



Step 1: Remove the area shown hatched to separate the F-1238-L & -R Snap Bushing Brackets as shown in Figure 1.

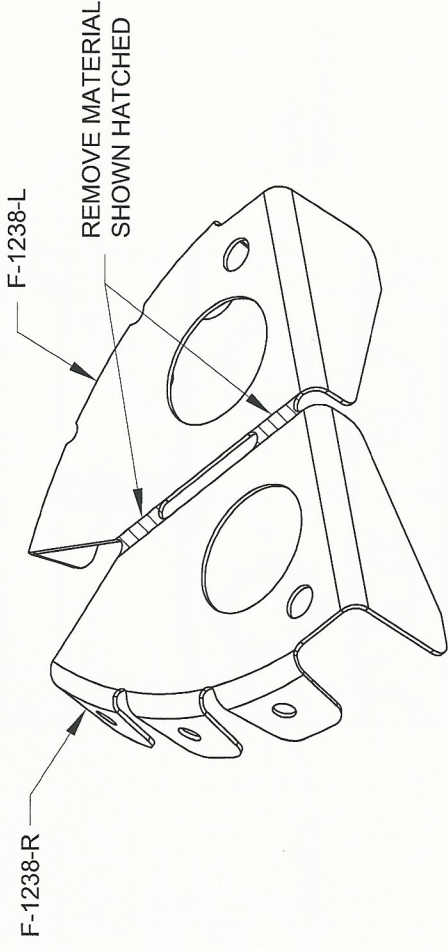


FIGURE 1:
SNAP BUSHING BRACKET SEPARATION

NOTE: Steps 2 through 6 explain installation for the F-1279-L Upper Left Skin and F-1238-L Snap Bushing Bracket. Installation for the F-1279-R Upper Right Skin and F-1238-R Snap Bushing Bracket is a mirror of the left and should be done at the same time.

Step 2: Hook the F-1279-L Upper Left Skin J-stiffener into the cutouts in the F-1208, F-1209 and F-1210 Frames. Cleco the upper left skin to the frames and F-1280-L Left Side Skin as shown in Figure 2.

Step 3: Cleco the F-1238-L Snap Bushing Bracket to the F-1279-L Upper Left Skin as shown in Figure 2.

Step 4: With a 12 inch extended bit, Match-Drill #30 the holes called out in the F-1279-L Upper Left Skin J-stiffener into the F-1238-L Snap Bushing Bracket. Cleco the first hole before drilling the next. Then remove, deburr, re-cleco.

Step 5: Rivet the F-1238-L Snap Bushing Bracket to the F-1279-L Upper Left Skin using the rivets called out in Figure 2.

Step 6: Insert the snap bushing into the F-1238-L Snap Bushing Bracket called out in Figure 2.

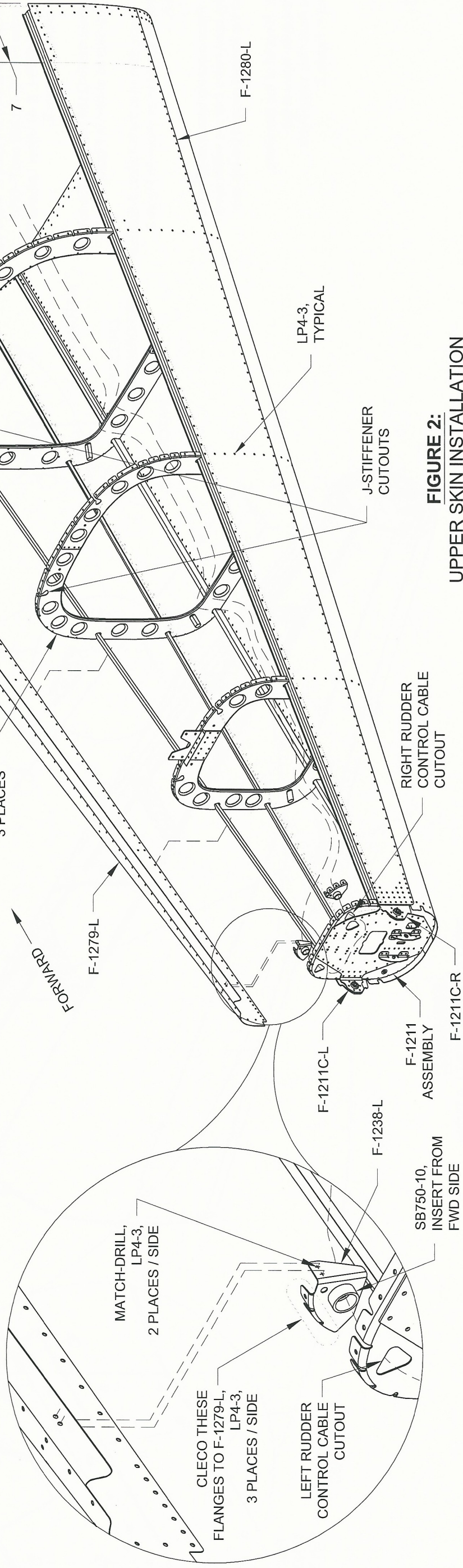


FIGURE 2:
UPPER SKIN INSTALLATION

Step 7: Route a string from the forward end of the existing structure to the F-1211 Assembly. The string will go through the F-1238-L Snap Bushing Bracket, out through the left rudder control cable cutout, then back in through the right rudder control cable cutout and through the F-1238-R Snap Bushing Bracket as shown in Figure 2. Return the end of the string to the forward end of the existing structure. Tape both ends of the string to the inside surface of the bottom skin.

Step 8: Place masking tape over all of the holes that are within seven inches of the forward edge of each tailcone skin. The masked holes will be left open for the remainder of this section.

Step 9: Rivet all of the open holes of the F-1280-L & -R Left and Right Side Skins. Rivet only the holes in the F-1279-L & -R Upper Left and Right Skins that are common to the left or right side skins. Capture the F-1211C Hinge Bracket when riveting the aft end of each left and right side skin.