



Step 1: Place F-1276 Bottom Skin on the tabletop. Place F-1204 Center Section Assembly over bottom skin and cleco the bottom flanges of the bulkheads as shown in Figure 1.

Step 2: Temporarily loosen the clamps holding the F-1204D Center Section Aft Bulkhead to the F-1204 Center Section Assembly and allow the parts to re-align according to their being clecoed to the F-1276 Bottom Skin. Tighten the clamps and match-drill #30 the holes in the center section aft bulkhead into the center section assembly beginning at the center and progressively drilling and clecoing outboard. See Figure 3. Drill #11 two places, see Pg 20-04, Figure 3.

Step 3: Un-cleco the bottom flanges from the F-1276 Bottom Skin and remove the F-1204 Center Section Assembly and F-1204D Center Section Aft Bulkhead. Set aside the bottom skin as it will be called for at a later stage of fuselage assembly. Un-cleco the center section aft bulkhead from the center section assembly, remove AN4 bolts, and deburr all match-drilled holes.

Step 4: Machine countersink 100° the holes in the F-1204 Center Section Assembly that receive an AN426AD4 rivet- see Figure 2 and Pg 20-04 Figure 3. A piece of thin scrap with a 1/4 inch hole drilled in it may be used to check the diameter (as described on Pg 14-02). Dimple the corresponding holes in the F-1204D Center Section Aft Bulkhead- see Pg 20-04 Figure 3.

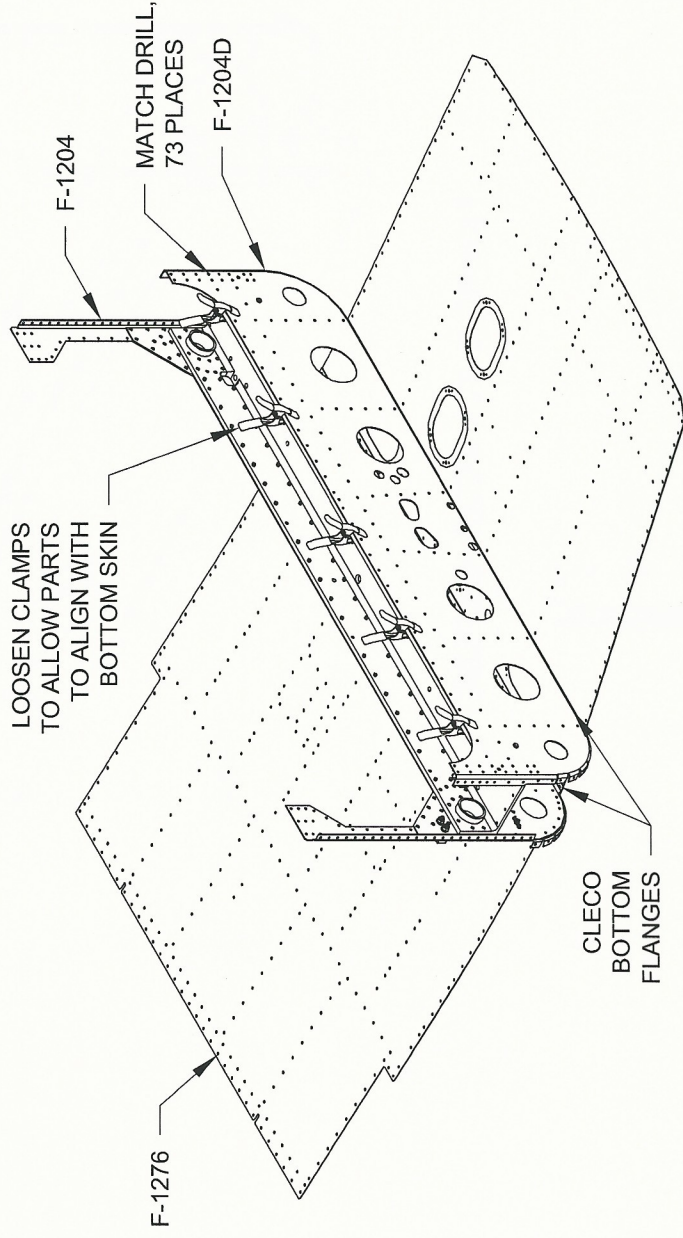


FIGURE 1: ALIGNING CENTER SECTION BULKHEAD TO BOTTOM SKIN

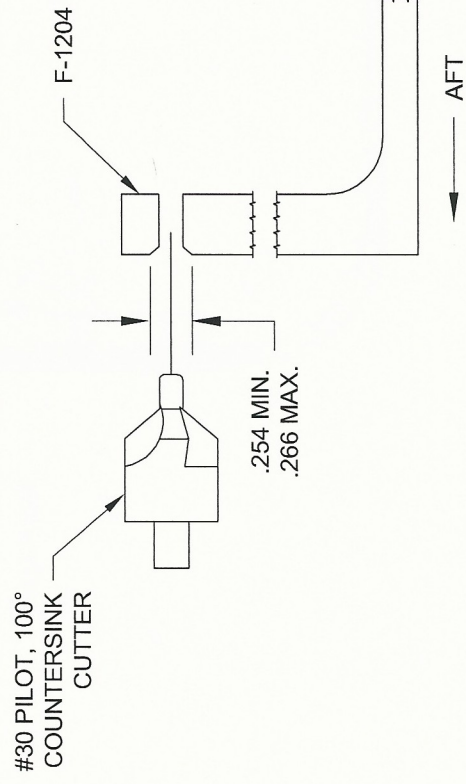


FIGURE 2: COUNTERSINK ORIENTATION DETAIL

Step 5: Cut apart the F-1204P Skin Attach Flange to make F-1204P-L and F-1204P-R Skin Attach Flanges as shown in Figure 3.

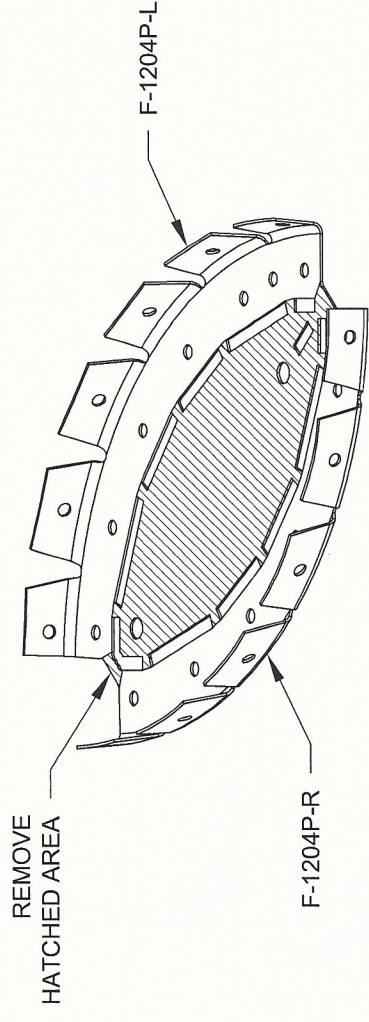


FIGURE 3: SEPARATING SKIN ATTACH FLANGES

Step 6: Separate F-1204T-L and F-1204T-R Skin Stiffeners by removing the hatched areas shown in Figure 4.

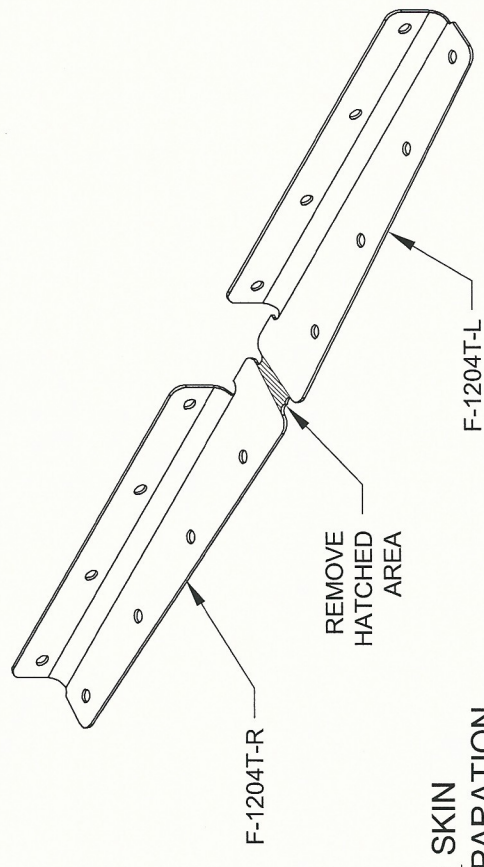


FIGURE 4: SKIN STIFFENER SEPARATION

Step 7: Separate F-1204U-L and F-1204U-R Skin Stiffeners by removing the hatched areas shown in Figure 5.

Step 8: Bend the bottom flanges of the F-1204U-L and F-1204U-R Skin Stiffeners up (to fit the inside radius of the F-1204 Center Section Assembly) as shown in Figure 6. See 20-05 Figure 1 for radius and part location.

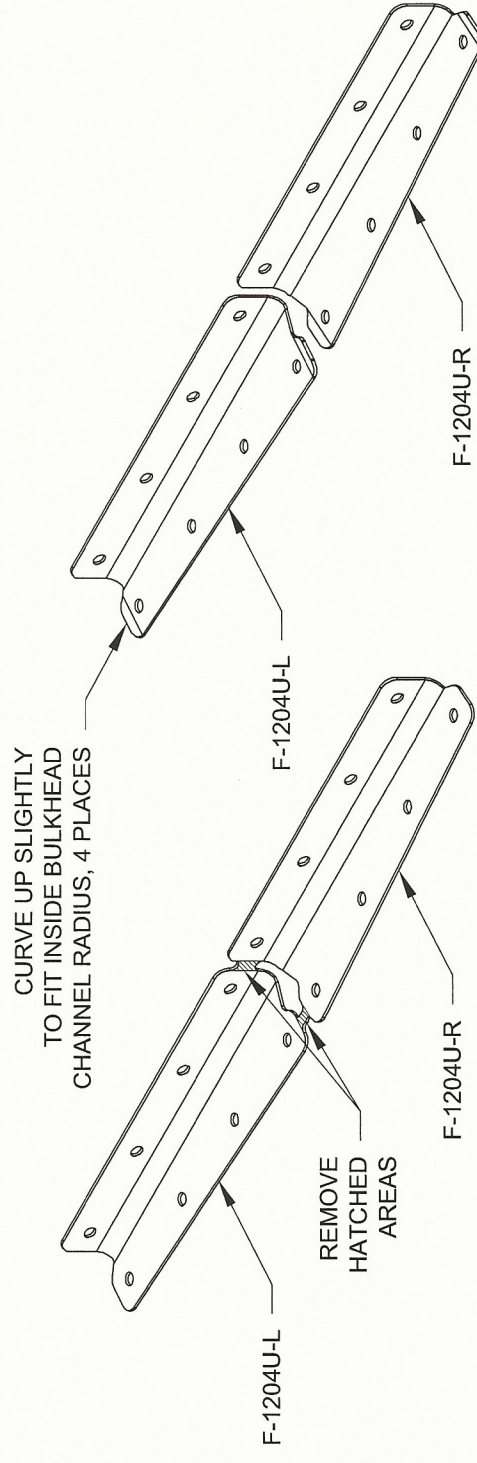


FIGURE 5: SKIN STIFFENERS

FIGURE 6: SKIN STIFFENER BENDS