

FIGURE 1: RIVETING BAGGAGE FLOORS

Step 2: Rivet the F-1224-L & -R Baggage Floors to the F-1204D Center Section Aft Bulkhead and F-1204F-L & -R Aft Side Bulkheads using the rivets called out in Figure 1. Use two thin flush sets in a hand squeezer and apply tape to the squeezer to prevent scratching the baggage floors.

Step 3: Dimple the holes in the F-1221-L & -R Baggage Ribs that correspond to the dimpled holes in the F-1224-L & R Baggage Floors.

Step 4: Rivet the F-1221-L & -R, F-1222-L & -R, and F-1223-L & R Baggage Ribs to the F-1204D Center Section Aft Bulkhead and F-1224-L & -R Baggage Floors using the rivets called out in Figure 2. Install all the rivets so that the manufactured heads are on the bulkhead.

Step 5: Dimple the nutplates depicted in Figure 2, then rivet them to the F-1221-L & -R Baggage Ribs and F-1224-L & -R Baggage Floors.

- CS4-4
5X PER F-1221-L & -R
- K1000-08
6X PER
2X AN426AD3-3.5 | F-1221-L & -R
- LP4-3
ALL F-1222-L & -R AND F-1223-L & -R TO F-1224-L & -R RIVETS
- LP4-3
ALL F-1221-L & -R, F-1222-L & -R, AND F-1223-L & -R TO F-1204D RIVETS

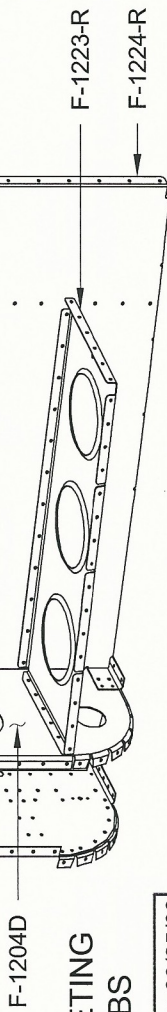


FIGURE 2: RIVETING BAGGAGE RIBS

Step 6: Separate the F-1206B Rear Spar Receptacle Support by removing the hatched areas shown in Figure 3.

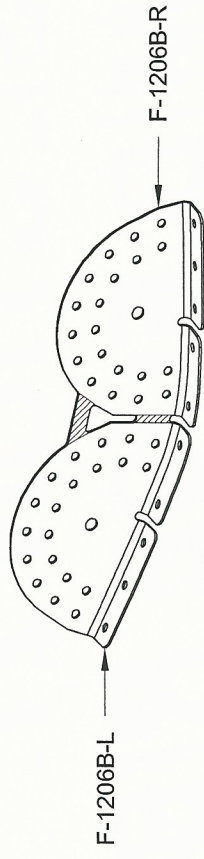


FIGURE 3: SEPARATE F-1206B

Step 7: File the curved recess of both F-1206C Rear Spar Receptacles to closely fit the rounded mating ends of the Rear Spar Assemblies of both wings. The small flat on both rear spar receptacles locates the top of the parts. Once filed, mark the parts so that they will be assembled on the side they were fitted to.

Step 8: Rivet the F-1206B-L & -R Rear Spar Receptacle Supports and the F-1206C Rear Spar Receptacles to the F-1206A Bulkhead using the rivets called out in Figure 4. Insert the rivets in all the holes before setting any of them.

Step 9: Dimple the #19, #30, and #40 holes in the top flange of the F-1206A Baggage Bulkhead that correspond to the dimpled holes in the F-1224-L & -R Baggage Floors (see Page 21-3, Figure 1 for the orientation of the bulkhead on the baggage floors).

Step 10: Dimple the nutplate attach rivet holes in the top flange of the F-1206A Bulkhead for the two nutplates depicted in Figure 4.

Step 11: Dimple the two nutplates depicted in Figure 4, then rivet them to the top flange of the F-1206A Bulkhead.

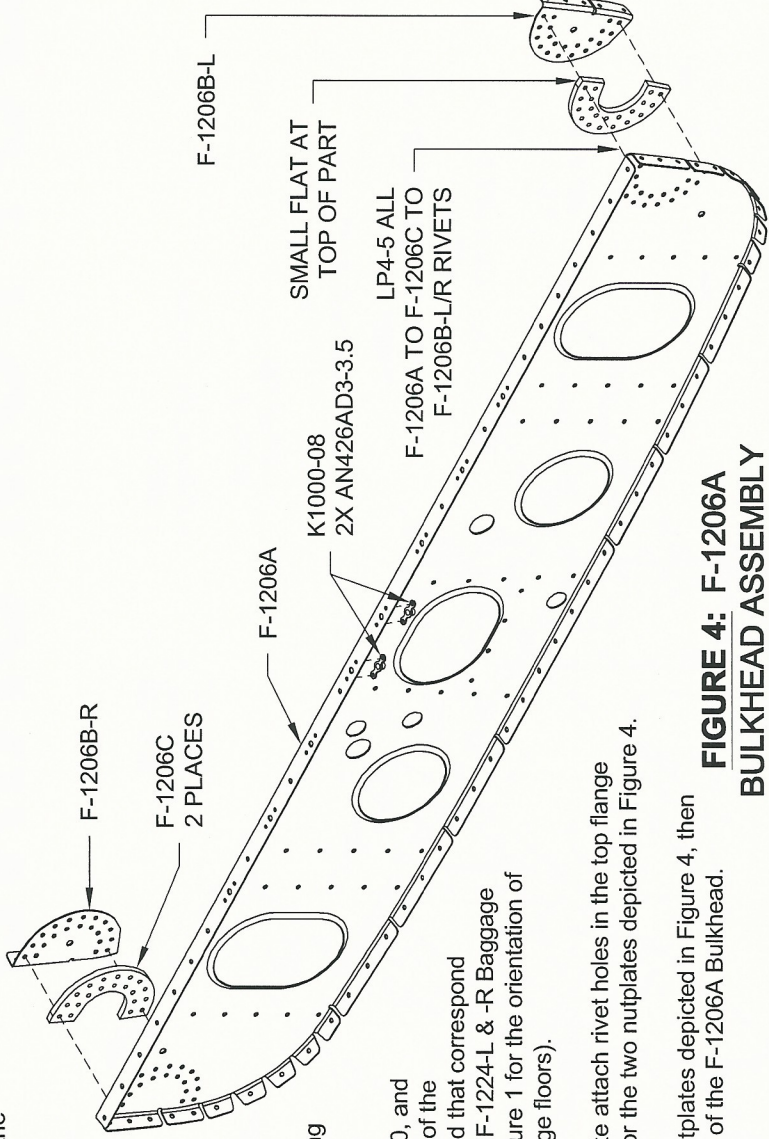


FIGURE 4: F-1206A BULKHEAD ASSEMBLY

Step 12: Dimple the nutplates called out in Figure 5 and the corresponding holes in the top flange of the F-1206G-L & -R Baggage Ribs.

Step 13: Rivet the nutplates called out in Figure 5 to the F-1206G-L & -R Baggage Ribs.

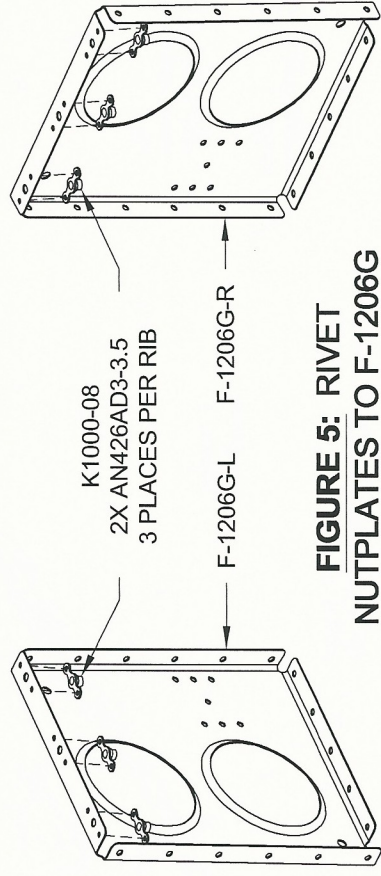


FIGURE 5: RIVET NUTPLATES TO F-1206G

Step 14: Rivet together two Bearing Bracket Assemblies using F-1206D Bearing Brackets and the hardware called out in Figure 6. Machine countersink one side of both Bearing Bracket Assemblies for the flush rivets shown.

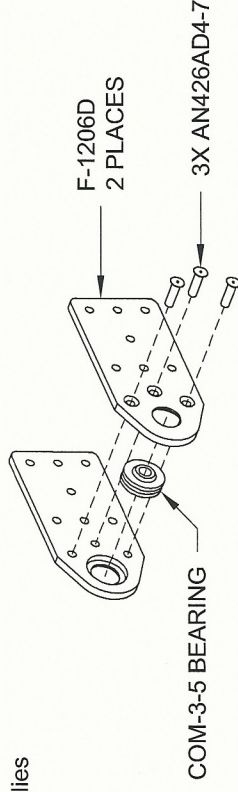


FIGURE 6: BEARING BRACKET ASSEMBLY