

CAUTION: In Step 1 deburr only enough to locate the bushing.

Step 1: Rivet the F-1211D Attach Brackets together per Figure 1. Deburr the 1/4 in. holes per call-outs. Install the bushing (oversize before press fit) as shown. If necessary use a C-clamp with a small socket opposite the bushing.

Step 2: Flute the F-1211A Fuselage Bulkhead as called out in Figure 2 only enough to reduce the slight pucker in the flange. Cracking may result from excessive force.

Step 3: Cleco the F-1211B Bulkhead Doubler to the F-1211A Fuselage Bulkhead as shown in Figure 2.

Step 4: Cleco the F-1211G Tail Skid Bracket to the F-1211A Fuselage Bulkhead as shown in Figure 2. Clamp the tail skid bracket in place.

Step 5: Match-Drill #30 the holes of the F-1211B Bulkhead Doubler into the F-1211G Tail Skid Bracket. Remove the tail skid bracket and deburr the holes.

Step 6: Final-Drill #12 the 3/16 holes called out in Figure 2. Disassemble, deburr, clear away chips, and re-cleco in place.

Step 7: Cleco the F-1211G Tail Skid Bracket and the F-1211D Attach Brackets (with bushing flange on the outboard side) to the F-1211A Fuselage Bulkhead and F-1211B Bulkhead Doubler.

Step 8: Rivet the F-1211A Fuselage Bulkhead to the F-1211B Bulkhead Doubler, using the rivets indicated in Figure 2.

Step 9: Rivet the F-1211D Attach Brackets and F-1211G Tail Skid Bracket to the F-1211 Assembly using the rivets indicated in Figure 2.

Hereafter refer to the F-1211A Fuselage Bulkhead and the F-1211B Bulkhead Doubler as the F-1211 Assembly.

Step 10: Rivet the nutplates to the F-1211 Assembly as shown using hardware indicated in Figure 2.

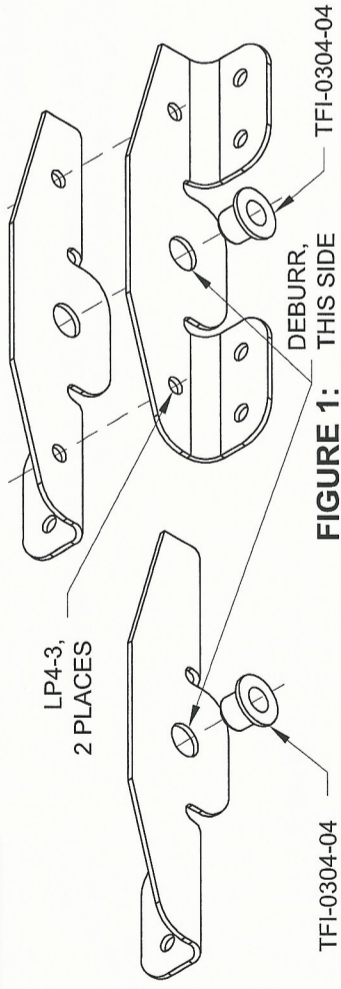


FIGURE 1:
F-1211D PREPARATION

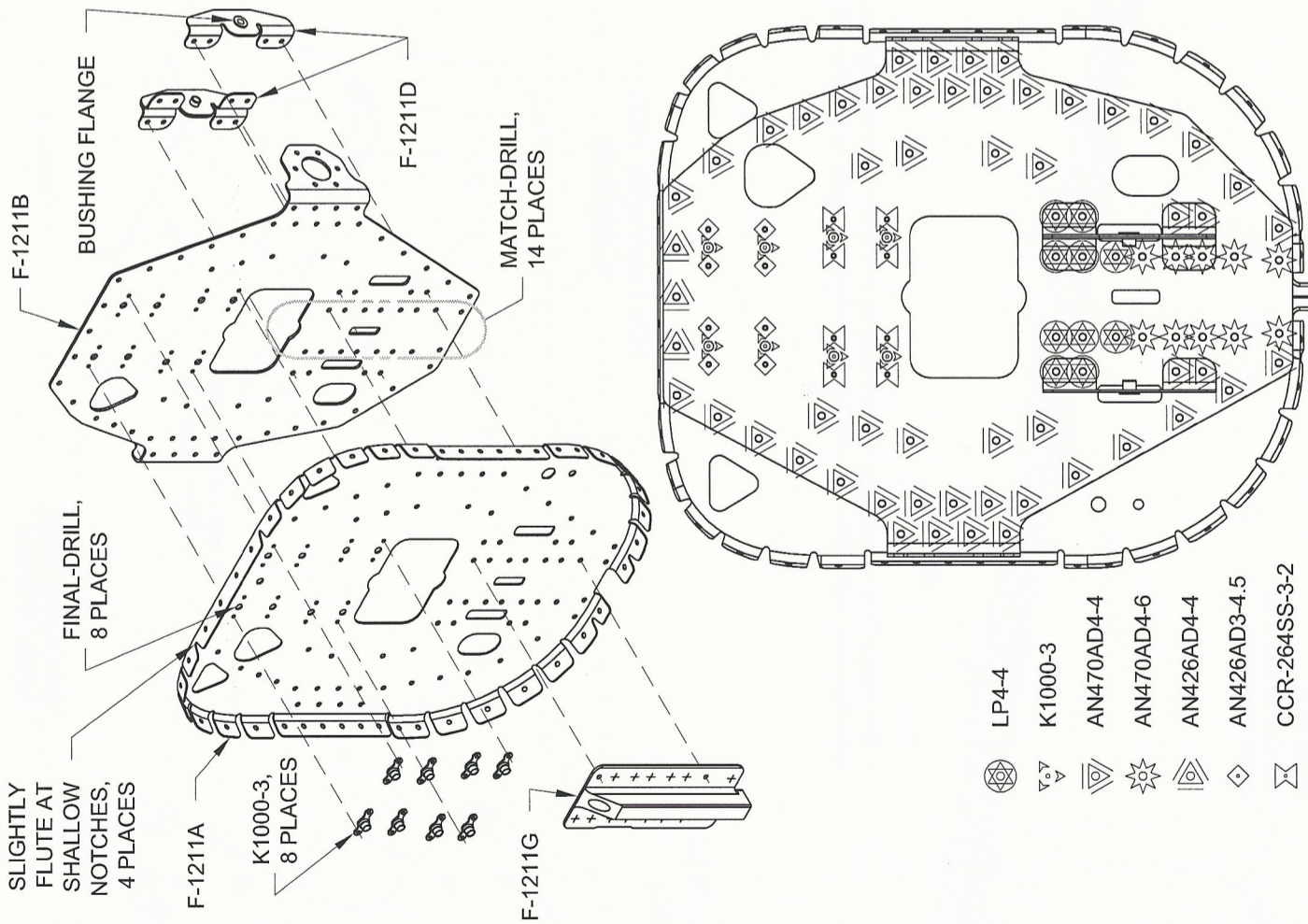


FIGURE 2:
F-1211 ASSEMBLY

Step 11: Cleco the F-1211C-L & -R Hinge Brackets and the VA-146 Flange Bearings to the F-1211 Assembly as shown in Figure 3.

Step 12: Final-Drill #30 the holes common to the F-1211C-L & -R Hinge Brackets, the VA-146 Flange Bearings, and the F-1211 Assembly. Cleco each hole before drilling the next. Disassemble, deburr, then re-cleco in place.

Step 13: Rivet the F-1211C-L & -R Hinge Brackets and the VA-146 Flange Bearings to the F-1211 Assembly as shown in Figure 3.

Step 14: Insert the snap bushing into the F-1211 Assembly called out in Figure 3.

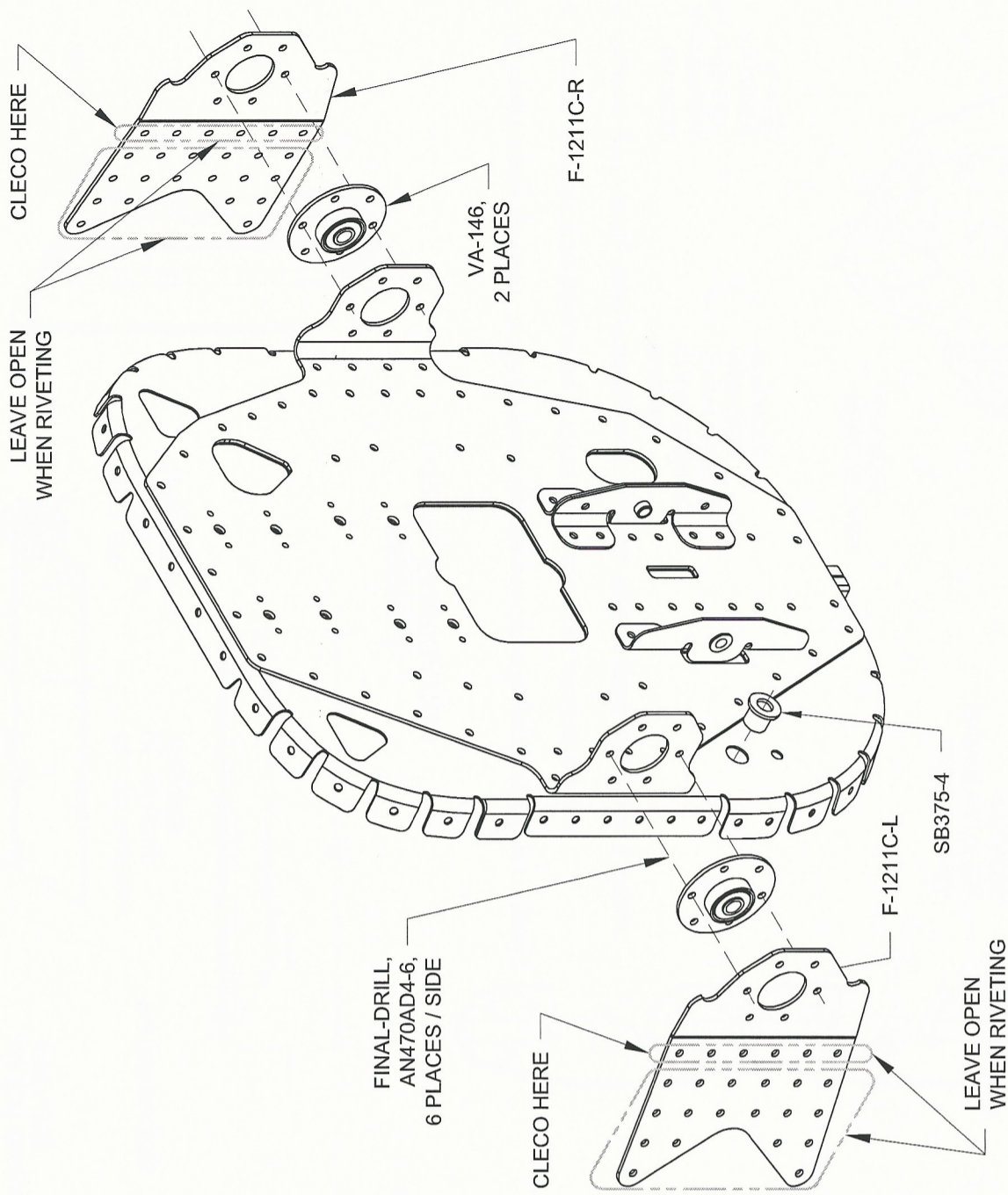


FIGURE 3:
BUSHINGS AND HINGE BRACKETS