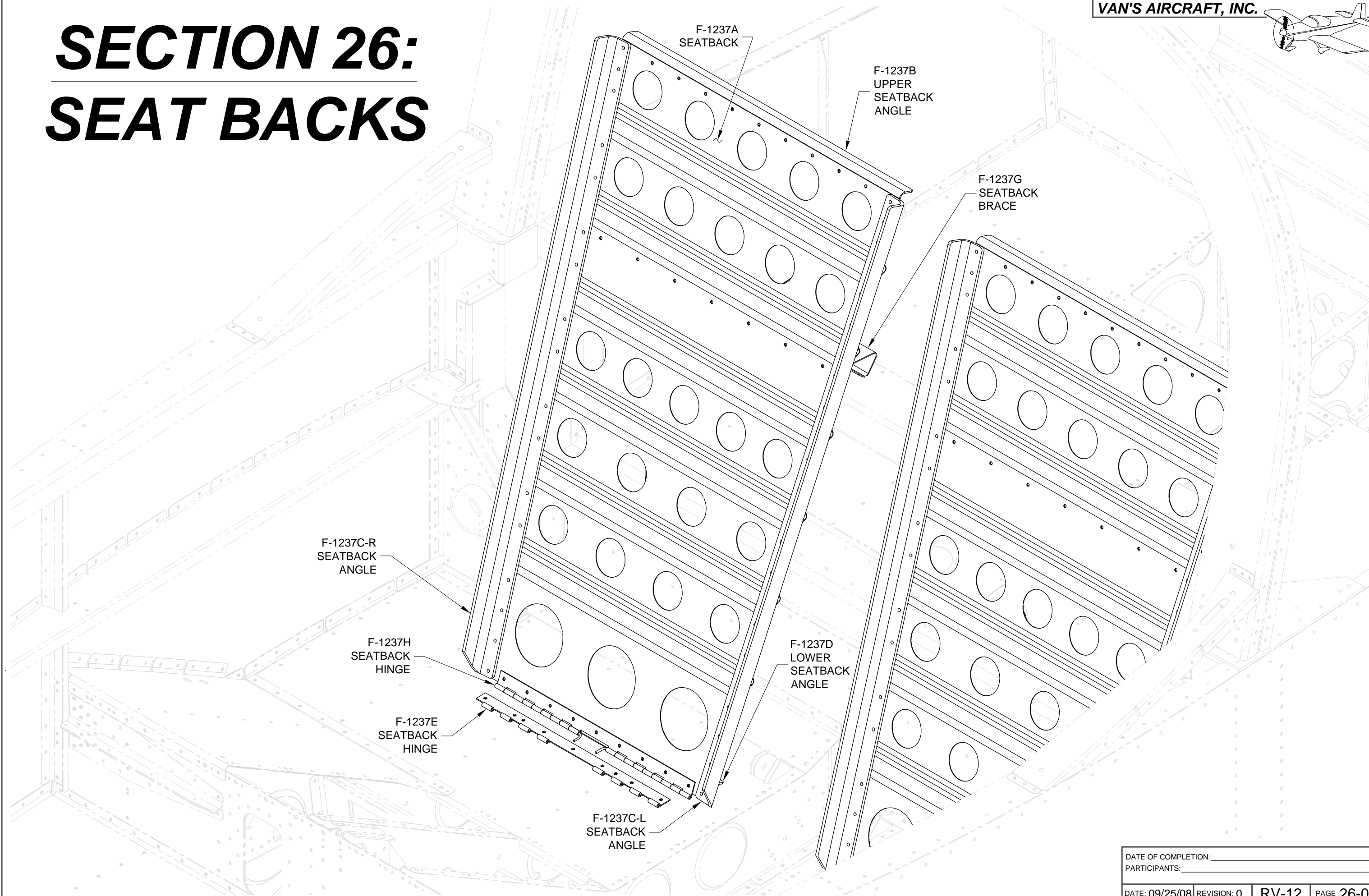




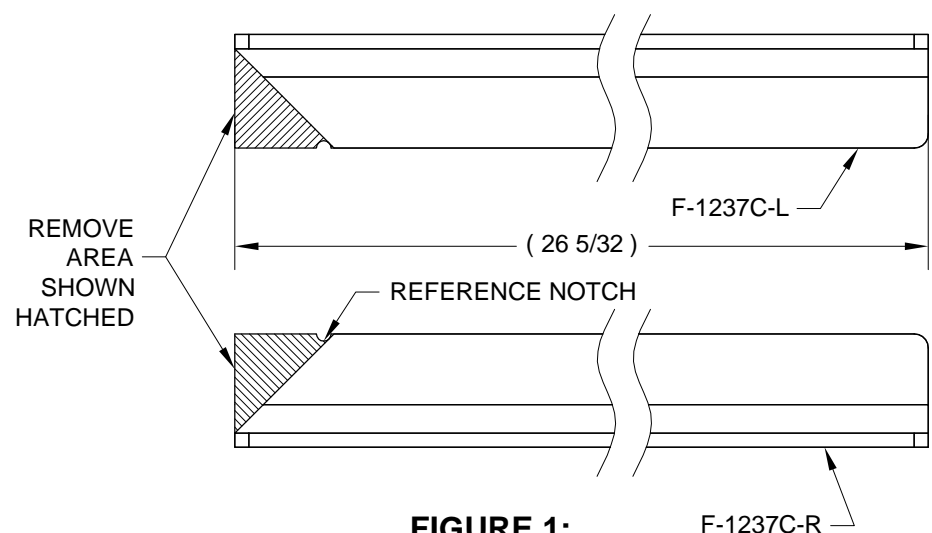
# SECTION 26: SEAT BACKS



DATE OF COMPLETION: \_\_\_\_\_  
PARTICIPANTS: \_\_\_\_\_

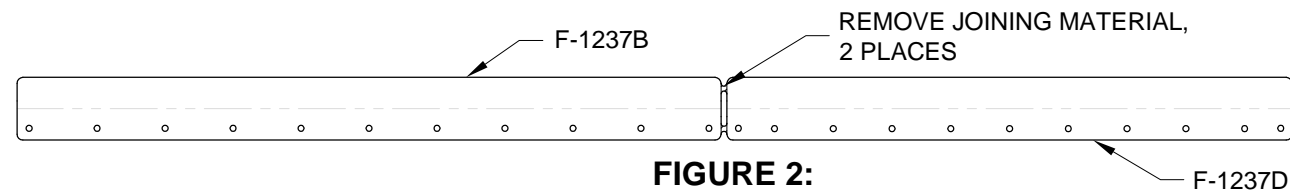
**NOTE:** The instructions in this section pertain to the assembly of one seatback only. Unless otherwise specified, all instructions given for one seatback apply to both. To help prevent mistakes and speed up the construction process, assemble both seatbacks at the same time.

**Step 1:** Trim the bottom corners of F-1237C-L and F-1237C-R Seatback Angles to the reference notch as shown in Figure 1.



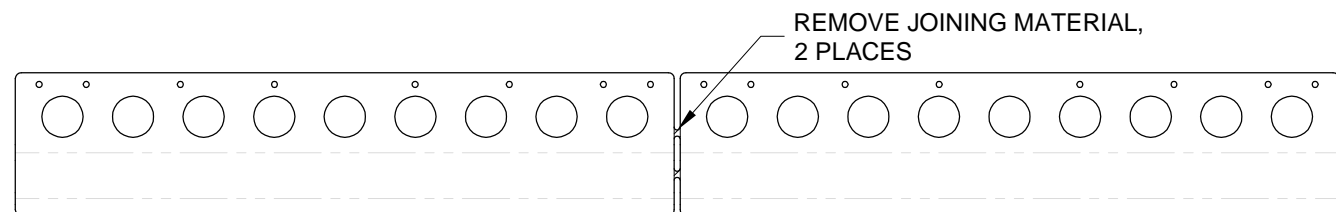
**FIGURE 1:**  
SEATBACK ANGLE TRIMMING

**Step 2:** Remove the joining material of the F-1237BD Seatback Angle (shown unbent) to separate the F-1237B Upper Seatback Angle, and the F-1237D Lower Seatback Angle called out in Figure 2.



**FIGURE 2:**  
F-1237BD SEATBACK ANGLE SEPARATION

**Step 3:** Separate the F-1237G Seatback Braces (shown unbent) by removing the joining material called out in Figure 3.

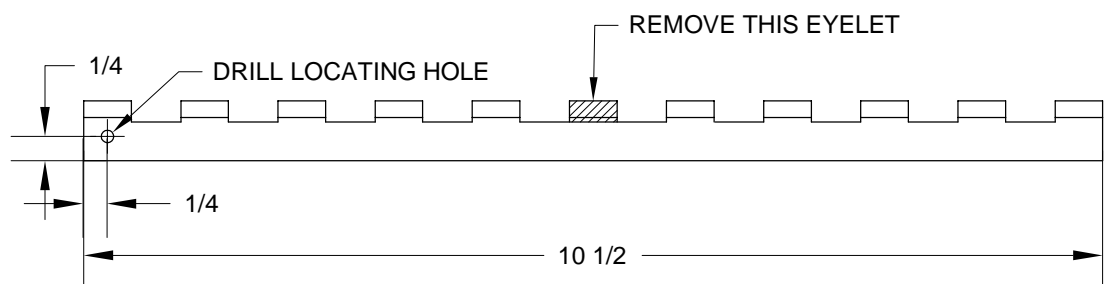


**FIGURE 3:**  
F-1237G SEATBACK BRACE SEPARATION

**Step 4:** Pull the hinge pin from an AN257-P3 hinge. Set the pin aside to be used on Page 26-04.

**Step 5:** From the AN257-P3 hinge halves, make an F-1237H Seatback Hinge using the dimension given, and remove the center eyelet as shown in Figure 4.

**Step 6:** Drill a #30 locating hole in the F-1237H Seatback Hinge using the dimensions given in Figure 4.

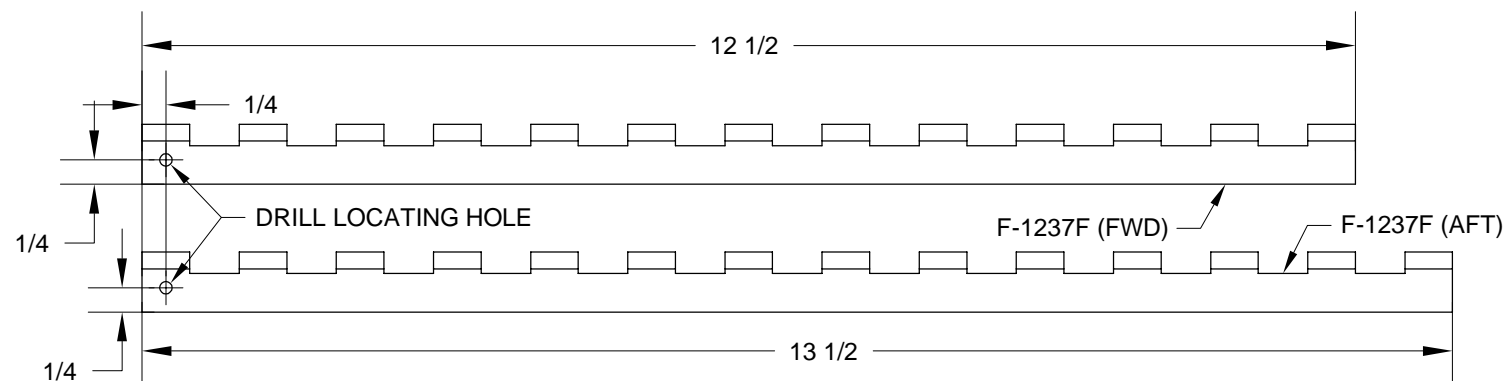


**FIGURE 4:**  
F-1237H SEATBACK HINGE PREPARATION

**Step 7:** Remove the hinge pin from an AN257-P2 hinge. Set the pin aside to be used on Page 26-04.

**Step 8:** From the AN257-P2 hinge halves, make the F-1237F Fwd and Aft Seatback Brace Hinges per dimensions given in Figure 5.

**Step 9:** Drill a #30 locating hole in the F-1237F Fwd and Aft Seatback Brace Hinges using the dimensions called out in Figure 5.

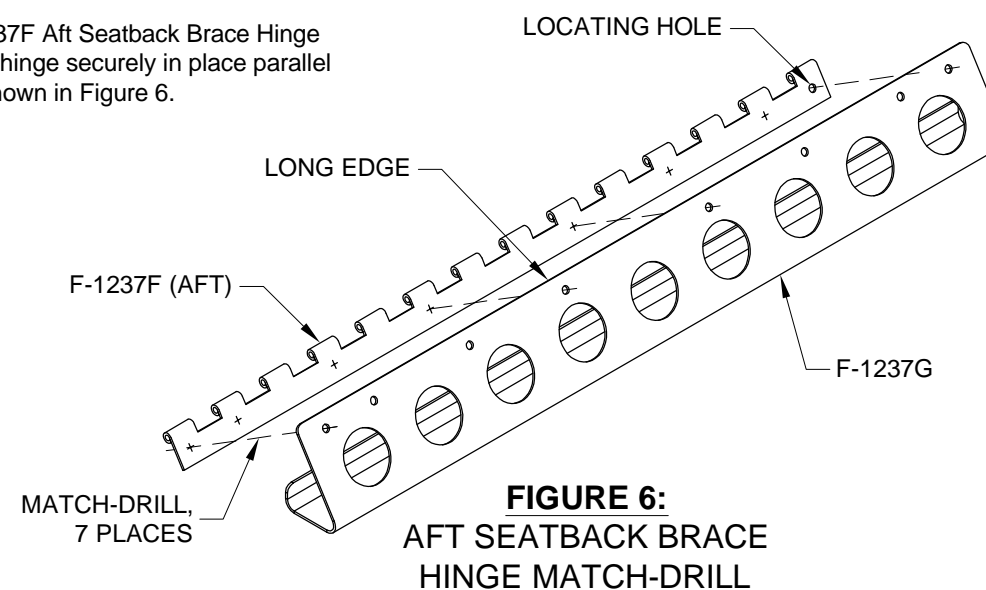


**FIGURE 5:**  
F-1237F FWD AND AFT  
SEATBACK BRACE HINGES

**Step 10:** Cleco the locating hole of the F-1237F Aft Seatback Brace Hinge to the F-1237G Seatback Brace. Clamp the hinge securely in place parallel to the long edge of the seatback brace as shown in Figure 6.

**Step 11:** Match-Drill #30 the holes from the F-1237G Seatback Brace into the F-1237F Aft Seatback Brace Hinge.

Mark parts, disassemble and deburr, cleco back together.

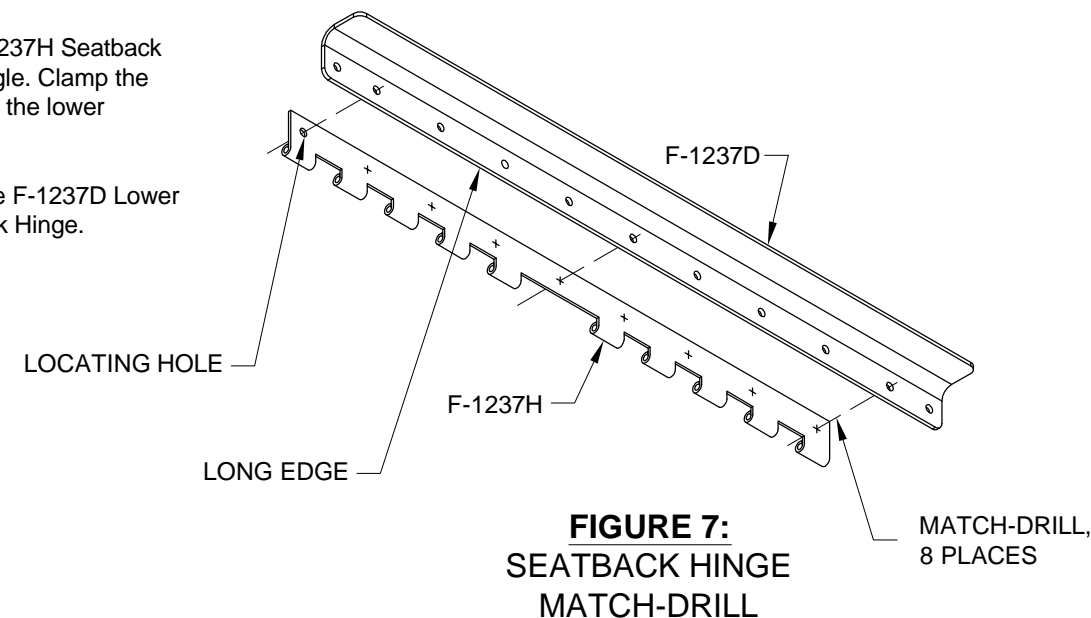


**FIGURE 6:**  
AFT SEATBACK BRACE  
HINGE MATCH-DRILL

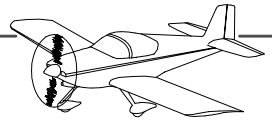
**Step 12:** Cleco the locating hole in the F-1237H Seatback Hinge to the F-1237D Lower Seatback Angle. Clamp the seatback hinge parallel to the long edge of the lower seatback angle as shown in Figure 7.

**Step 13:** Match-Drill #30 the holes from the F-1237D Lower Seatback Angle into the F-1237H Seatback Hinge.

Mark parts, disassemble and deburr, then cleco back together.



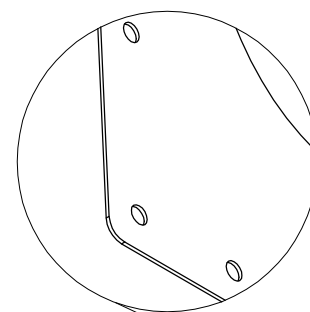
**FIGURE 7:**  
SEATBACK HINGE  
MATCH-DRILL



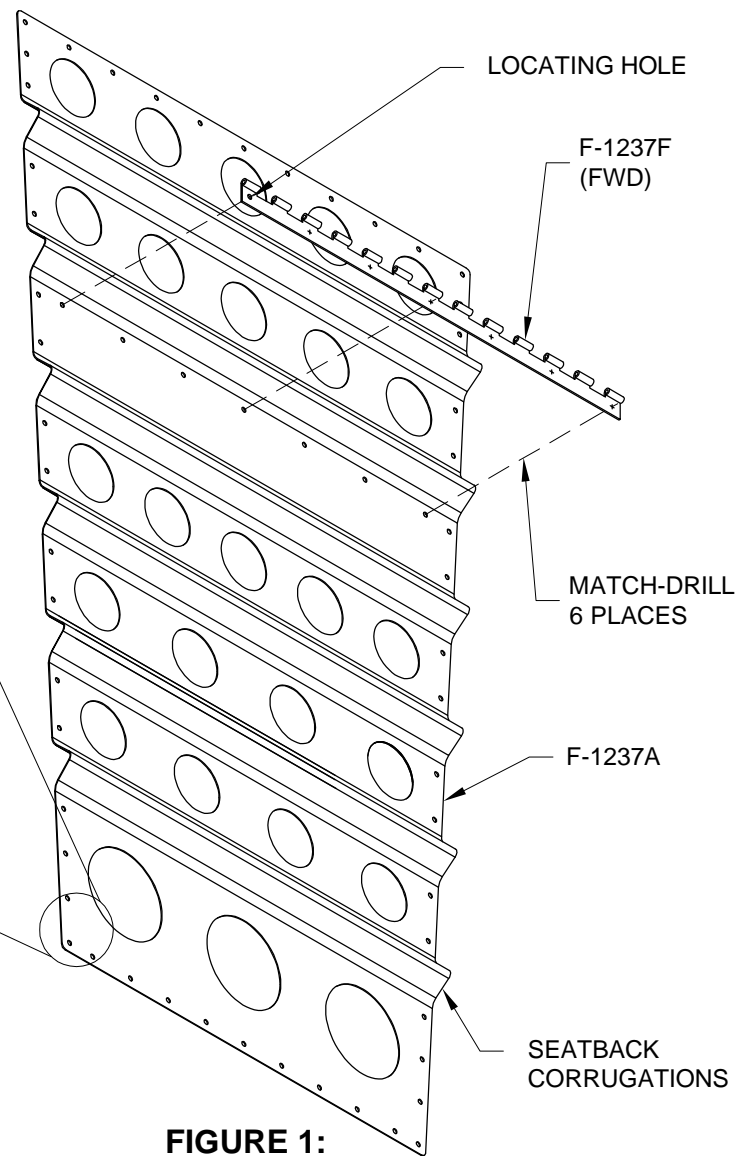
Step 1: Cleco the locating hole of the F-1237F Fwd Seatback Brace Hinge to the F-1237A Seatback at the location shown in Figure 1. Clamp the hinge parallel to the seatback corrugations.

Step 2: Match-Drill #30 the holes from the F-1237A Seatback into the F-1237F Fwd Seatback Brace Hinge.

Mark parts, disassemble and deburr, cleco back together.



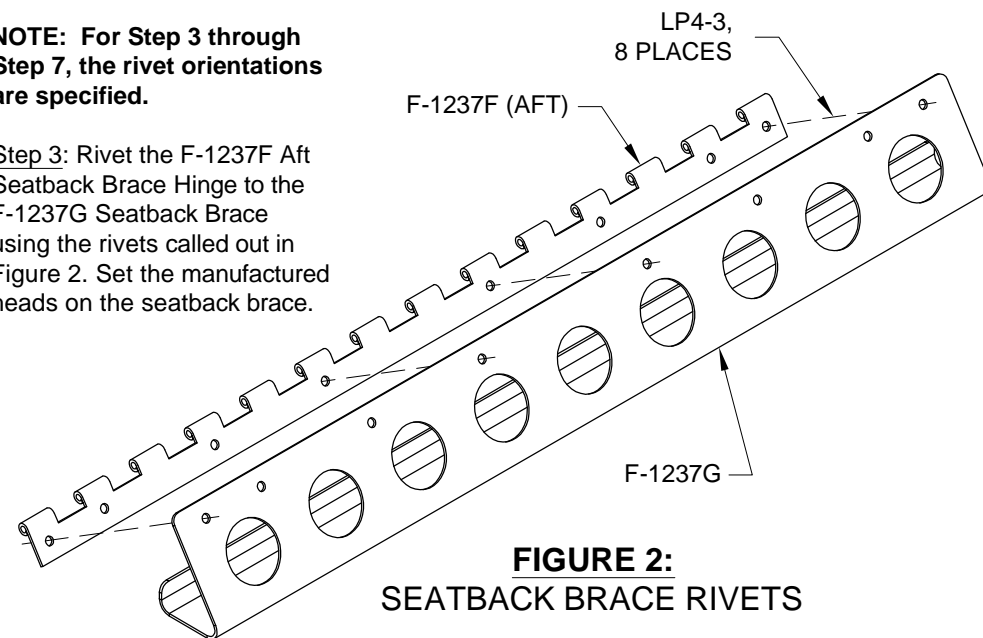
**DETAIL ORIENTATION**



**FIGURE 1:**  
SEATBACK BRACE HINGE MATCH-DRILL

**NOTE: For Step 3 through Step 7, the rivet orientations are specified.**

Step 3: Rivet the F-1237F Aft Seatback Brace Hinge to the F-1237G Seatback Brace using the rivets called out in Figure 2. Set the manufactured heads on the seatback brace.



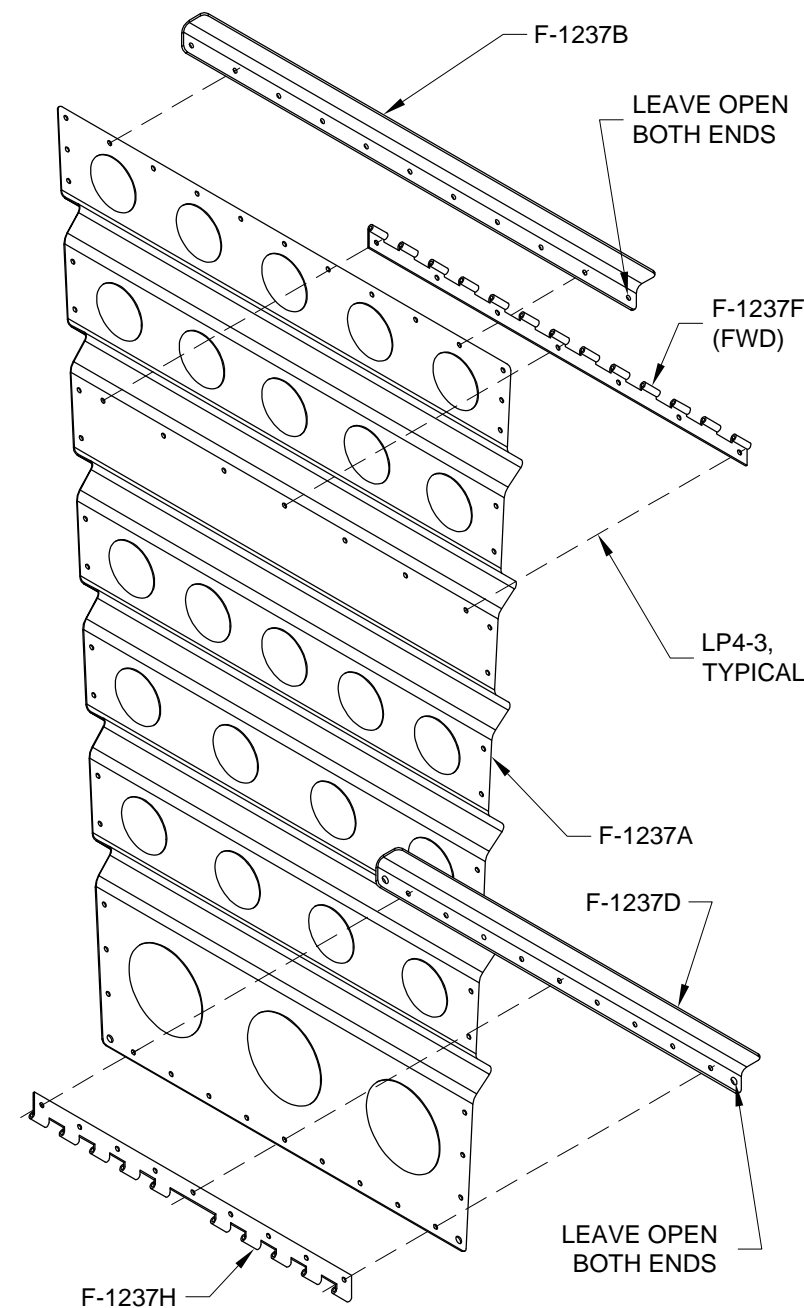
**FIGURE 2:**  
SEATBACK BRACE RIVETS

Step 4: Cleco the F-1237B Upper, F1237D Lower, and F-1237C-L & -R Seatback Angles to the F-1237A Seatback as shown in Figure 3 & 4. Final-Drill #12 the hole in each lower corner common to the left or right AND the lower seatback angles and seatback called out in Figure 4. Disassemble and deburr.

Step 5: Rivet the F-1237B Upper Seatback Angle to the top row of holes in the F-1237A Seatback per call-out in Figure 3. Set the manufactured heads on the seatback. Leave open the first hole at both ends of the upper seatback angle.

Step 6: Rivet the F-1237F Fwd Seatback Brace Hinge to the F-1237A Seatback using the rivets called out in Figure 3. Set the manufactured heads on the seatback.

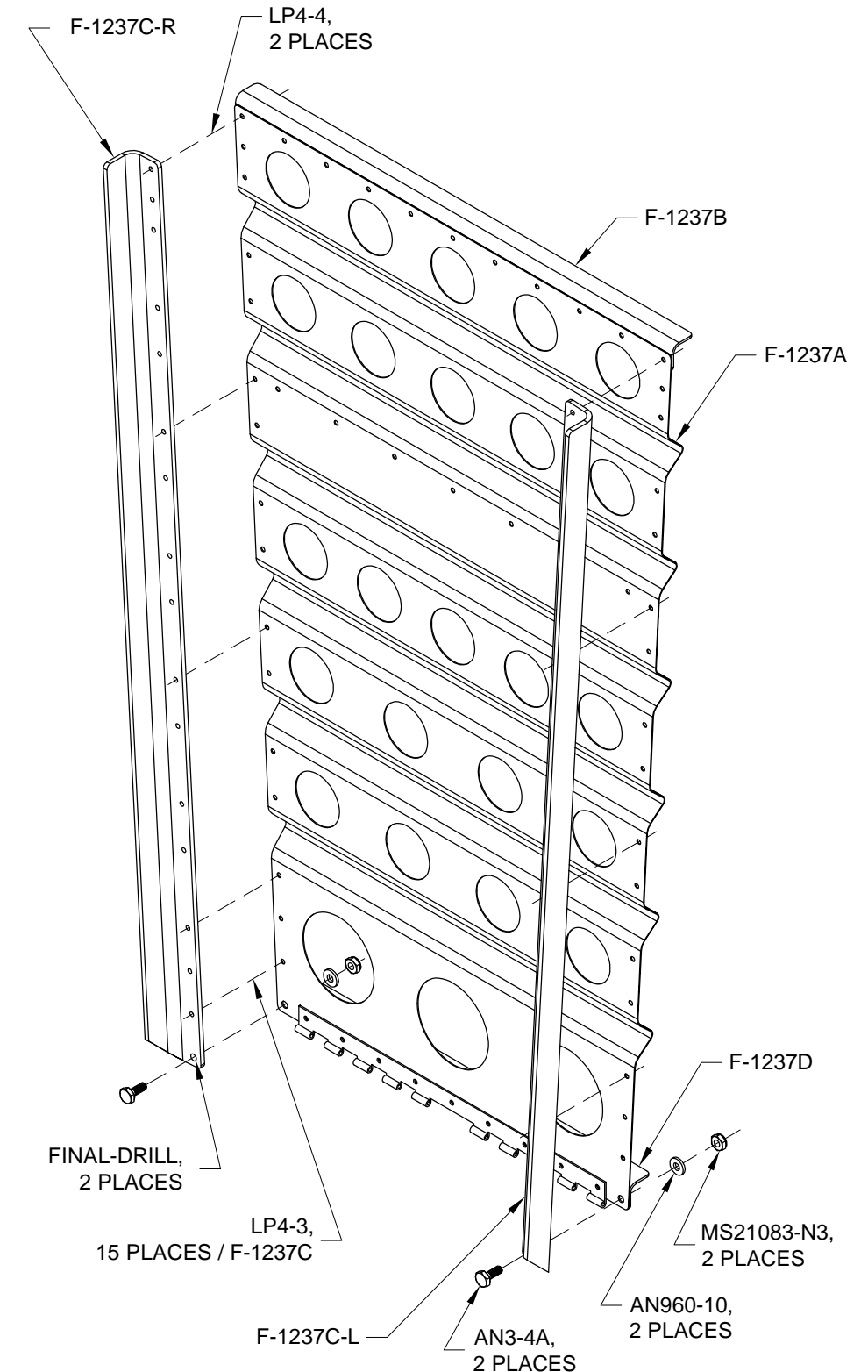
Step 7: Rivet the F-1237D Lower Seatback Angle and the F-1237H Seatback Hinge to the F-1237A Seatback per call-out in Figure 3. Set the manufactured heads on the seatback hinge. Leave open the first hole at both ends of the lower seatback angle.



**FIGURE 3:**  
SEATBACK RIVETS

Step 8: Rivet the F-1237C-L & -R Seatback Angles to the F-1237A Seatback using the rivets called out in Figure 4. In each lower corner hole use hardware called out in Figure 4. Set the manufactured heads on the seatback angles.

Hereafter refer to this assembly as the Seatback Assembly.



**FIGURE 4:**  
SEATBACK HARDWARE

**NOTE:** The hinge pins that will be used for the steps on this page were set aside on Page 26-02, Step 4 and Step 7.

**Step 1:** Cut a 14 1/2 inch length of hinge pin. Make a one inch long, 90° bend at one of the ends. File the other end of the hinge pin to make a dull point.

**Step 2:** Attach the F-1237G Seatback Brace to the back of the Seatback Assembly, by inserting the 14 1/2 inch hinge pin through the F-1237F Fwd and Aft Hinges as shown in Figure 1.

**Step 3:** Drill #52 a hole in the F-1237G Seatback Brace next to the bend at the end of the hinge pin as shown in Figure 1.

**Step 4:** Secure the bent end of the hinge pin using safety wire through the #52 hole.

SEATBACK ASSEMBLY

F-1237F (FWD AND AFT)

F-1237G

14 1/2 INCH HINGE PIN

DRILL

**FIGURE 1:**  
SEATBACK BRACE INSTALLATION

**Step 5:** Cut two 5 1/2 inch lengths of hinge pin. Make a one inch long, 90° bend at one end of each pin. File the other end of each hinge pin to make a dull point.

**Step 6:** Using the 5 1/2 inch hinge pins, secure the Seatback Assembly to either the forward or aft F-1237E Seatback Hinge as shown in Figure 2.

SEATBACK ASSEMBLY

F-1237H

F-1237E

5 1/2 INCH HINGE PINS

**FIGURE 2:**  
SECURING THE SEAT BACK ASSEMBLY