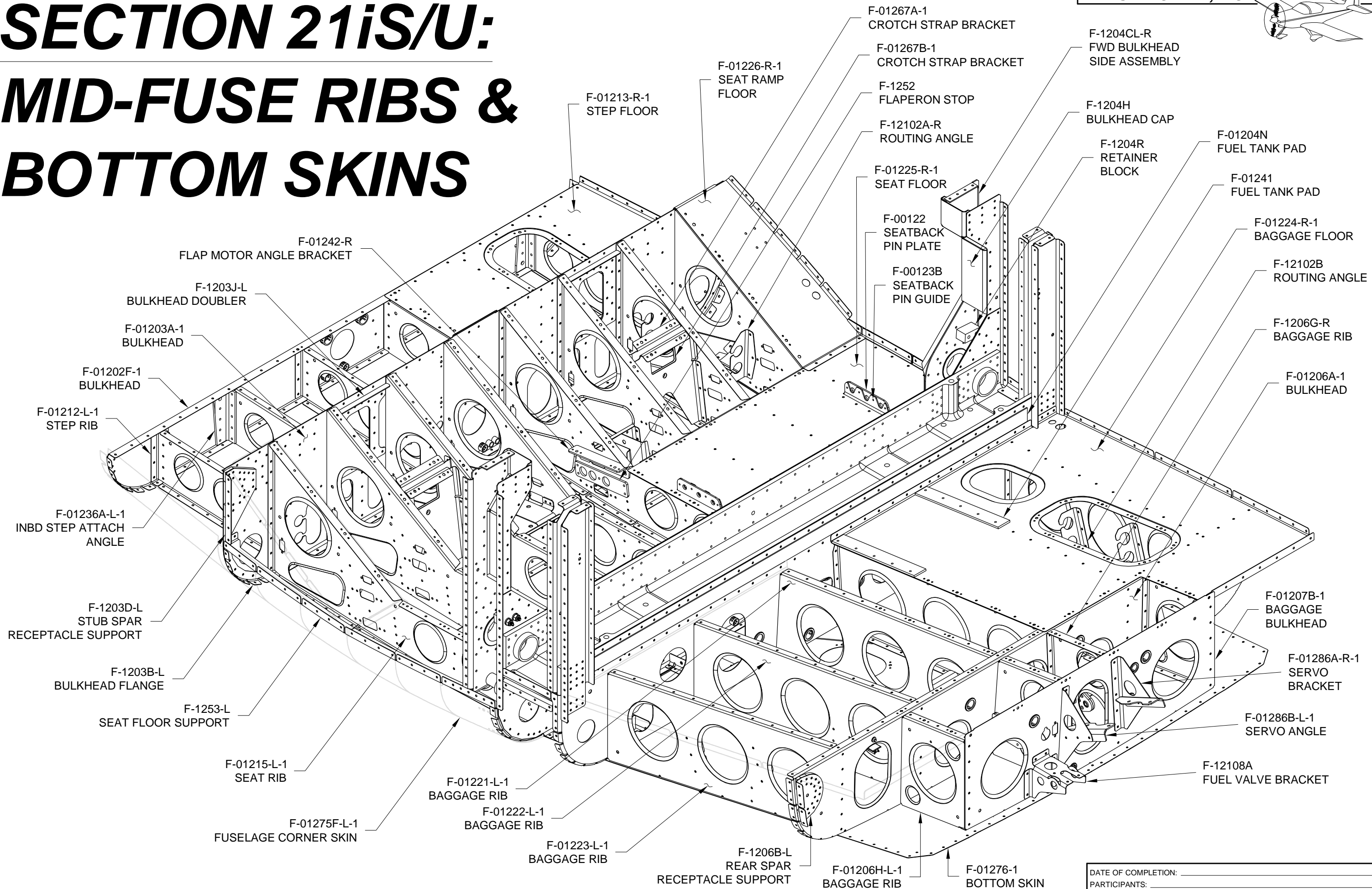
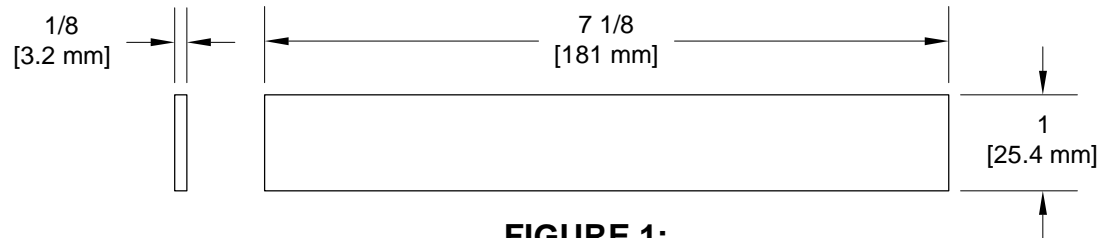


# SECTION 21iS/U: MID-FUSE RIBS & BOTTOM SKINS



DATE OF COMPLETION: \_\_\_\_\_  
 PARTICIPANTS: \_\_\_\_\_  
 DATE: 09/18/17 REVISION: 0 RV-12iS PAGE: 21iS/U-01

**Step 1:** Cut to length four F-01241 (UHMW plastic bar) as shown in Figure 1.



**FIGURE 1:**  
CUTTING FUEL TANK PADS

**Step 2:** Align two each F-01241 to F-01224-L-1 and F-01224-R-1 as shown in Figure 2.

Match-Drill #30 F-01241 using F-01224-L-1 and F-01224-R-1 as guides. Mark for reassembly.

"Over" machine countersink #30 all the holes in each F-01241 for CS4 rivets to prevent the rivet head from abrading the tank skin.

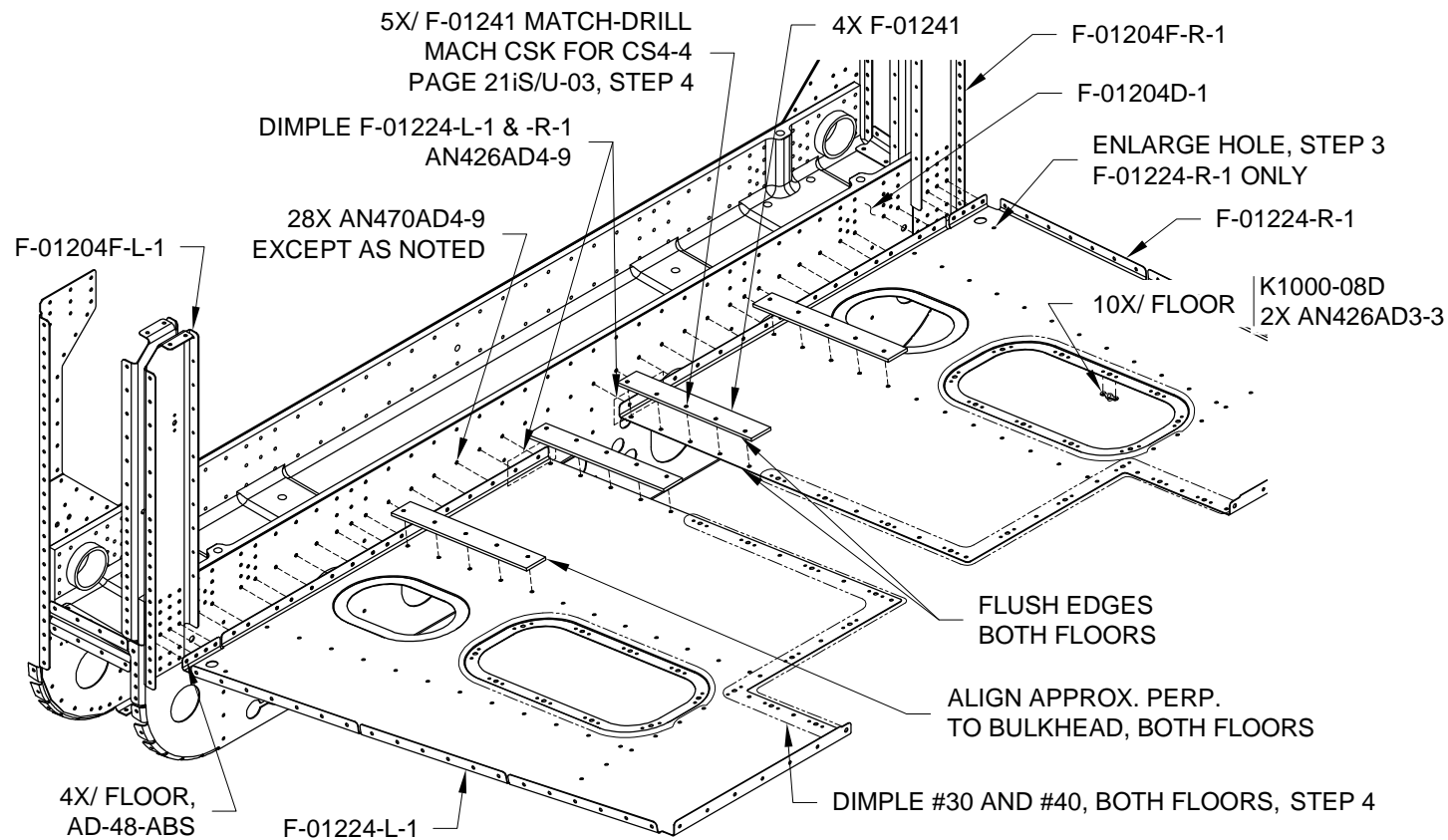
**Step 3:** Use a step drill to enlarge the #30 hole to 5/8 in F-01224-R-1 per the call-out.

**Step 4:** Dimple the #30 and #40 holes in F-01224-L-1 & -R-1 along the edges bordered by the dashed lines and around the access holes. See Figure 2.

Dimple #30 the two holes in each F-01224-L-1 & -R-1 enclosed in dashed-line boxes.

**Step 5:** Rivet nutplates around the access holes of F-01224-R-1 & -L-1.

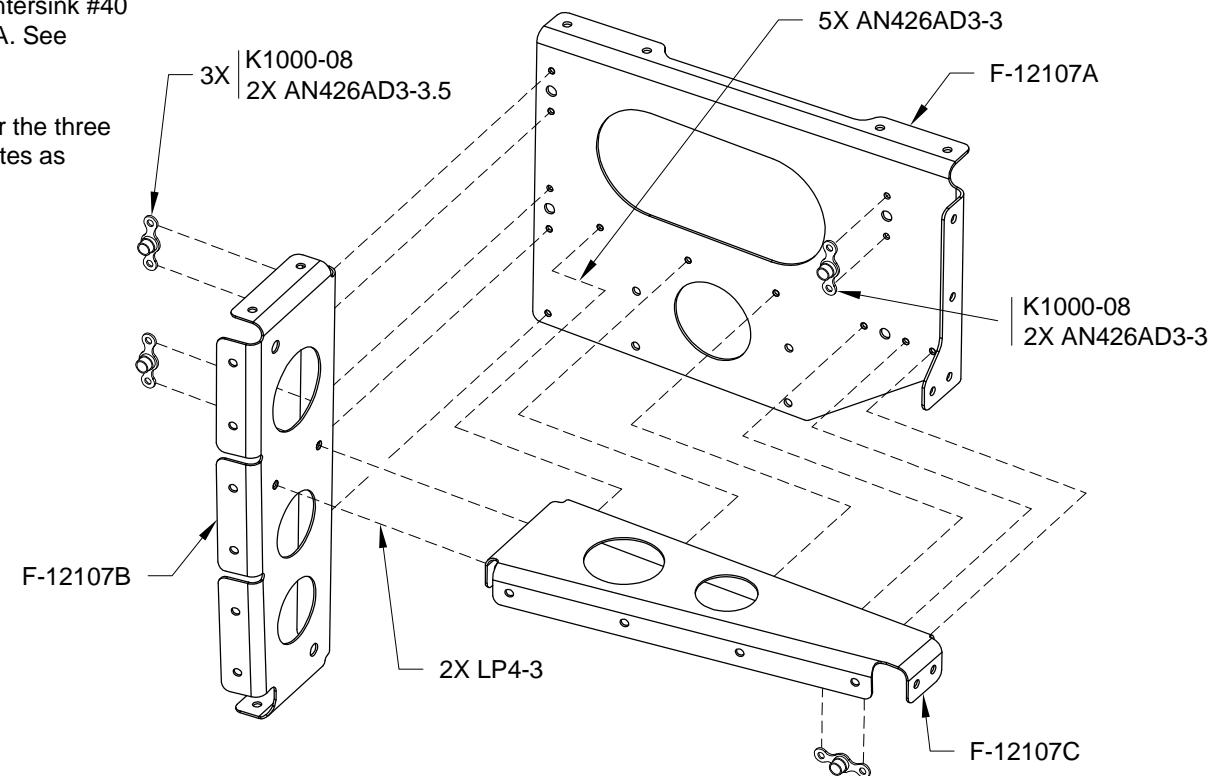
**Step 6:** Rivet F-01224-L-1 & -R-1 to F-01204D-1 and F-01204F-L-1 & -R-1 using the rivets called out in Figure 2. Use two thin flush sets in a hand squeezer and apply tape to the squeezer to prevent scratching the baggage floors.



**FIGURE 2:**  
RIVETING BAGGAGE FLOORS

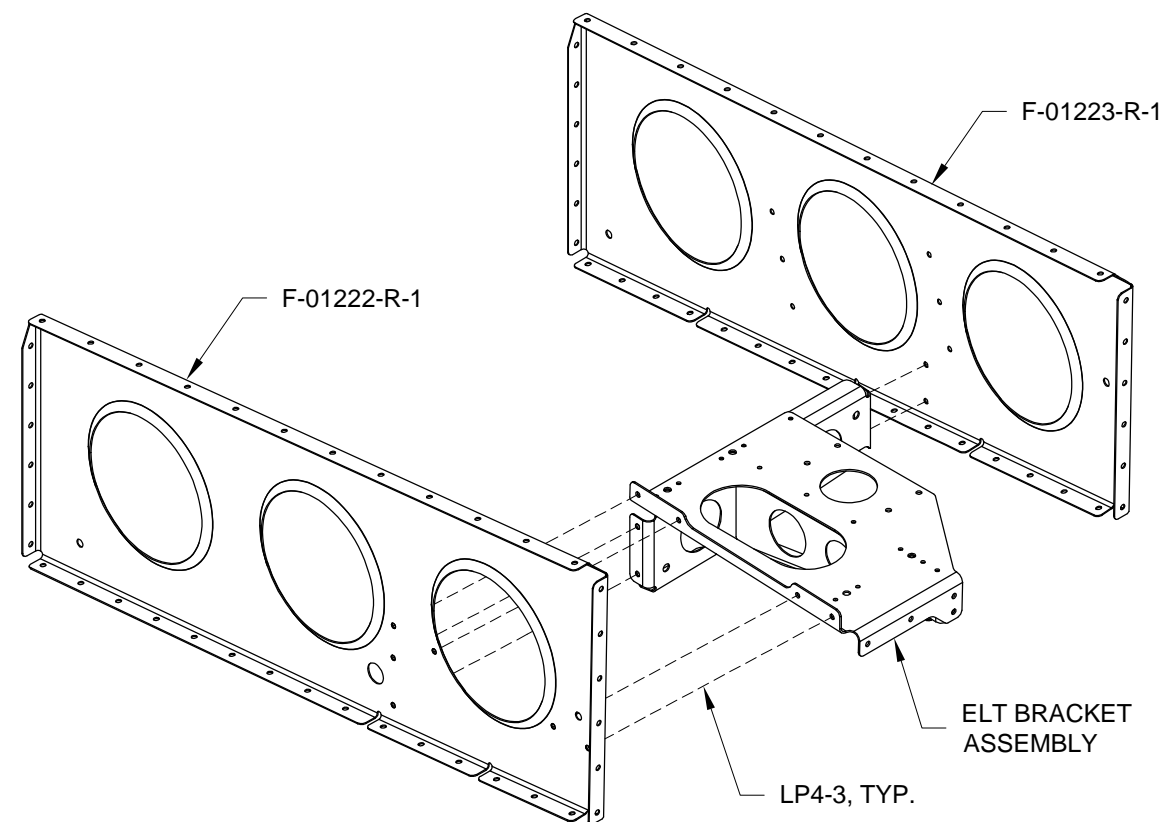
**Step 7:** Machine countersink #40 the holes in F-12107A. See Figure 3.

**Step 8:** Rivet together the three parts including nutplates as shown in Figure 3.



**FIGURE 3:** RIVETING ELT BRACKET ASSEMBLY

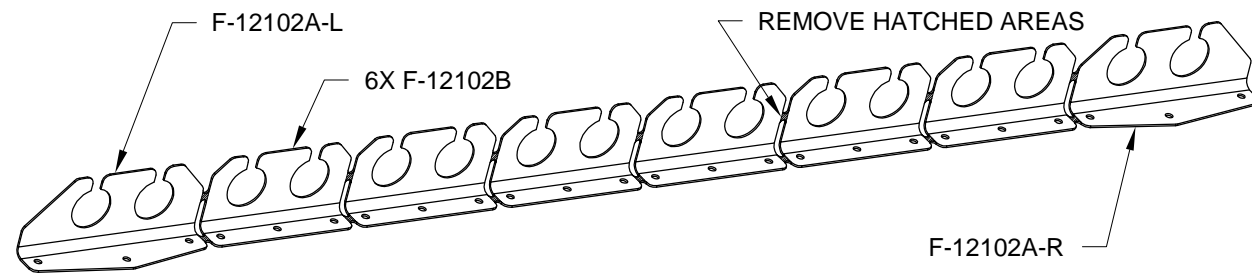
**Step 9:** Cleco together then rivet the ELT Bracket Assembly to F-01223-R-1 and F-01222-R-1 as shown in Figure 4.



**FIGURE 4:** RIVETING ELT BRACKET/ BAGGAGE RIBS



Step 1: Separate F-12102AB by removing the hatched areas shown in Figure 1.



**FIGURE 1: SEPARATING F-12102AB**

Step 2: Dimple the #30 and #40 holes in the F-01221-R-1 that correspond to the dimpled holes in F-01224-R-1. See Figure 2.

Tape over the holes attaching F-01241 to F-01224-R-1 and to the baggage ribs. See Page 21iS/U-02, Figure 2.

Step 3: Rivet F-01221-R-1, F-01222-R-1, and F-01223-R-1 to F-01204D-1 and F-01224-R-1 using the rivets called out in Figure 2. Install the rivets so the manufactured heads are on F-01204D-1. Note the flush rivet location in F-01223-R-1, (also applies to F-01223-L-1, though not shown in Figure 2).

**NOTE: Installation of the four F-01241 may be delayed until after painting.**

Step 4: Rivet F-01241 to F-01224-R-1 and F-01221-R-1 and F-01222-R-1 as shown on Page 21iS/U-02, Figure 2.

Step 5: Rivet the nutplates to F-01221-R-1 and F-01224-R-1.

Step 6: Rivet two F-12102B to F-01223-R-1.

Repeat Steps 2-6 for the left side.

FOR RIVETS SEE PAGE 21iS/U-02, FIGURE 2

K1000-08D  
2X AN426AD3-3.5 | 4X/ FLOOR

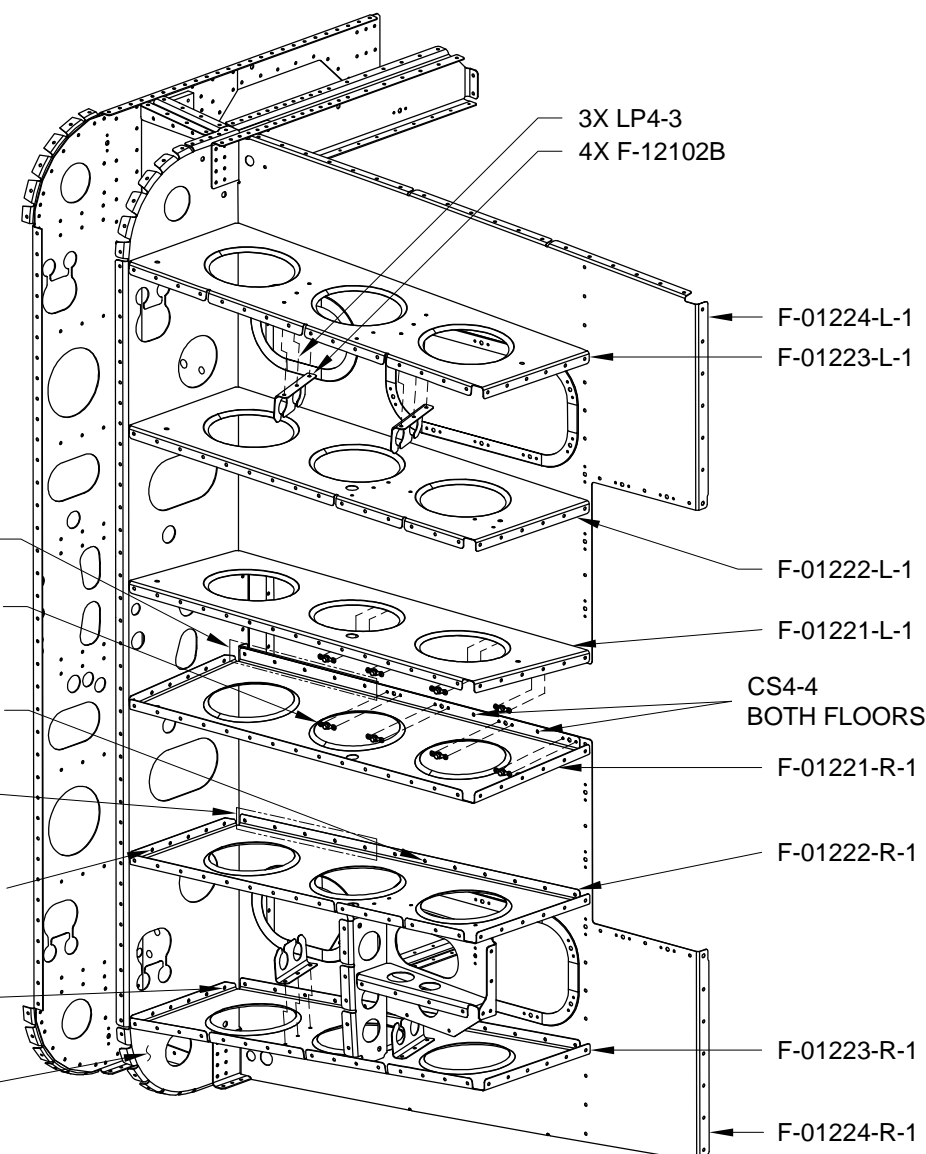
LP4-3 TYP.  
ALL F-01222-R-1 AND F-01223-R-1  
TO F-01224-R-1 RIVETS

FOR RIVETS SEE PAGE 21iS/U-02, FIGURE 2

LP4-3 TYP.  
ALL F-01221-R-1, F-01222-R-1,  
AND F-01223-R-1 TO F-01204D-1 RIVETS

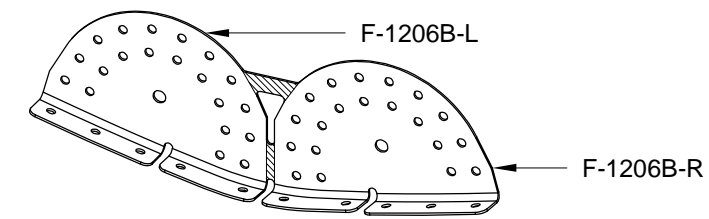
CS4-4, BOTH ENDS  
FLUSH FWD SIDE

F-01204D-1



**FIGURE 2: RIVETING BAGGAGE RIBS**

Step 7: Separate F-1206B by removing the hatched areas shown in Figure 3.



**FIGURE 3: SEPARATING F-1206B**

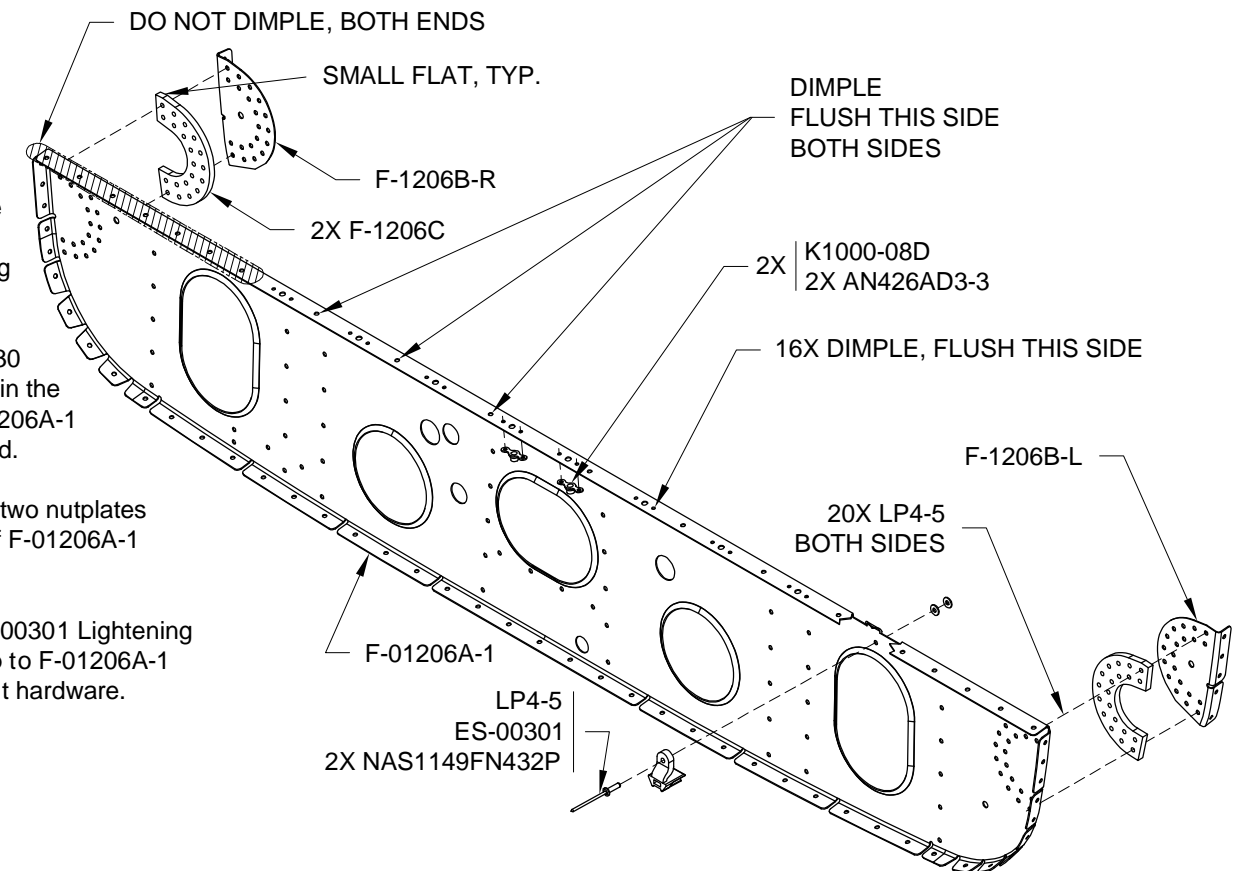
Step 8: File the rear stub spar rounded ends of both wings to closely fit the recessed machined curve of the F-1206C. See Figure 4. The small flat on F-1206C locates the top of the part.

Step 9: Rivet F-1206B-L & -R and F-1206C to F-01206A-1 using the rivets called out in Figure 4. Insert the rivets in all the holes before setting any of them.

Step 10: Dimple #30 and #40 the holes in the top flange of F-01206A-1 except where noted.

Step 11: Rivet the two nutplates to the top flange of F-01206A-1 as shown.

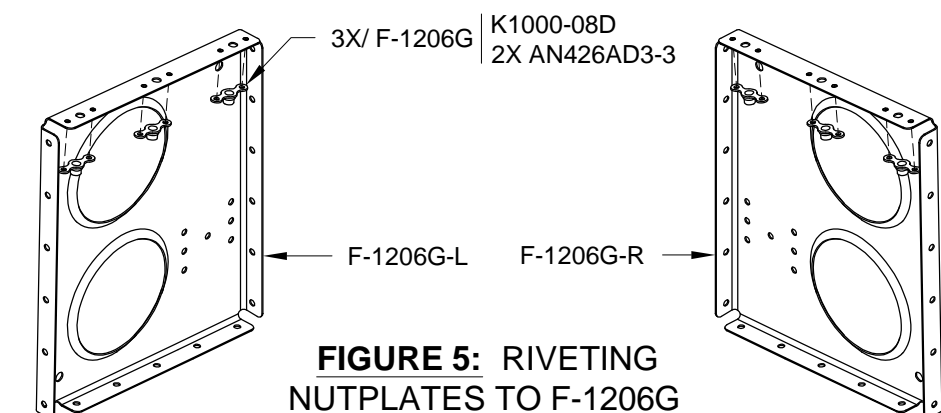
Step 12: Rivet ES-00301 Lightening Hole Tie Wrap Clip to F-01206A-1 using the called out hardware.



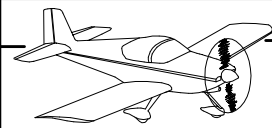
**FIGURE 4: F-01206A-1 BULKHEAD ASSEMBLY**

Step 13: Dimple #40 the nutplate attach holes in the top flange of F-1206G-L & -R. See Figure 5.

Step 14: Rivet the called out nutplates to F-1206G-L & -R.

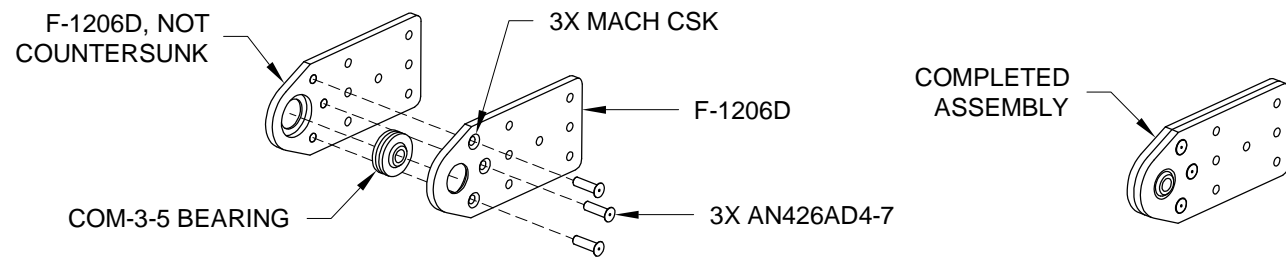


**FIGURE 5: RIVETING NUTPLATES TO F-1206G**



Step 1: Machine countersink #30 two F-1206D for the flush rivets called out in Figure 1.

Rivet together two Bearing Bracket Assemblies per the Figure 1 call-outs.



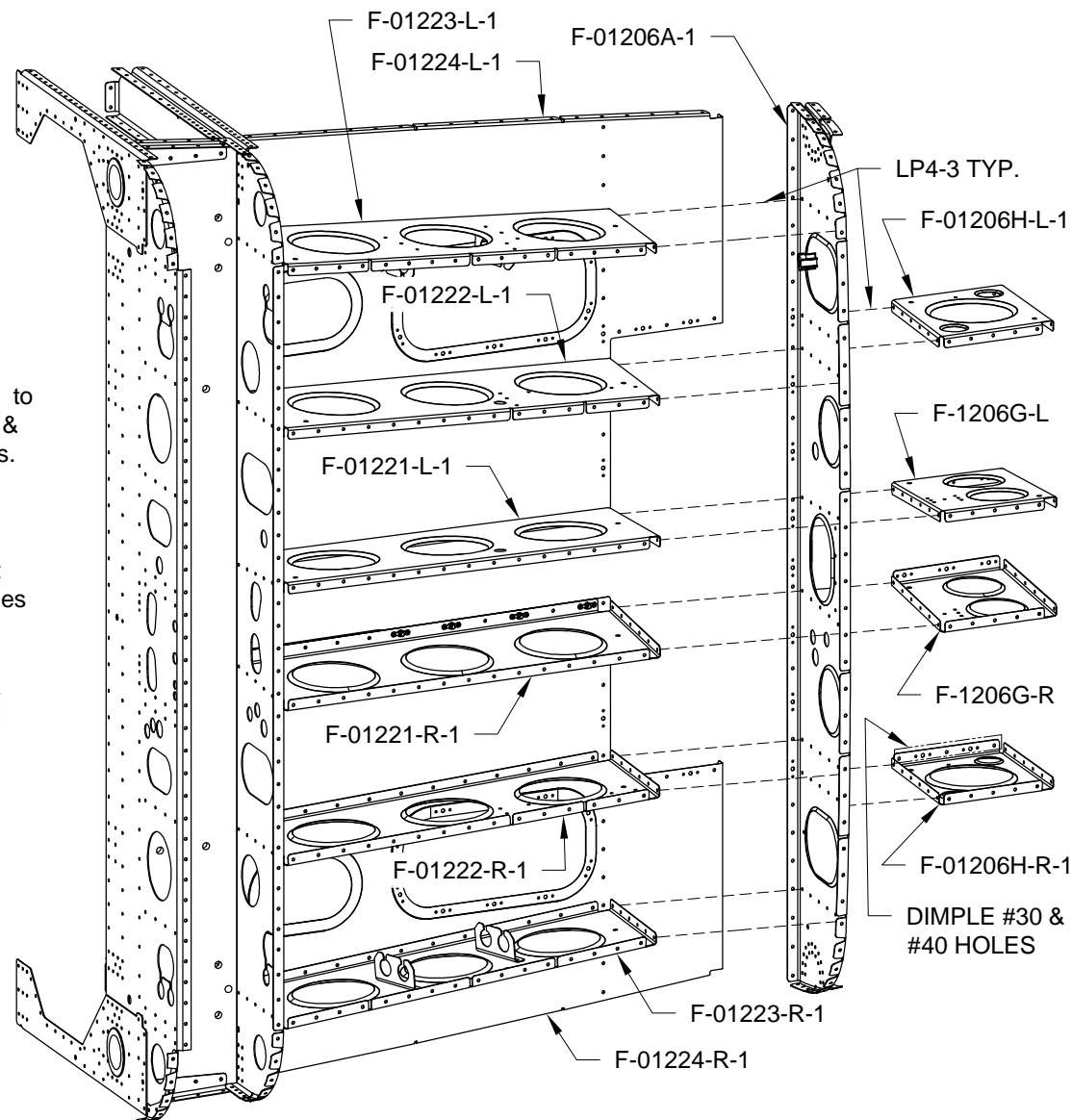
**FIGURE 1: RIVETING BEARING BRACKET ASSEMBLIES**

Step 2: Rivet F-01206A-1 to F-01222-L-1 & -R-1 and F-01223-L-1 & -R-1 using the rivets called out in Figure 2.

Step 3: Rivet F-1206G-L & -R to F-01206A-1 and F-01221-L-1 & -R-1 using the called out rivets.

Step 4: Dimple #30 and #40 the holes in the top flange of F-01206H-L-1 & -R-1 ribs that correspond to the dimpled holes in F-01224-L-1 & -R-1 floors.

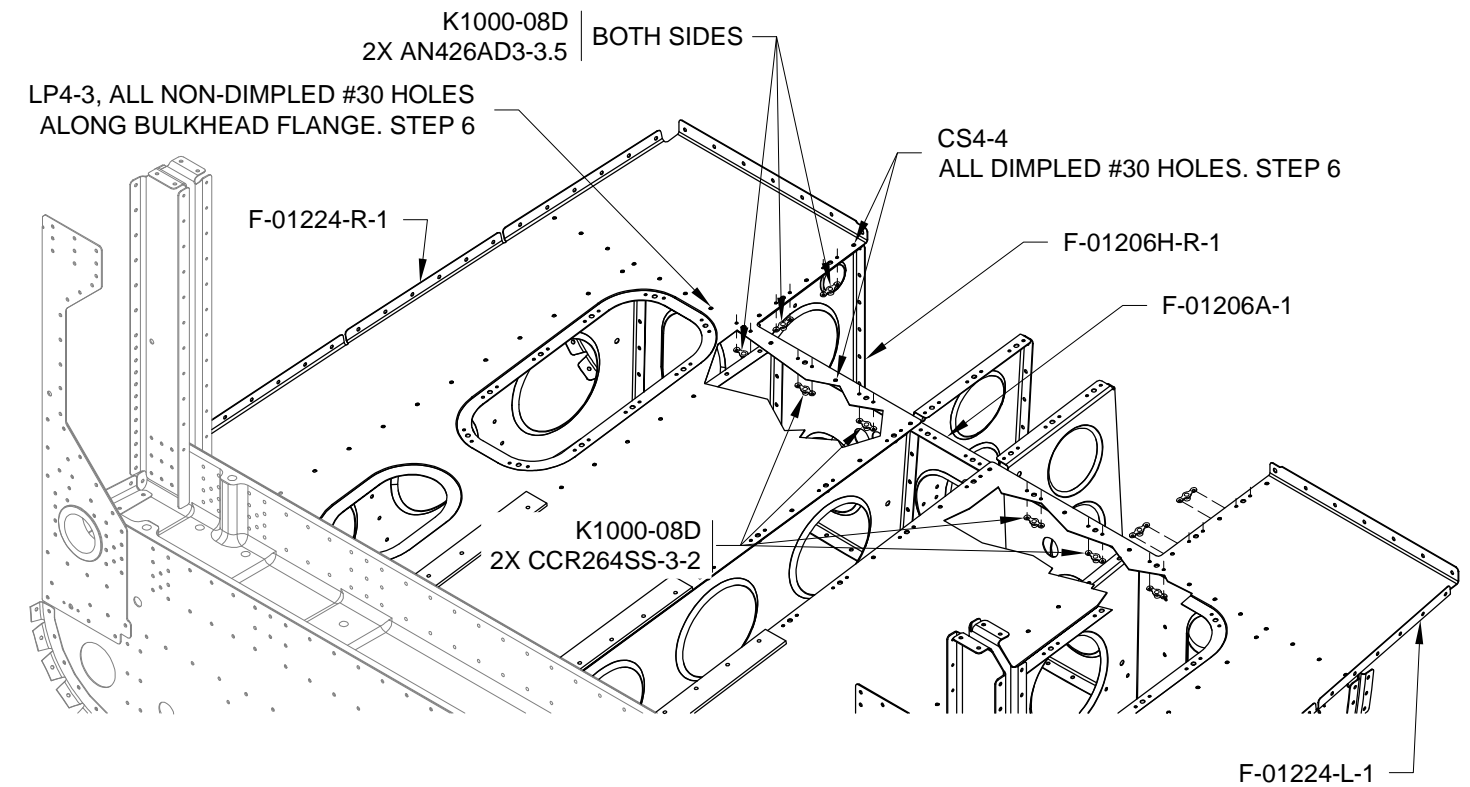
Step 5: Rivet F-01206H-L-1 & -R-1 ribs to F-01206A-1 using the called out rivets.



**FIGURE 2:  
RIVETING F-01206A-1, F-1206G-L & -R, &  
F-01206H-L-1 & -R-1**

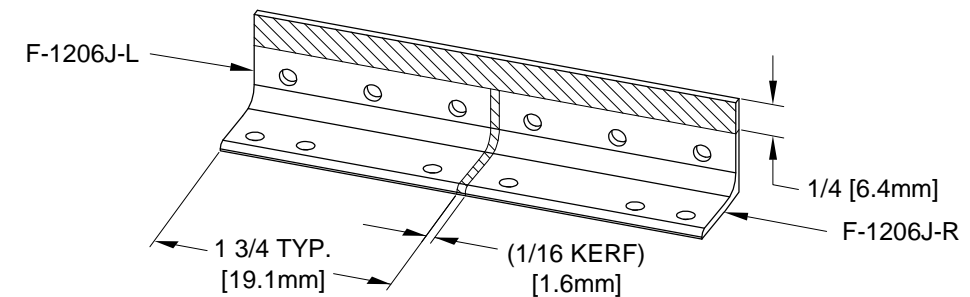
Step 6: Rivet F-01224-L-1 & -R-1 to F-01206A-1 and F-01206H-L-1 & -R-1 using the rivets called out in Figure 3.

Step 7: Rivet the called out nutplates to F-01206A-1, F-01206H-L-1 & -R-1, and F-01224-L-1 & -R-1.

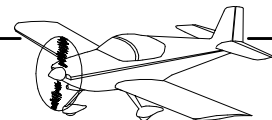


**FIGURE 3: RIVETING NUTPLATES TO F-01224-L-1 & F-01224-R-1**

Step 8: Trim off the top shaded portion of F-1206J angle, then cut the part in half. See Figure 4.



**FIGURE 4: SEPARATING AND TRIMMING F-1206J**



Step 1: Dimple #40 one set of nutplate attach holes in F-01206F-2 and in the nutplate itself.

**DO NOT** install the nutplate now. See Figure 1.

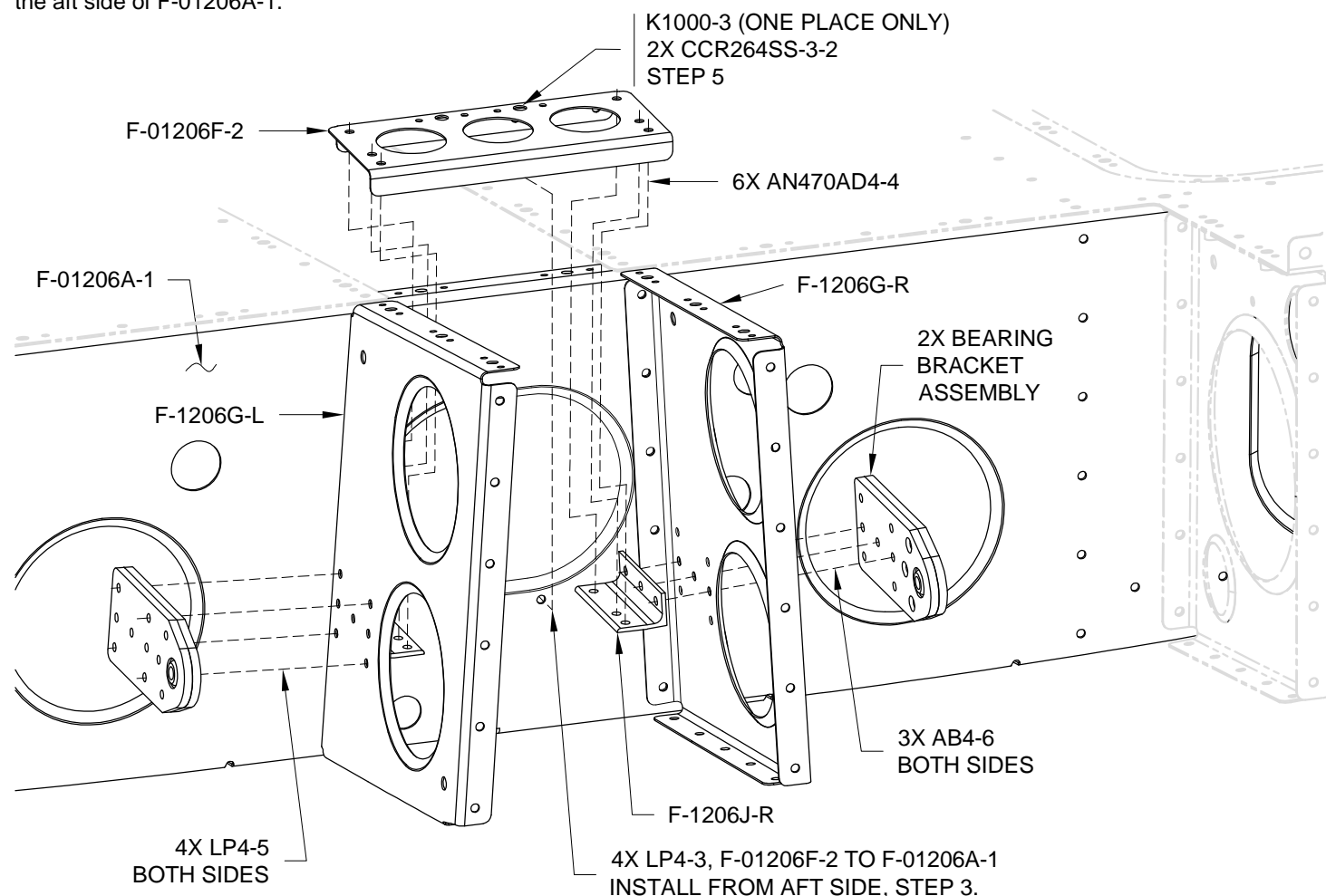
Step 2: Rivet F-01206F-2 to F-1206J-L & -R.

Step 3: Rivet F-01206F-2 to F-01206A-1. Install the rivets from the aft side of F-01206A-1.

Step 4: Rivet the Bearing Bracket Assemblies to F-1206G-L & -R and to F-1206J-L & -R using the rivets called out in Figure 1.

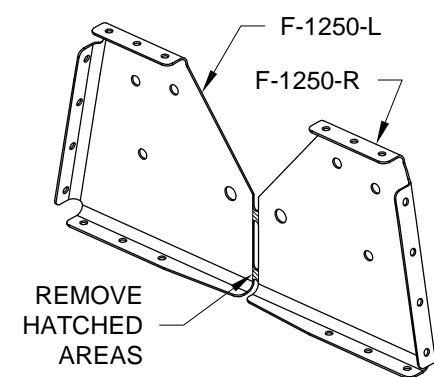
Place the flush, manufactured heads of the rivets in the Bearing Bracket Assemblies against the web of F-1206G-L & -R.

Step 5: Rivet the nutplate from Step 1 to F-01206A-1 at this time.



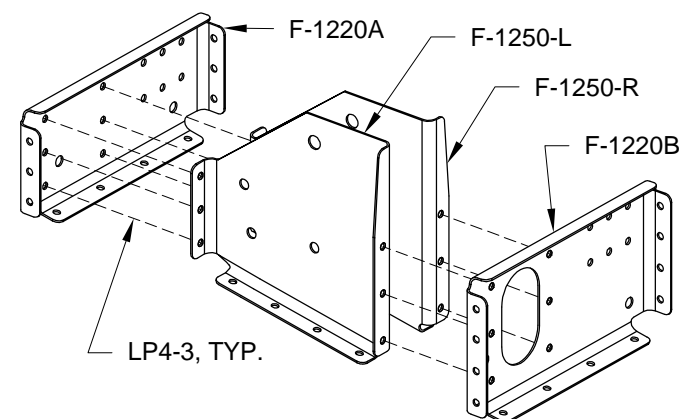
**FIGURE 1: RIVETING F-01206F-2**

Step 6: Separate F-1250 by removing the hatched areas shown in Figure 2.



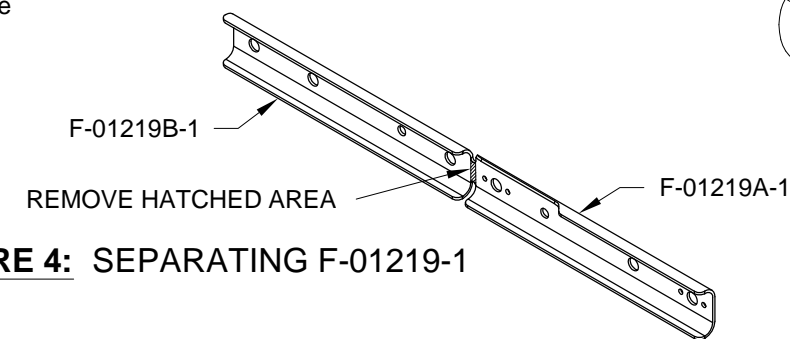
**FIGURE 2: SEPARATING F-1250**

Step 7: Rivet F-1250-L & -R to F-1220A and F-1220B using the rivets called out in Figure 3. Set aside for now.



**FIGURE 3: RIVETING PULLEY BRACKET ASSY**

Step 8: Separate F-01219-1 by removing the hatched area shown in Figure 4.



**FIGURE 4: SEPARATING F-01219-1**

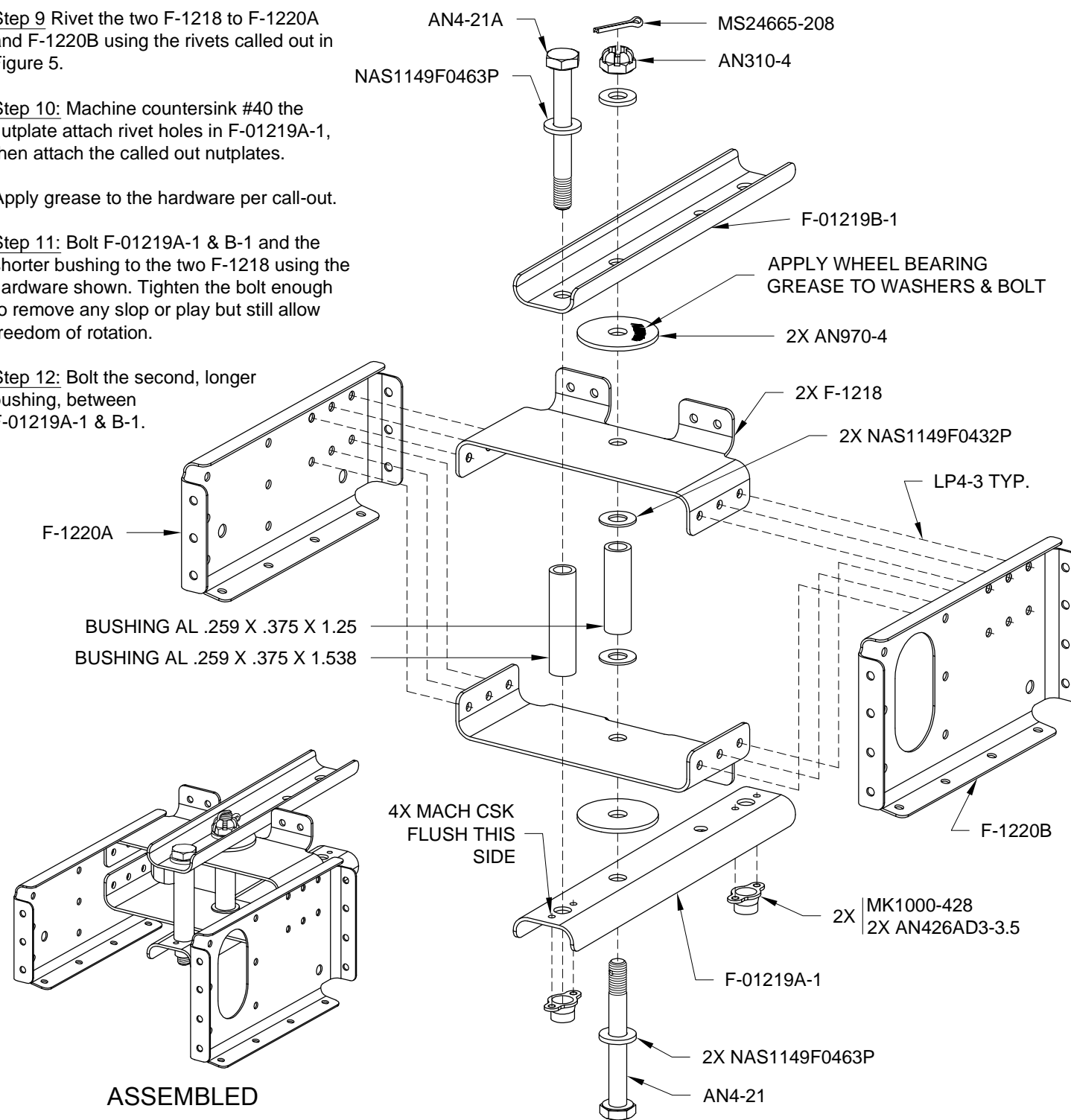
Step 9: Rivet the two F-1218 to F-1220A and F-1220B using the rivets called out in Figure 5.

Step 10: Machine countersink #40 the nutplate attach rivet holes in F-01219A-1, then attach the called out nutplates.

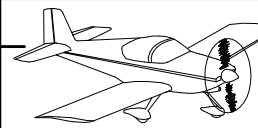
Apply grease to the hardware per call-out.

Step 11: Bolt F-01219A-1 & B-1 and the shorter bushing to the two F-1218 using the hardware shown. Tighten the bolt enough to remove any slop or play but still allow freedom of rotation.

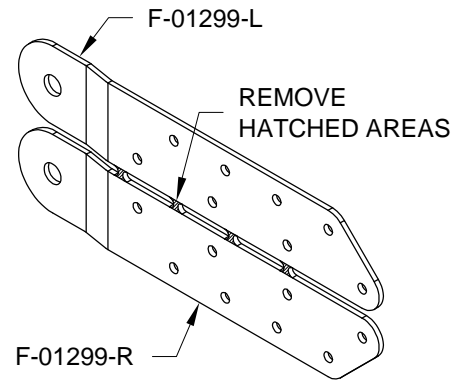
Step 12: Bolt the second, longer bushing, between F-01219A-1 & B-1.



**FIGURE 5: ASSEMBLING FLAPERON MIXER ARM**

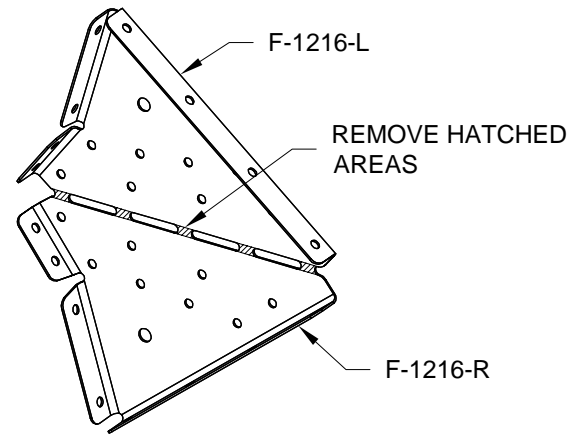


**Step 1:** Separate the four F-01299 per Figure 1 by removing the hatched areas.



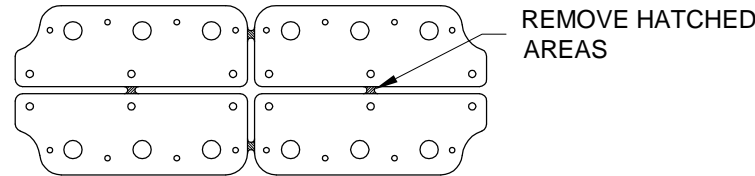
**FIGURE 1: SEPARATING THE F-01299**

**Step 2:** Separate the two F-1216 per Figure 2 by removing the hatched areas.



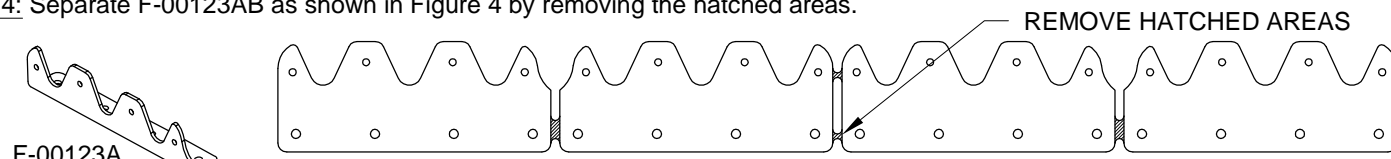
**FIGURE 2: SEPARATING THE F-1216**

**Step 3:** Separate F-00122 as shown in Figure 3 by removing the hatched areas.



**FIGURE 3: SEPARATING F-00122**

**Step 4:** Separate F-00123AB as shown in Figure 4 by removing the hatched areas.

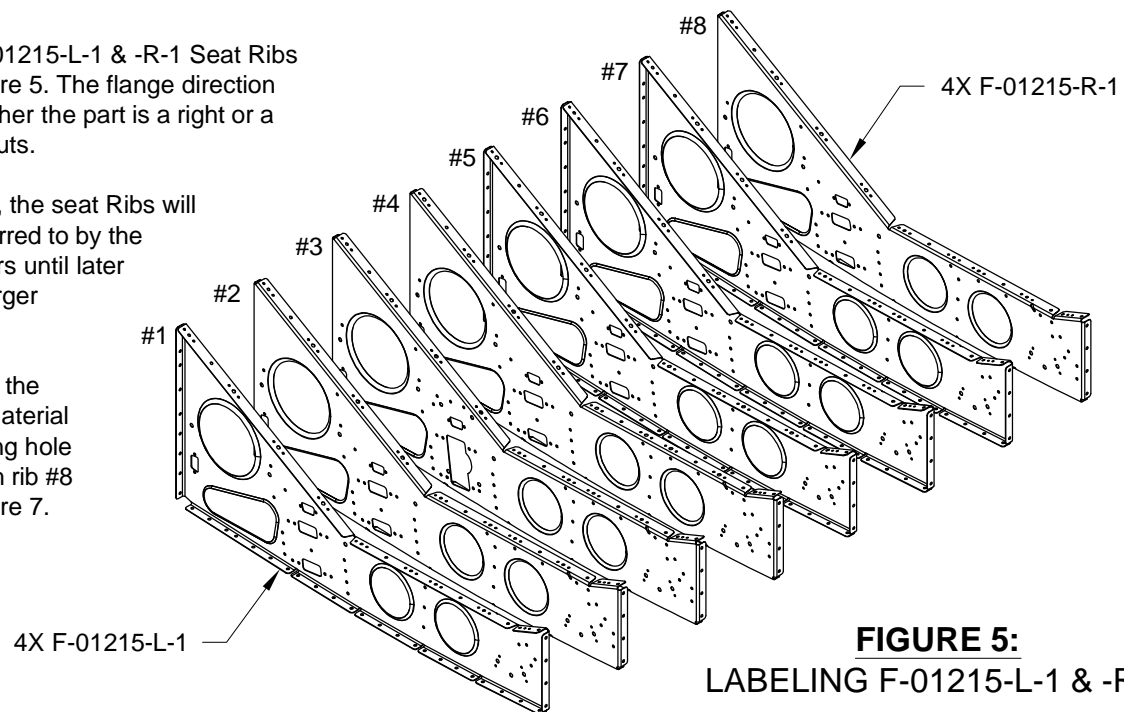


**FIGURE 4: SEPARATING F-00123AB (FLAT PATTERN SHOWN)**

**Step 5:** Label F-01215-L-1 & -R-1 Seat Ribs as shown in Figure 5. The flange direction determines whether the part is a right or a left per the call-outs.

For convenience, the seat Ribs will hereafter be referred to by the assigned numbers until later combined into larger assemblies.

**Step 6:** Remove the vertical strip of material from the lightening hole of Rib #1 through rib #8 as shown in Figure 7.



**FIGURE 5: LABELING F-01215-L-1 & -R-1**

**Step 7:** Cleco F-01299-L to #4. See Figure 6. Inspect for interference at oblong hole in rib #4 per the call-out. File #4 if/as req'd to remove interference. Repeat for #8. Repeat this Step for #1 and #5 using F-01299-R instead.

**Step 8:** Cleco together F-00123A and F-00122 then machine countersink #40 F-00123A per the call-out. See Figure 7.

Rivet together F-00123A and F-00122 per the call-out, then rivet this assembly to Rib #1. Repeat Step 8 for #5.

**Step 9:** Machine countersink #40 then rivet together F-00123B and F-00122 per the call-out, then rivet to #4. See Figure 6. Repeat for #8.

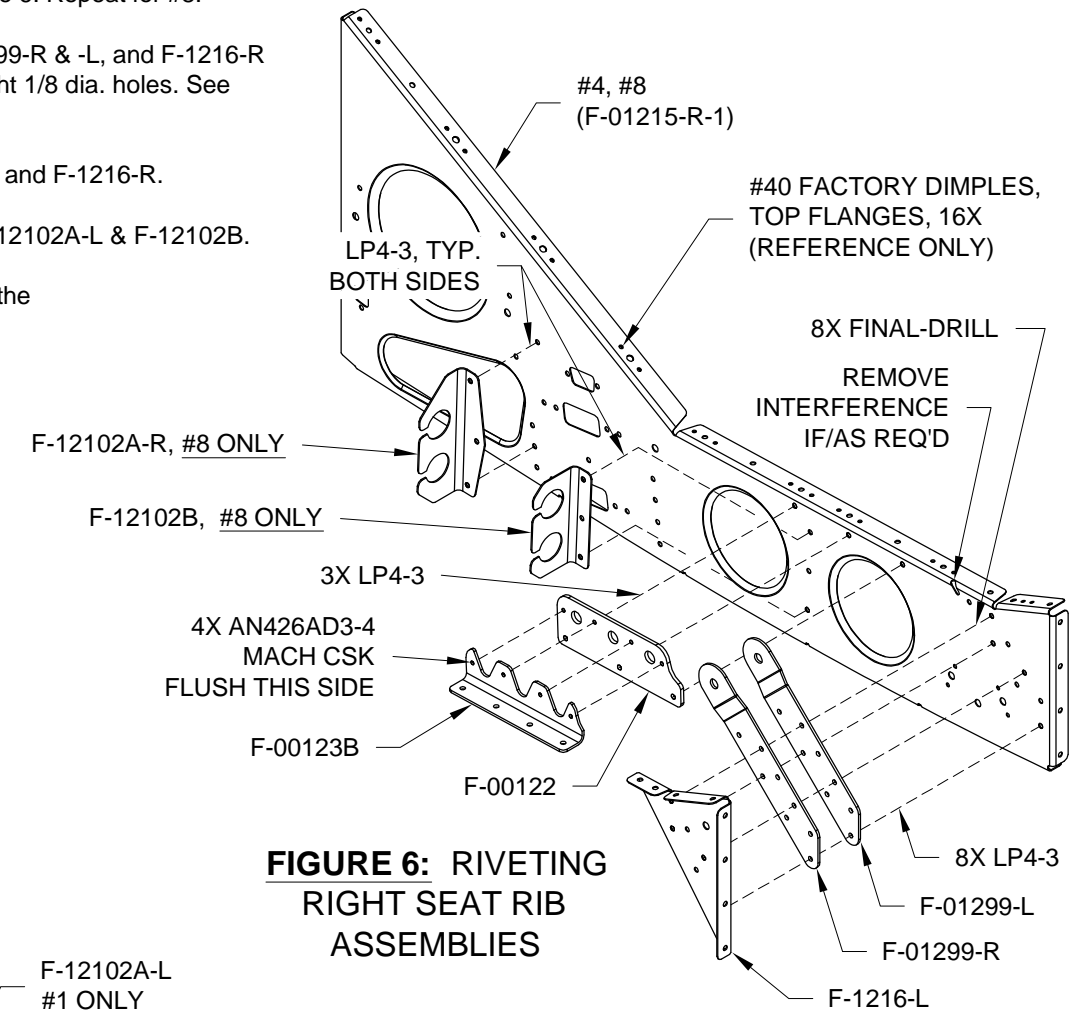
**Step 10:** Cleco together #5, F-01299-R & -L, and F-1216-R then final-drill #30 the common eight 1/8 dia. holes. See Figure 7.

Rivet together #5, F-01299-R & -L, and F-1216-R.

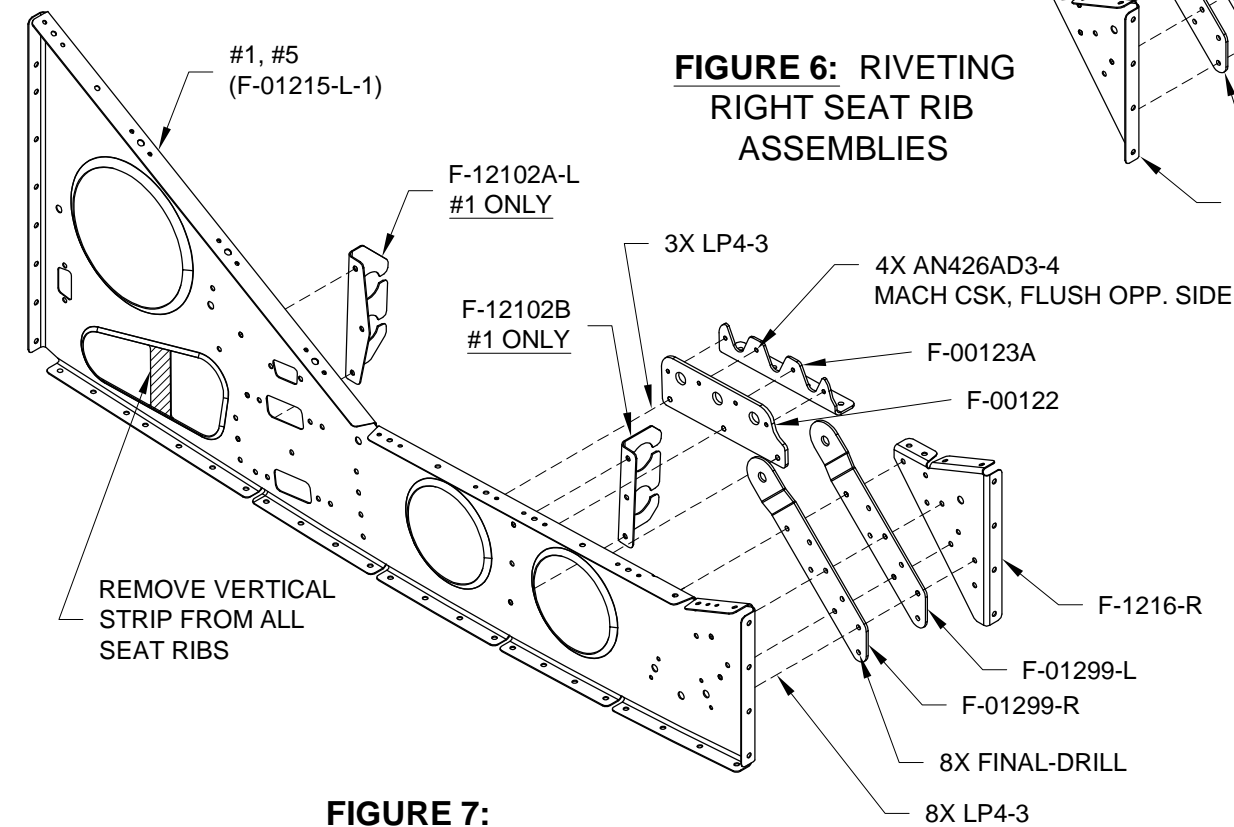
Repeat Step 10 for #1, and add F-12102A-L & F-12102B.

**Step 11:** Cleco then final-drill #30 the eight 1/8 dia. holes in F-1216-L, F-01299-R, F-01299-L and #4 as shown in Figure 6, then rivet them together.

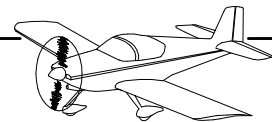
Repeat Step 11 for #8 and add F-12102A-R and F-12102B.



**FIGURE 6: RIVETING RIGHT SEAT RIB ASSEMBLIES**



**FIGURE 7: RIVETING LEFT SEAT RIB ASSEMBLIES**



**NOTE: Refer to Figure 3 for seat rib numbers and locations.**

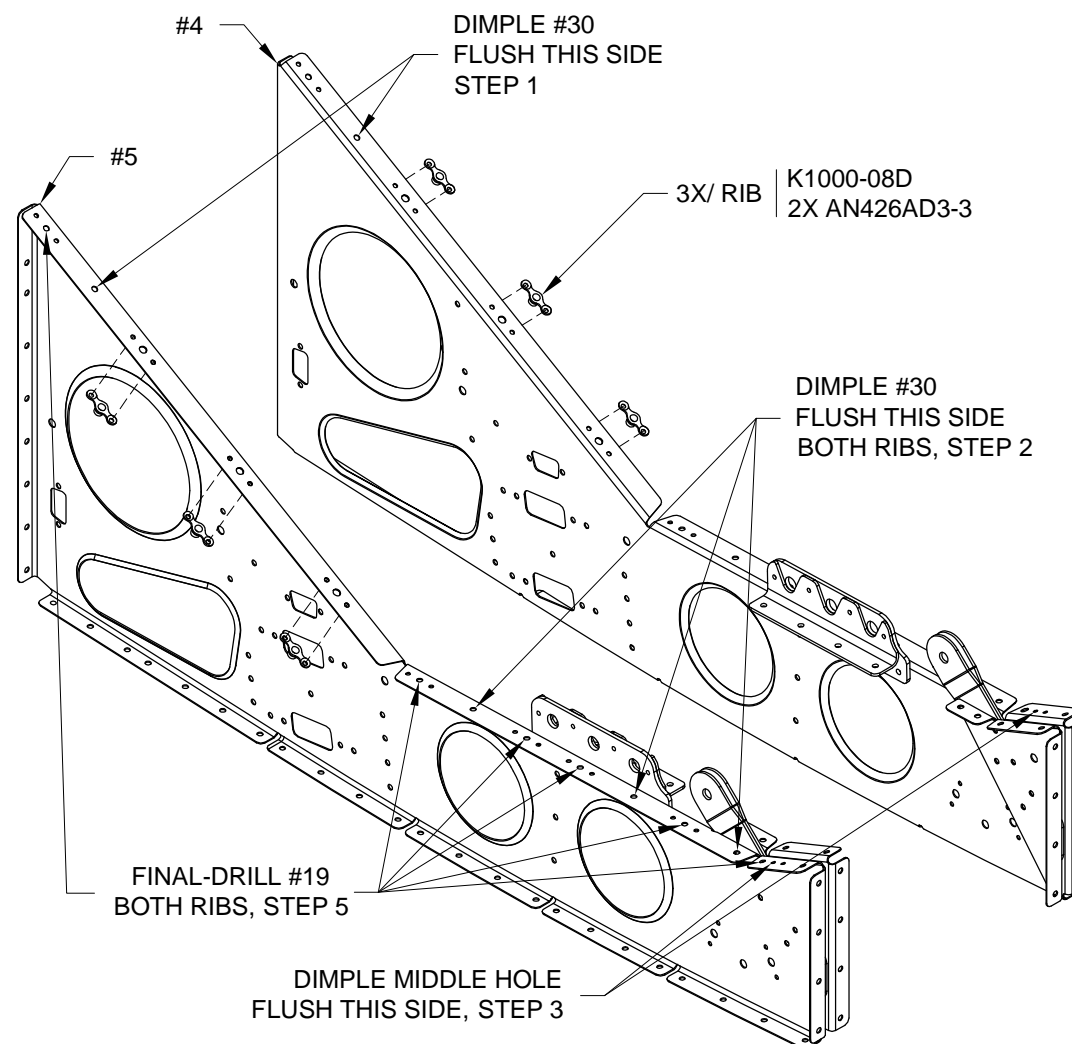
**Step 1:** Dimple #30 the hole in Ribs #4 and #5 fwd (sloped) flange per the call-out. See Figure 1.

**Step 2:** Dimple #30 the aft three holes in the middle flange of #4 and #5 per the call-outs.

**Step 3:** Dimple #40 the middle rivet hole for a one-lug nutplate in the aft (sloped) flange of #4 and #5.

**Step 4:** Rivet three nutplates to the fwd flange of #4 and #5 per the call-out.

**Step 5:** Final-Drill #19 the #30 nutplate screw holes in the fwd, middle and aft flanges of #4 and #5 per the call-out.



**FIGURE 1: PREPARING SEAT RIB ASSEMBLIES**

**Step 6:** Cleco F-1269 to Rib #3. See Figure 2.

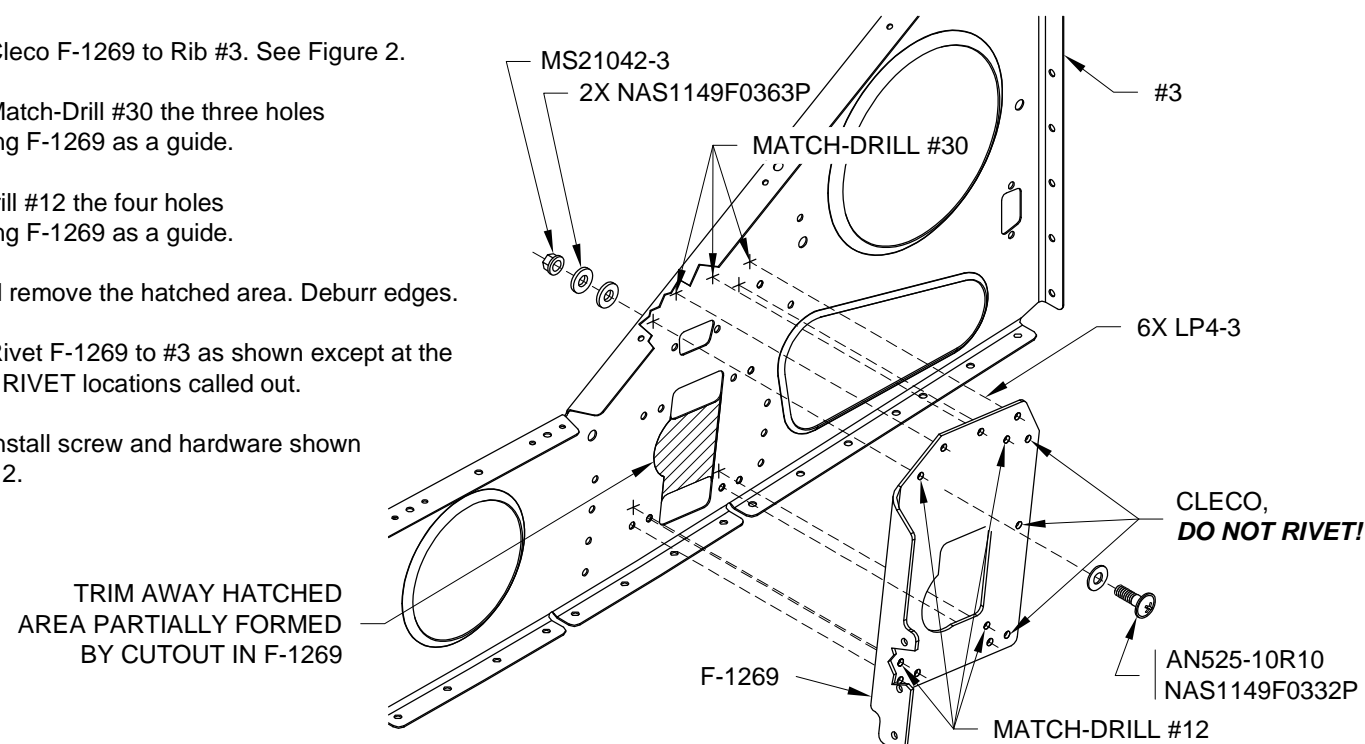
**Step 7:** Match-Drill #30 the three holes in #3 using F-1269 as a guide.

Match-Drill #12 the four holes in #3 using F-1269 as a guide.

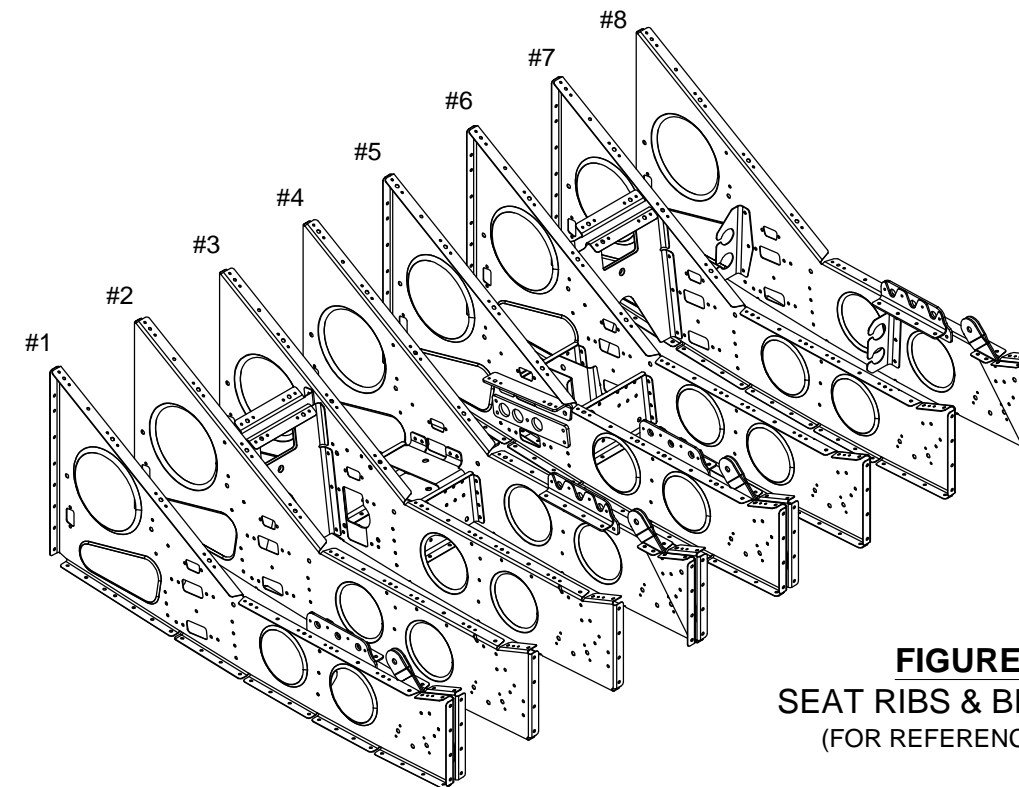
Mark and remove the hatched area. Deburr edges.

**Step 8:** Rivet F-1269 to #3 as shown except at the DO NOT RIVET locations called out.

**Step 9:** Install screw and hardware shown in Figure 2.

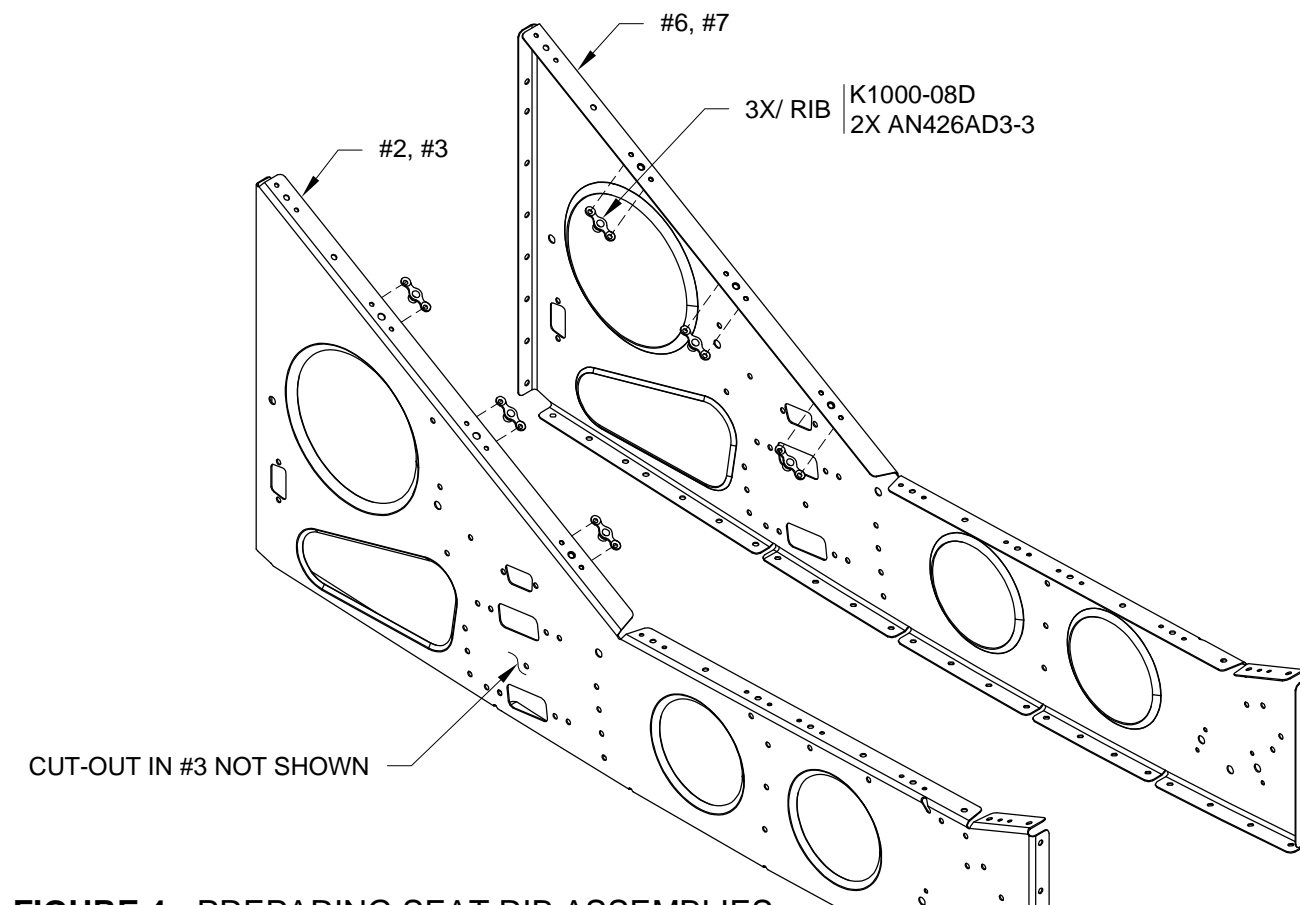


**FIGURE 2: ATTACHING F-1269**



**FIGURE 3: SEAT RIBS & BRACKETS (FOR REFERENCE ONLY)**

**Step 10:** Rivet nutplates to ribs #2, #3, #6 and #7 ribs per the Figure 4 call-out.

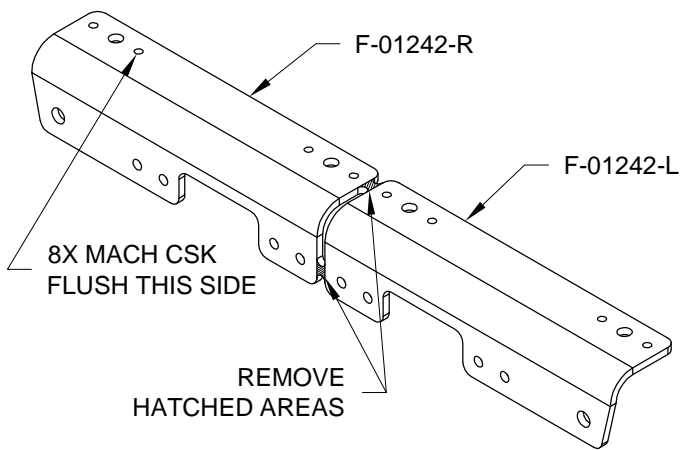


**FIGURE 4: PREPARING SEAT RIB ASSEMBLIES**

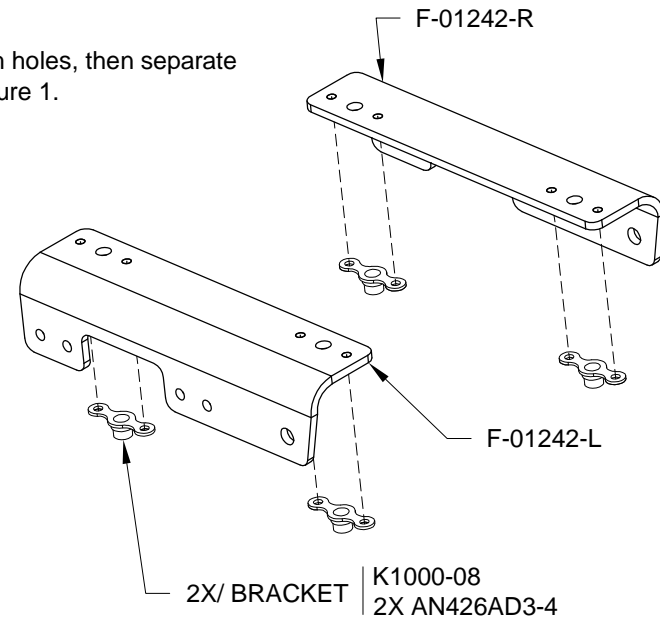


**Step 1:** Machine countersink #40 nutplate attach holes, then separate F-01242 into right and left parts as shown in Figure 1.

**Step 2:** Attach nutplates to F-01242-L & -R as shown in Figure 2.



**FIGURE 1: COUNTERSINKING & SEPARATING F-01242**



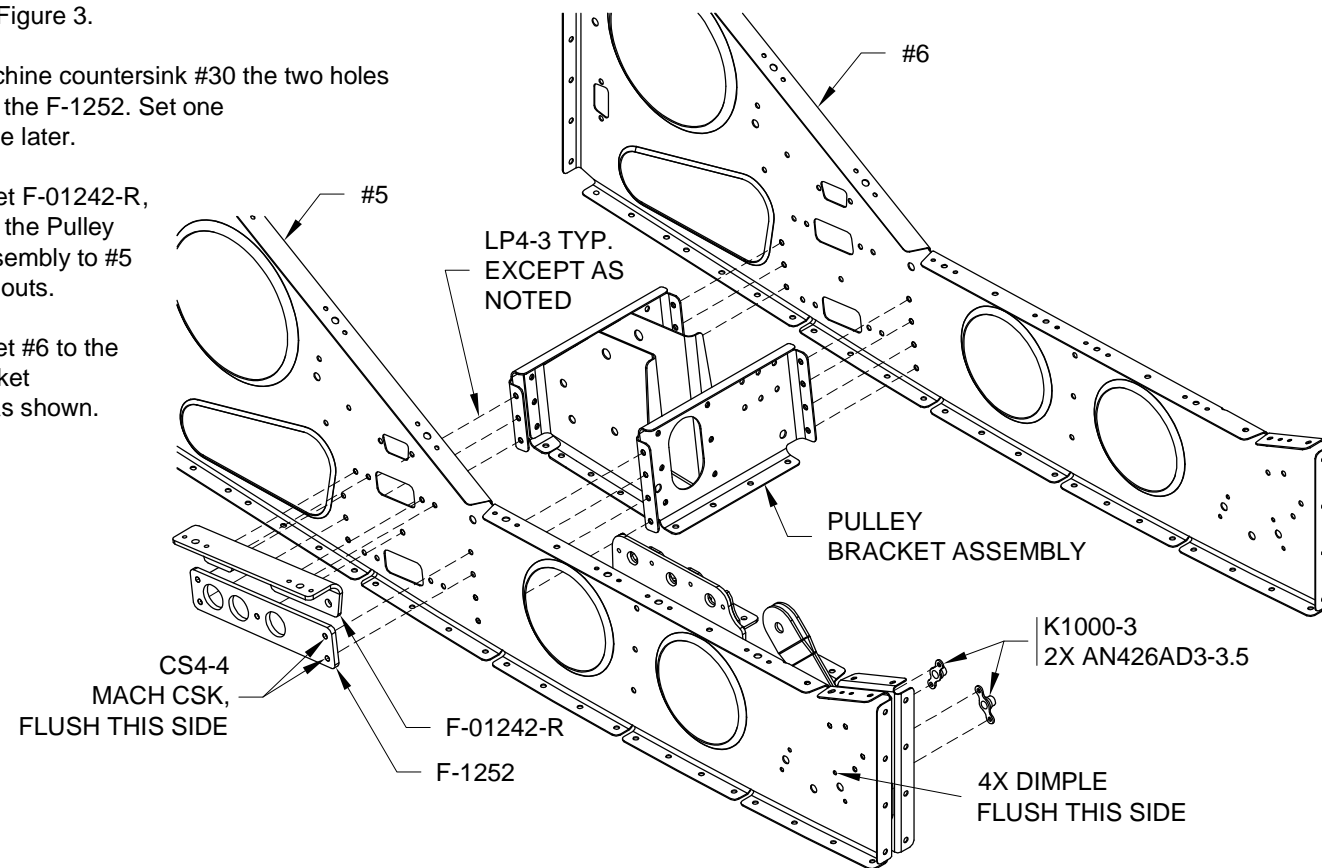
**FIGURE 2: RIVETING NUTPLATES TO F-01242-L & -R**

**Step 3:** Dimple #40 the nutplates and attach holes in Rib #5, then rivet the nutplates in place using the called out rivets. See Figure 3.

**Step 4:** Machine countersink #30 the two holes indicated in the F-1252. Set one aside for use later.

**Step 5:** Rivet F-01242-R, F-1252 and the Pulley Bracket Assembly to #5 per the call-outs.

**Step 6:** Rivet #6 to the Pulley Bracket Assembly as shown.

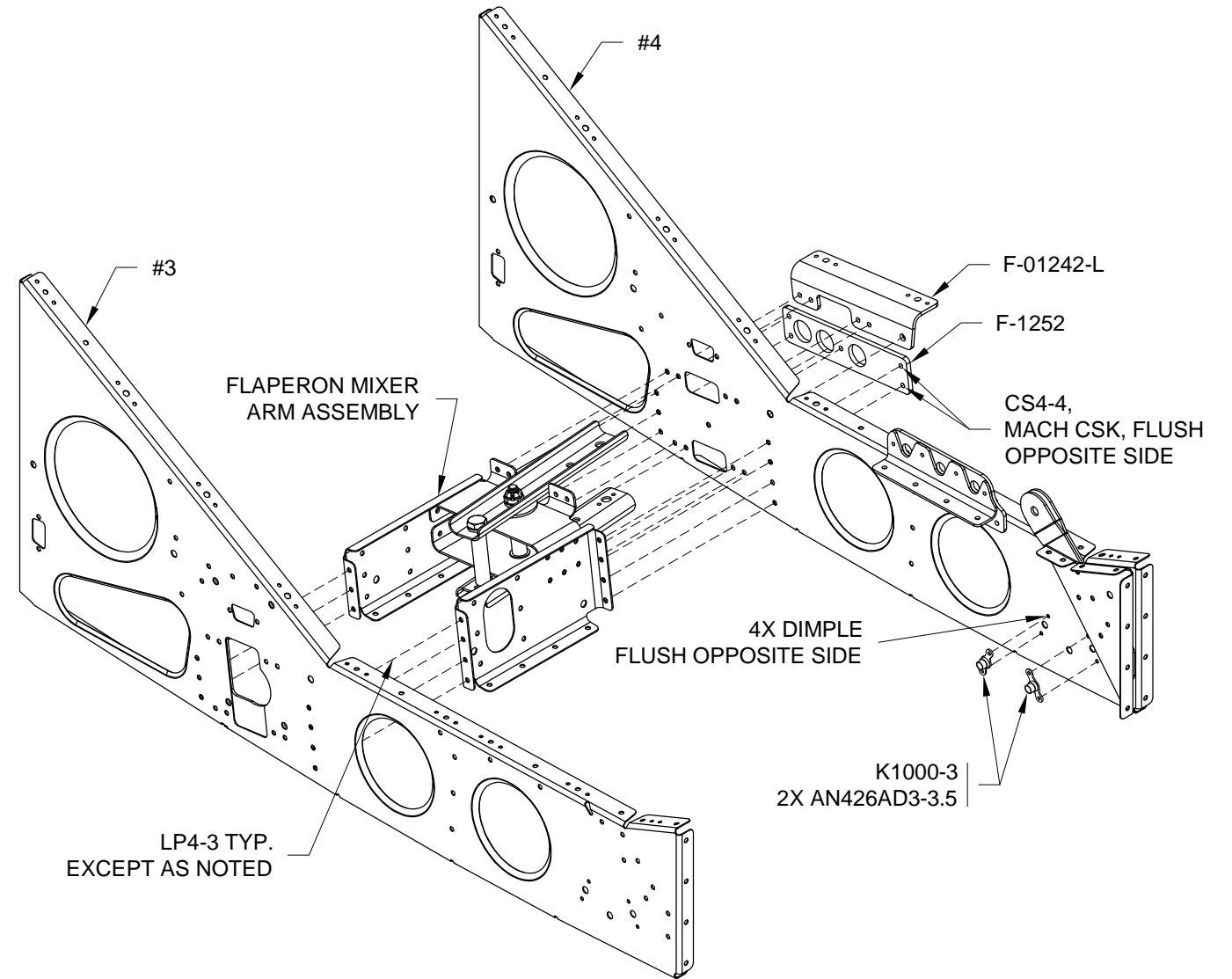


**FIGURE 3: RIVETING PULLEY BRACKET ASSEMBLY TO RIBS #5 & #6**

**Step 7:** Dimple #40 the nutplates and attach holes in Rib #4, then rivet the nutplates in place using the called out rivets. See Figure 4.

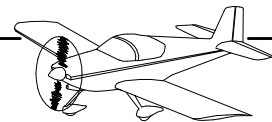
**Step 8:** Rivet F-01242-L, F-1252, and the Flaperon Mixer Arm Assembly to #4 using the called out rivets.

**Step 9:** Rivet #3 to the Flaperon Mixer Arm Assembly as shown.



**FIGURE 4: RIVETING FLAPERON MIXER ARM ASSEMBLY TO RIBS #3 & #4**

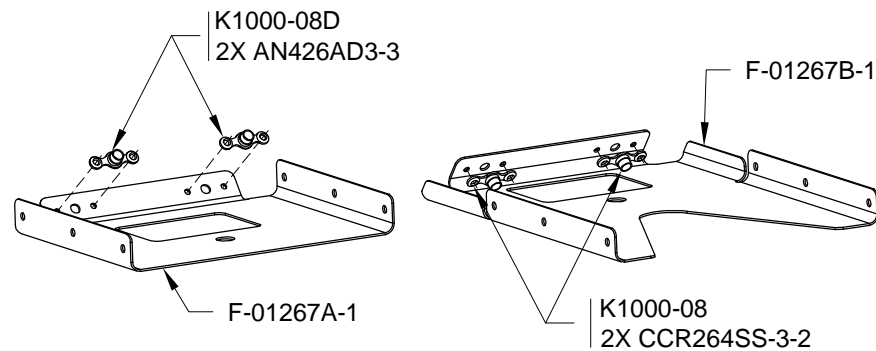




Step 1: Dimple #40 the nutplate attach holes in two F-01267A-1. See Figure 1.

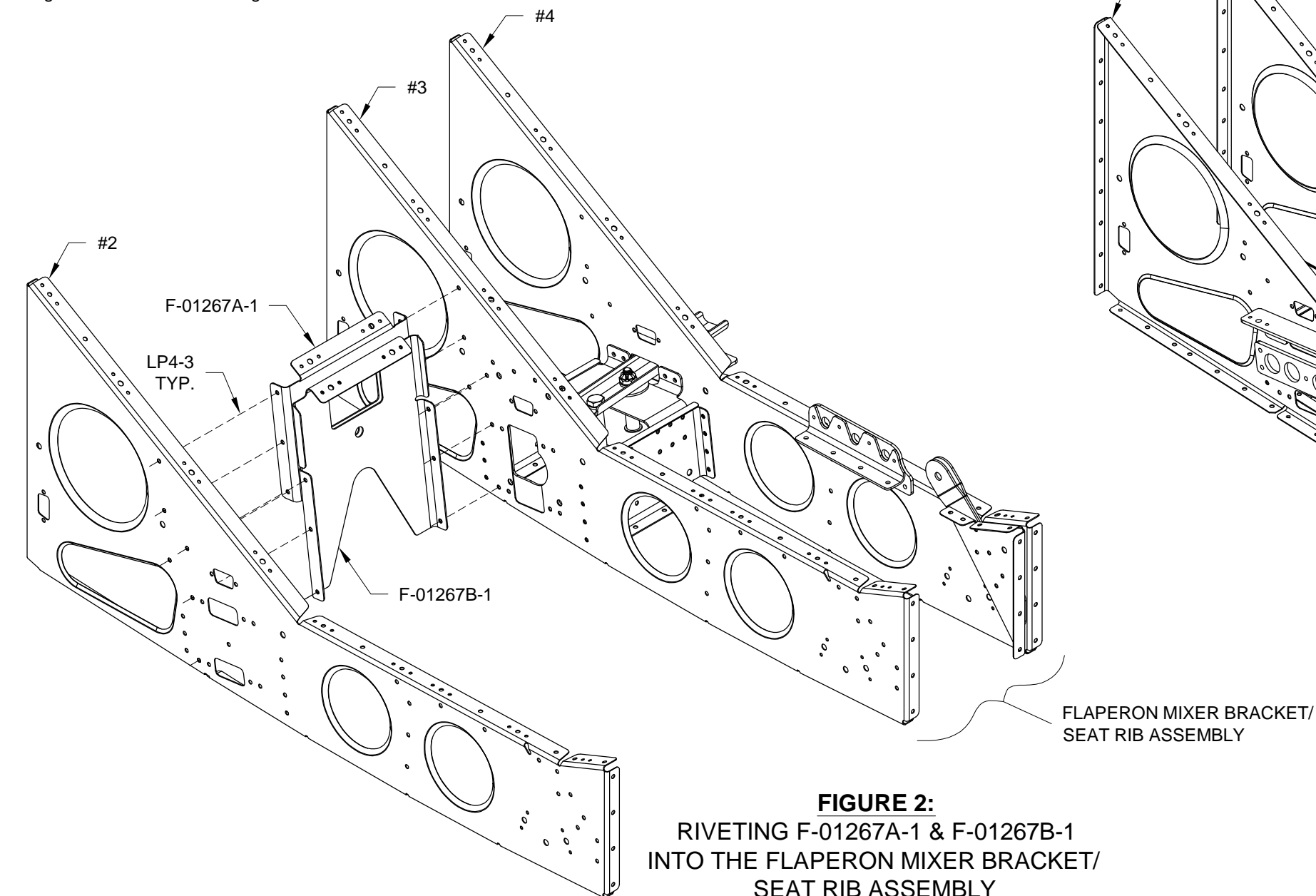
Step 2: Machine countersink #40 the nutplate attach holes in two F-01267B-1.

Step 3: Using the rivets called out in Figure 1, rivet the nutplates to two F-01267A-1 and to two F-01267B-1.



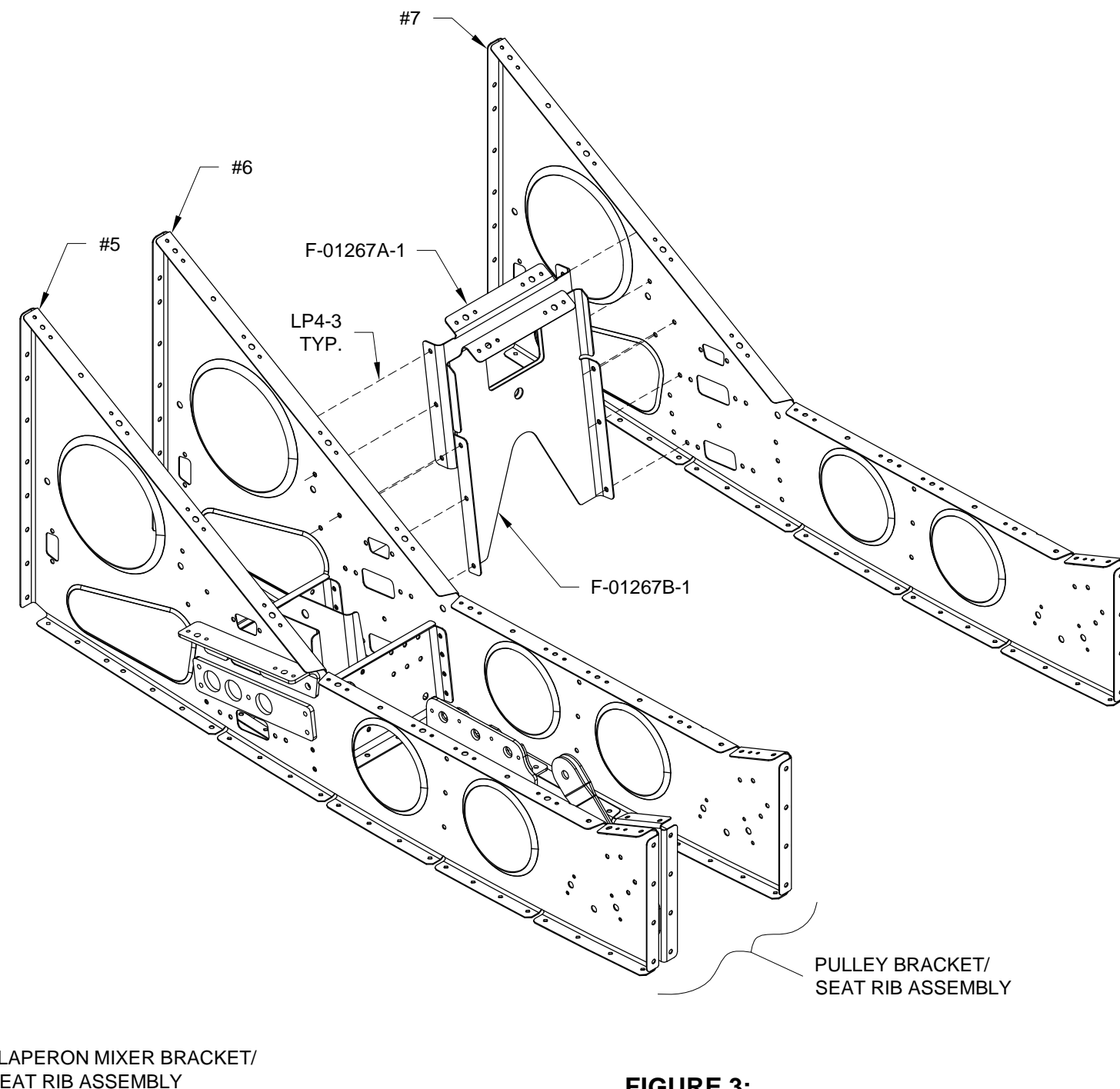
**FIGURE 1:** ATTACHING NUTPLATES TO F-01267A-1 & F-01267B-1

Step 4: Rivet one each of F-01267A-1 & B-1 to the Flaperon Mixer Bracket/ Seat Rib Assembly and to Rib #2 using the rivets called out in Figure 2.



**FIGURE 2:**  
RIVETING F-01267A-1 & F-01267B-1  
INTO THE FLAPERON MIXER BRACKET/  
SEAT RIB ASSEMBLY

Step 5: Rivet the remaining F-01267A-1 & B-1 to the Pulley Bracket/ Seat Rib Assembly and to Rib #7 per the rivet call-out.



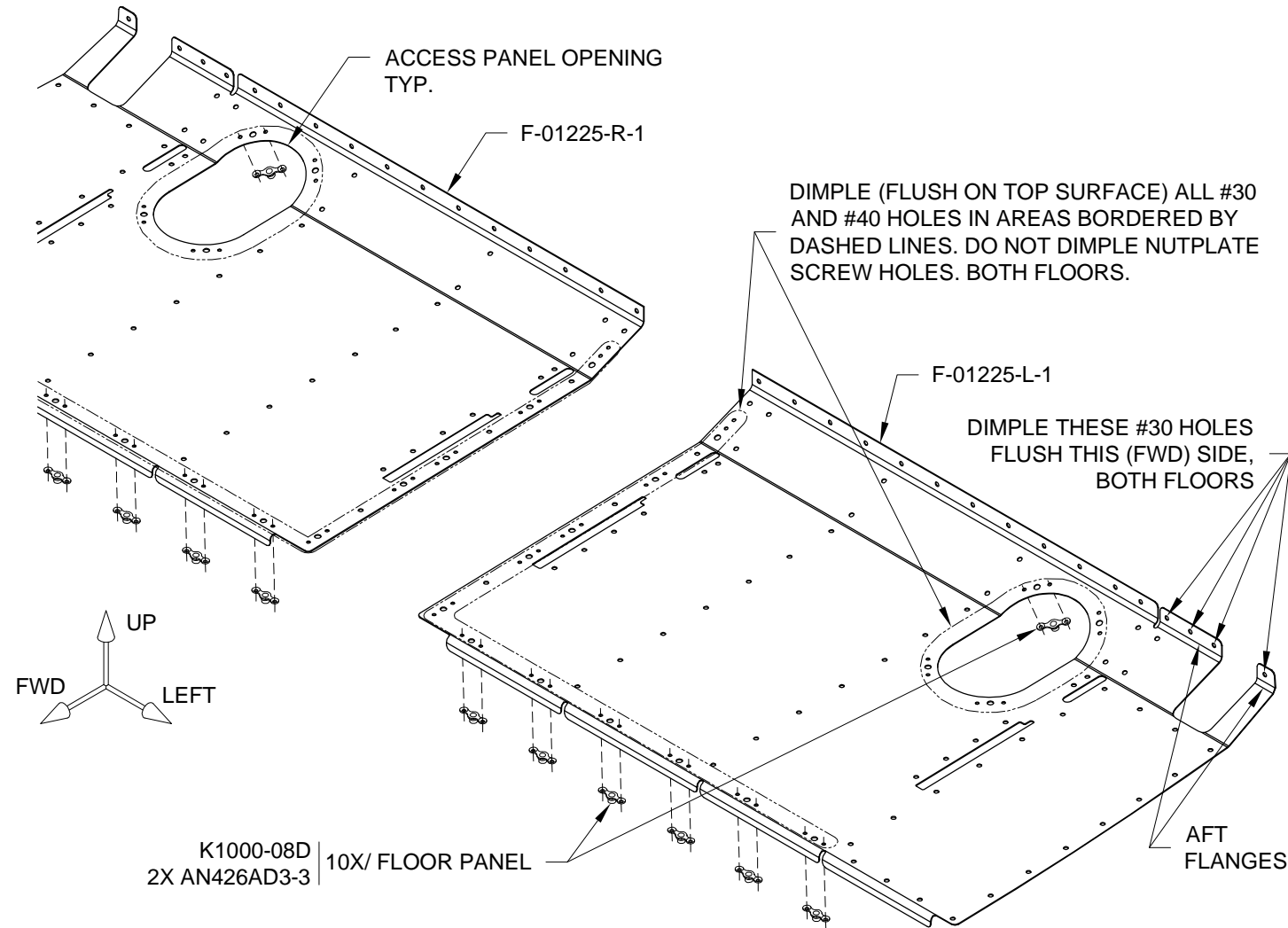
**FIGURE 3:**  
RIVETING F-01267A-1 & F-01267B-1 INTO  
THE PULLEY BRACKET/ SEAT RIB ASSEMBLY



**Step 1:** Dimple #30 the four holes in the aft flanges in both F-01225-L-1 & -R-1. See Figure 1 call-outs.

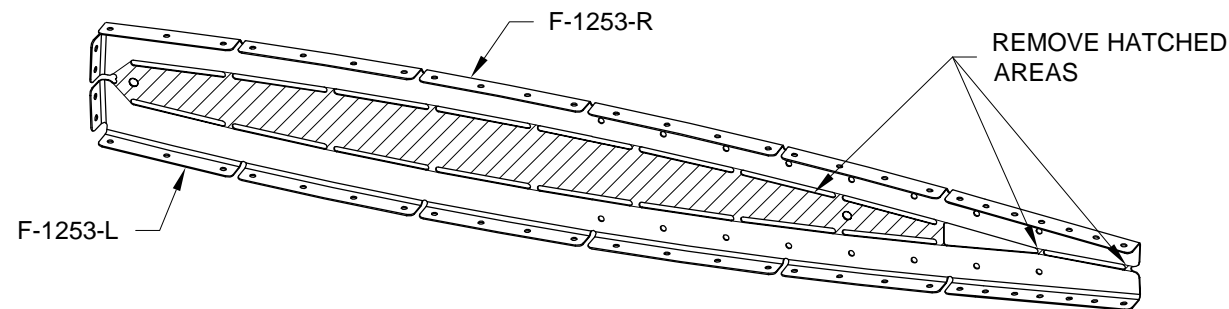
Dimple #30 and #40 the holes around the access panel openings and along the fwd and inbd edges enclosed by borderlines in both F-01225-L-1 & -R-1.

**Step 2:** Rivet nutplates to F-01225-L-1 and to F-01225-R-1 per the call-outs.



**FIGURE 1: ATTACHING NUTPLATES TO F-01225L-1 & -R-1**

**Step 3:** Separate F-1253 by removing the hatched areas shown in Figure 2.

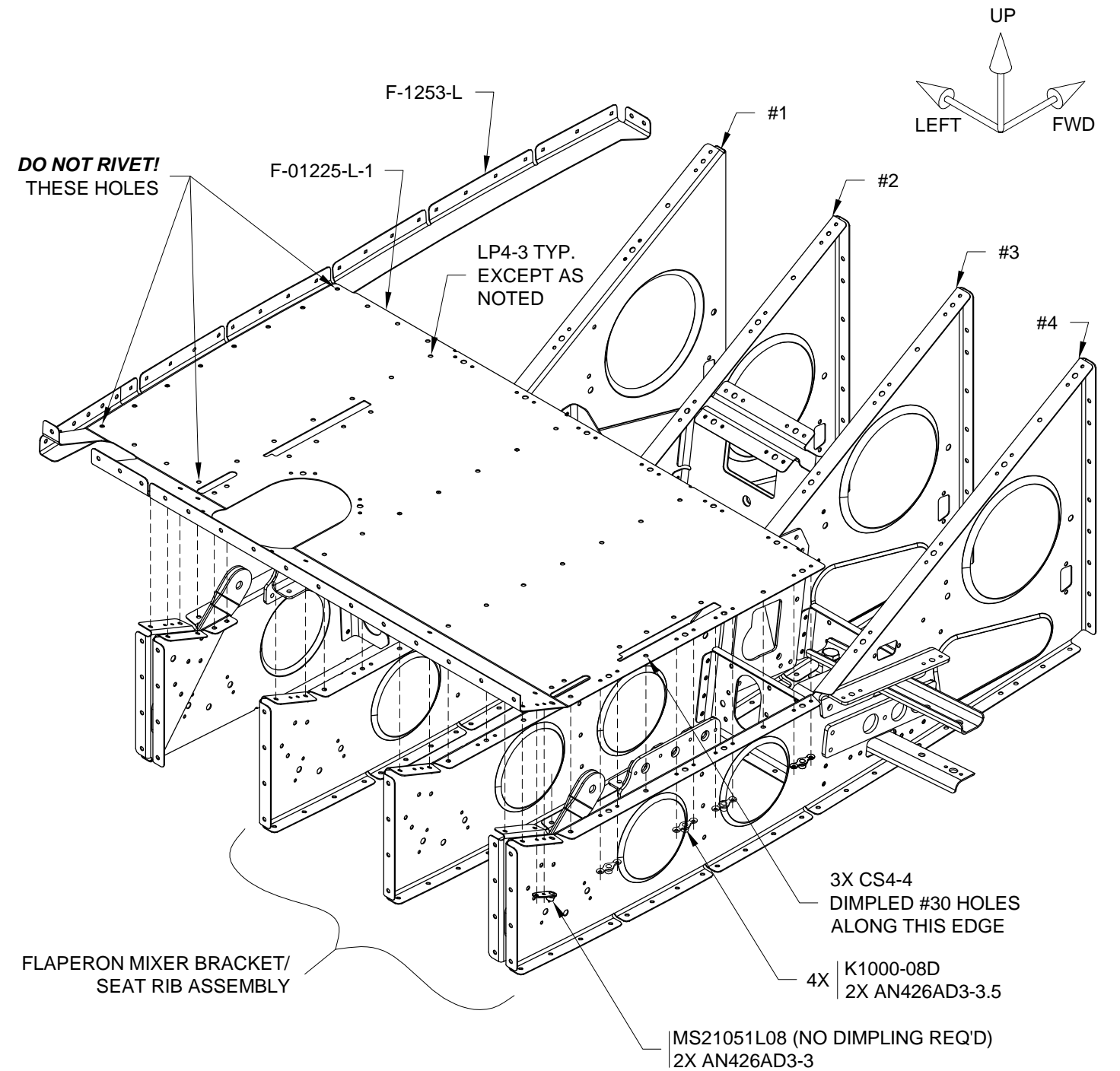


**FIGURE 2: SEPARATING F-1253**

**Step 4:** Rivet F-01225-L-1 to #1 (except for the hole indicated) and the Flaperon Mixer Bracket/ Seat Rib Assembly using the rivets called out in Figure 3.

**Step 5:** Rivet the nutplates shown to the Flaperon Mixer Bracket/ Seat Rib Assembly and to the F-01225-L Seat Floor using the rivets called out. Temporarily install an 8-32 screw in the MS21051L08 nutplate to prevent misalignment while riveting.

**Step 6:** Rivet F-1253-L (shown installed) to the bottom of the F-01225-L-1 using the rivets called out in Figure 3. Do not install a rivet in the aft most and forward most hole as indicated.



**FIGURE 3: RIVETING LEFT SEAT FLOOR**



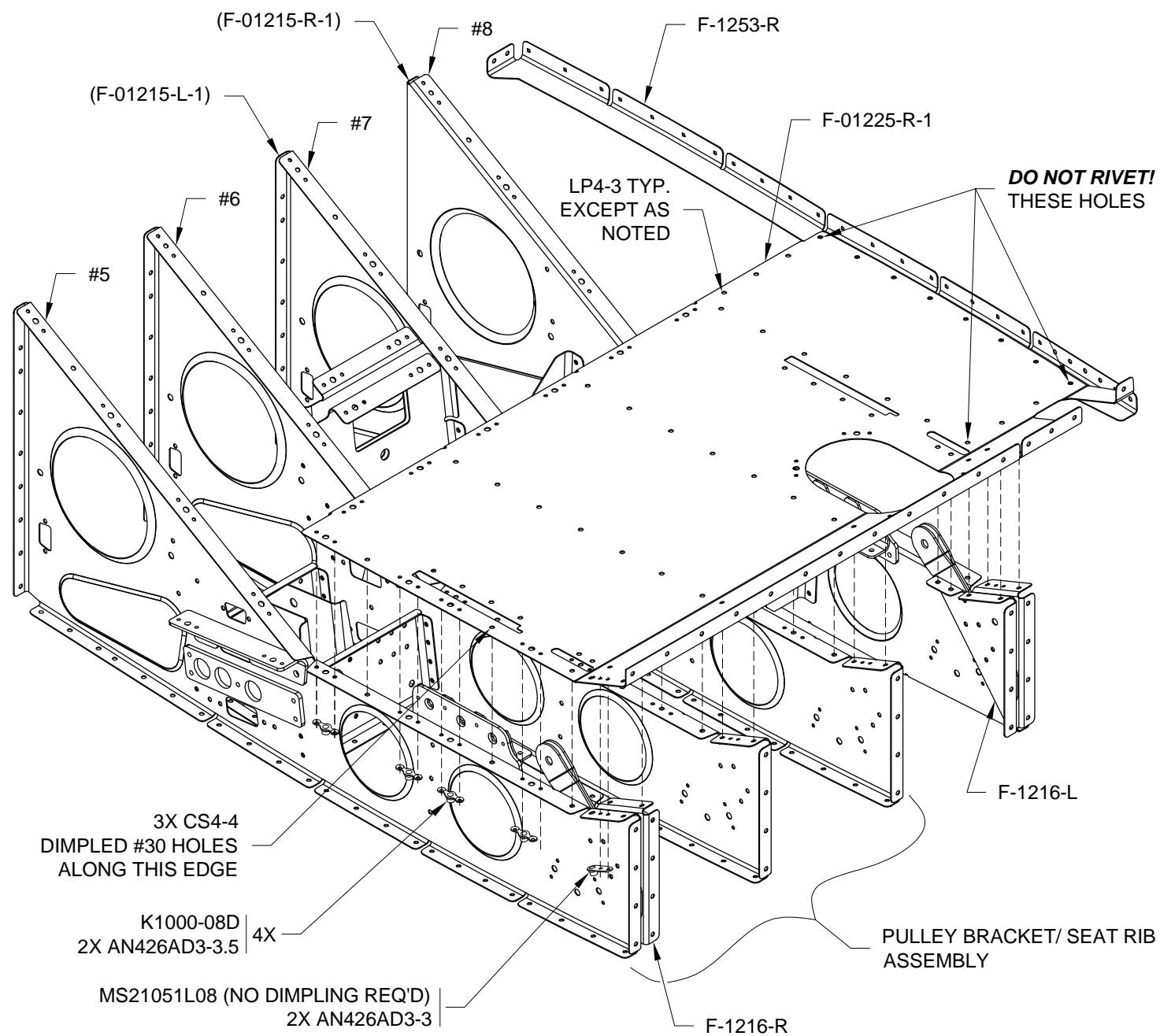
**Step 1:** Rivet F-01225-R-1 to #8 (except the hole indicated) and the Pulley Bracket/ Seat Rib Assembly using the rivets called out in Figure 1.

**Step 2:** Rivet nutplates shown in Figure 1 to the Pulley Bracket/ Seat Rib Assembly and to F-01225-R-1 using the rivets called out. Again, temporarily install an 8-32 screw in the MS21051L08 nutplate to prevent misalignment while riveting.

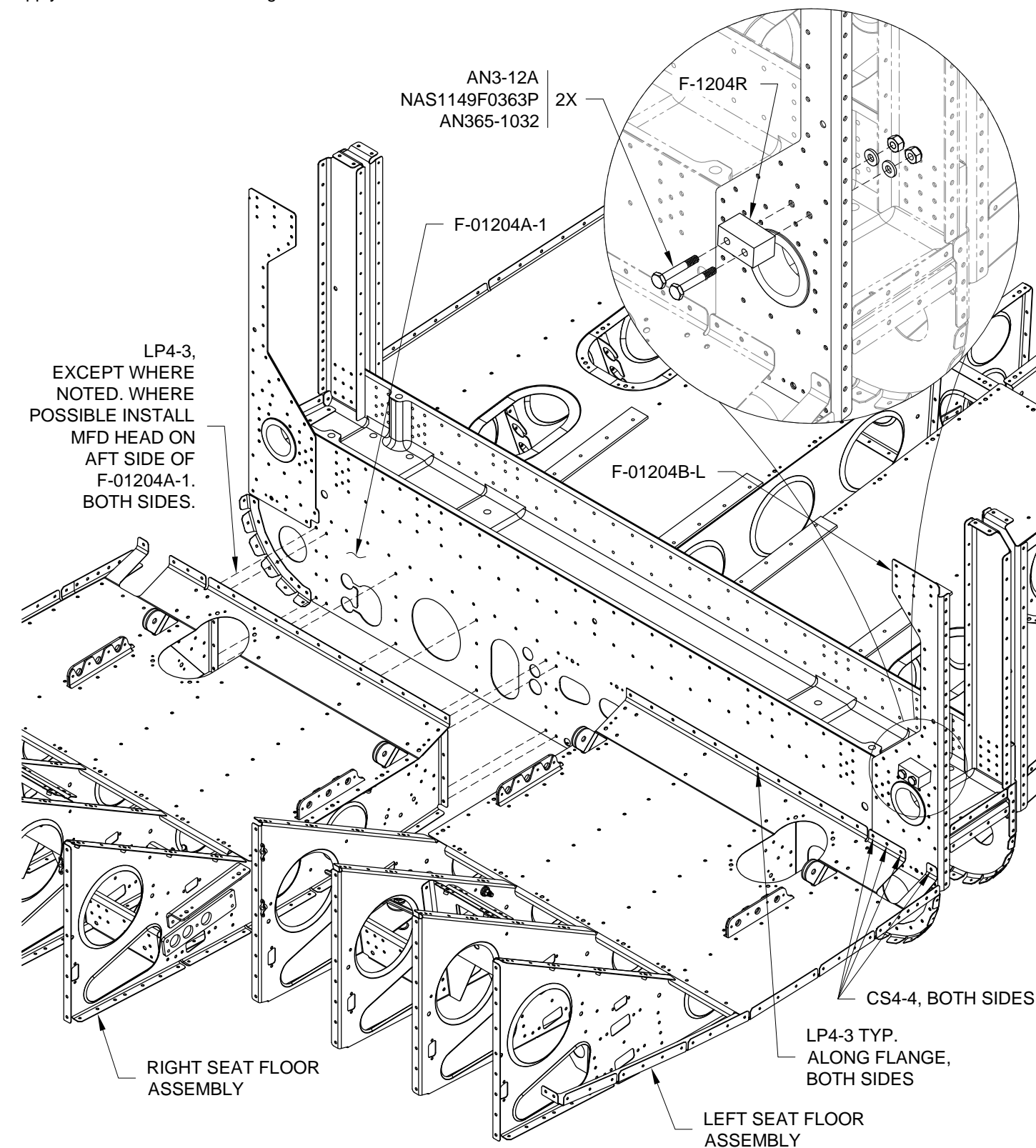
**Step 3:** Using the rivets called out in Figure 1 rivet F-1253-R (shown installed) to the bottom of F-01225-R-1. Do not install a rivet in the aft most and forward most hole as indicated.

**Step 4:** Bolt F-1204R to F-01204B-L using the hardware called out in the Figure 2 detail.

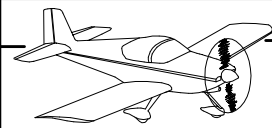
**Step 5:** Rivet the Left and Right Seat Floor Assemblies to F-01204A-1 Center Section Bulkhead using the rivets called out in Figure 2. Rivet call-outs apply to both sides of the fuselage.



**FIGURE 1: RIVETING RIGHT SEAT FLOOR**



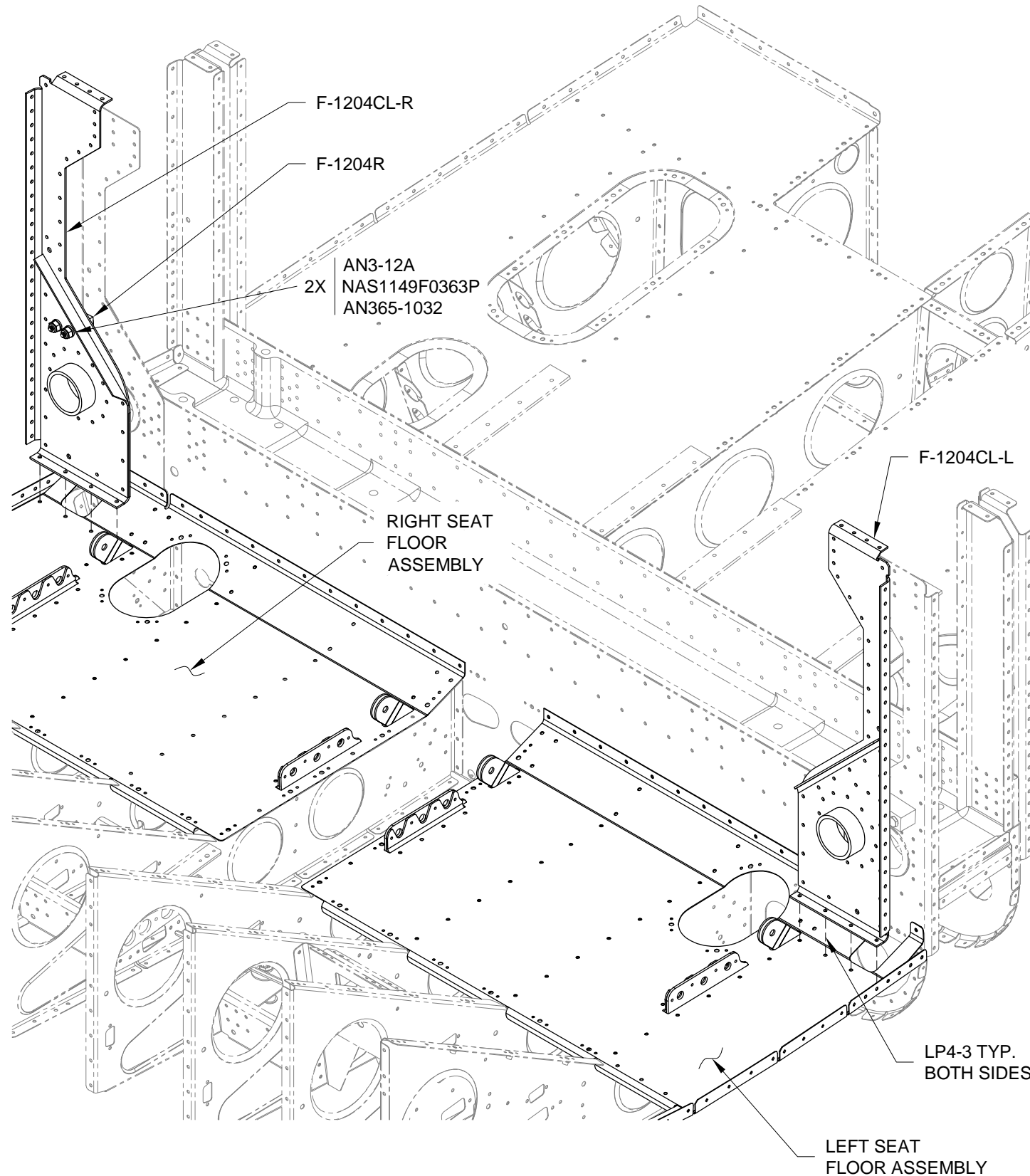
**FIGURE 2: RIVETING SEAT FLOOR ASSEMBLIES**



Step 1: Bolt F-1204R to F-1204CL-R using the hardware called out in Figure 1.

Step 2: Rivet F-1204CL-L to the Left Seat Floor Assembly using the rivets called out in Figure 1.

Rivet F-1204CL-R to the Right Seat Floor Assembly using the rivets called out in Figure 1.

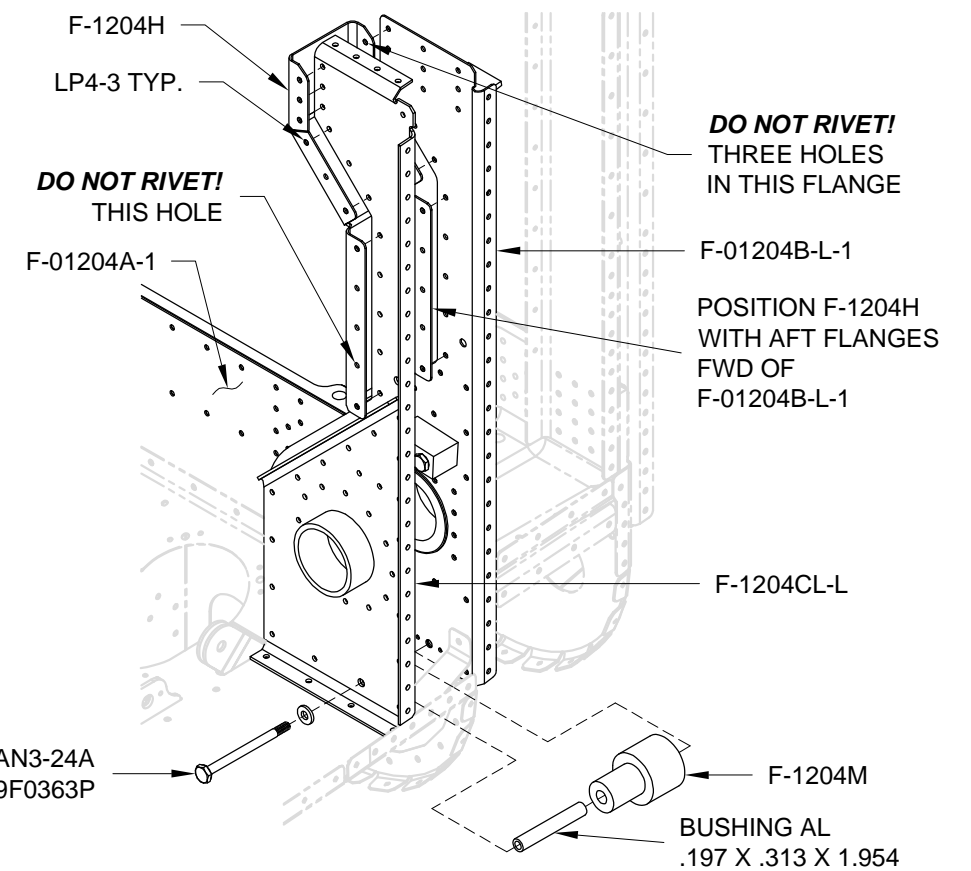


**FIGURE 1: RIVETING F-1204CL-L & -R**

**NOTE: DO NOT rivet the three holes in the top flange of F-1204H which are common to F-01204B-L-1, or the single hole in the bottom forward flange indicated in Figure 2.**

Step 3: Rivet F-1204H to the forward side of F-01204B-L-1 and forward side of F-1204CL-L using the rivets called out in Figure 2.

Step 4: Slide the called out bushing into F-1204M then install them between the F-01204B-L-1 and F-1204CL-L using the hardware called out in Figure 2. (The bolt is secured with the nutplate already attached to the aft side of F-01204A-1.)



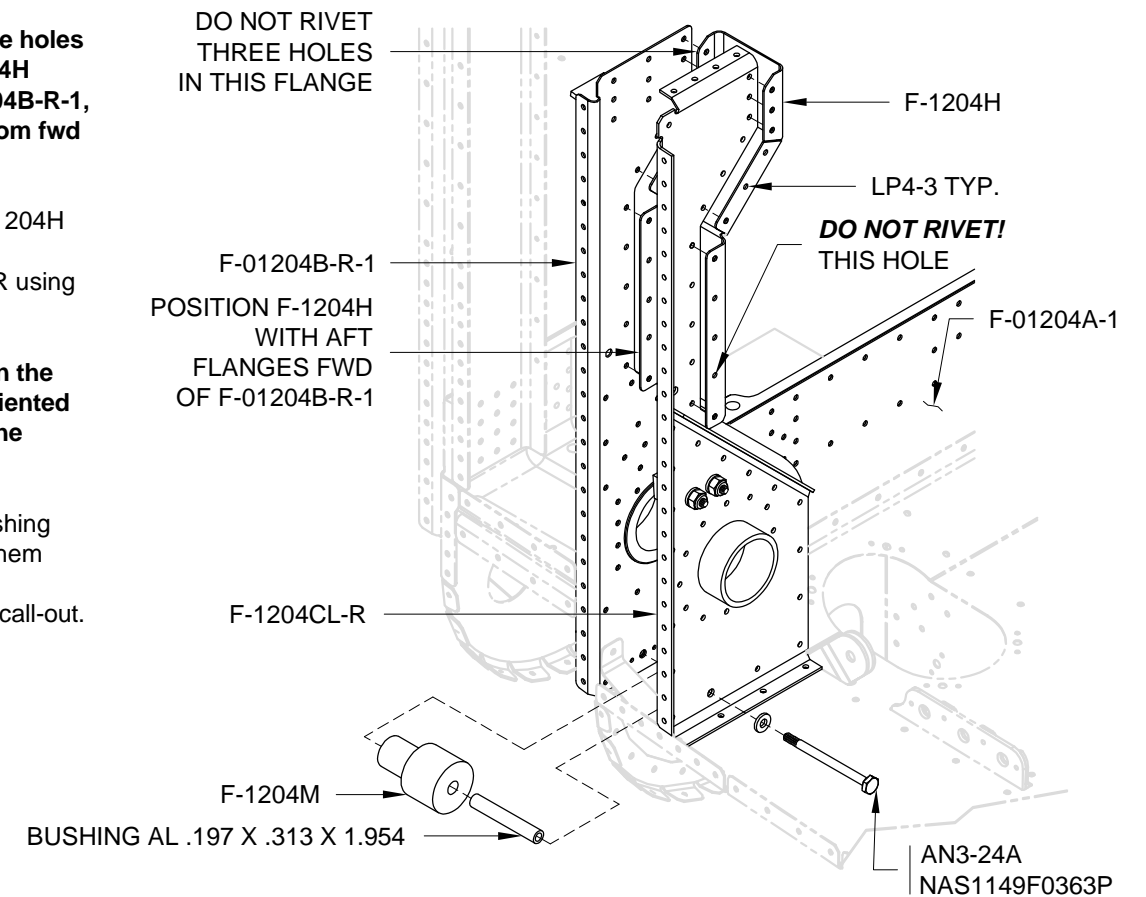
**FIGURE 2: INSTALLING F-1204H & F-1204M ON LEFT SIDE**

**NOTE: DO NOT rivet the three holes in the top flange of the F-1204H which are common to F-01204B-R-1, or the single hole in the bottom fwd flange indicated in Figure 3.**

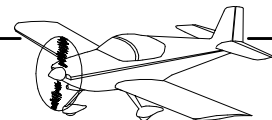
Step 5: Rivet the remaining F-1204H to the forward side of both F-01204B-R-1 and F-1204CL-R using the called out rivets.

**NOTE: The F-1204M Roller on the right side of the aircraft is oriented in the opposite direction of the roller on the left side.**

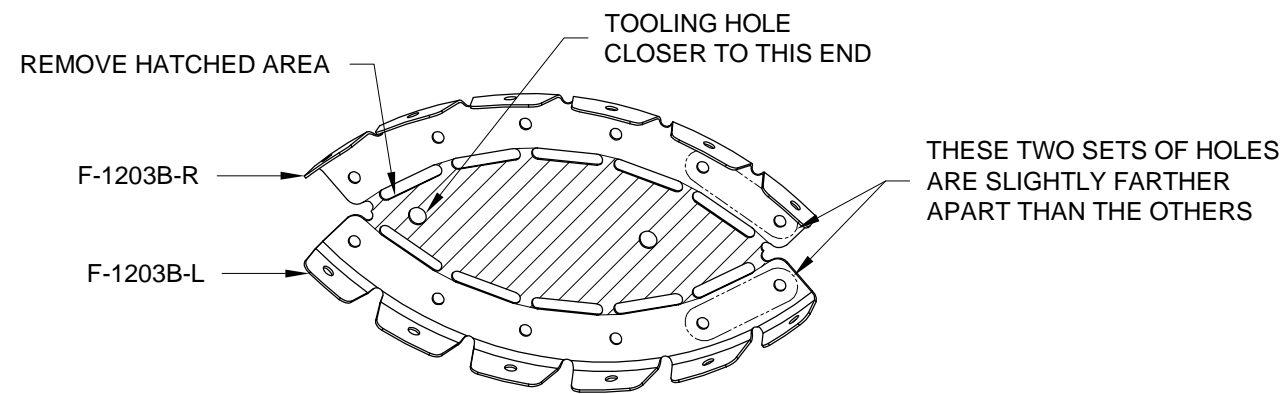
Step 6: Slide the called out bushing into the F-1204M, then install them between F-01204B-R-1 and F-1204CL-R per the hardware call-out.



**FIGURE 3: INSTALLING F-1204H & F-1204M ON RIGHT SIDE**

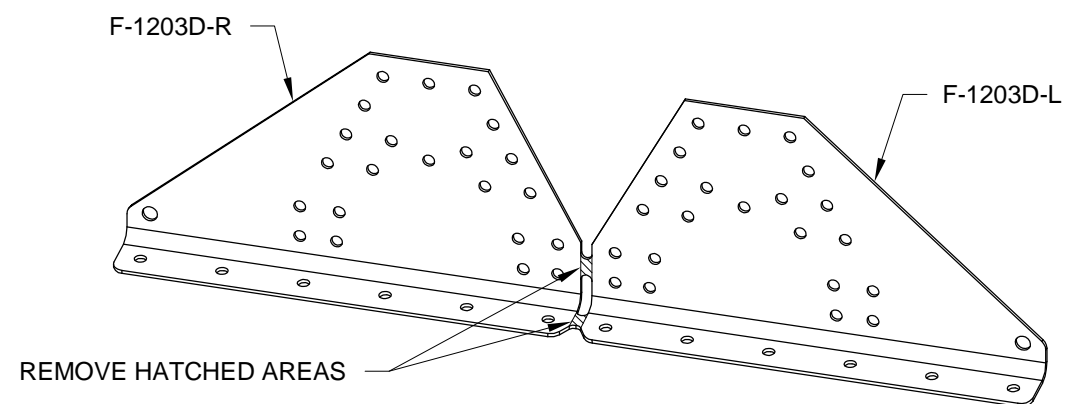


Step 1: Separate F-1203B by removing the hatched area shown in Figure 1.



**FIGURE 1: SEPARATING F-1203B**

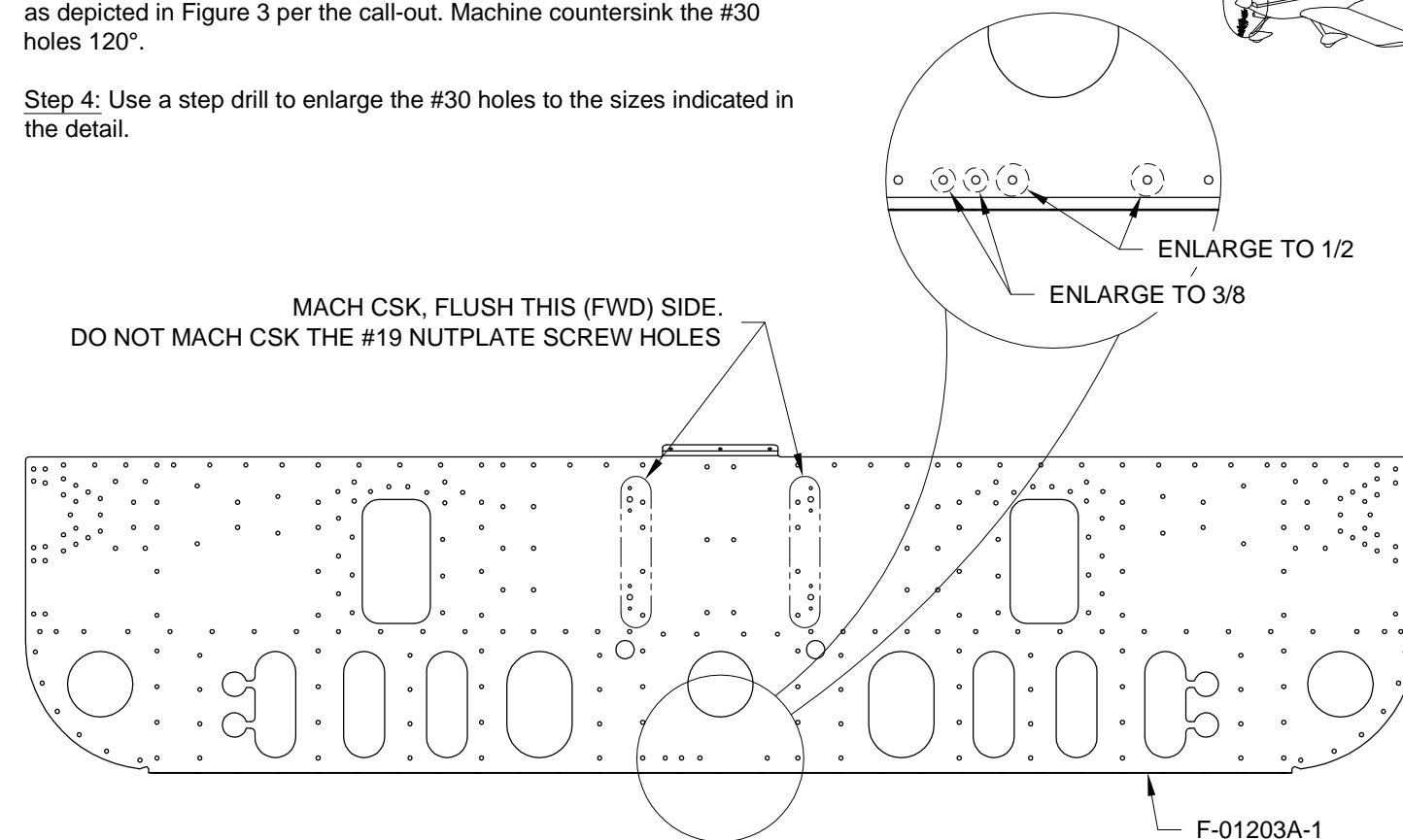
Step 2: Separate F-1203D by removing the hatched areas shown in Figure 2.



**FIGURE 2: SEPARATING F-1203D**

Step 3: Machine countersink #30 and #40 the forward face of F-01203A-1 as depicted in Figure 3 per the call-out. Machine countersink the #30 holes 120°.

Step 4: Use a step drill to enlarge the #30 holes to the sizes indicated in the detail.



**FIGURE 3: PREPARING F-01203A-1**  
(FRONT VIEW; BOTTOM FLANGE BENT BACK INTO PAGE)

Step 5: Rivet F-1203B-L to the left, aft side of the F-01203A-1 using the rivets called out in Figure 4.

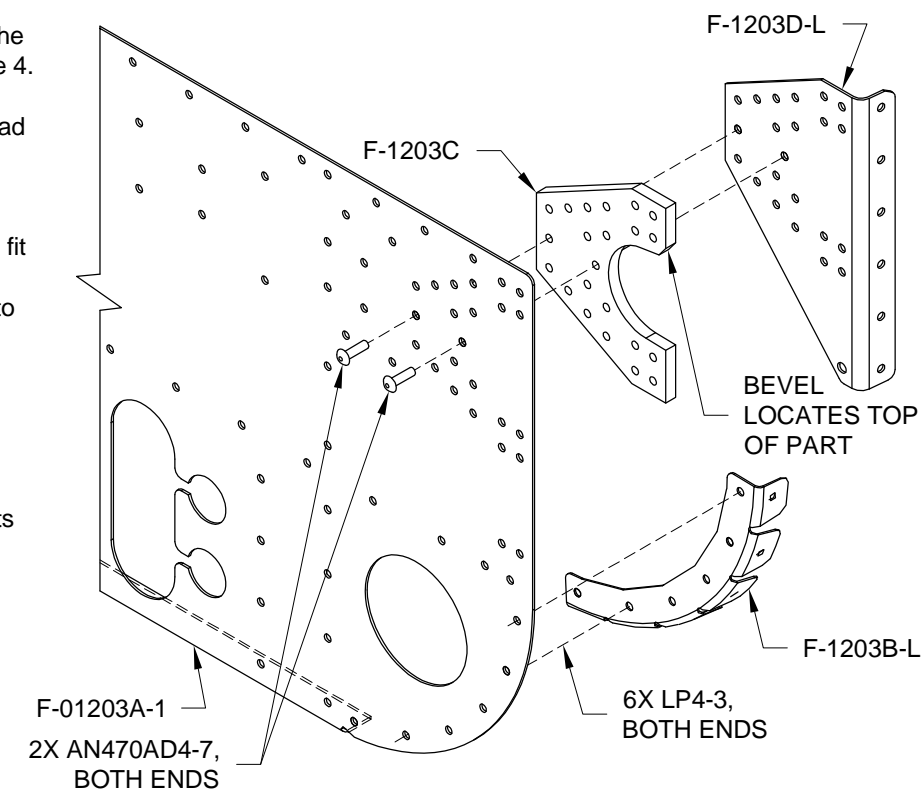
Repeat this step for the right side of the bulkhead using the F-1203B-R.

Step 6: File the curved recess of both F-1203C (the bevel locates the top of the part) to closely fit the rounded mating ends of the Stub Spar Assemblies of both wings then mark the parts to ensure they can be assembled on the side to which they were fitted.

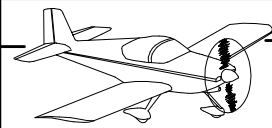
Step 7: Cleco F-1203C and F-1203D-L to F-01203A-1 as shown in Figure 4.

Rivet the parts together using only the two rivets called out. Final-Drill #30 if a hole is too tight to accept a rivet.

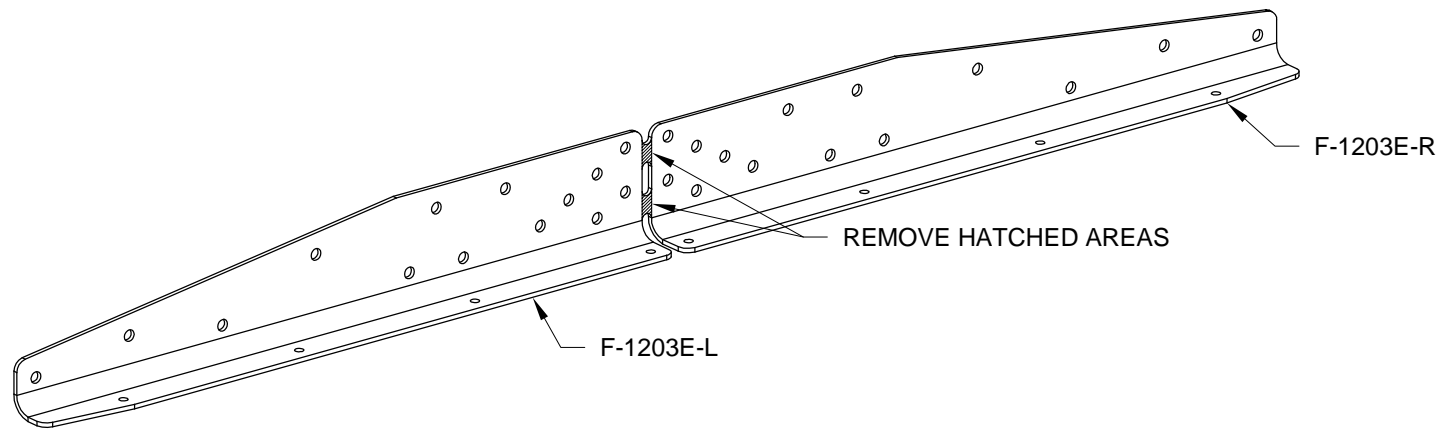
Repeat this step for the right side of F-01203A-1 using the remaining F-1203C and F-1203D-R.



**FIGURE 4: RIVETING F-01203A-1**



Step 1: Separate the two F-1203E by removing the hatched areas shown in Figure 1.

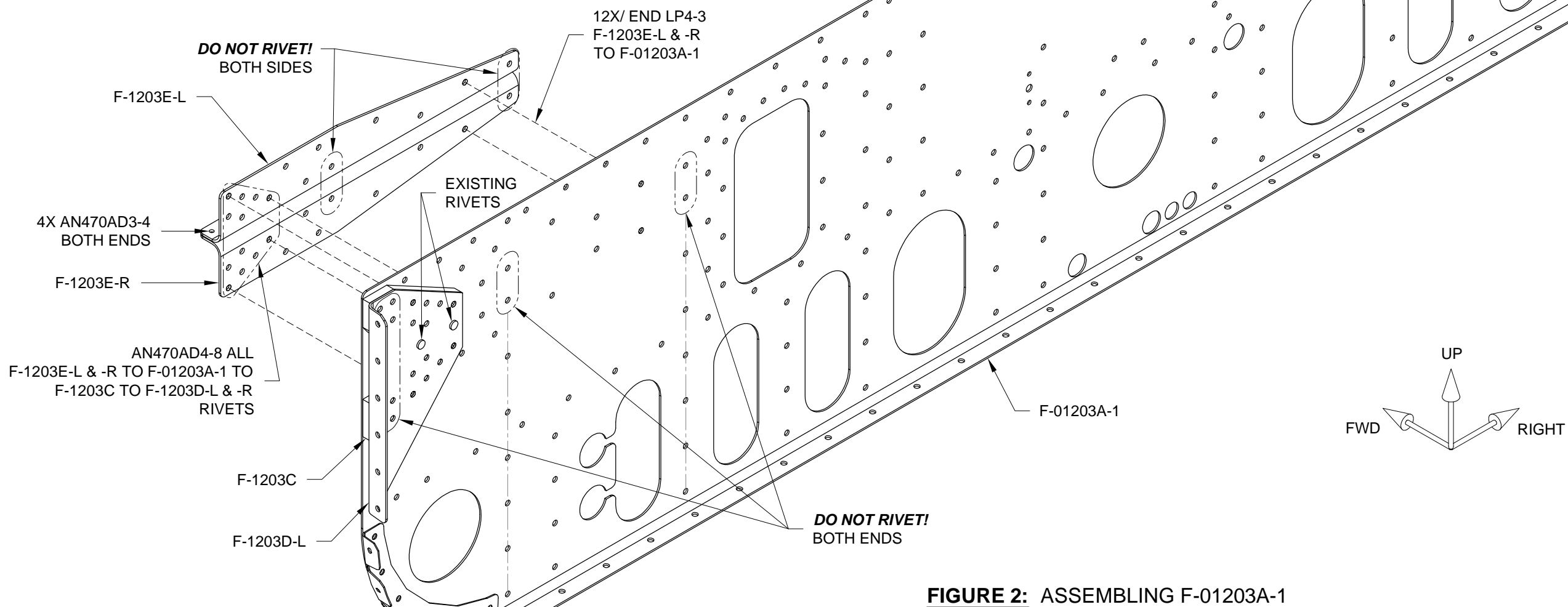


**FIGURE 1: SEPARATING F-1203E**

**NOTE: Where possible install rivets in F-01203A-1 with the manufactured heads on the forward side.**

Step 2: Rivet F-1203E-L & -R to both ends of F-01203A-1, to F-1203C, and F-1203D-L & -R using the rivets called out in Figure 2. As indicated in the figure, do not install rivets in the four holes in both sets of F-1203E-L & -R, or in the eight holes in F-1203D-L outbd of F-1203E-L & -R.

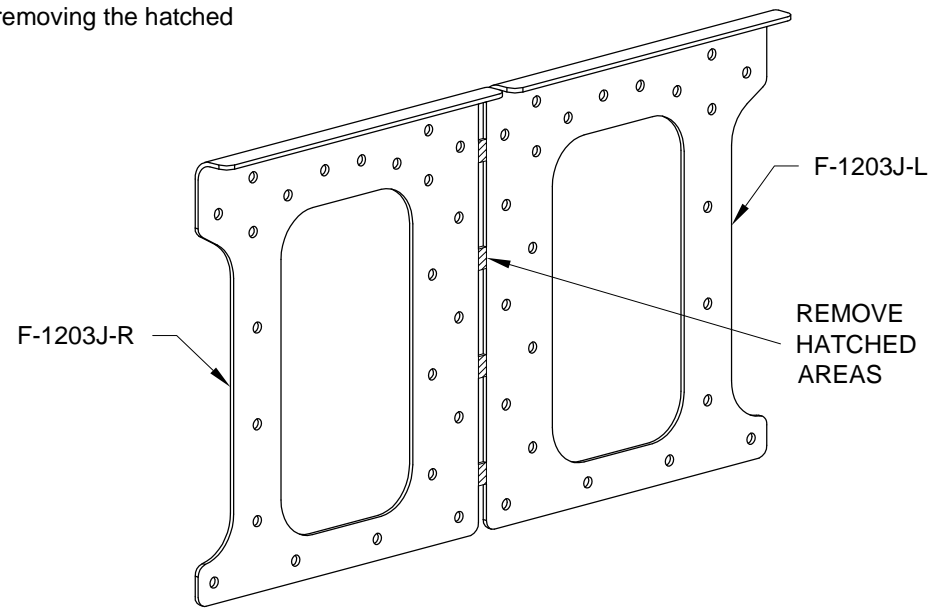
Step 3: Rivet the flanges of the F-1203E-L & -R to each other using the rivets called out in Figure 2. It is acceptable to squeeze these rivets with two flush rivet sets.



**FIGURE 2: ASSEMBLING F-01203A-1**



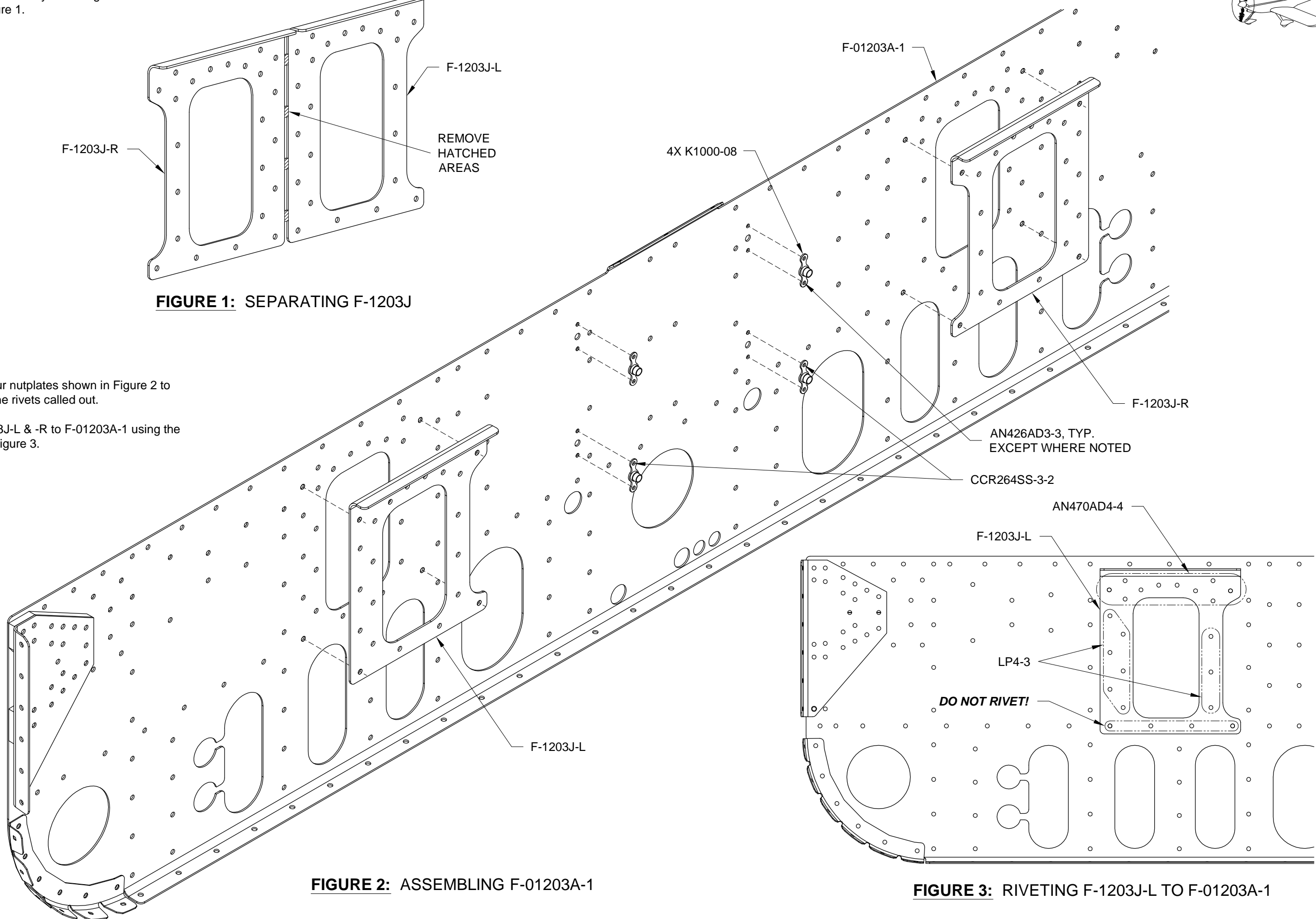
Step 1: Separate F-1203J by removing the hatched areas shown in Figure 1.



**FIGURE 1: SEPARATING F-1203J**

Step 2: Rivet the four nutplates shown in Figure 2 to F-01203A-1 using the rivets called out.

Step 3: Rivet F-1203J-L & -R to F-01203A-1 using the rivets called out in Figure 3.



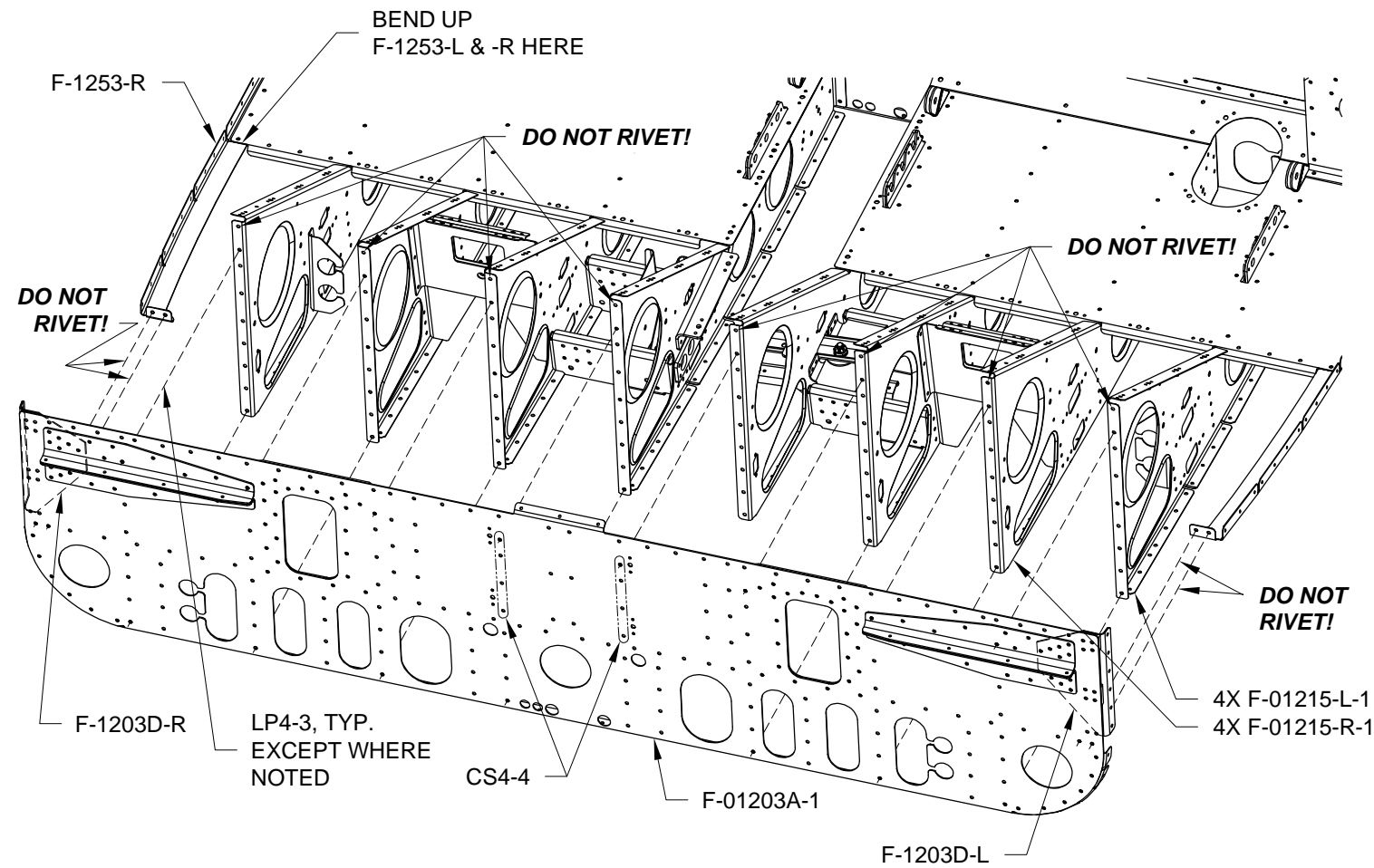
**FIGURE 2: ASSEMBLING F-01203A-1**

**FIGURE 3: RIVETING F-1203J-L TO F-01203A-1**



**Step 1:** Cleco F-01203A-1 to the front flanges of each F-01215-L-1 & -R-1 and to the front flange of F-1253-L & -R. In order to align the holes in F-1253-L & -R with their corresponding holes in F-01203A-1 (the holes just below F-1203D-L & -R ), the F-1253-L & -R need to be bent up slightly at the front of the seat floors. See Figure 1 call-out.

**Step 2:** Rivet F-01203A-1 to the front flange of each F-01215-L-1 & -R-1 using the rivets called out in Figure 1 except where indicated. **DO NOT** rivet F-1253-L & -R at this time.

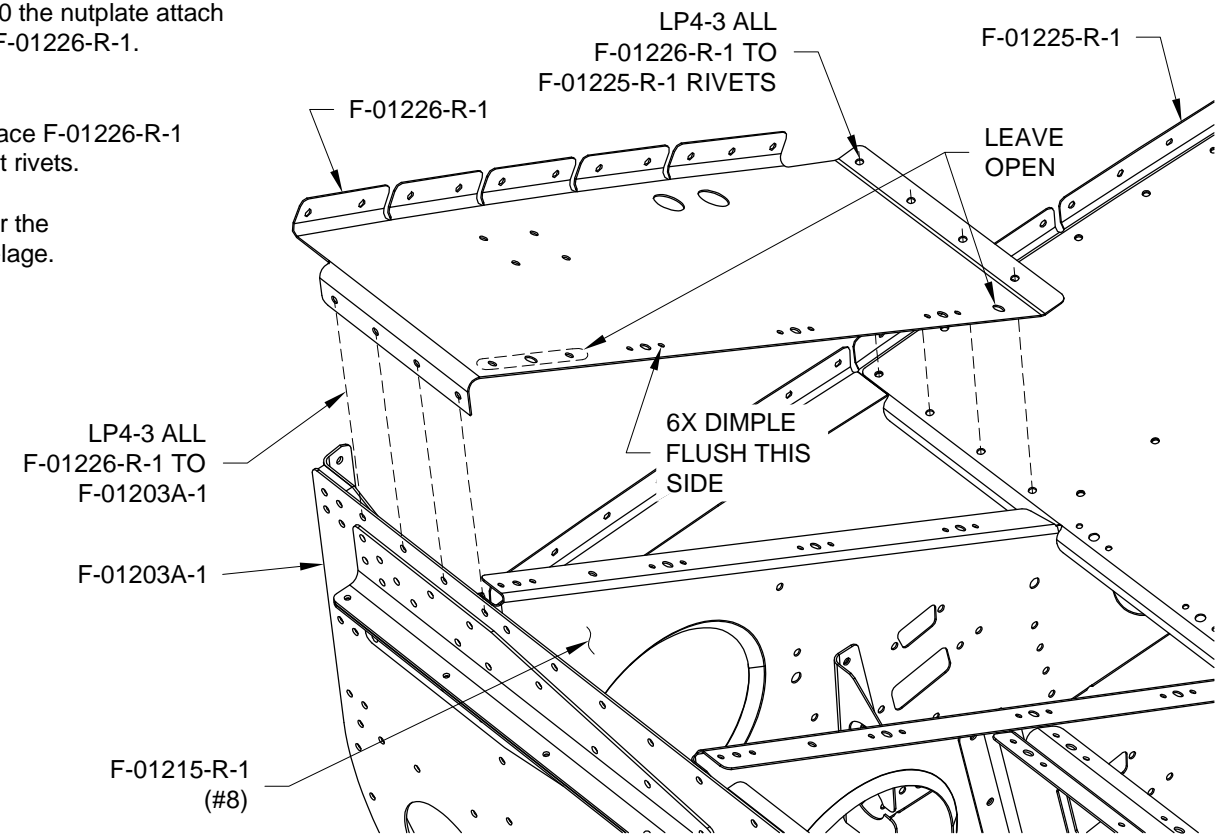


**FIGURE 1: INSTALLING F-01203A-1**

**Step 3:** Dimple #40 the nutplate attach holes indicated in F-01226-R-1. See Figure 2.

**Step 4:** Rivet in place F-01226-R-1 using the called out rivets.

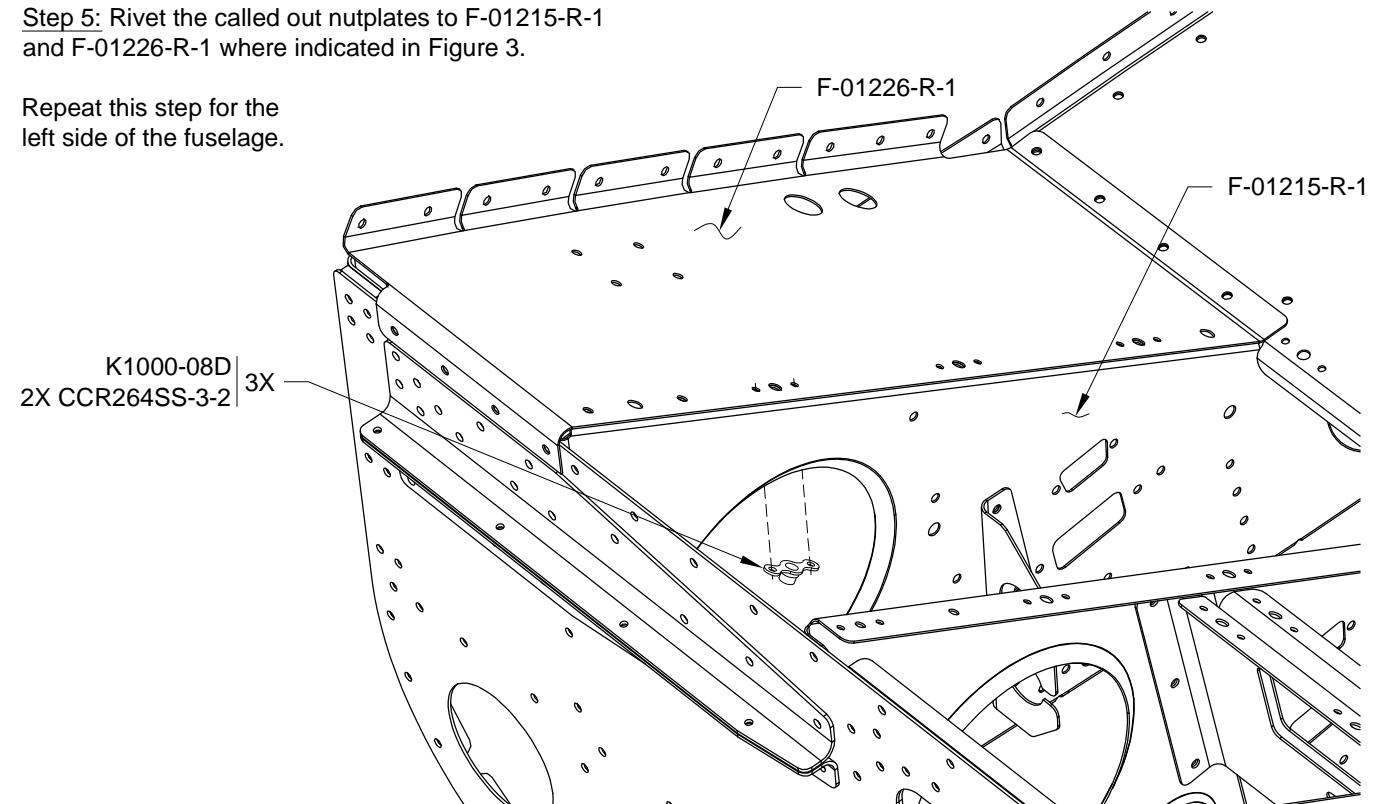
Repeat this step for the left side of the fuselage.



**FIGURE 2: RIVETING F-01226-R-1**

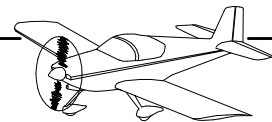
**Step 5:** Rivet the called out nutplates to F-01215-R-1 and F-01226-R-1 where indicated in Figure 3.

Repeat this step for the left side of the fuselage.

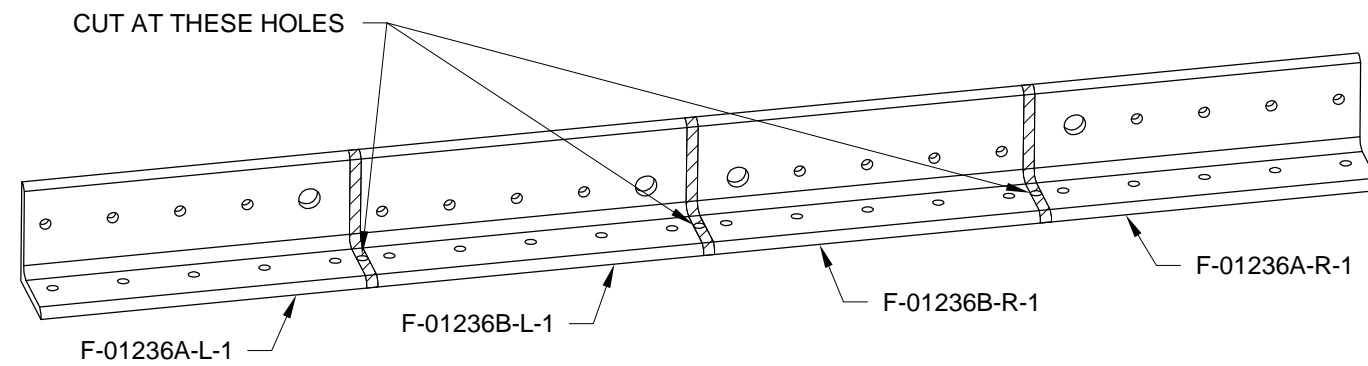


**FIGURE 3: ATTACHING NUTPLATES**





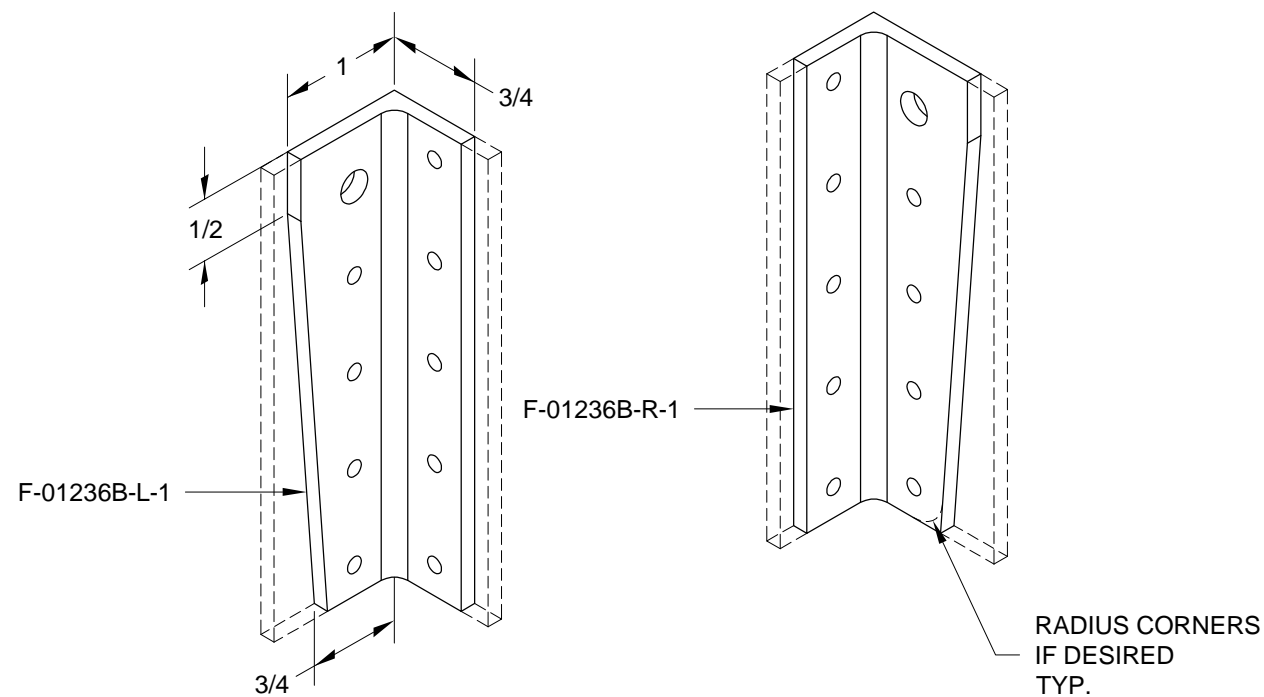
Step 1: Separate F-01236-1 into four angles by removing the hatched areas shown in Figure 1.



**FIGURE 1: SEPARATING F-01236-1**

**NOTE: F-01236B-R-1 is the mirror image of F-01236B-L-1.**

Step 2: Trim the flanges of F-01236B-L-1 & -R-1 as shown in Figure 2.

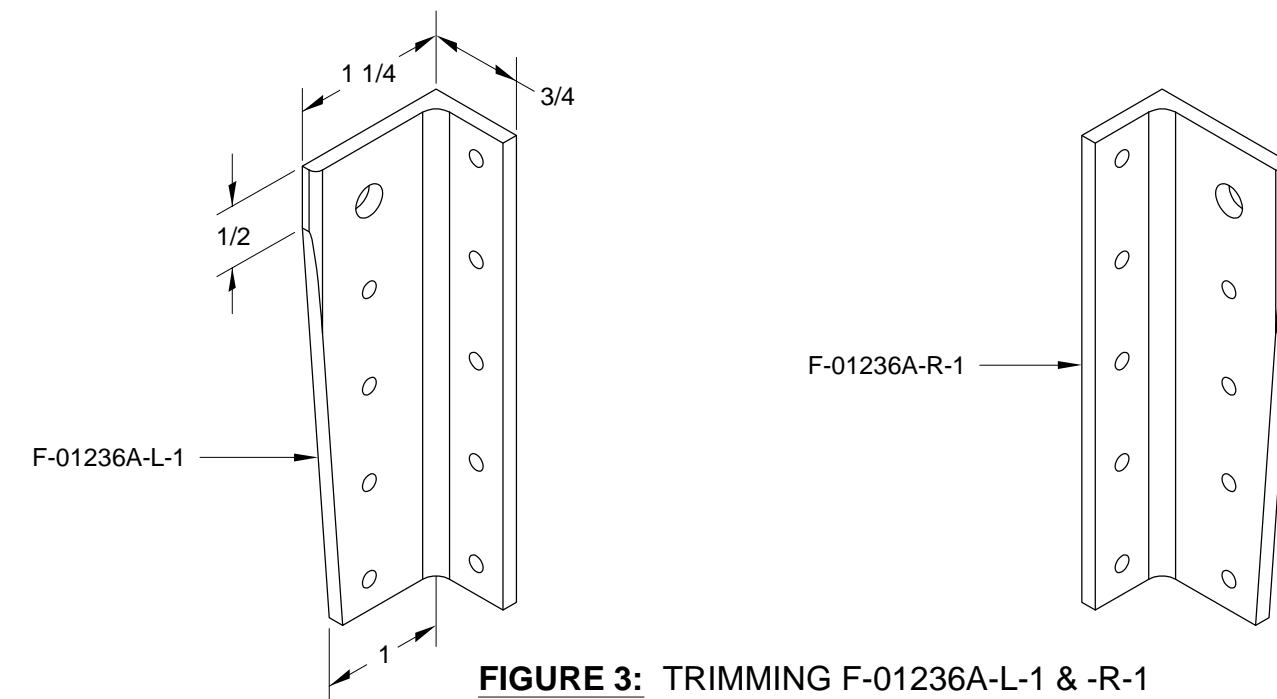


**FIGURE 2: TRIMMING F-01236B-L-1 & -R-1**

**NOTE: F-01236A-R-1 is the mirror image of F-01236A-L-1.**

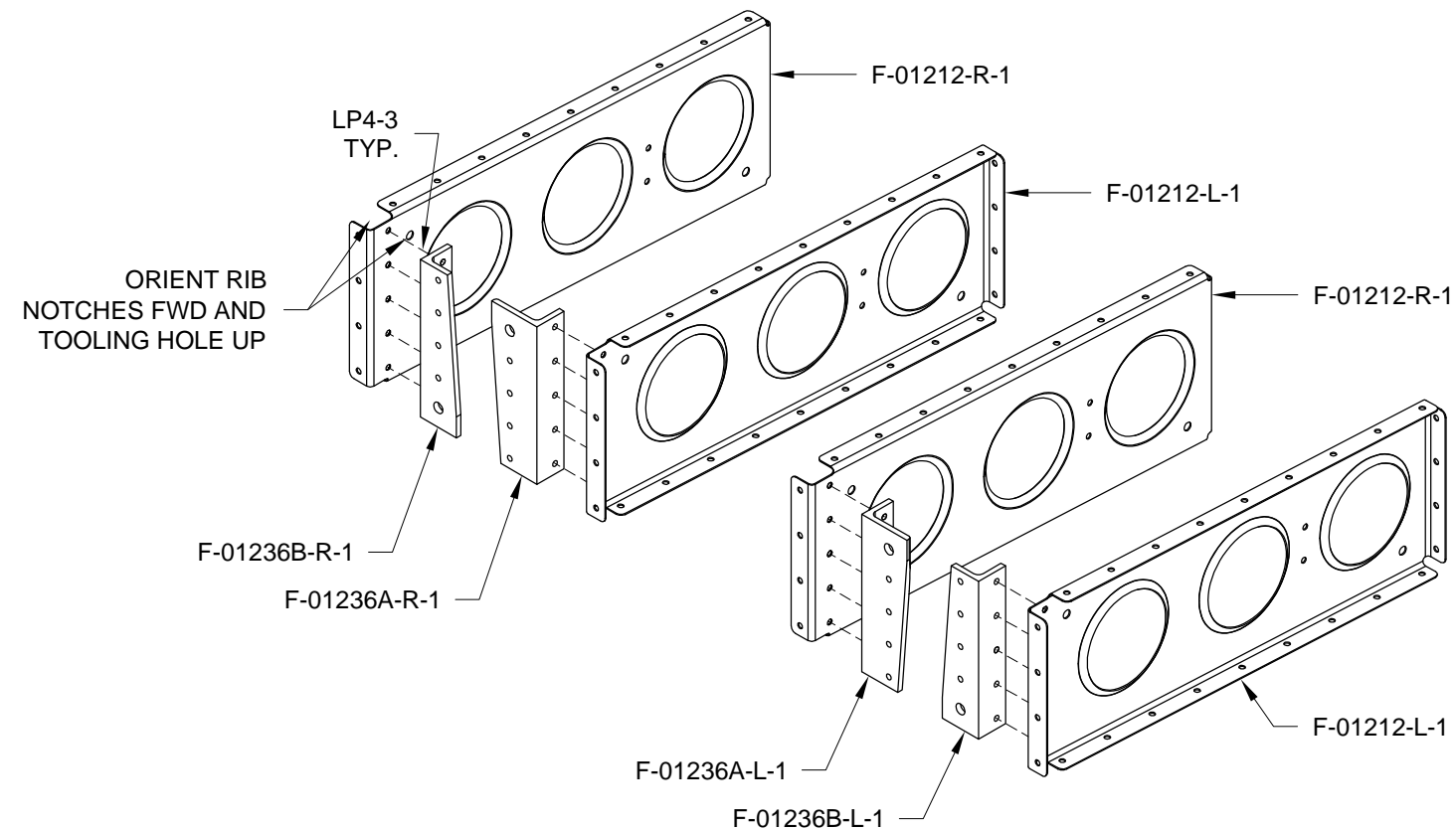
Step 3: Trim the flanges of F-01236A-L-1 & -R-1 as shown in Figure 3.

Step 4: Prime the four angles.



**FIGURE 3: TRIMMING F-01236A-L-1 & -R-1 (SHOWN TRIMMED)**

Step 5: Cleco then rivet the called out angles to the step ribs depicted in Figure 4. Hereafter refer to as Step Rib Assemblies.



**FIGURE 4: RIVETING STEP RIB ASSEMBLIES**



**Step 1:** Dimple #30 the holes in the top flange of both inboard most F-01212-L-1 & -R-1 indicated in Figure 1.

**Step 2:** Dimple #30 the bottom hole in the fwd flange of both outboard most Step Rib Assemblies and the two corresponding holes in F-01202F-1 where indicated.

**Step 3:** Dimple #40 the four nutplate attach holes in the top flange of F-01202F-1.

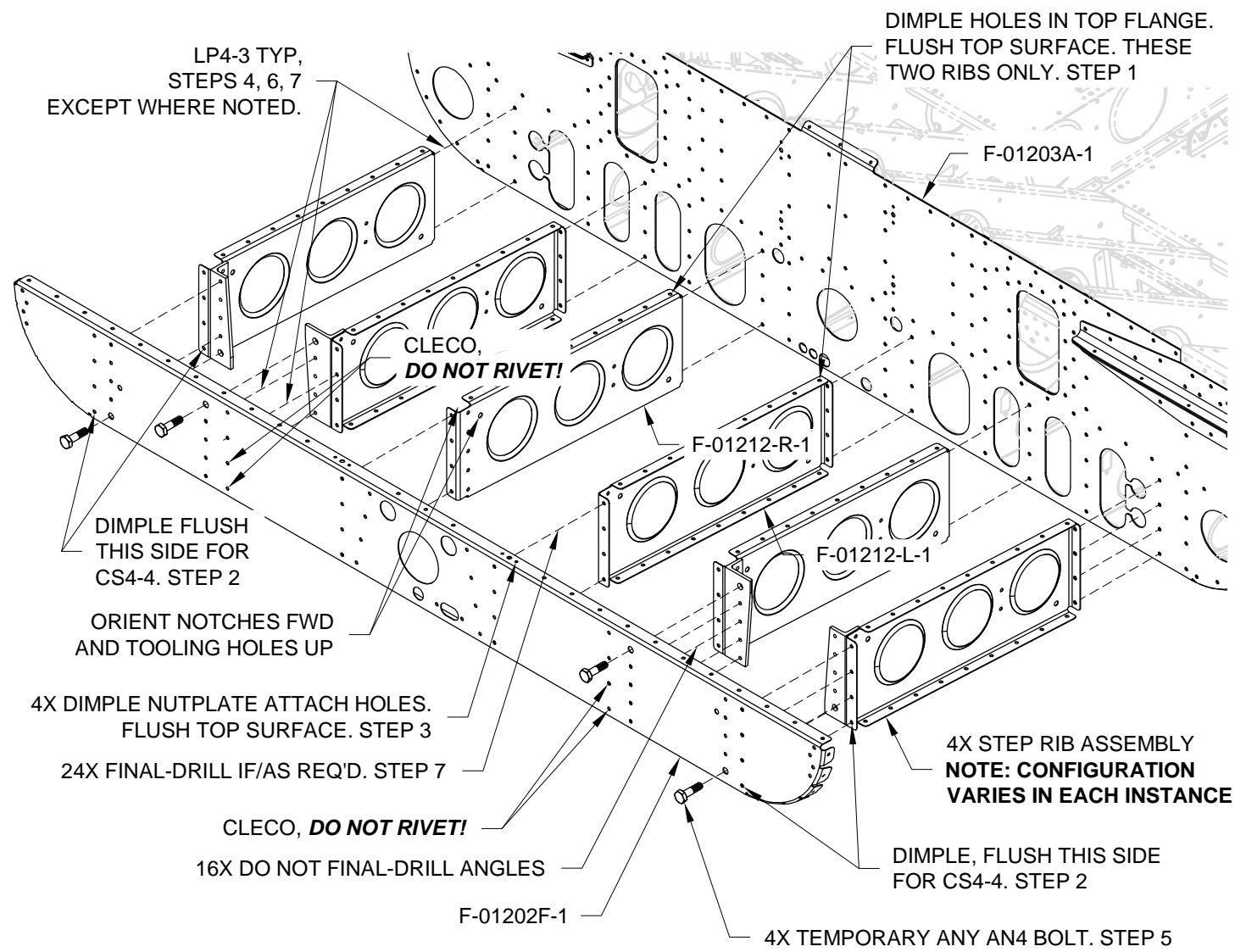
**Step 4:** Cleco then rivet all Step Rib Assemblies and F-01212-L-1 & -R-1 to F-01203A-1 as shown in Figure 1.

**NOTE: DO NOT final-drill any Step Rib Assembly angles (F-01236A-L-1, F-01236A-R-1, F-01236B-L-1, F-01236B-R-1).**

**Step 5:** Insert temporary bolts where indicated then cleco F-01202F-1 to all Step Rib Assembly angles and F-01212-L-1 & -R-1.

**Step 6:** Rivet F-01202F-1 ONLY to Step Rib Assembly angles.

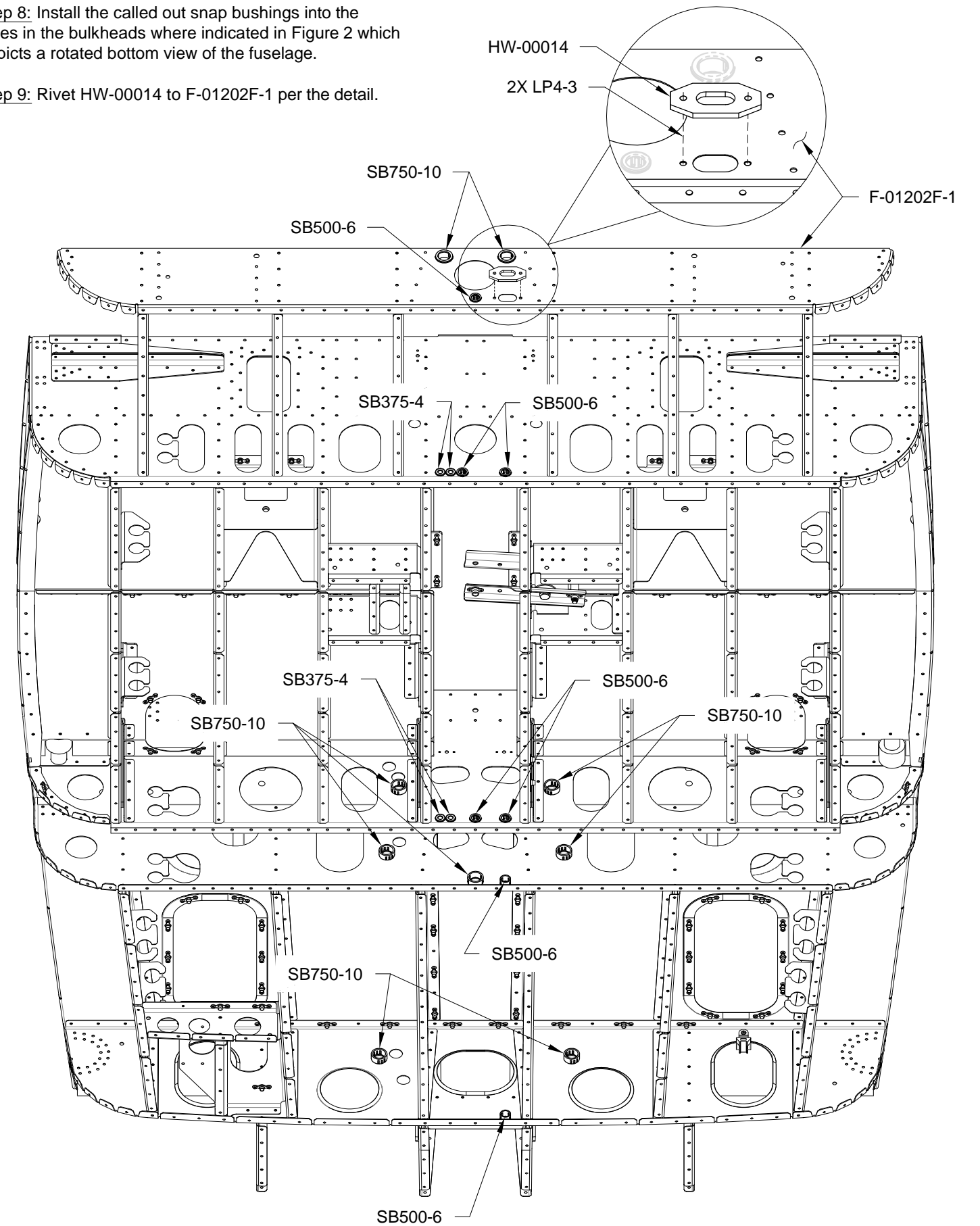
**Step 7:** Rivet F-01202F-1 to F-01212-L-1 & -R-1 and to the four Step Rib Assembly ribs with the exception of the four holes marked "CLECO, DO NOT RIVET." Final-Drill #30 F-01202F-1 to F-01212-L-1 & -R-1 holes if/as req'd.



**FIGURE 1: RIVETING STEP RIBS AND F-01202F-1**

**Step 8:** Install the called out snap bushings into the holes in the bulkheads where indicated in Figure 2 which depicts a rotated bottom view of the fuselage.

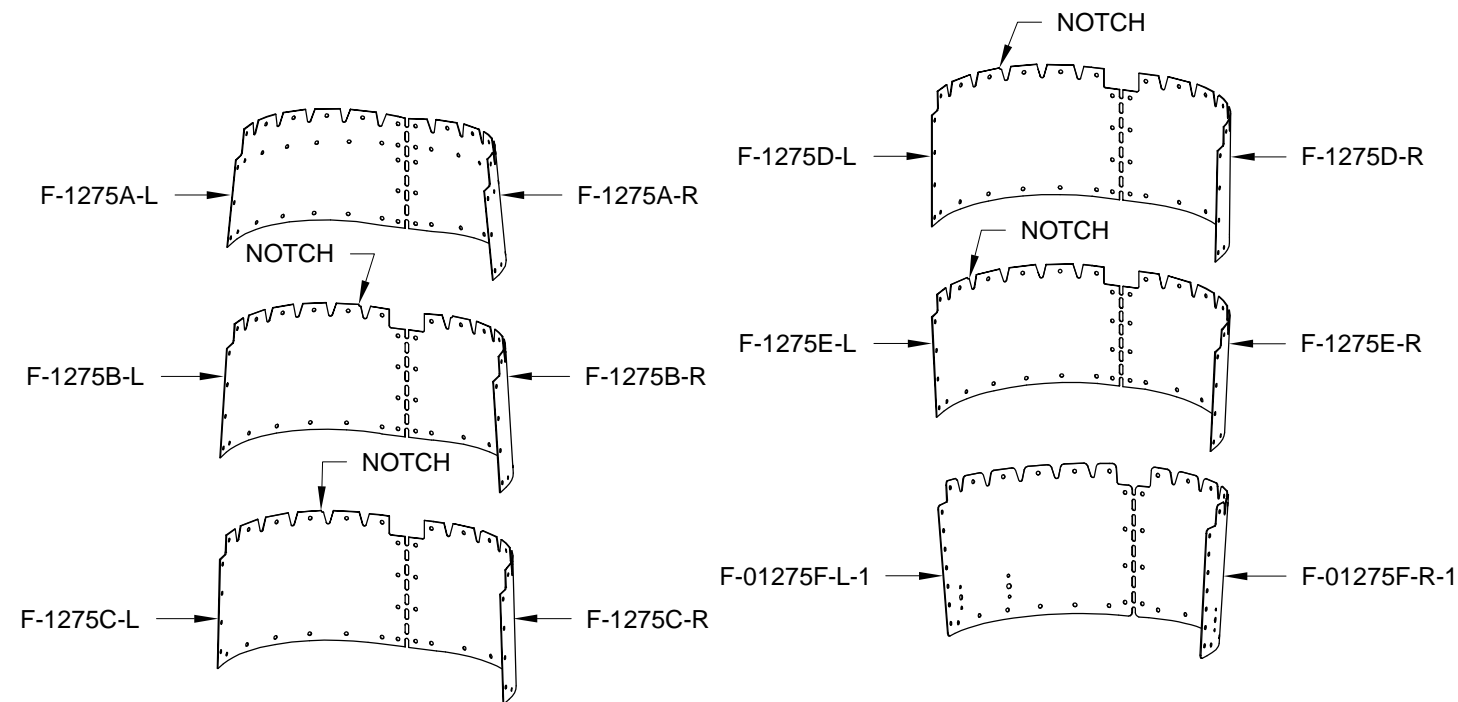
**Step 9:** Rivet HW-00014 to F-01202F-1 per the detail.



**FIGURE 2: INSTALLING SNAP BUSHINGS**



Step 1: Separate F-1275A, B, C, D, E, and F-01275F-1 Fuselage Corner Skins along the center perforations. Notches in called out tabs differentiate the four similar parts as shown in Figure 1.

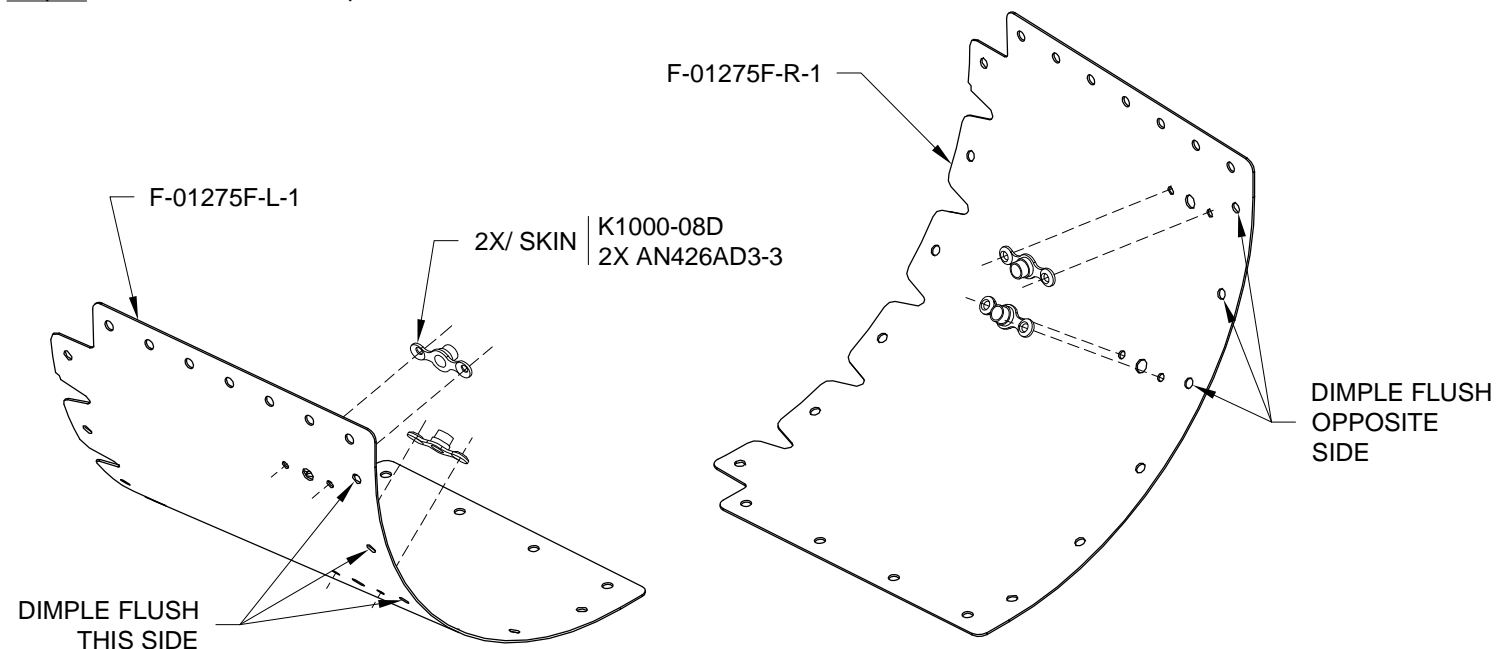


**FIGURE 1: SEPARATING FUSELAGE CORNER SKINS**

Step 2: Dimple #40 the nutplate attach holes in F-01275F-L-1 & -R-1 Fuselage Corner Skins. See Figure 2.

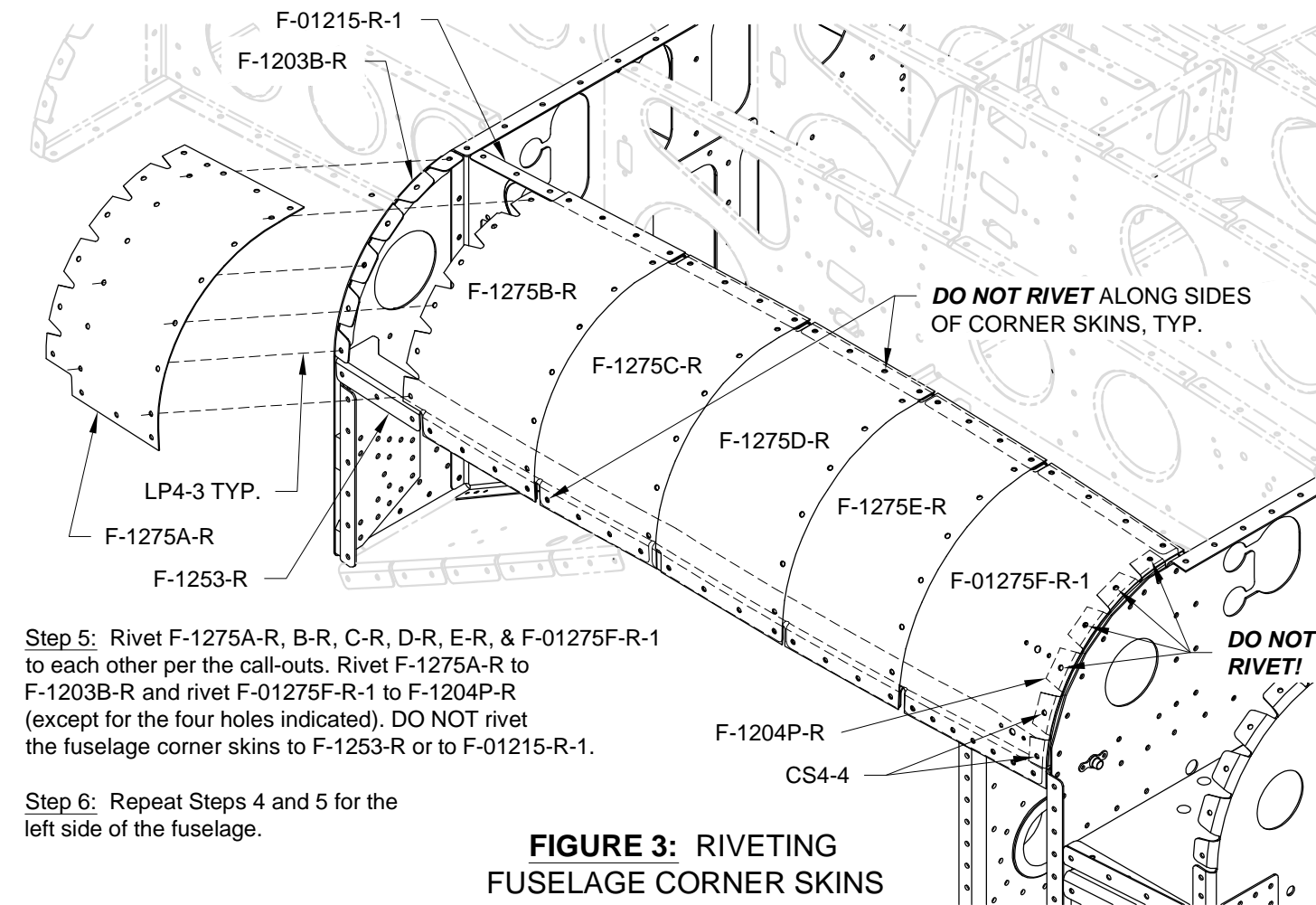
Dimple #30 the rivet holes per the call-outs.

Step 3: Rivet the called out nutplates to F-01275F-L-1 & -R-1 as shown.



**FIGURE 2: RIVETING NUTPLATES TO F-01275F-L-1 & -R-1**

Step 4: Turn the fuselage upside-down on saw horses. Cleco F-01275F-R-1 to F-1253-R, F-01215-R-1, and F-1204P-R. See Figure 3. Then one after the other cleco in place F-1275E-R, D-R, C-R, B-R, & A-R as shown.



**FIGURE 3: RIVETING FUSELAGE CORNER SKINS**

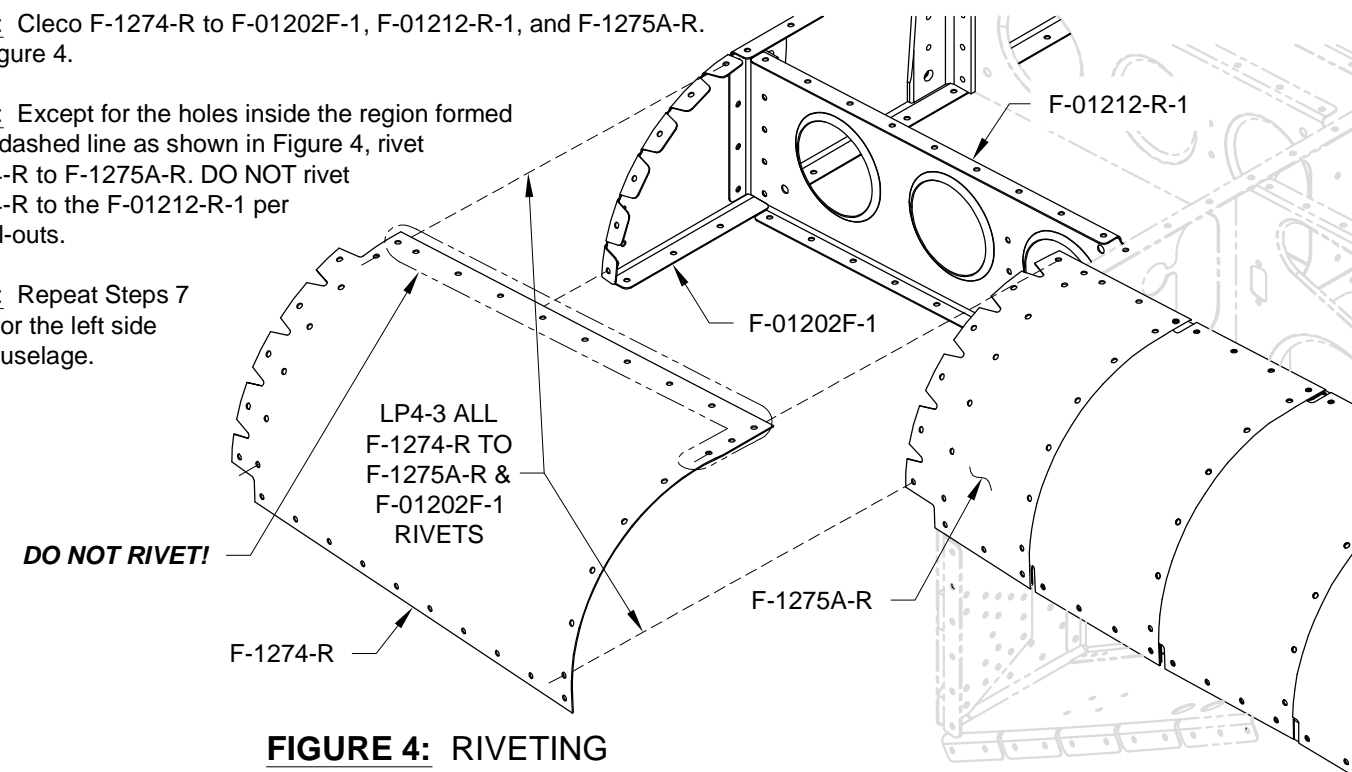
Step 5: Rivet F-1275A-R, B-R, C-R, D-R, E-R, & F-01275F-R-1 to each other per the call-outs. Rivet F-1275A-R to F-1203B-R and rivet F-01275F-R-1 to F-1204P-R (except for the four holes indicated). DO NOT rivet the fuselage corner skins to F-1253-R or to F-01215-R-1.

Step 6: Repeat Steps 4 and 5 for the left side of the fuselage.

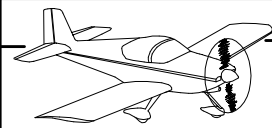
Step 7: Cleco F-1274-R to F-01202F-1, F-01212-R-1, and F-1275A-R. See Figure 4.

Step 8: Except for the holes inside the region formed by the dashed line as shown in Figure 4, rivet F-1274-R to F-1275A-R. DO NOT rivet F-1274-R to the F-01212-R-1 per the call-outs.

Step 9: Repeat Steps 7 and 8 for the left side of the fuselage.



**FIGURE 4: RIVETING FUSELAGE CORNER SKINS**

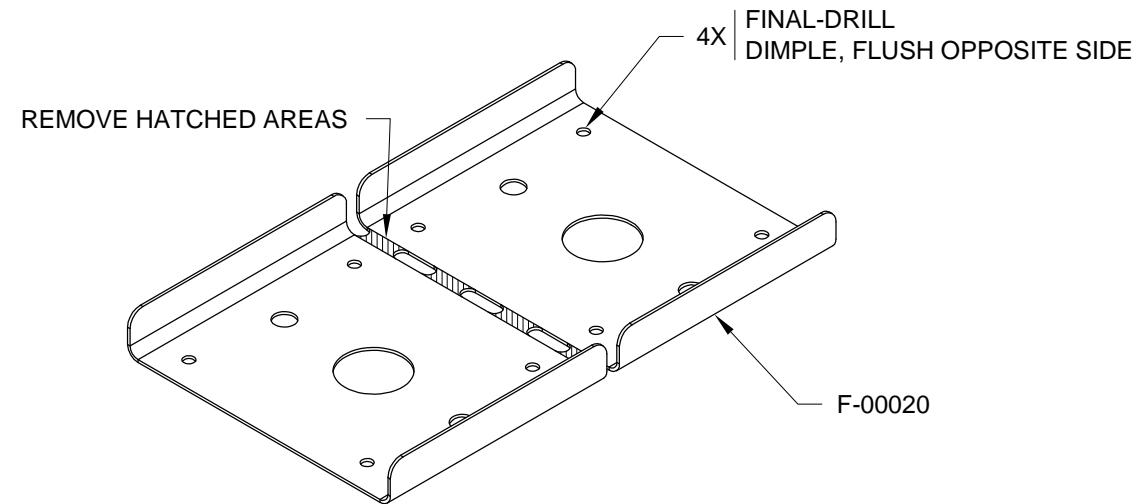


**NOTE: Only one F-00020 will be needed at this time.**

Step 1: Separate F-00020 by removing the hatched areas shown in Figure 1.

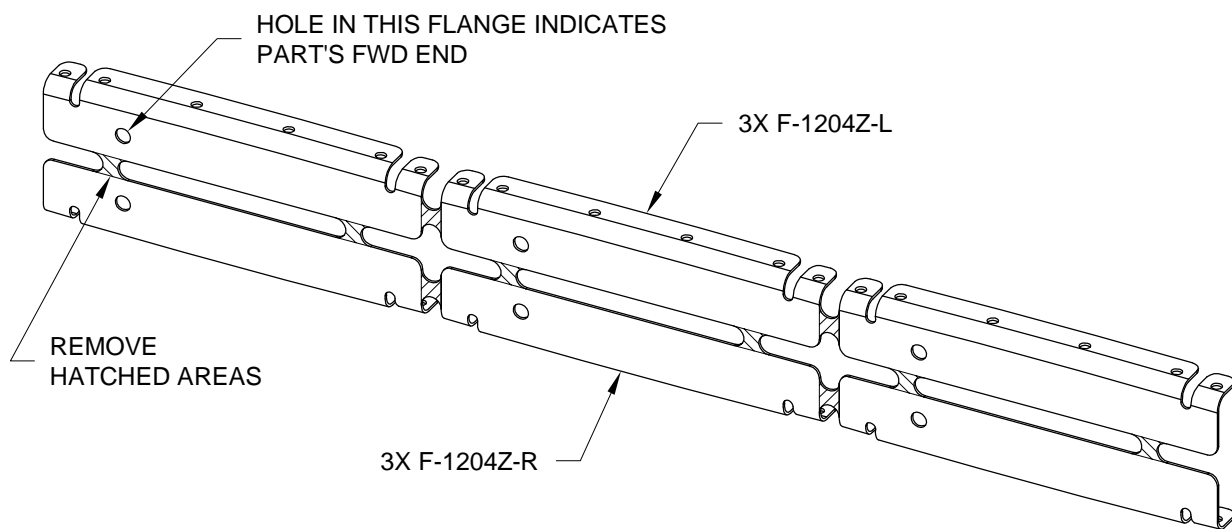
Step 2: Final-Drill #30 the four #40 holes.

Step 3: Dimple #30 F-00020 for the dimpled F-01276-1 Bottom Skin.



**FIGURE 1: SEPARATING & PREPARING F-00020**

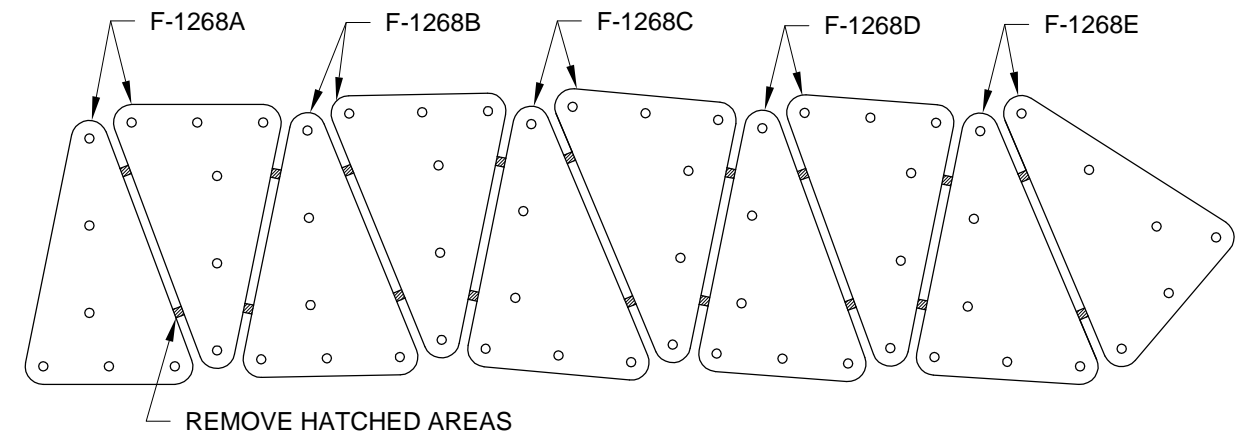
Step 4: Separate F-1204Z by removing the hatched areas shown in Figure 2.



**FIGURE 2: SEPARATING F-1204Z**

Step 5: Orient F-1268 as shown then mark each part.

Separate by removing the hatched areas shown in Figure 3.

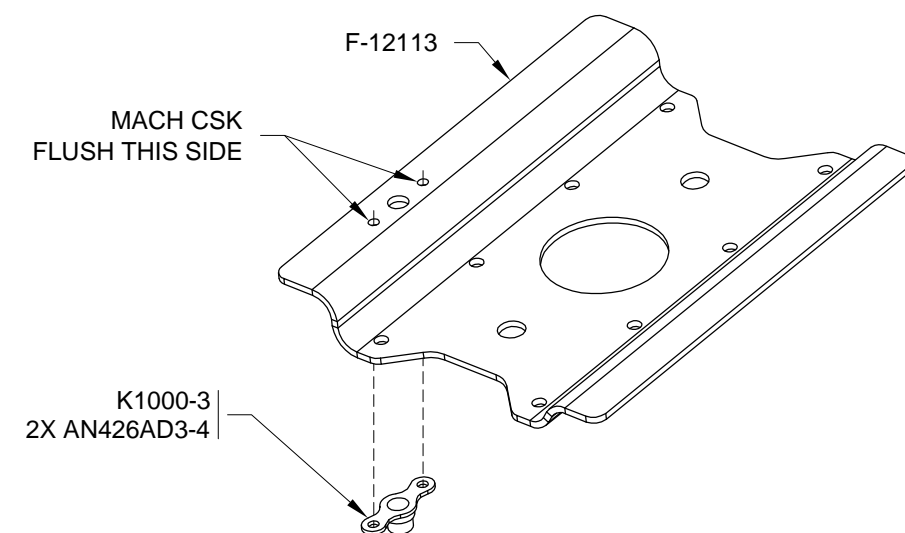


**FIGURE 3: MARKING & SEPARATING F-1268**

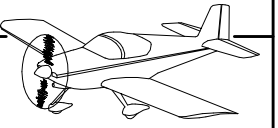
Step 6 (iS): Go to the next page.

Step 6 (ULS): Machine countersink #40 the nutplate attach holes in F-12113. See Figure 4.

Step 7: Rivet the called out nutplate to F-12113.



**FIGURE 4: RIVETING NUTPLATE**



Step 1 (iS): Go to Step 2.

Step 1 (ULS): Cleco F-12113 to F-01276-1 then match-drill using F-12113 as a guide. See Figure 1 upper Detail.

Rivet F-12113 to F-01276-1.

Step 2: Dimple the nutplate attach holes around each access hole in F-01276-1 depicted in Figure 1.

Step 3: Rivet nutplates to F-01276-1 at the locations dimpled in the previous step. See lower Detail.

Step 4: Rivet F-00020 to F-01276-1 per the call-out.

Step 5: Apply Boelube or equivalent to the stud screw threads.

Step 6: Install the six system block studs and nuts in F-01276-1 at the locations depicted in Figure 1.

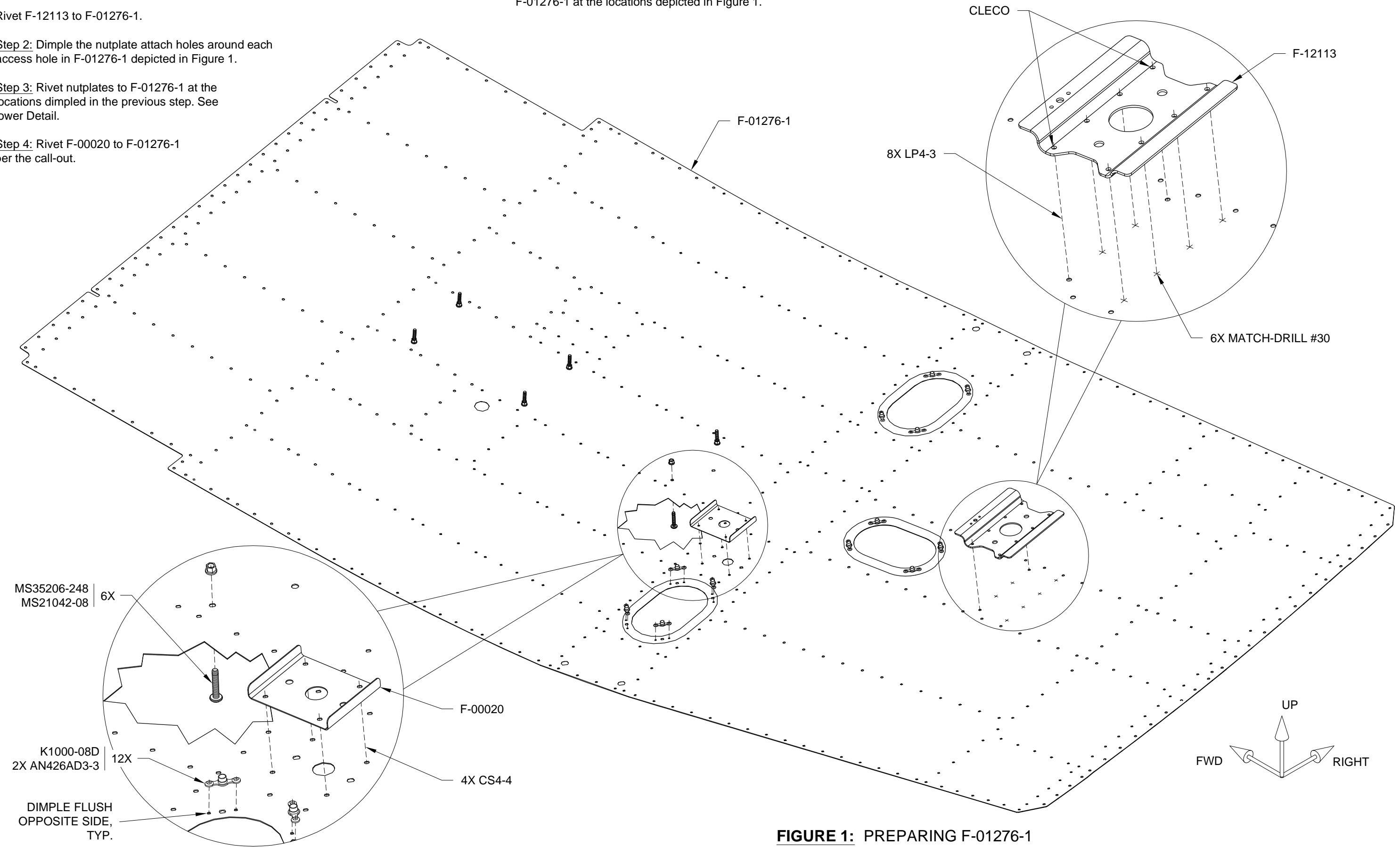
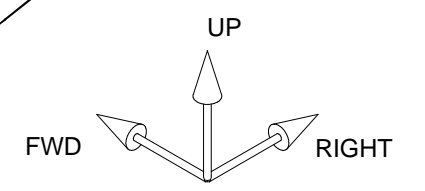
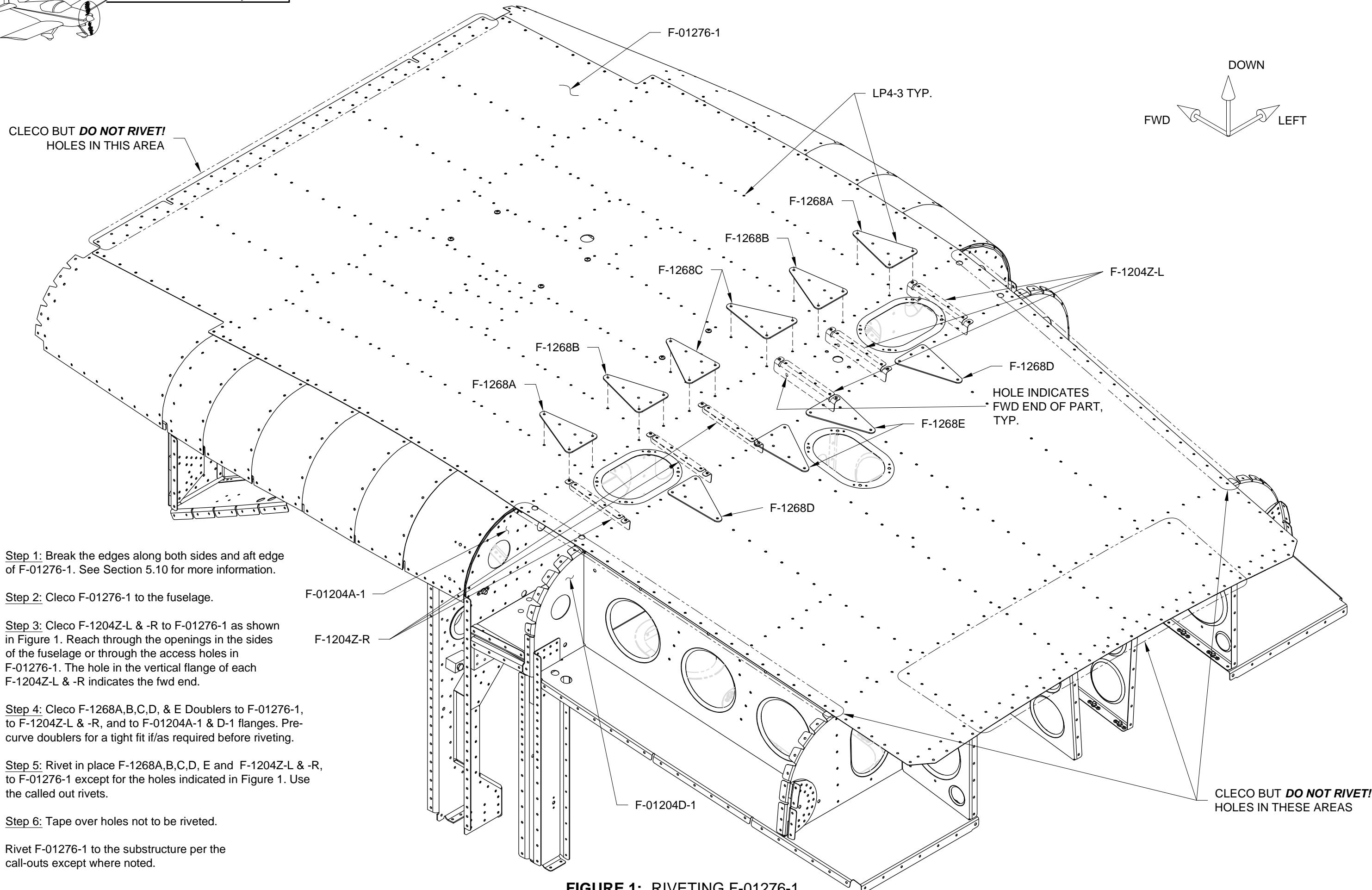
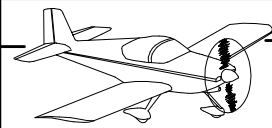


FIGURE 1: PREPARING F-01276-1





Step 1: Break the edges along both sides and aft edge of F-01276-1. See Section 5.10 for more information.

Step 2: Cleco F-01276-1 to the fuselage.

Step 3: Cleco F-1204Z-L & -R to F-01276-1 as shown in Figure 1. Reach through the openings in the sides of the fuselage or through the access holes in F-01276-1. The hole in the vertical flange of each F-1204Z-L & -R indicates the fwd end.

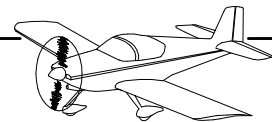
Step 4: Cleco F-1268A,B,C,D, & E Doublers to F-01276-1, to F-1204Z-L & -R, and to F-01204A-1 & D-1 flanges. Pre-curve doublers for a tight fit if/as required before riveting.

Step 5: Rivet in place F-1268A,B,C,D, E and F-1204Z-L & -R, to F-01276-1 except for the holes indicated in Figure 1. Use the called out rivets.

Step 6: Tape over holes not to be riveted.

Rivet F-01276-1 to the substructure per the call-outs except where noted.

FIGURE 1: RIVETING F-01276-1



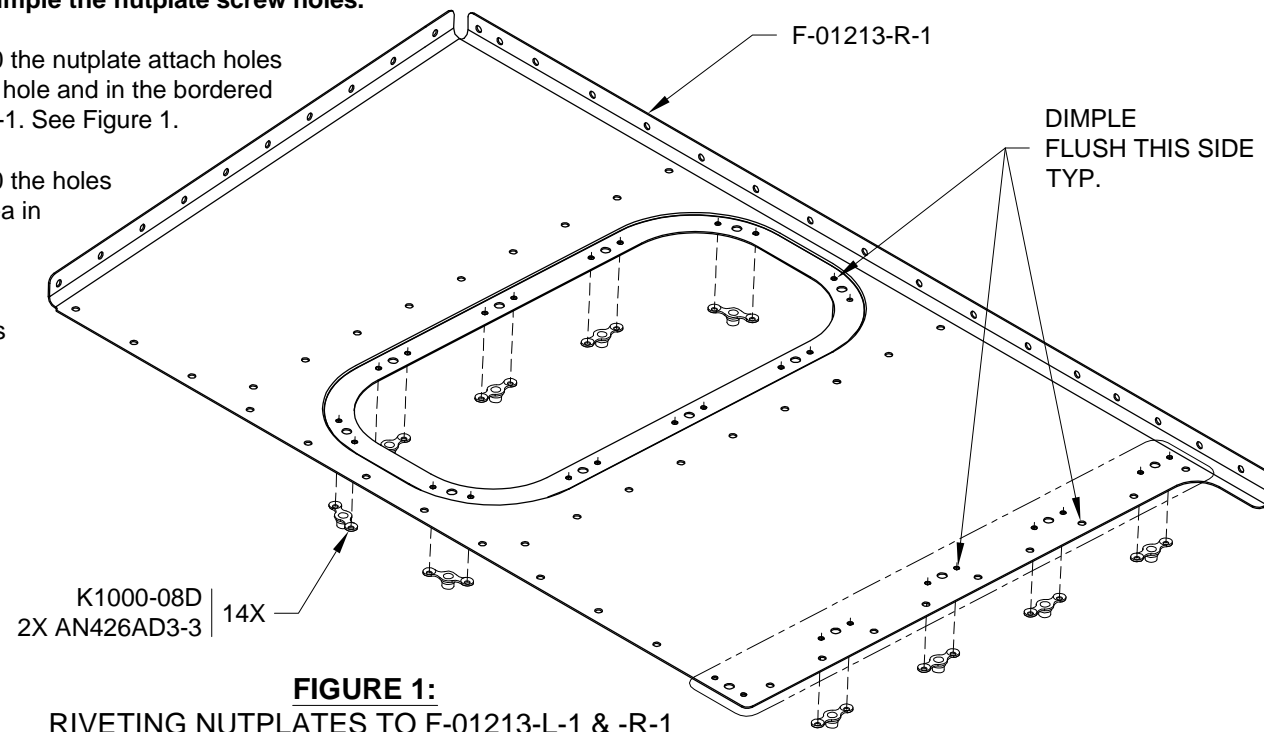
**NOTE: DO NOT** dimple the nutplate screw holes.

**Step 1:** Dimple #40 the nutplate attach holes around the access hole and in the bordered area in F-01213-R-1. See Figure 1.

**Step 2:** Dimple #30 the holes in the bordered area in F-01213-R-1.

**Step 3:** Install the called out nutplates in F-01213-R-1.

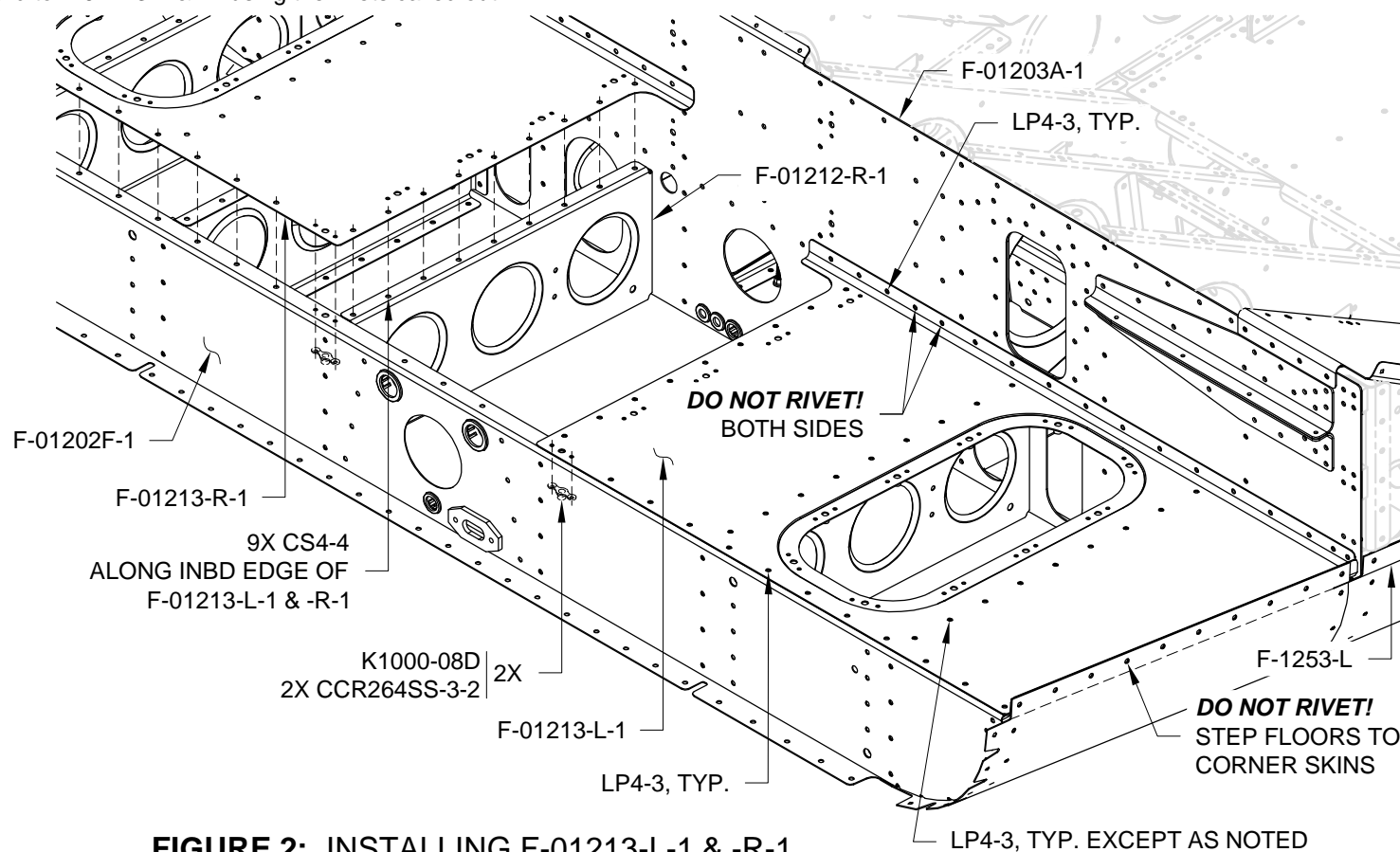
Repeat Steps 1-3 for F-01213-L-1.



**FIGURE 1:**  
RIVETING NUTPLATES TO F-01213-L-1 & -R-1

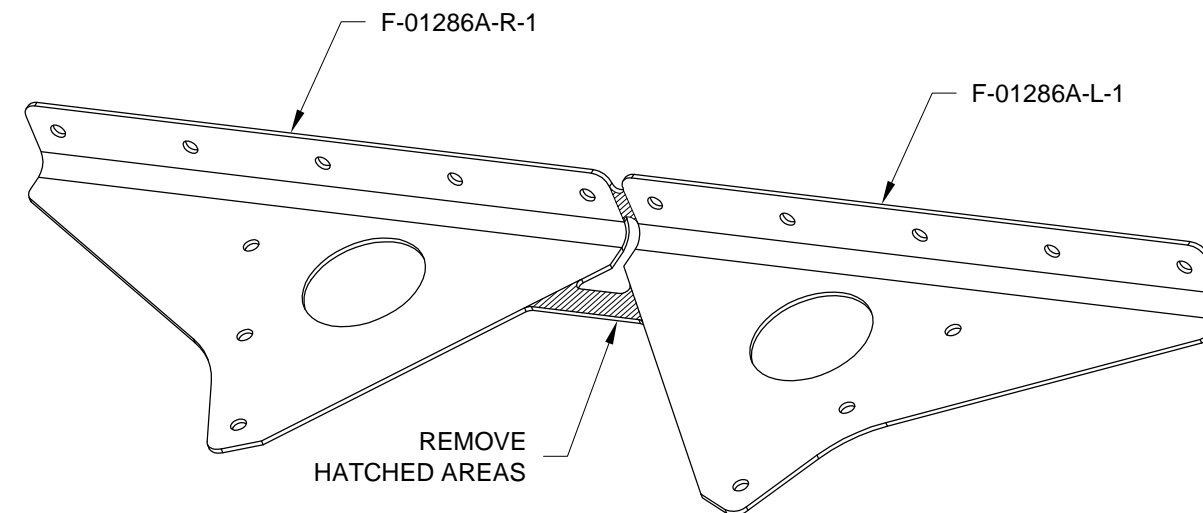
**Step 4:** Turn the fuse right side up then rivet F-01213-L-1 & -R-1 to F-01202F-1, F-01212-L-1 & -R-1, and F-01203A-1, except as noted, using the rivets called out in Figure 2. Be sure to capture the two holes in the front flange of F-1253-L & -R when riveting the two outbd holes of F-01213-L-1 & -R-1 to F-01203A-1.

**Step 5:** Reach through the lightening holes in F-01212-L-1 & -R-1 and rivet the nutplates to the top flange of F-01202F-1 and to F-01213-L & -R using the rivets called out.



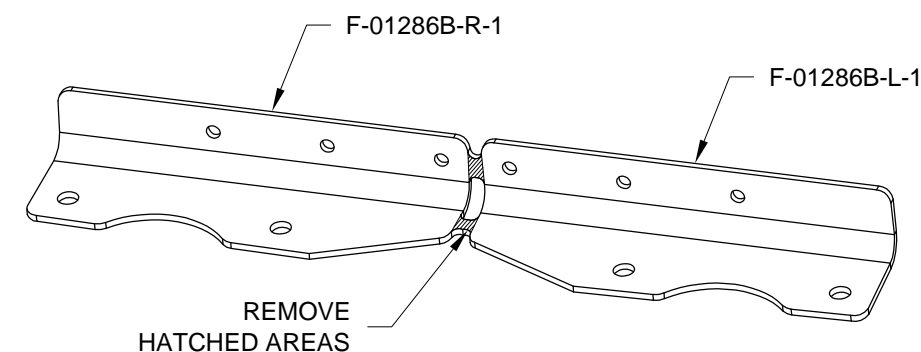
**FIGURE 2:** INSTALLING F-01213-L-1 & -R-1

**Step 6:** Separate F-01286A-1 by removing the hatched areas shown in Figure 3.



**FIGURE 3:** SEPARATING F-01286A-1

**Step 7:** Separate F-01286B-1 by removing the hatched areas shown in Figure 4.



**FIGURE 4:** SEPARATING F-01286B-1



**Step 1:** Dimple #40 the four sets of nutplate attach holes in F-01207B-1 as shown in Figure 1.

**Step 2:** Rivet the nutplates to F-01207B-1 per the call-out.

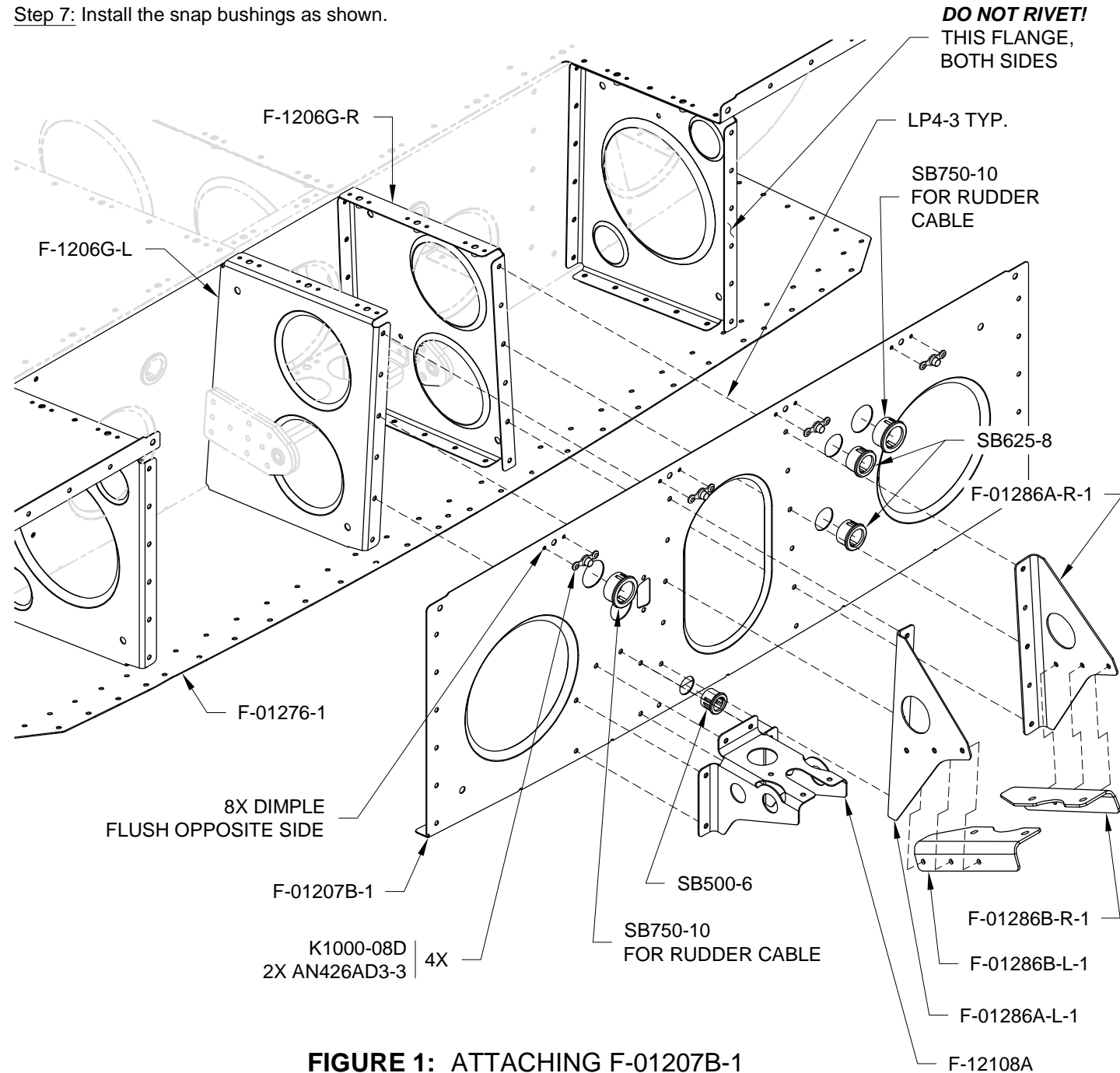
**Step 3:** Rivet F-12108A to F-01207B-1 per the call-out.

**Step 4:** Cleco F-01207B-1 in place on the ribs shown, then rivet F-01286A-L-1 & -R-1 to F-01207B-1 and to F-1206G-L & -R. DO NOT rivet F-01207B-1 to the outboard ribs as noted.

**Step 5:** Rivet F-01286B-L-1 to F-01286A-L-1 as shown.

**Step 6:** Rivet F-01286B-R-1 to F-01286A-R-1 as shown.

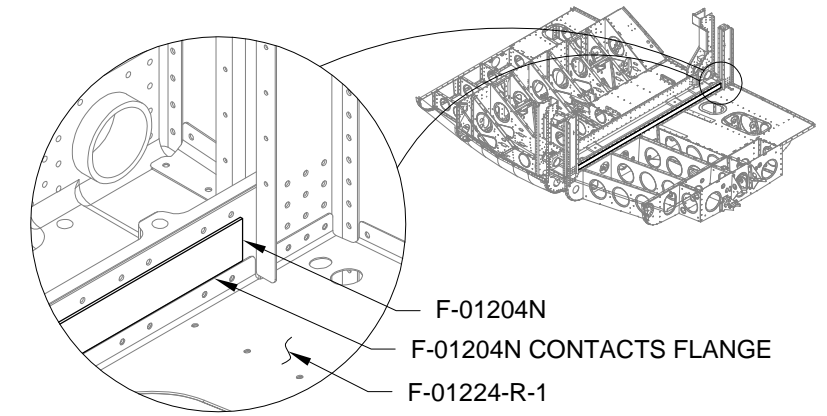
**Step 7:** Install the snap bushings as shown.



**FIGURE 1: ATTACHING F-01207B-1**

**Step 8:** Clean the region of the aft center section bulkhead in which the F-01204N Fuel Tank Pad will be placed. See Figure 2 and Page 21iS/U-01.

Remove the adhesive backing from F-01204N and position it horizontally centered (side-to-side), and vertically contacting the edge of the F-01224-L-1 and -R-1 Baggage Floor flanges as shown. Press firmly for a good bond.



**FIGURE 2: ATTACHING F-01204N**