



- Step 1: Final-Drill #19 the screw holes of the F-12106 Fwd Skin Rib per call-outs in Figure 1.
- Step 2: Dimple #8 the screw holes of the F-12106 Fwd Skin Rib per call-outs in Figure 1.
- Step 3: Dimple 3/32 the nutplate attach holes of the F-12106 Fwd Skin Rib per call-outs in Figure 1.
- Step 4: Dimple 3/32 the nutplate attach holes of eight nutplates per call-outs in Figure 1.
- Step 5: Rivet the dimpled nutplates to the F-12106 Fwd Skin Rib using hardware called out in Figure 1.

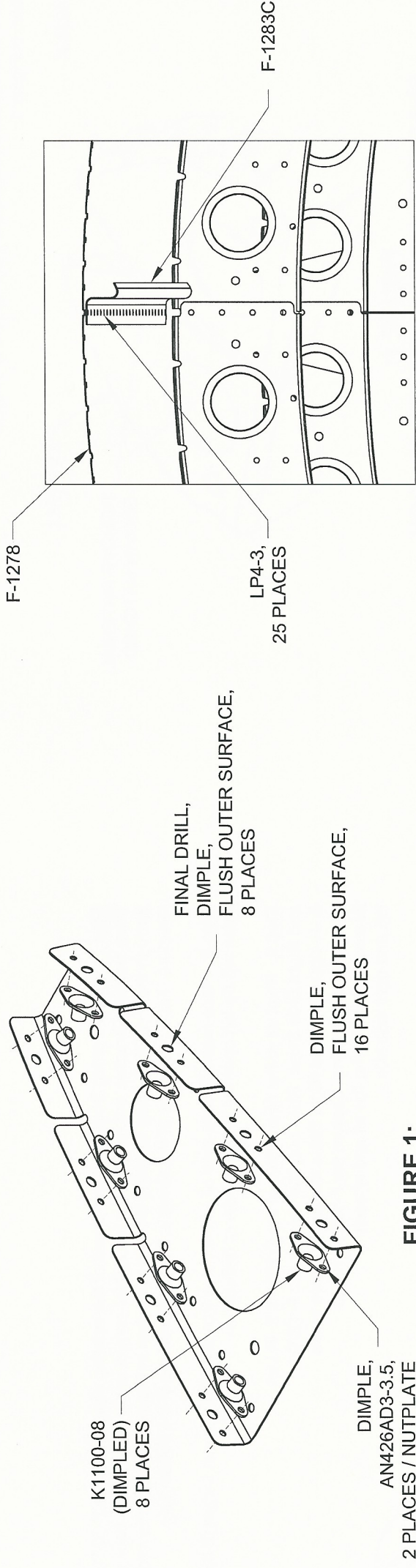


FIGURE 1:
F-12106 PREPARATION

DETAIL A-A
FRONT VIEW - LOOKING AFT

- Step 6: Guide the F-12106 Plate through the slot in the F-1278 Top Skin. Cleco the Top Skin to the F-1210 Frame. Match-Drill #30 the two outboard-most holes in the F-1210C Angle using the Top Skin as a guide. Check the top skin for deformations caused by the F-1210C Angle at the locations called out in Figure 2. Remove the top skin. Deburr the angle. If deformations were present in the top skin file material from the angle to minimize deformations on the top skin. Cleco the top skin to the F-1208, F-1209 and F-1210 Frames and F-1279-L & -R Upper Left and Right Skins as shown in Figure 2. Cleco the top skin to the F-1208, F-1209 and F-1210 Frames and F-1279-L & -R Upper Left and Right Skins as shown in Figure 2.

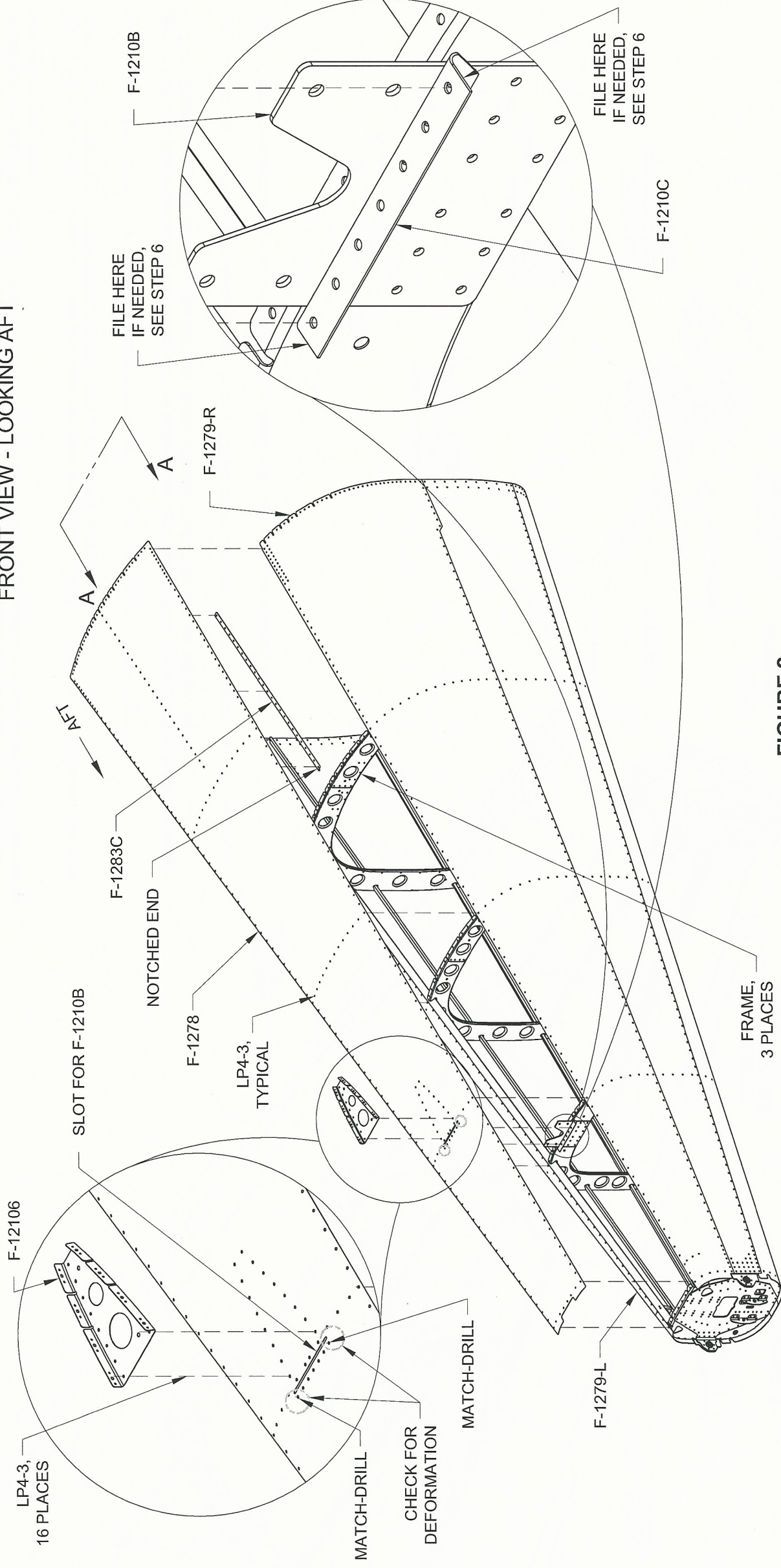


FIGURE 2:
TOP SKIN INSTALLATION

- Step 7: Rivet the F-12106 Fwd Skin Rib to the F-1278 Top Skin as shown in Figure 2.
- Step 8: Cleco, then rivet the F-1283C J-Stiffener to the F-1278 Top Skin as shown in Figure 2, Detail A-A.
- Step 9: Place masking tape over all of the remaining open holes that are within seven inches of the forward edge of the top skin.
- Step 10: Rivet all of the remaining, unmasked open holes in the Tailcone Assembly using rivets called out in Figure 2.