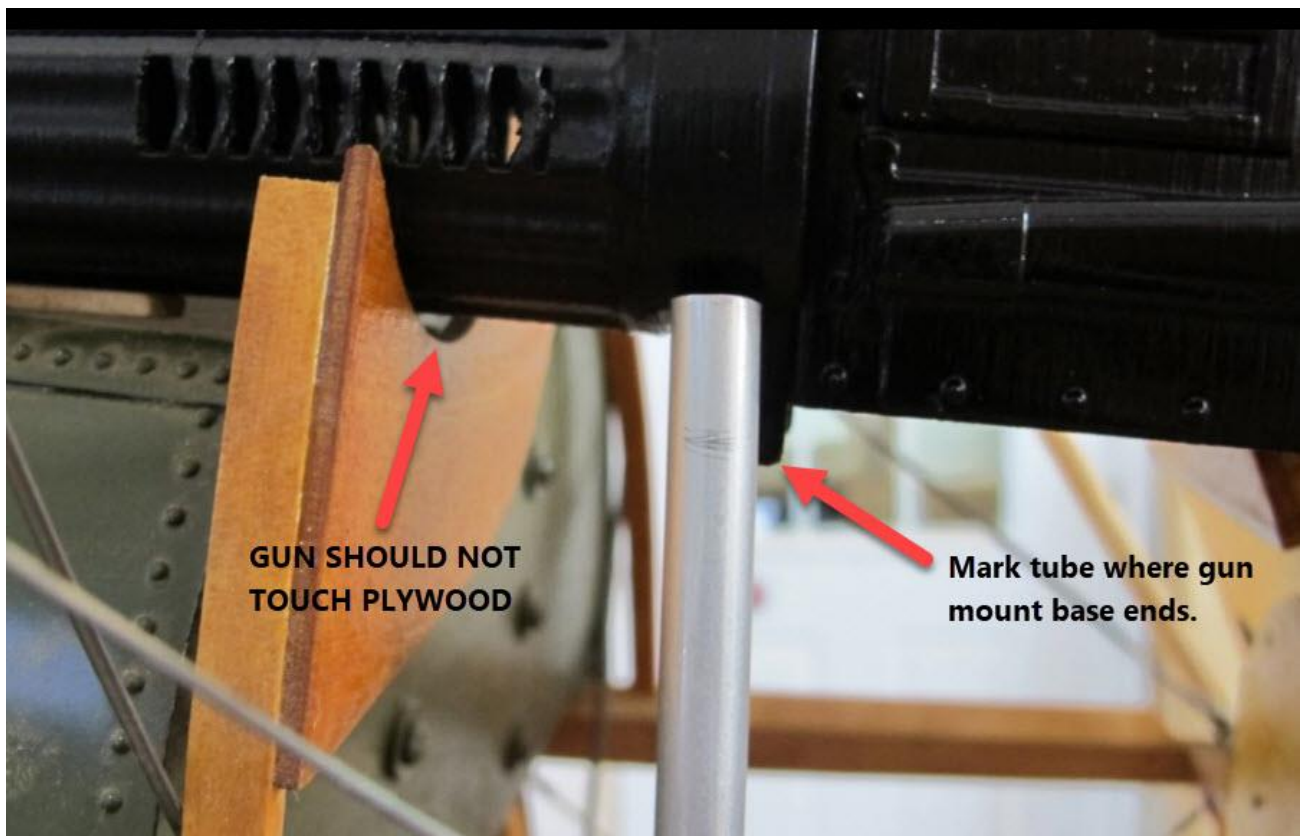


This tube mounts to the top port side longeron 5.3 then goes up to the Vickers forward gun mount. The aluminum tube will be on the outside of the gun mount. Put some scrap 1/8-inch thick wood between the gun muzzle and gas tank which will raise the gun slightly above the gas tank. Test fit this tube in place. Adjust the base plate so the tube goes against the gun mount. See photos below -





Using a pencil mark the tube where the bottom of the gun mount ends. You will flatten the tube from this line up. See photo below -



Flatten the tube at this line. Use a vice or pliers to accomplish that. Due to the thin metal thickness you need to be careful of over bending as it will fatigue the metal. Reposition the tube into place adjusting this flat tab so it aligns to the gun mount. Ensure the base plate is flush with the outside edge of the top longeron which will keep it square to the gun. See photos below -



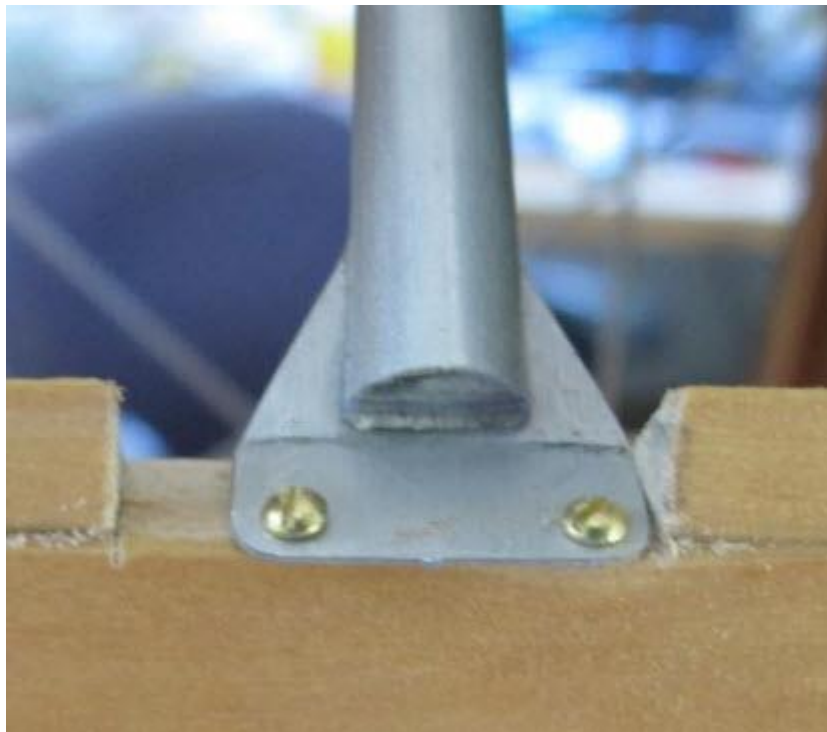
Hold the tube against the gun mount; use a marker to locate the drill hole location. Drill a 5/32-inch hole in the flat tab for screw 3.114 where you made that mark. Carefully, trim and sand the extra part of the tab. See photos below -



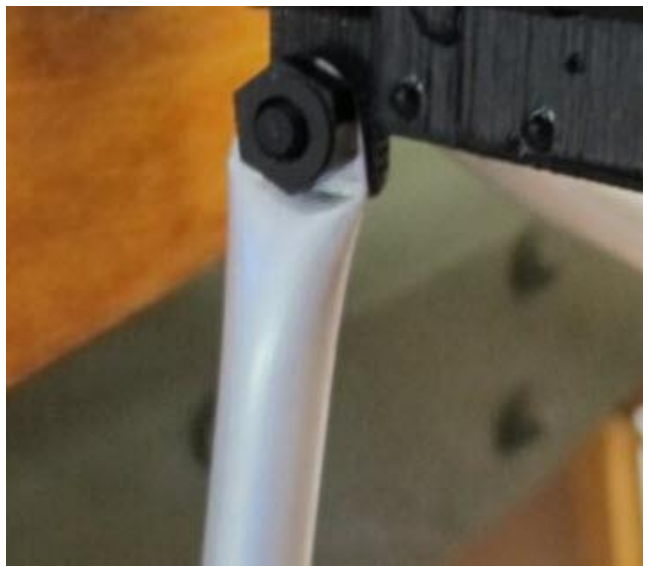
Test fit the tube in place using the plastic screw 3.114. Make any adjustments that are needed. The tube should be straight and not crooked to the gun. Remember the ammo box fitting will be positioned pretty close to the base plate. Note - the screw head should be on the starboard side of the gun when permanently installed. See photo below -



Use two screws 6.78 to secure the base to the top longeron. The edge of the metal base should not extend past the edge of the top longeron. See photo below -



You need to repeat the above tube installation instructions for the starboard tube. You want the gun to stay slightly above the gas tank as well as being perpendicular to the instrument board. Secure both tubes to the longerons and to the base of the gun. Check all clearances. For the starboard (right) cross tube you need to cut a 7-1/2-inch long piece of aluminum tube 4.111 repeating the above assembly instructions. Ensure this tube is not crooked when installed. Test fit the ammo box to help locate where the base plate should go. See photos below -



With the Vickers gun mounted you can now position and secure the ammo box in place.