



- Step 1: Machine countersink 100° the nutplate attach rivet holes called out in Figure 1.
- Step 2: Rivet the nutplate onto the inside of the F-1287A Servo Tray using hardware called out in Figure 1.
- Step 3: Rivet the F-1287J Doublers to the F-1287A Servo Tray. Orient and use rivets as called out in Figure 1.

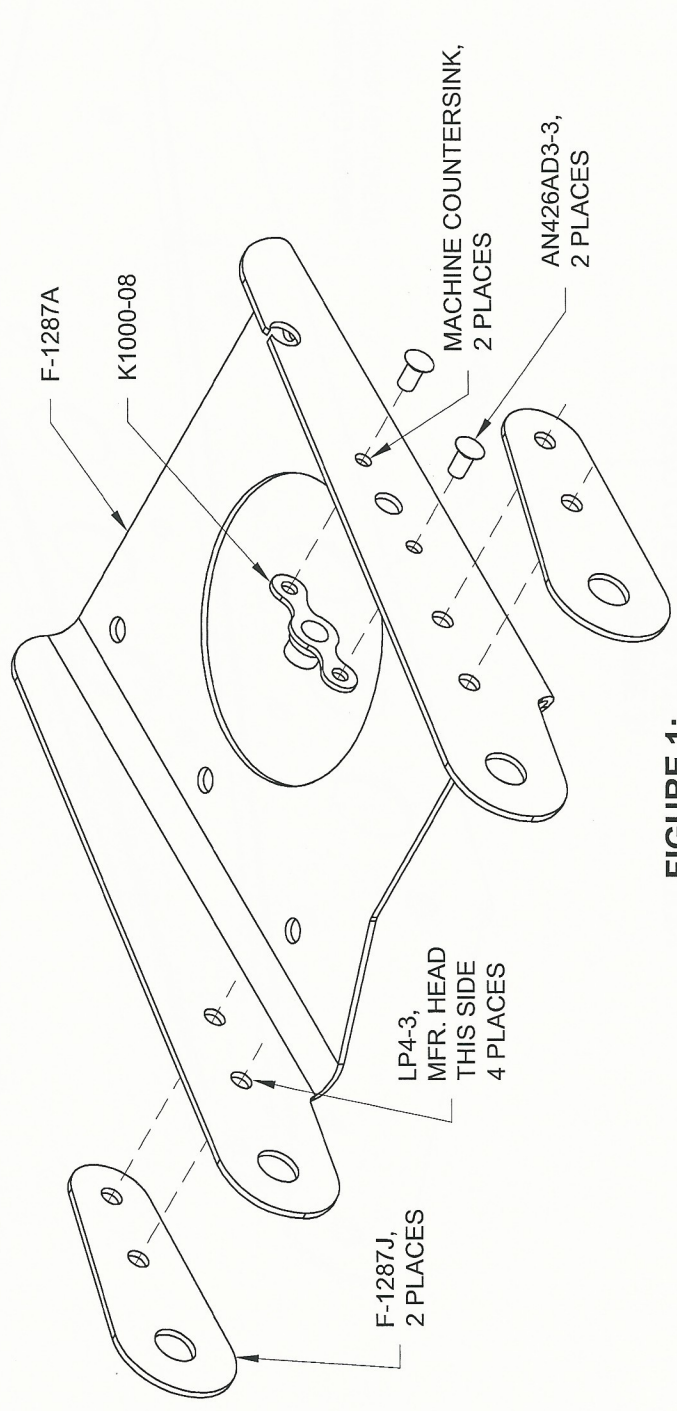


FIGURE 1:
NUTPLATE INSTALLATION

- Step 4: Cleco the ES MSTST-3-7A-2 Pitch Trim Servo and both F-1287B Doublers to the F-1287A Servo Tray as shown in Figure 2.
- Step 5: Match-Drill #27 the center holes, and final-drill #27 the end holes in the F-1287B Doublers into the ES MSTST-3-7A-2 Pitch Trim Servo and F-1287A Servo Tray. Remove parts, clear away chips and deburr holes.
- Step 6: Install the ES MSTST-3-7A-2 Pitch Trim Servo to the F-1287A Servo Tray using hardware called out in Figure 2.

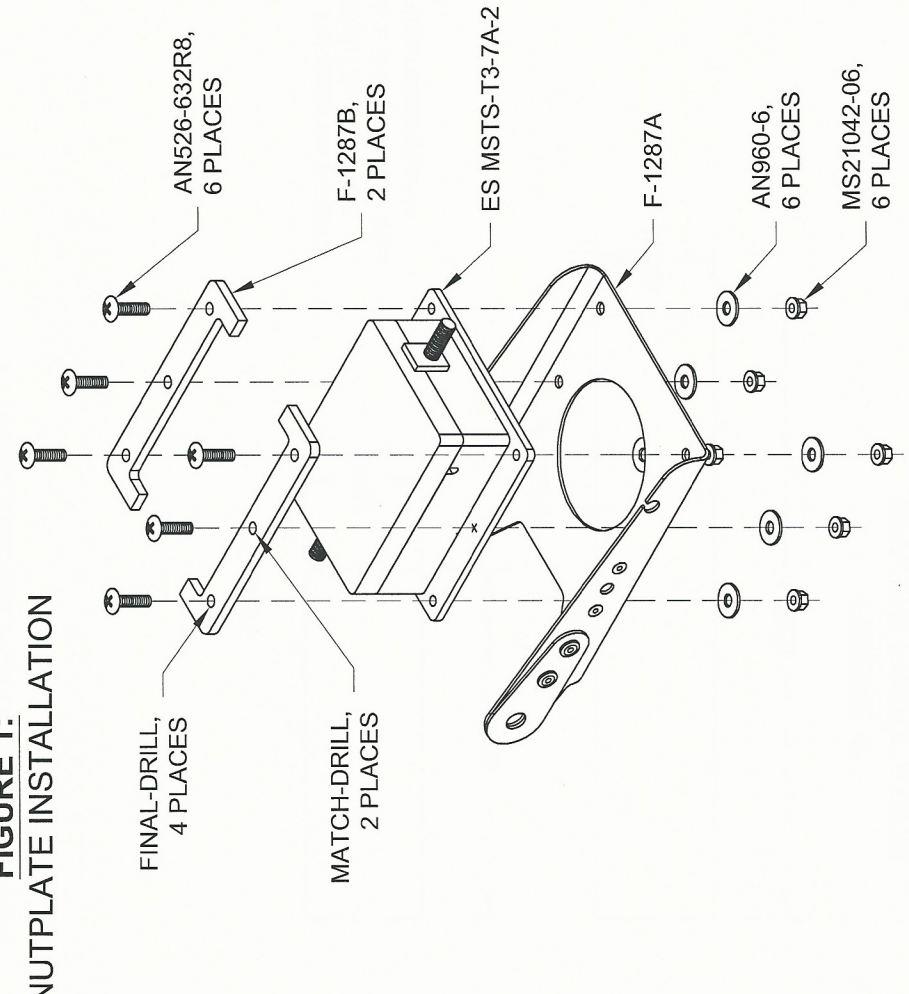


FIGURE 2:
SERVO TRAY ASSEMBLY

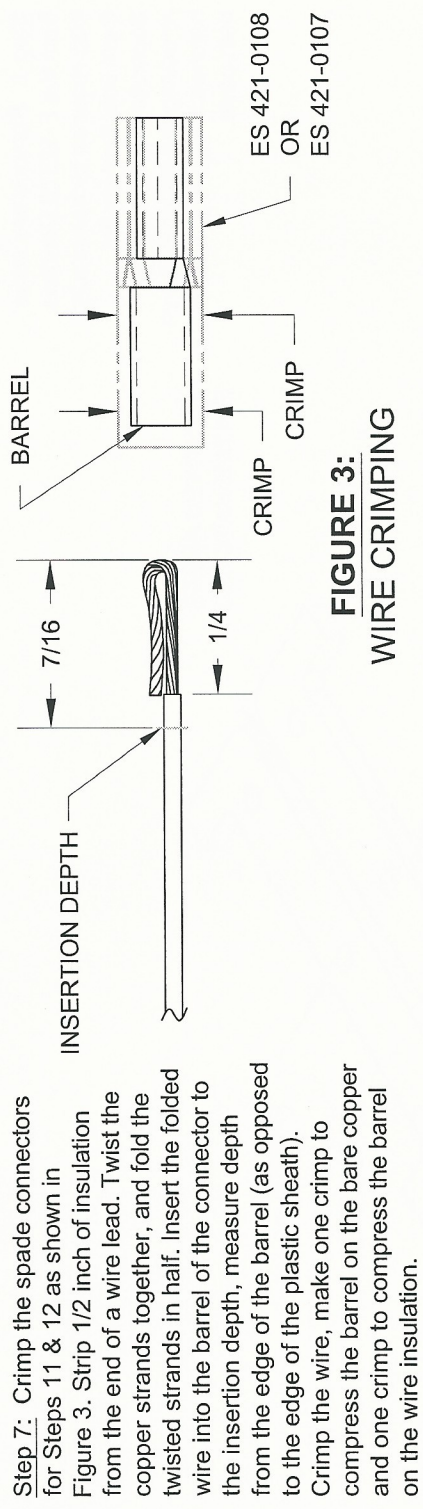


FIGURE 3:
WIRE CRIMPING

CAUTION: In Step 8 deburr only enough to locate the bushing.

- Step 7: Crimp the spade connectors for Steps 11 & 12 as shown in Figure 3. Strip 1/2 inch of insulation from the end of a wire lead. Twist the copper strands together, and fold the twisted strands in half. Insert the folded wire into the barrel of the connector to the insertion depth, measure depth from the edge of the barrel (as opposed to the edge of the plastic sheath). Crimp the wire, make one crimp to compress the barrel on the bare copper and one crimp to compress the barrel on the wire insulation.
- Step 8: Deburr the F-1287C Link called out in Figure 4. Deburr the F-1287A Servo Tray called out in Figure 6.
- Step 9: Insert the polymer bushing into the F-1287C Link as shown in Figure 4. Insert the polymer bushings into the F-1287A Servo Tray as shown in Figure 6.
- Step 10: File the polymer bushings inserted in previous step. The bushings must be **greater than** the thickness of the part and **less than** the dimension given in Figure 5.
- Step 11: String the ES MSTST-3-7A-2 Pitch Trim Servo wire through the called out snap bushing and insert the snap bushing into the F-1287A Servo Tray as shown in Figure 6.
- Step 12: Crimp a male spade connector to one of the white wires of the ES MSTST-3-7A-2 Pitch Trim Servo wire. Crimp female spade connectors to each remaining trim wires as shown in Figure 6.

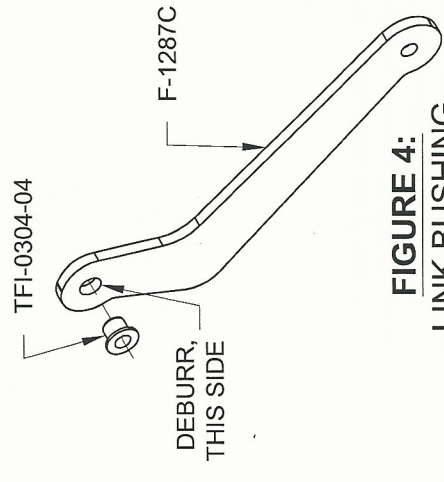


FIGURE 4:
LINK BUSHING

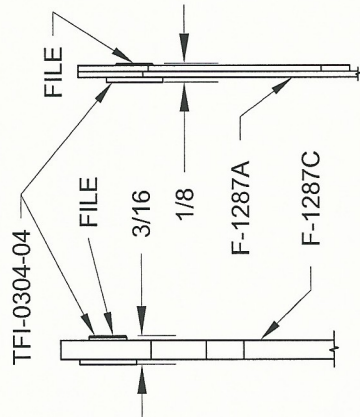


FIGURE 5:
POLYMER BUSHINGS

- Step 13: Crimp one ES 421-0108 female spade connector to one of the white wires of the WH-P30 Trim Wires that exits the aft end of the Tailcone Assembly. Crimp ES 421-0107 male spade connectors to each of the remaining trim wires. For trim wires reference see Page 10-08.
- Step 14: String the ES MSTST-3-7A-2 Pitch Trim Servo wire into the cushioned clamp, then temporarily install the cushioned clamp to the F-1287A Servo Tray as shown in Figure 6.

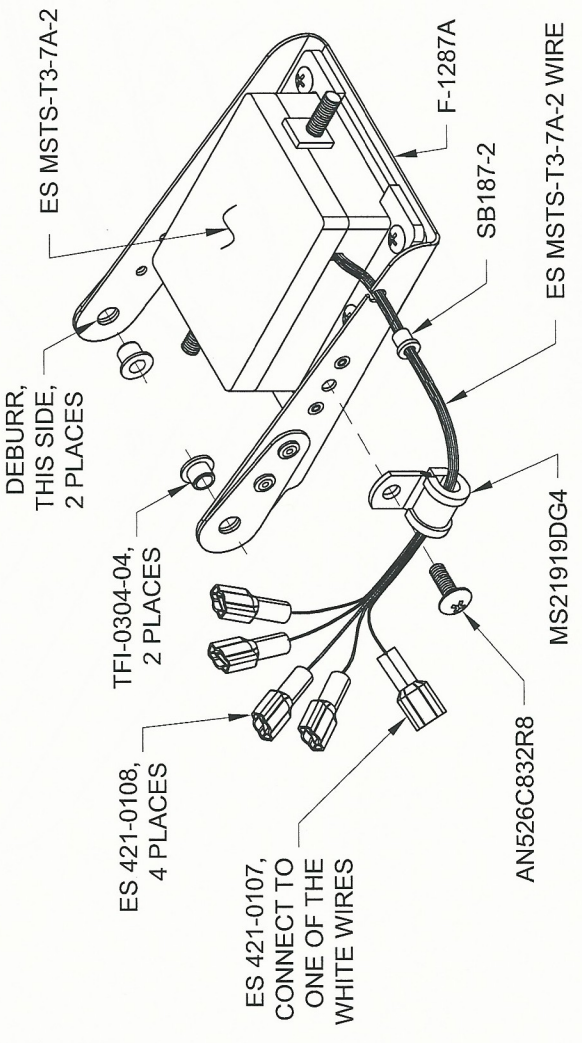


FIGURE 6:
SERVO WIRE