



Step 1: Place the F-1282-L & -R Bottom Left and Right Skins on a flat surface.

Step 2: Trim the called out material from the F-1282-L Bottom Left Skin as shown in Figure 1.

REMOVE MATERIAL SHOWN HATCHED

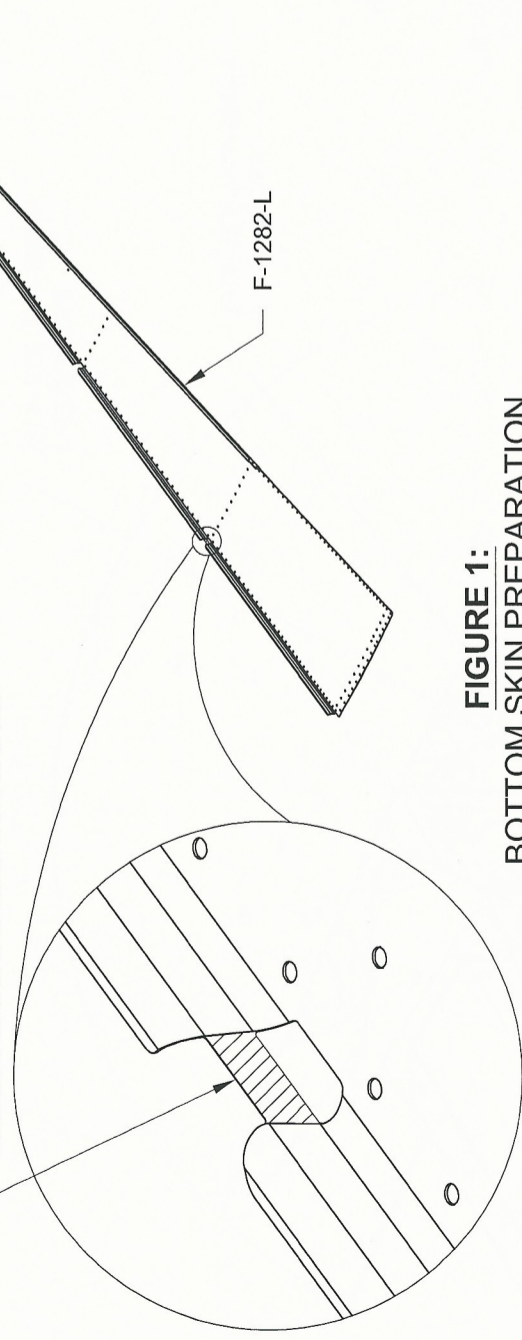


FIGURE 1:
BOTTOM SKIN PREPARATION

Step 3: Rivet the F-1284-L & -R Shear Clips to the F-1283A & B J-Stiffeners using rivets called out in Figure 2.

Step 4: Cleco the F-1283A & B J-Stiffeners to the F-1282-L & -R Bottom Left and Right Skins.

Step 5: Match-Drill #30 the holes in each of the F-1282-L & -R Bottom Left and Right Skins into the F-1283A & B J-Stiffeners called out in Figure 2.

Remove, clear away chips, deburr and re-cleco.

Step 6: Rivet the F-1283A & B J-Stiffeners only to the J-stiffener of the F-1282-L & -R Bottom Left and Right Skins using rivets called out in Figure 2.

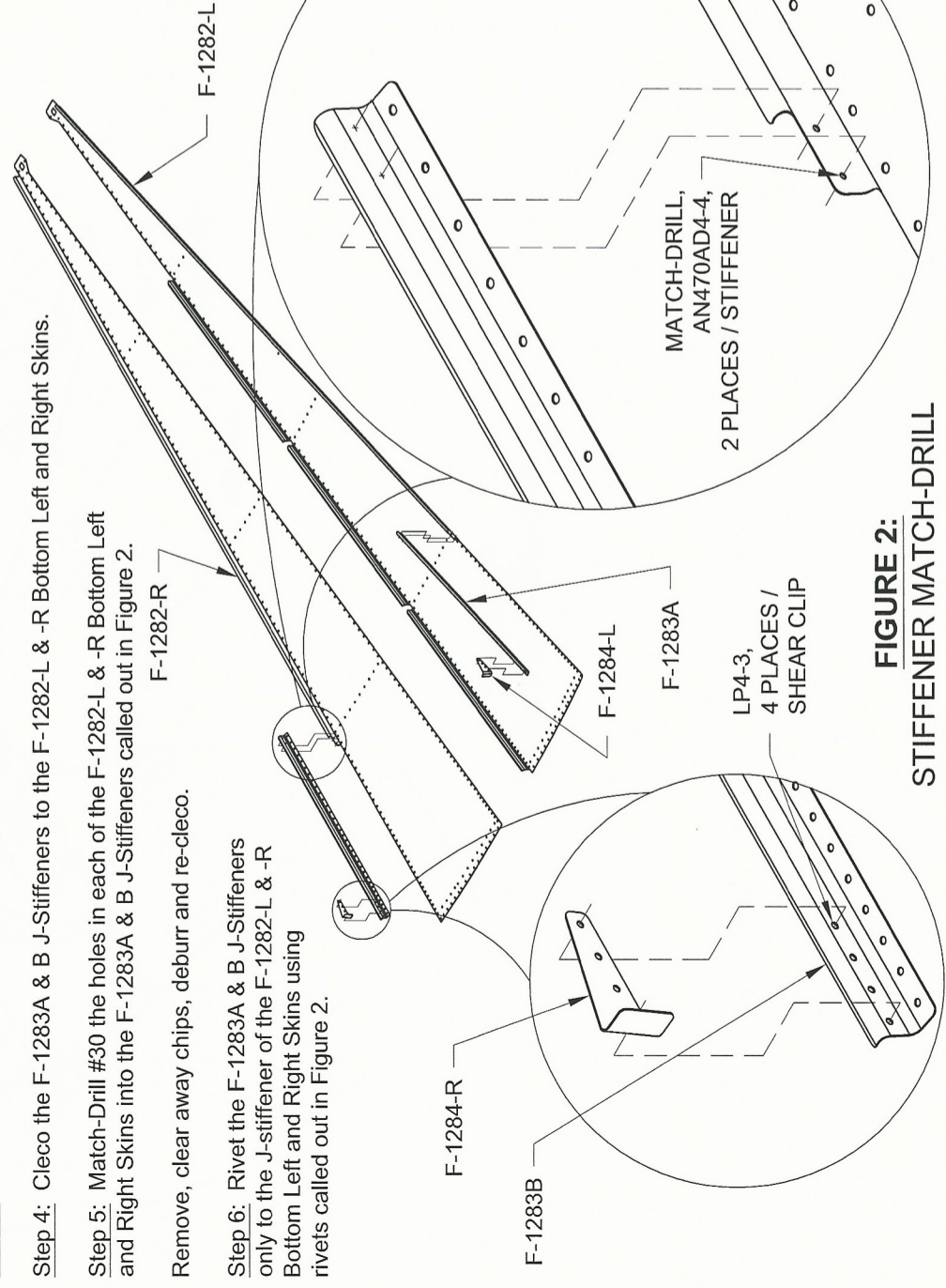


FIGURE 2:
STIFFENER MATCH-DRILL

Step 7: Place the F-1282-L Bottom Left Skin upside down across two sawhorses that are at least 38 inches tall. Locate the forward sawhorse just forward of where the F-1208 Frame will be, and the rear sawhorse just aft of where the F-1210 Frame will be. See Figure 3.

Step 8: Hook the J-stiffener cutout of the F-1208, F-1209 and F-1210 Frames onto the J-stiffener of the F-1282-L Bottom Left Skin. Cleco each fuse frame to the left bottom skin.

Step 9: Hook the J-stiffener of the F-1282-R Bottom Right Skin into the J-stiffener cutout of the F-1208, F-1209 and F-1210 Frames. If the J-stiffeners interfere with J-stiffener cutouts in the fuse frames, either the J-stiffeners can be bent or the J-stiffener cutouts in the frames can be enlarged slightly until the J-stiffeners clear. Cleco the bottom right skin to the F-1282-L Bottom Left Skin and frames.

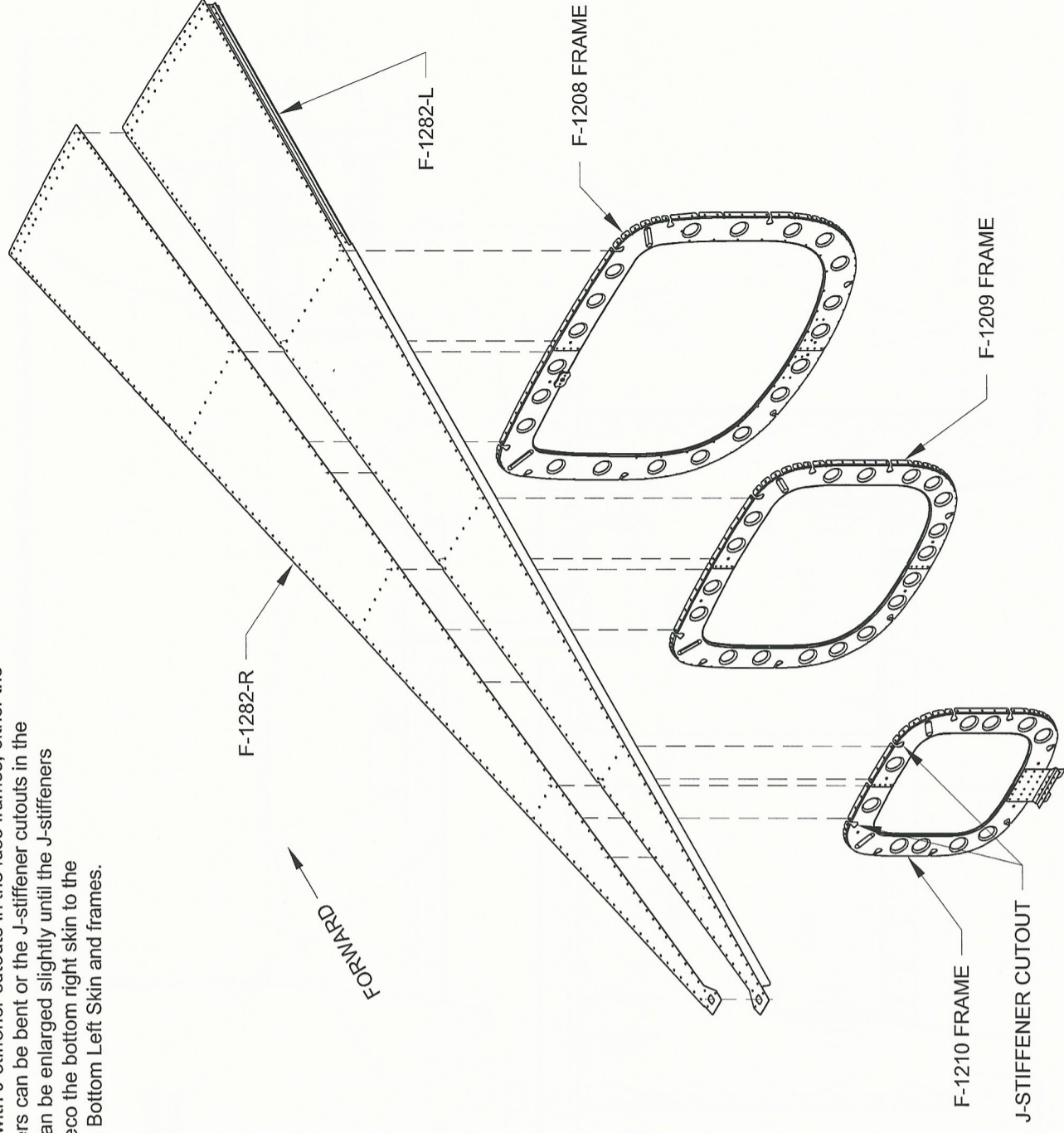


FIGURE 3:
BOTTOM SKIN INSTALLATION