



Step 1: Locate a nutplate, using a #6 screw, through one of the #27 fairing attach holes in the aft of the Tailcone Assembly. Bend the nutplate attach tabs as necessary to conform to the tailcone skins.

Step 2: Match-Drill using an extended #40 one of the nutplate attach rivet holes into the Tailcone Assembly. Cleco that hole. Then match-drill #40 the remaining nutplate attach rivet hole. Mark the location of each nutplate.

Repeat Step 1 and 2 for all of the fairing attach nutplates.

Step 3: Tap the called out nutplates half way through the screw hole per call-out in Figure 1.

Step 4: Dimple, using a 3/32 die, the #40 nutplate attach rivet holes in the Tailcone Assembly per call-outs in Figure 1.

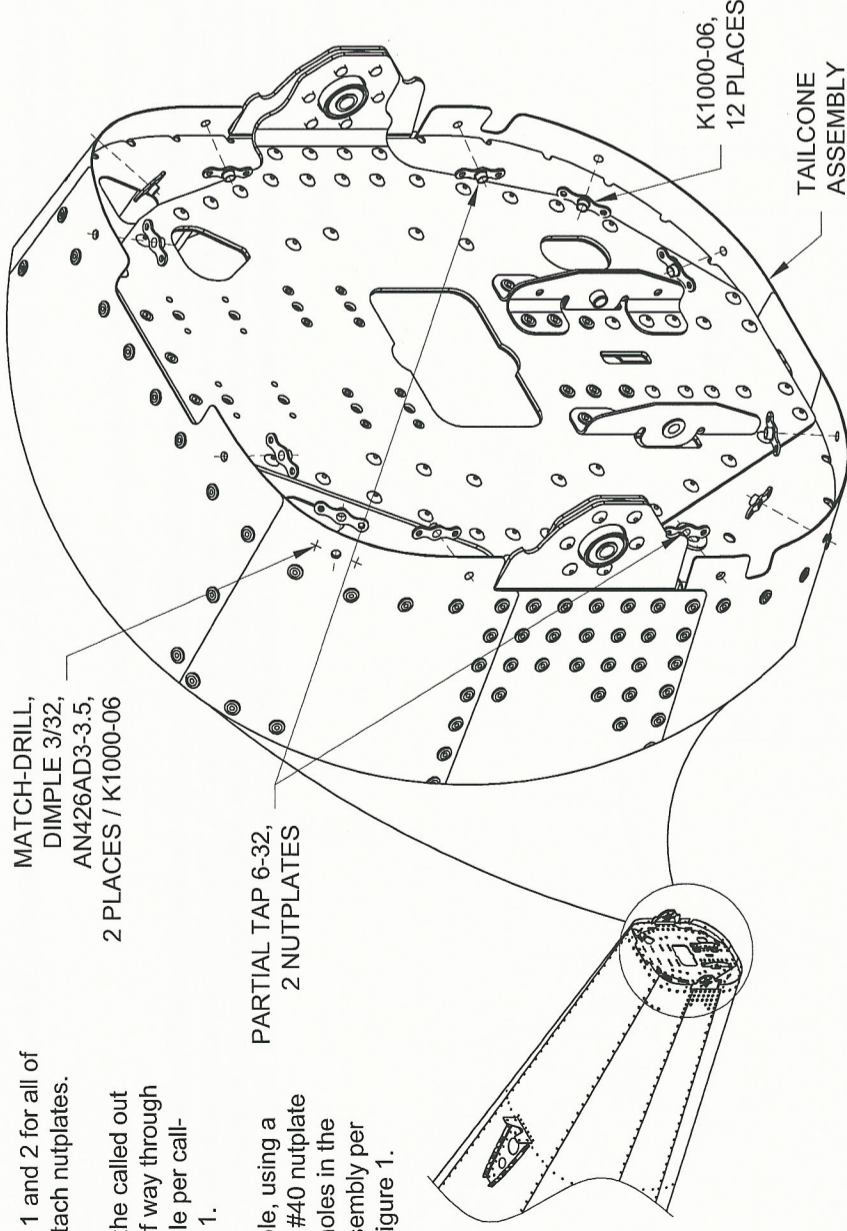


FIGURE 1:
FAIRING ATTACH NUTPLATES

Step 5: Dimple, using a 3/32 die, the attach rivet holes in the nutplates called out in Figure 2.

Step 6: Rivet the nutplates to the tailcone per marks made in Step 2, and call-outs in Figure 1.

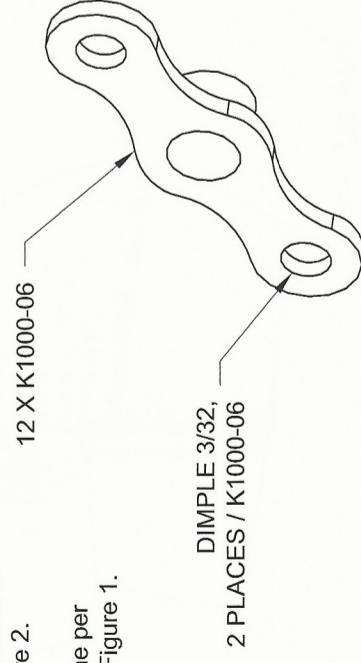


FIGURE 2:
NUTPLATE PREPARATION

Step 7: Drill a 3/4 hole using a step drill bit within the scribe line at the bottom of the F-1294B Lower Tailcone Fairing as shown in Figure 3.

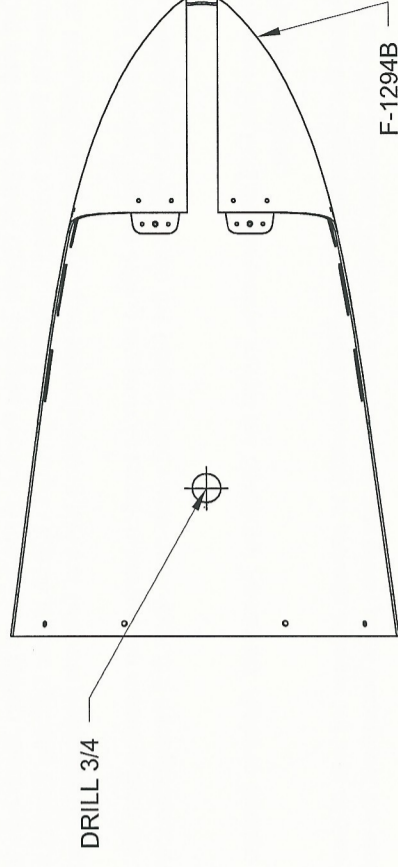


FIGURE 3:
TRIM/SERVO LINKAGE HOLE

Step 8: Install the Trim/Servo Assembly. Refer to Section 11, Page 7 for attachment instructions.

Step 9: Refer to Page 11-08 for temporary Trim/Servo Assembly actuation instructions. Actuate the Trim/Servo Assembly to be fully retracted.

Step 10: Attach the F-1294A & B Upper and Lower Tailcone Fairings to the Tailcone Assembly.

Step 11: Check the clearance between the Trim/Servo Assembly and the F-1294A & B Upper and Lower Tailcone Fairing throughout the Stabilator Assembly travel as shown in Figure 4. If necessary, mark then trim the upper and lower tailcone fairings to provide at least 1/8 inch of clearance for the Trim/Servo Assembly.

Remove the upper and lower tailcone fairings.

Step 12: Repeat Step 8 through 10 with the Trim/Servo Assembly fully extended.

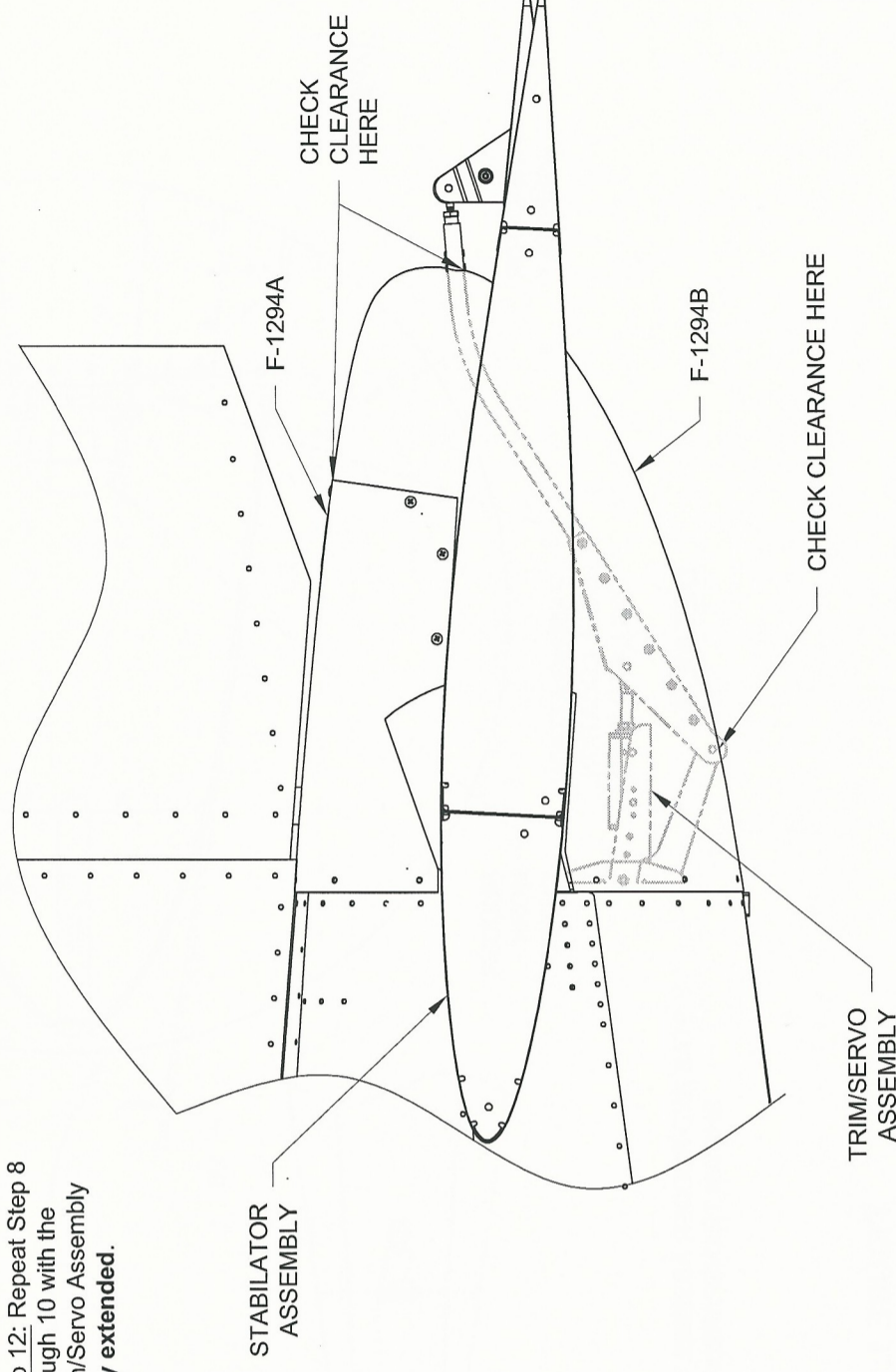


FIGURE 4:
TRIM/SERVO CLEARANCE