



Step 1: Drill #40 the F-1294A Upper Tailcone Fairing at the inboard fairing attach hole location marked on masking tape 'AL' as shown in Figure 1, Detail A. Sight through the F-1294A Upper Tailcone Fairing material to locate the fairing attach hole mark, then drill through the upper tailcone fairing into the Tailcone Assembly. Cleco the hole.

Step 2: Drill #40 at the inboard fairing attach hole location marked on masking tape 'BL'. Sight through the F-1294B Lower Tailcone Fairing material to locate the fairing attach hole mark then drill through the lower tailcone fairing into the Tailcone Assembly.

Step 3: Remove the F-1294 Assembly. Install the Stabilator Assembly. Refer to Section 11, Page 3. Cleco the F-1294 Assembly back in place.

Step 4: Adjust the alignment of the F-1294 Assembly to provide at least 1/8 inch of clearance between the F-1294 Assembly and the Stabilator Assembly main skins at any given point throughout the stabilator travel as shown in Figure 1.

Step 5: Repeat Steps 1 and 2 to the right side using the 'AR' and 'BR' masking tape.

Re-check clearances between the F-1294 Assembly and the Rudder and Stabilator Assembly main skins.

Step 6: With the four existing holes clecoed, drill #40 the remaining fairing attach hole locations marked on masking tapes 'AL', 'BL', 'AR' and 'BR'. Sight through the F-1294A & B Upper and Lower Tailcone Fairing material to locate the marks then drill through the fairing into the Tailcone Assembly. Cleco as you go.

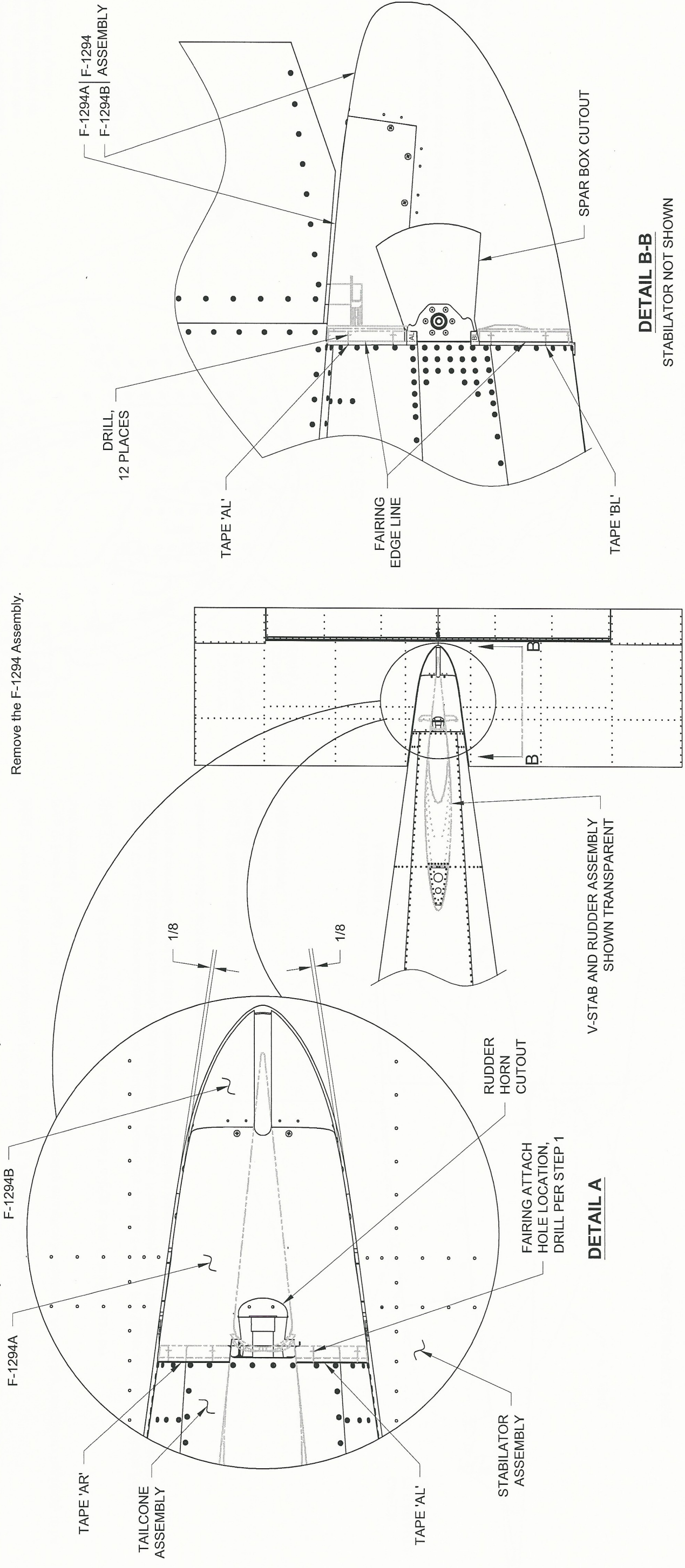
Remove F-1294 Assembly, deburr holes and clear away loose material. Re-cleco. Recheck clearance between the F-1294 Assembly and the Rudder and Stabilator Assemblies.

Step 7: Final-Drill with modified #27 (Ref Page 12-07) the holes common to the F-1294 Assembly and the Tailcone Assembly. Cleco as you go.

Remove F-1294 Assembly, deburr holes and clear away loose material. Re-cleco.

Step 8: Check the clearance between the F-1294 Assembly spar box cutout and the Stabilator Assembly spar box throughout the full travel of the Stabilator Assembly as shown in Figure 1, Detail B-B. Check the clearance between the F-1294 Assembly rudder horn cutout and the rudder horn throughout the full travel of the Rudder Assembly as shown in Figure 1, Detail A. Mark, and trim any areas of interference for at least 1/8 inch of clearance to the F-1294 Assembly.

Remove the F-1294 Assembly.



DETAIL B-B
STABILATOR NOT SHOWN

FIGURE 1:
FAIRING ALIGNMENT