



Step 1: Hook the J-stiffeners of the F-1281-L & -R Lower Left and Right Skins into the cutouts in the F-1208, F-1209 and F-1210 Frames. Cleco the lower skins to the frames and F-1282-L & -R Bottom Left and Right Skins. Capture the F-1283A & B J-Stiffeners with the bottom and lower left and right skins.

Step 2: Place masking tape over all of the holes that are within seven inches of the forward edge of each tailcone skin. Those holes will be left open for the remainder of this section.

Step 3: Rivet the F-1282-L & -R Bottom Left and Right Skins together. Rivet the F-1208, F-1209 and F-1210 Frames to the bottom left and right skins. Rivet the F-1281-L & -R Lower Left and Right Skins only to the bottom left and right skins, and the F-1283A & B J-Stiffeners using rivets called out in Figure 1. Leave open all remaining holes in the lower left and right skins.

LEAVE OPEN
AFT HOLES,
16 PLACES

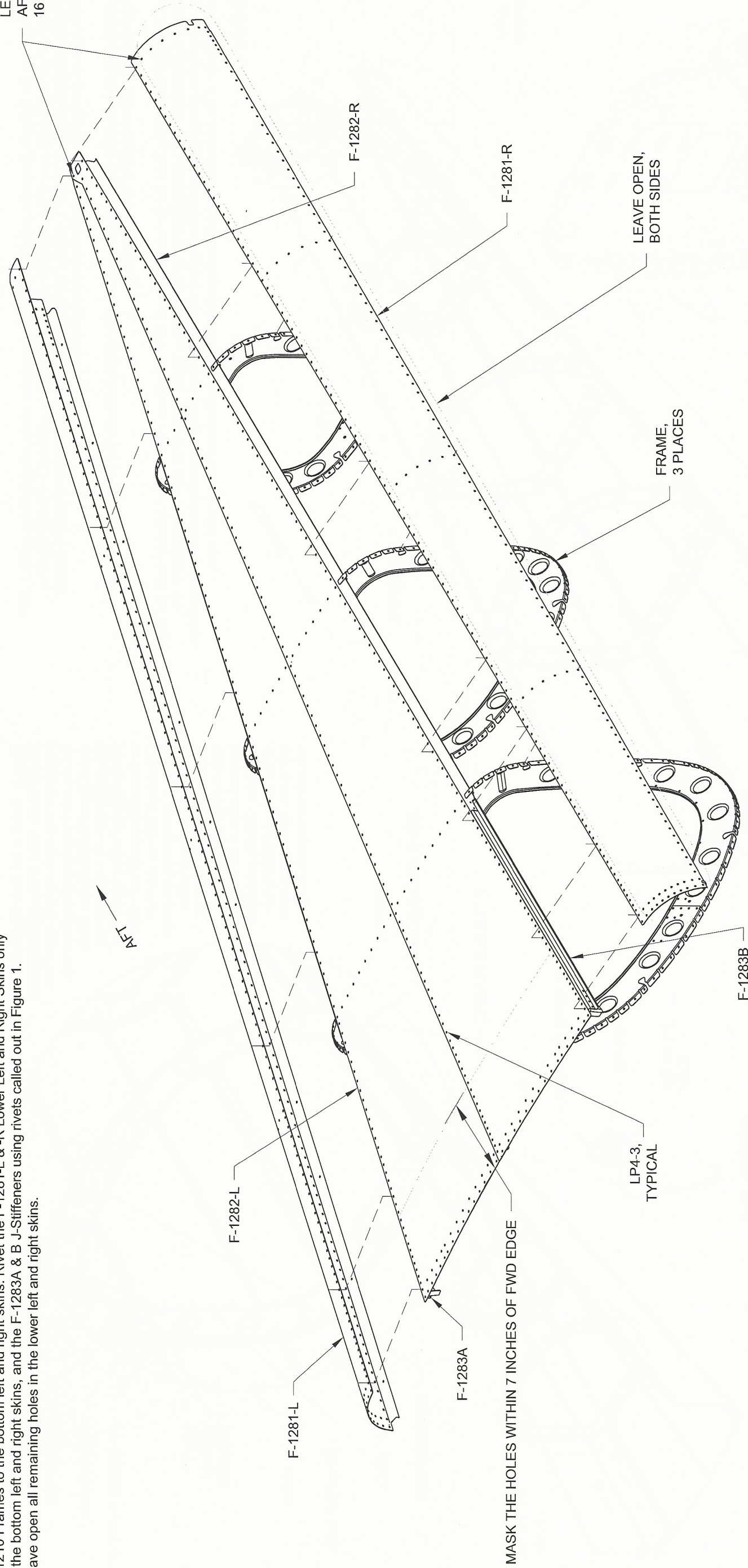


FIGURE 1:
LOWER SKIN INSTALLATION