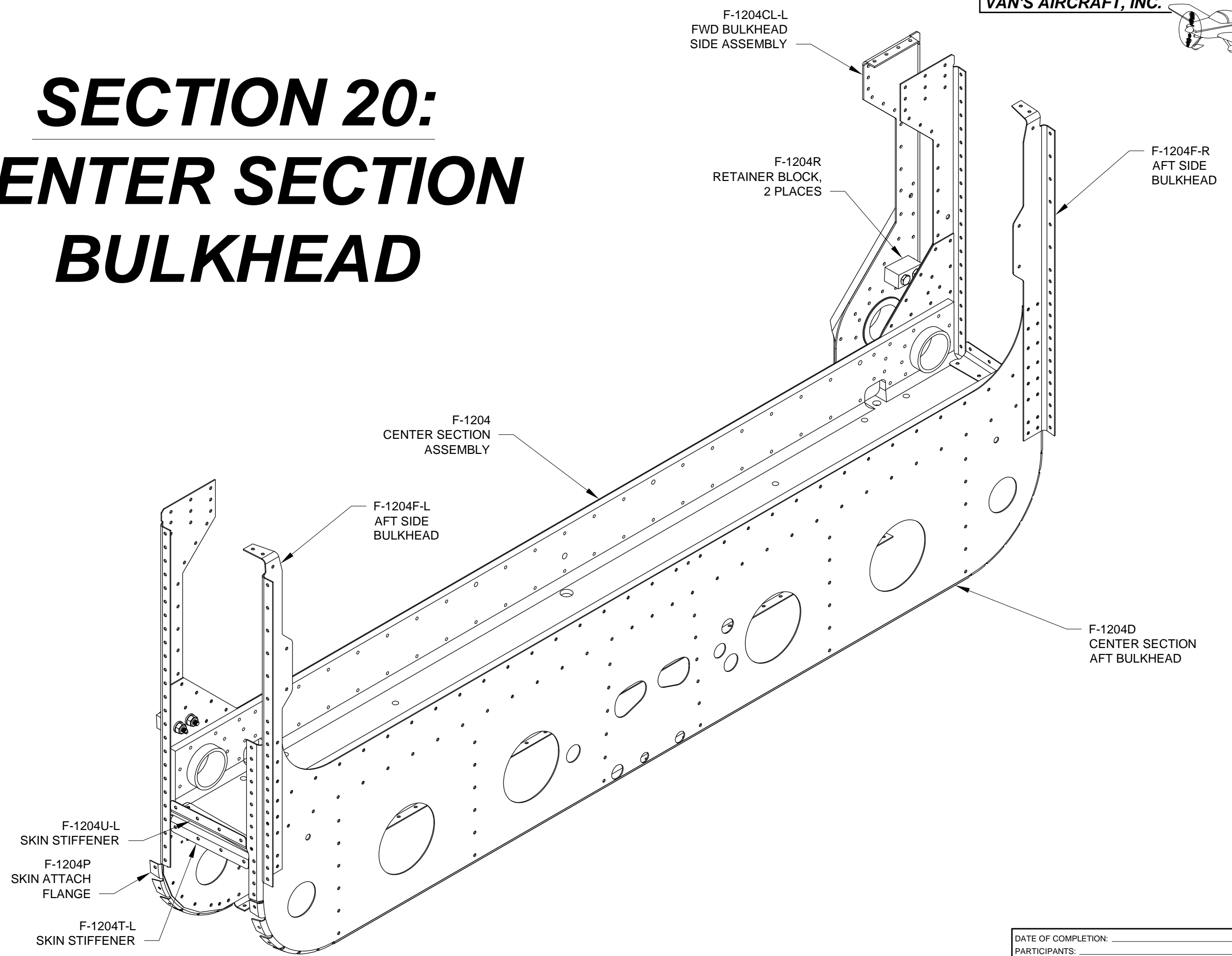


SECTION 20: CENTER SECTION BULKHEAD



Step 1: Machine countersink 100° the nutplate rivet holes on the F-1204 Center Section Assembly to fit the the head of AN426AD3 rivet as shown in Figure 1. Machine countersink 100° the nutplate rivet holes in the center section assembly to fit the head of CCR-264SS-3-2 rivet as shown in Figure 1. Install nutplates on the center section assembly as shown in Figure 1.

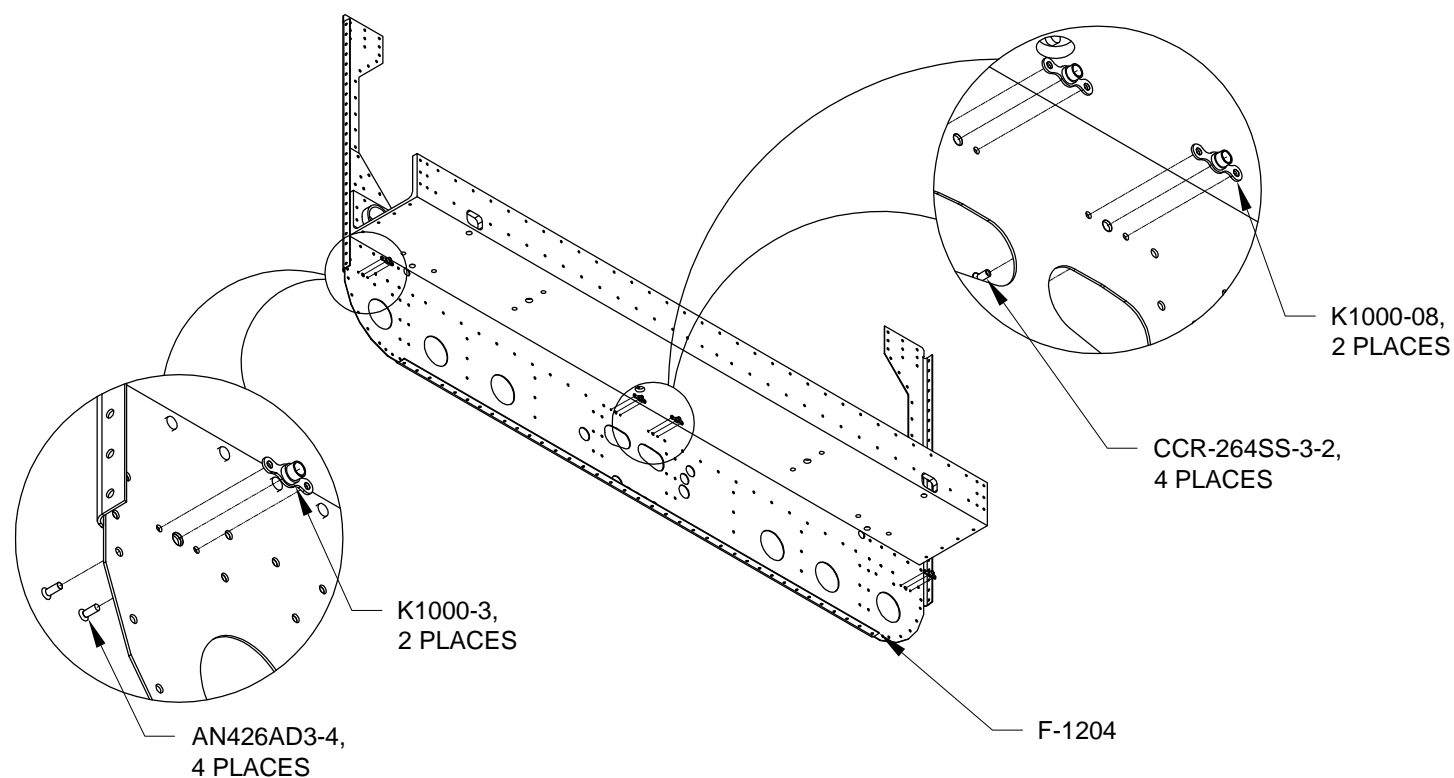


FIGURE 1: INSTALLING THE NUTPLATES

Step 2: Final-Drill the two bolt holes in the F-1204CL-R Fwd Bulkhead Side Assembly and install the F-1204R Retainer Block as shown in Figure 2.

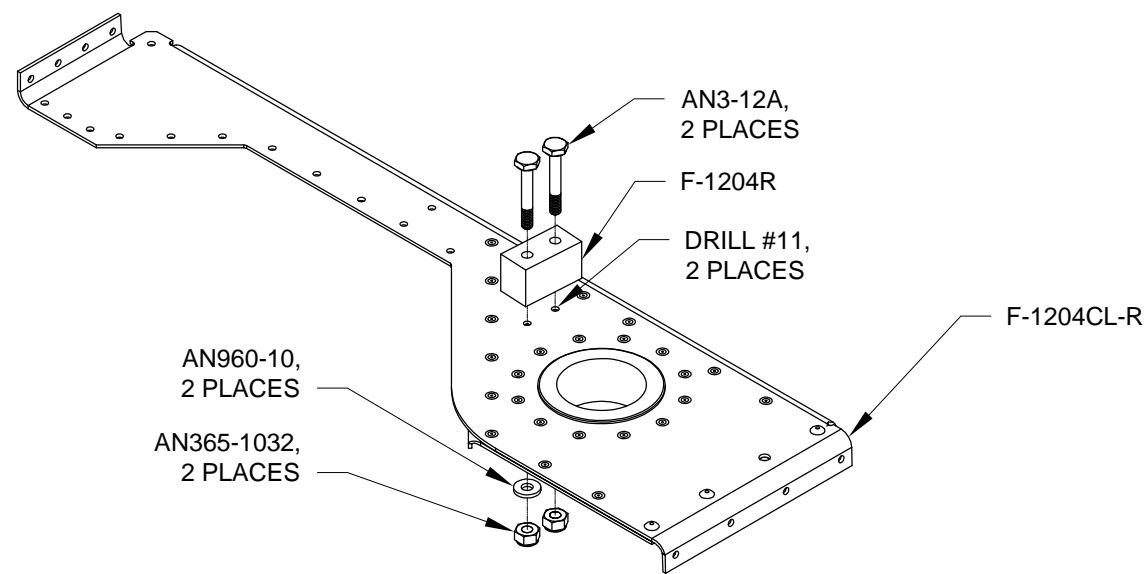


FIGURE 2: INSTALLING THE RETAINER BLOCK

Step 3: Final-Drill the F-1204 Center Section Assembly and install the F-1204R Retainer Block as shown in Figure 3.

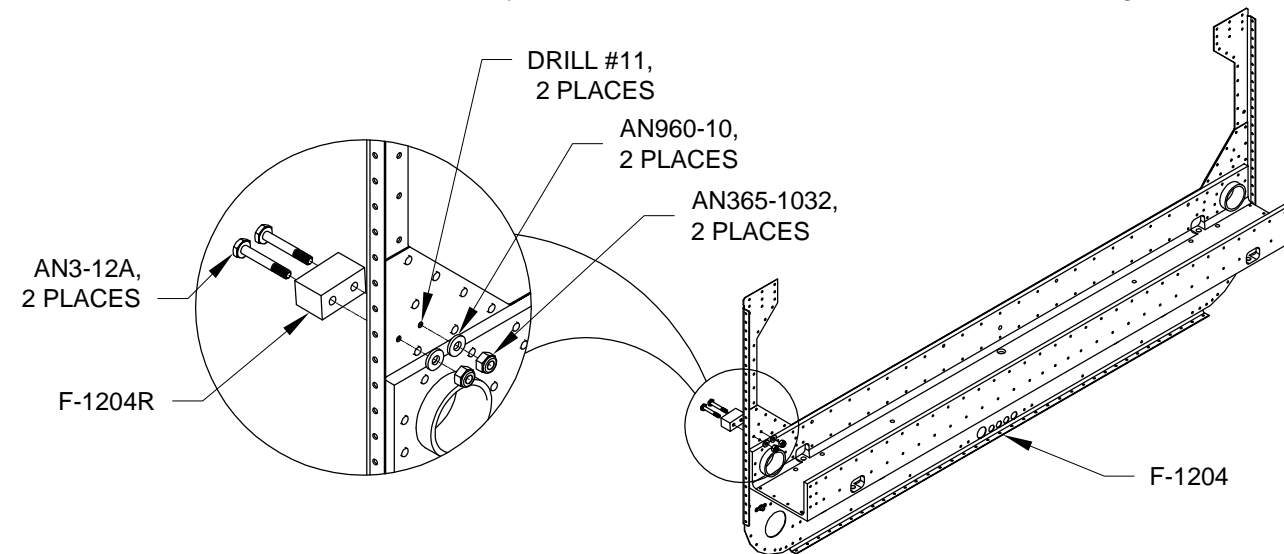


FIGURE 3: INSTALLING THE RETAINER BLOCK IN CENTER SECTION

Step 4: Insert two AN4 bolts into the 1/4 inch holes punched in the F-1204D Center Section Aft Bulkhead. Clamp the center section aft bulkhead to the F-1204 Center Section Assembly as shown in Figure 4. The bottom surface of the center section channel rest on the shanks of the two AN4 bolts.

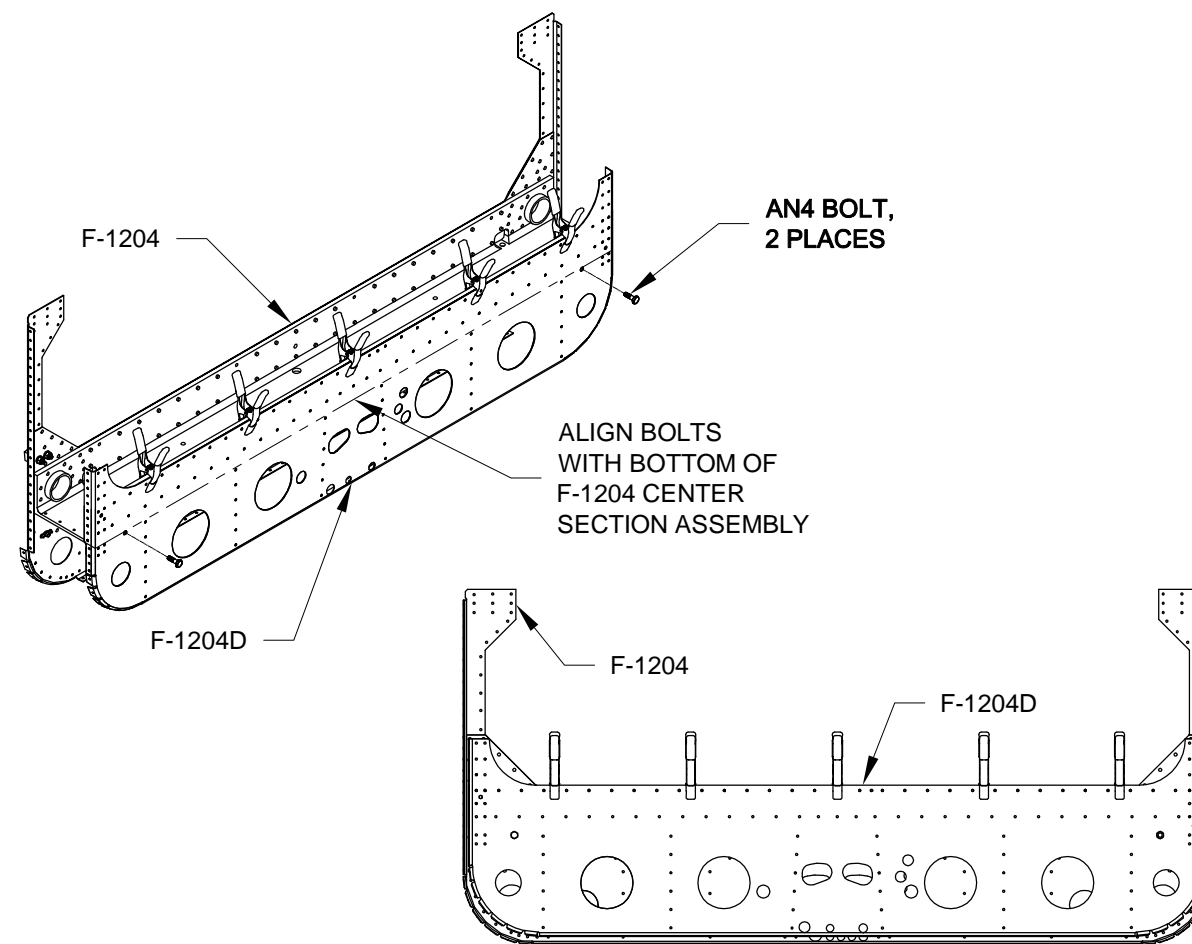


FIGURE 4: ALIGNING CENTER SECTION AFT BULKHEAD



Step 1: Place F-1276 Bottom Skin on the tabletop. Place F-1204 Center Section Assembly over bottom skin and cleco the bottom flanges of the bulkheads as shown in Figure 1.

Step 2: Temporarily loosen the clamps holding the F-1204D Center Section Aft Bulkhead to the F-1204 Center Section Assembly and allow the parts to re-align according to their being clecoed to the F-1276 Bottom Skin. Tighten the clamps and match-drill #30 the holes in the center section aft bulkhead into the center section assembly beginning at the center and progressively drilling and clecoing outboard. See Figure 3. Drill #11 two places, see Pg 20-04, Figure 3.

Step 3: Un-cleco the bottom flanges from the F-1276 Bottom Skin and remove the F-1204 Center Section Assembly and F-1204D Center Section Aft Bulkhead. Set aside the bottom skin as it will be called for at a later stage of fuselage assembly. Un-cleco the center section aft bulkhead from the center section assembly, remove AN4 bolts, and deburr all match-drilled holes.

Step 4: Machine countersink 100° the holes in the F-1204 Center Section Assembly that receive an AN426AD4 rivet- see Figure 2 and Pg 20-04 Figure 3. A piece of thin scrap with a 1/4 inch hole drilled in it may be used to check the diameter (as described on Pg 14-02). Dimple the corresponding holes in the F-1204D Center Section Aft Bulkhead- see Pg 20-04 Figure 3.

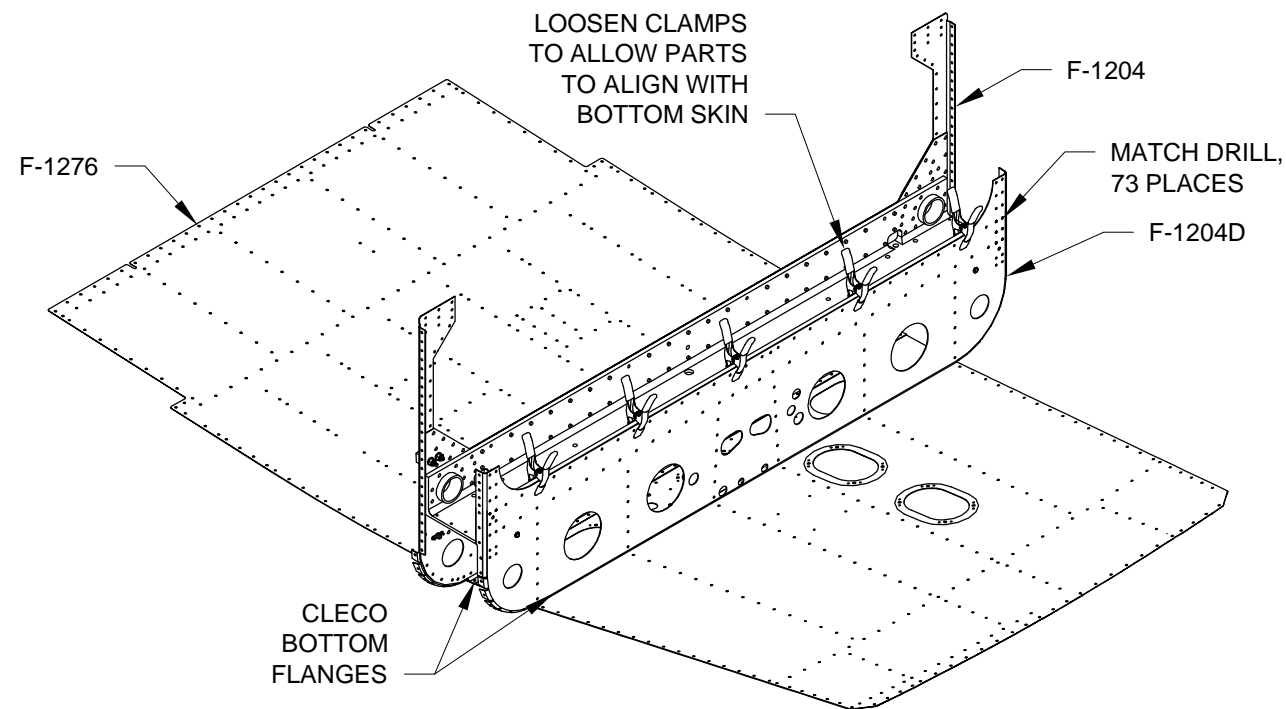


FIGURE 1: ALIGNING CENTER SECTION BULKHEAD TO BOTTOM SKIN

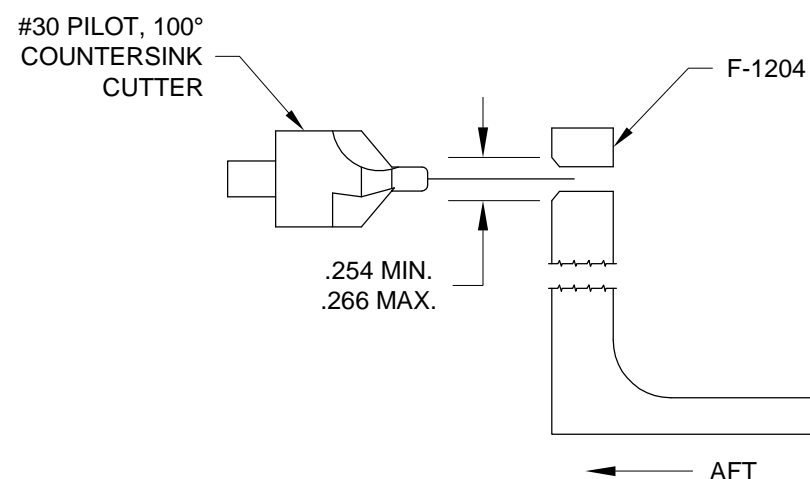


FIGURE 2: COUNTERSINK ORIENTATION DETAIL

Step 5: Cut apart the F-1204P Skin Attach Flange to make F-1204P-L and F-1204P-R Skin Attach Flanges as shown in Figure 3.

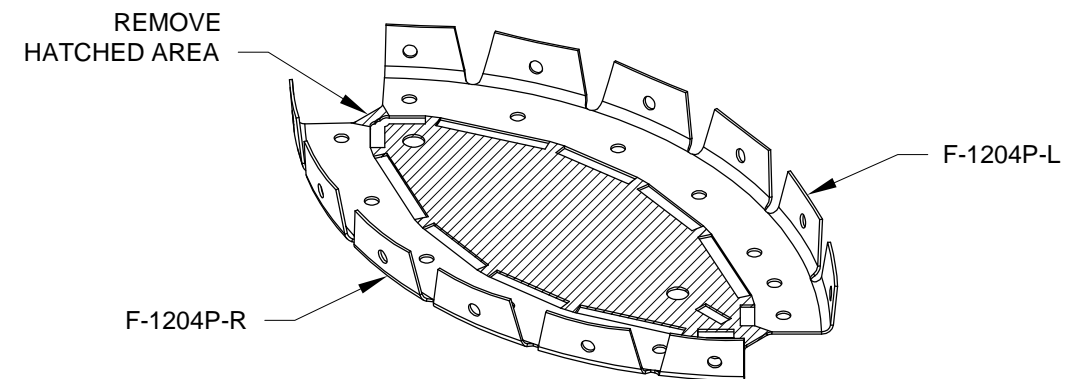


FIGURE 3: SEPARATING SKIN ATTACH FLANGES

Step 6: Separate F-1204T-L and F-1204T-R Skin Stiffeners by removing the hatched areas shown in Figure 4.

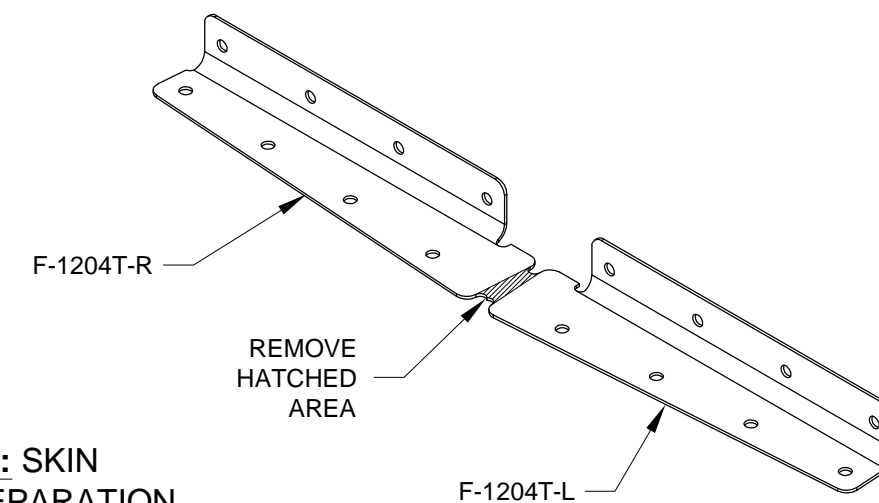


FIGURE 4: SKIN STIFFENER SEPARATION

Step 7: Separate F-1204U-L and F-1204U-R Skin Stiffeners by removing the hatched areas shown in Figure 5.

Step 8: Bend the bottom flanges of the F-1204U-L and F-1204U-R Skin Stiffeners up (to fit the inside radius of the F-1204 Center Section Assembly) as shown in Figure 6. See 20-05 Figure 1 for radius and part location.

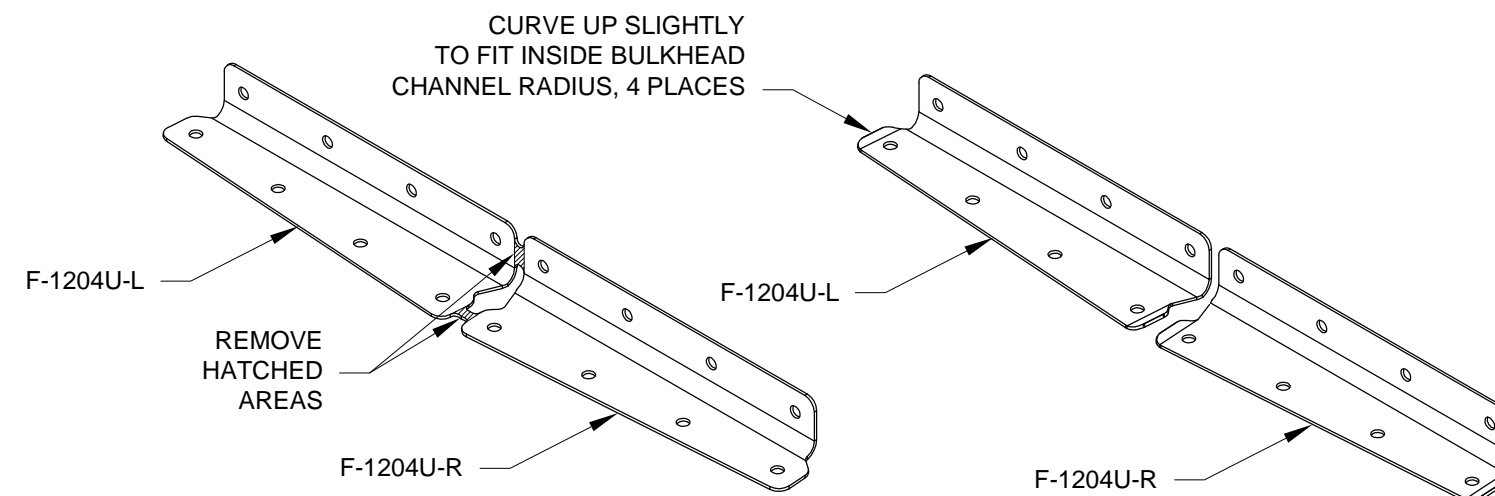


FIGURE 5: SKIN STIFFENERS

FIGURE 6: SKIN STIFFENER BENDS



Step 1: Attach the F-1204P-L and F-1204P-R Skin Attach Flanges to the F-1204 Center Section Assembly as shown in Figure 1.

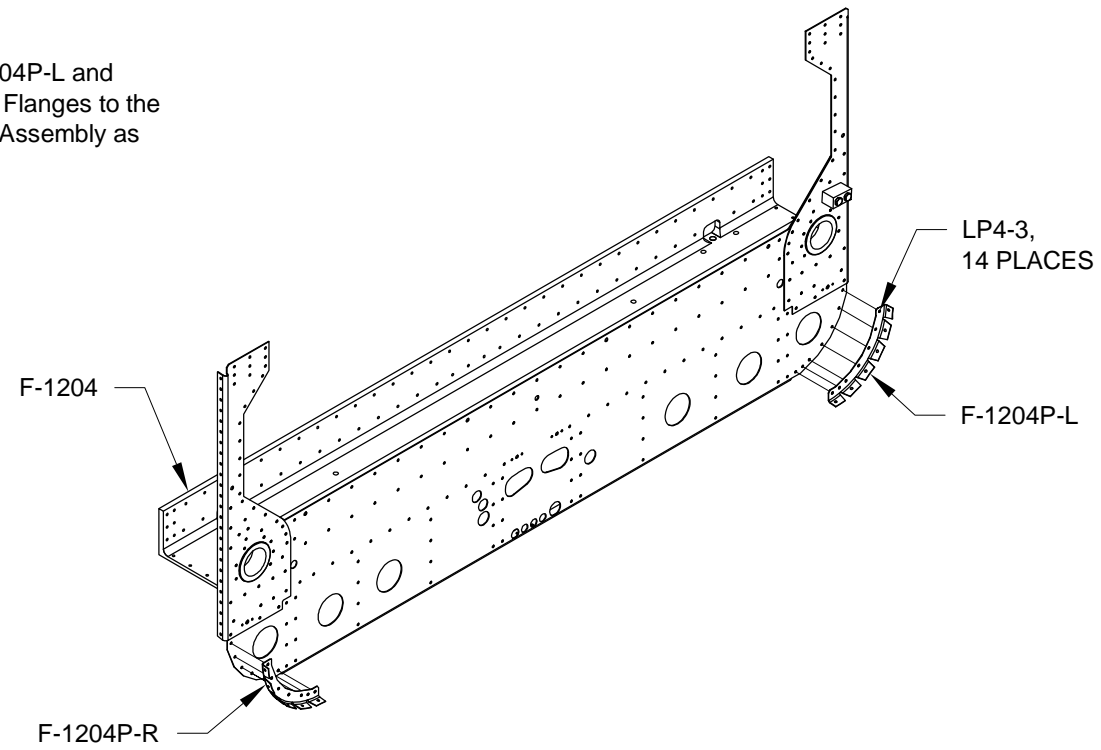


FIGURE 1: ATTACHING SKIN ATTACH FLANGES

Step 2: Attach the F-1204D Center Section Aft Bulkhead and the F-1204F-L and F-1204F-R Aft Side Bulkheads to the F-1204 Center Section Assembly as shown in Figure 2 and Figure 3.

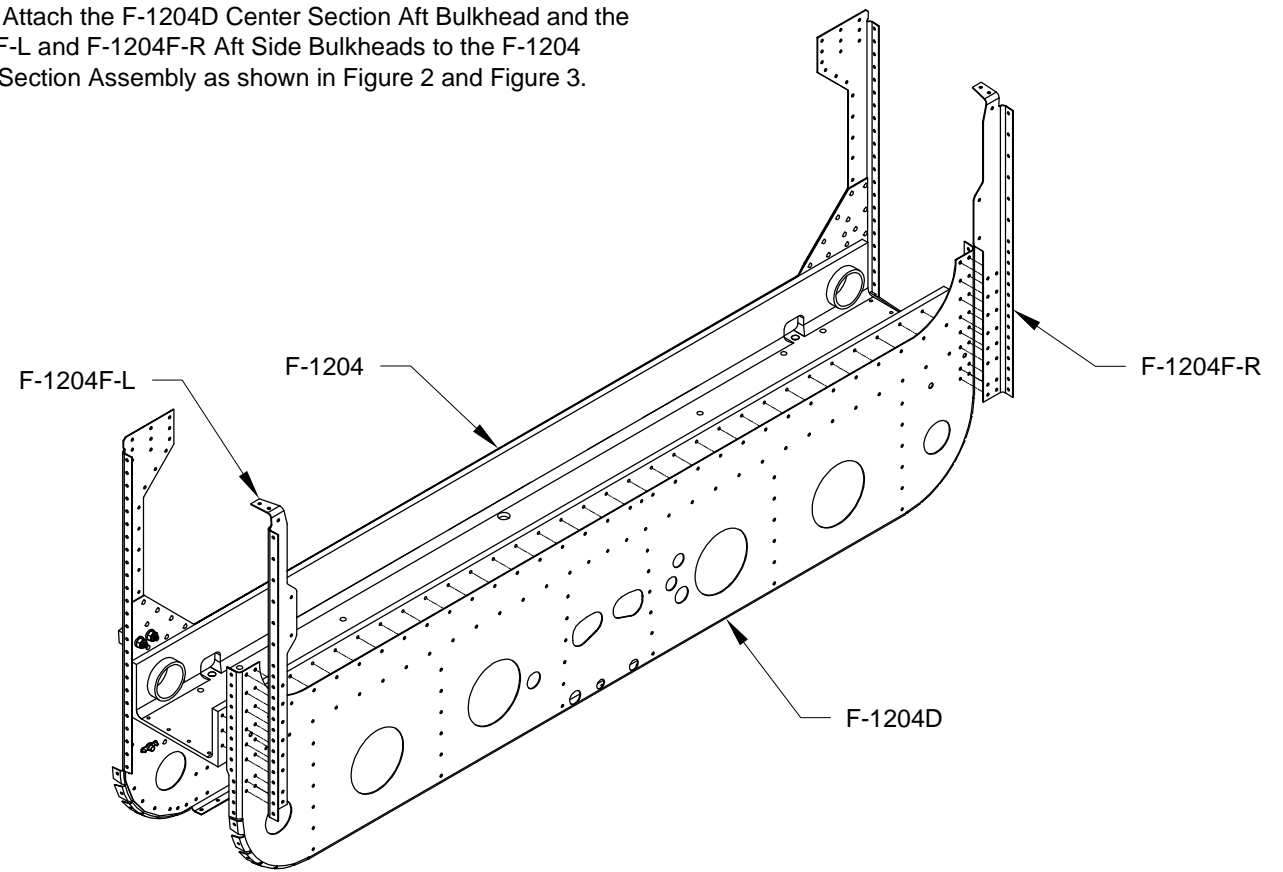


FIGURE 2: BULKHEAD ASSEMBLY

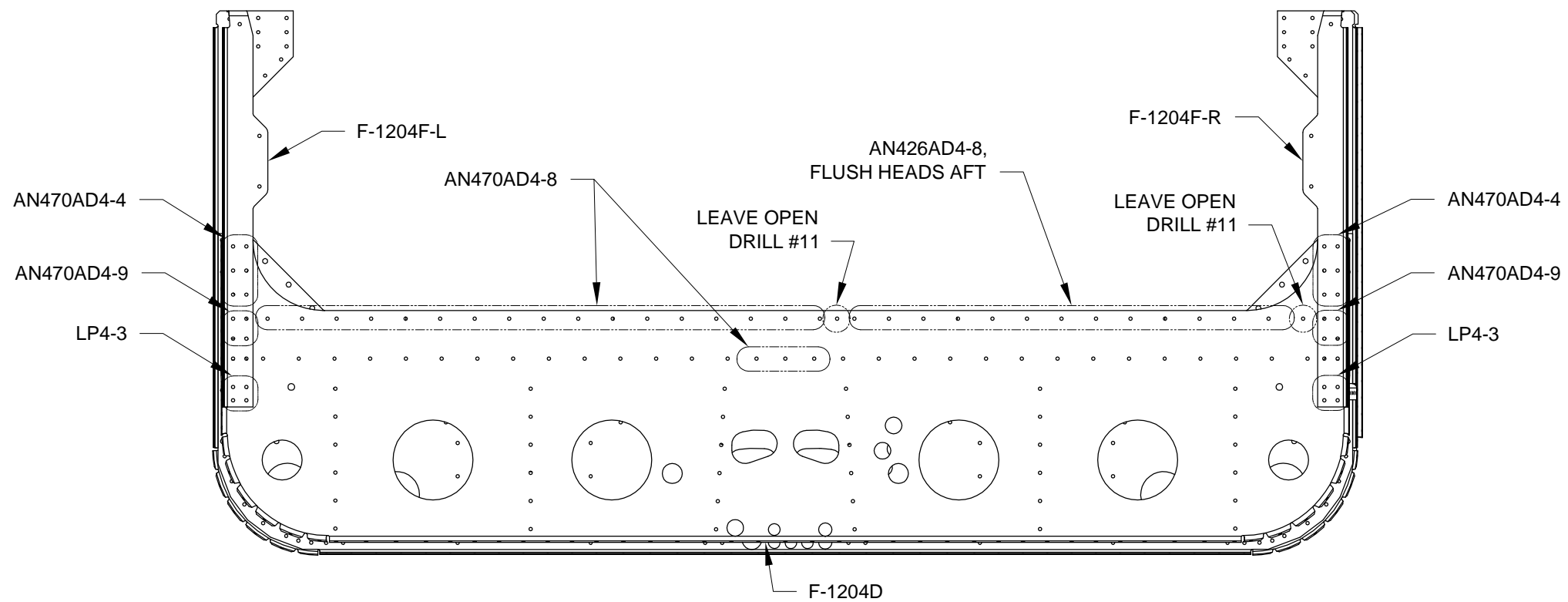
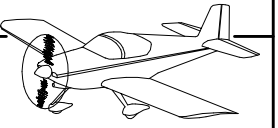


FIGURE 3: BULKHEAD ASSEMBLY



Step 1: Rivet the F-1204T-L and F-1204U-L Skin Stiffeners to the Center Section Assembly as shown in Figure 1.

Rivet the F-1204T-R and F-1204U-R Skin Stiffeners to the Center Section Assembly. See Figure 1.

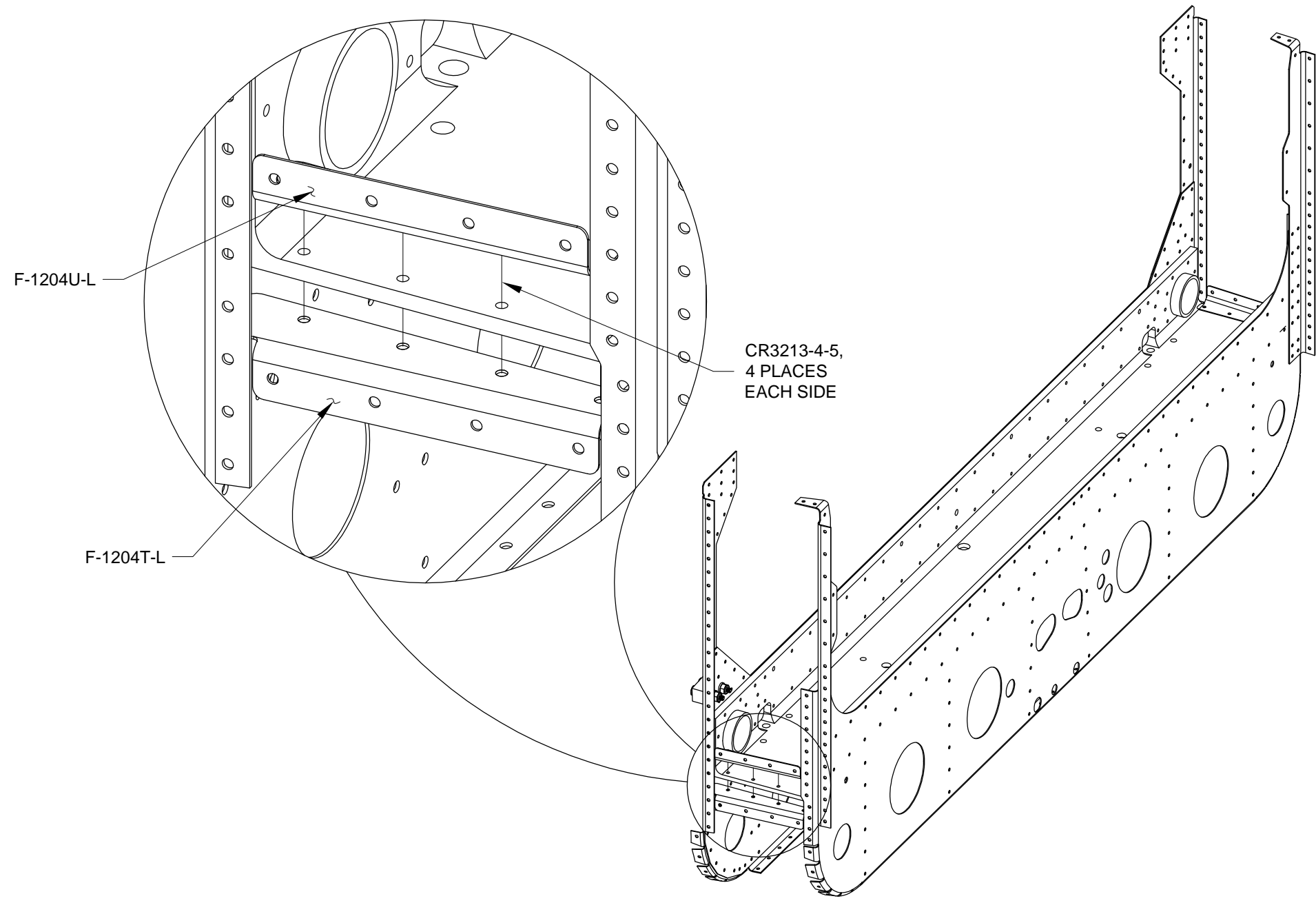


FIGURE 1: INSTALLING SKIN STIFFENERS



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