



Step 1: Set aside two Seat Rib Assemblies (one left and one right). In the remaining two Seat Rib Assemblies (one left and one right), final-drill #19 the screw holes for the nine nutplates depicted in Figure 1.
Note that in the case of the MS21051-L08 nutplate, the screw hole is NOT the center hole.

Step 2: Dimple the indicated attach hole for the MS21051-L08 nutplate in the aft, sloped flange of the two Seat Rib Assemblies. (The second attach hole has been factory dimpled.) See Figure 1.

Step 3: Dimple the four K1000-08 nutplates called out in Figure 1, then rivet them to both Seat Rib Assemblies. The five remaining nutplates are installed on Pages 21-7 and 21-8.
K1000-08
2X AN426AD3-3.5
(SEE STEP 3)

Step 4: In both Seat Rib Assemblies, dimple (flush on top surface) the three #30 holes indicated in Figure 1.

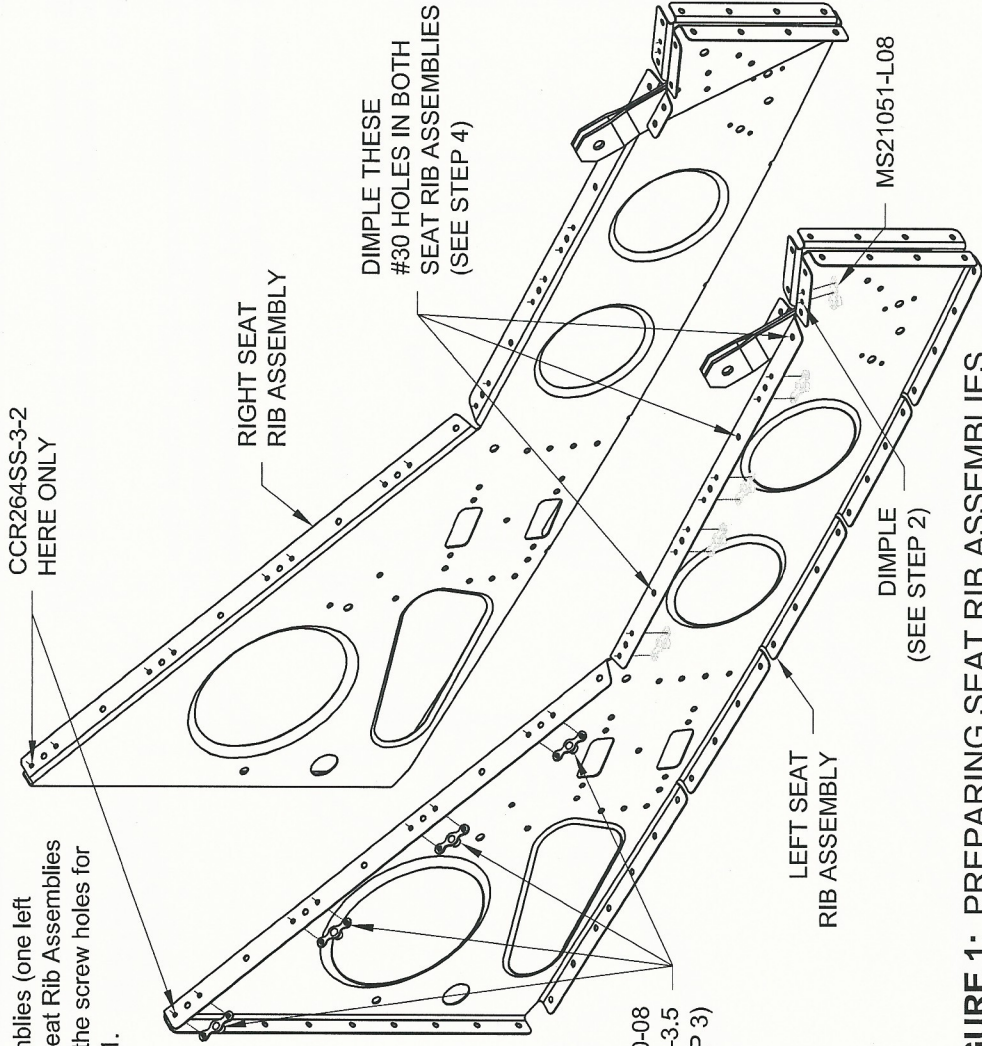


FIGURE 1: PREPARING SEAT RIB ASSEMBLIES

Step 5: Locate the four remaining F-1215-L & -R Seat Ribs (two left and two right, without seat belt attach lugs). In all four seat ribs, final-drill #19 the screw holes for the nutplates depicted in Figure 2.

Step 6: Set aside one pair of F-1215-L & -R Seat Ribs (one left and one right). Dimple the nutplates shown in Figure 2, then rivet them to the remaining two F-1215-L & -R Seat Ribs (one left and one right) using the rivets called out.

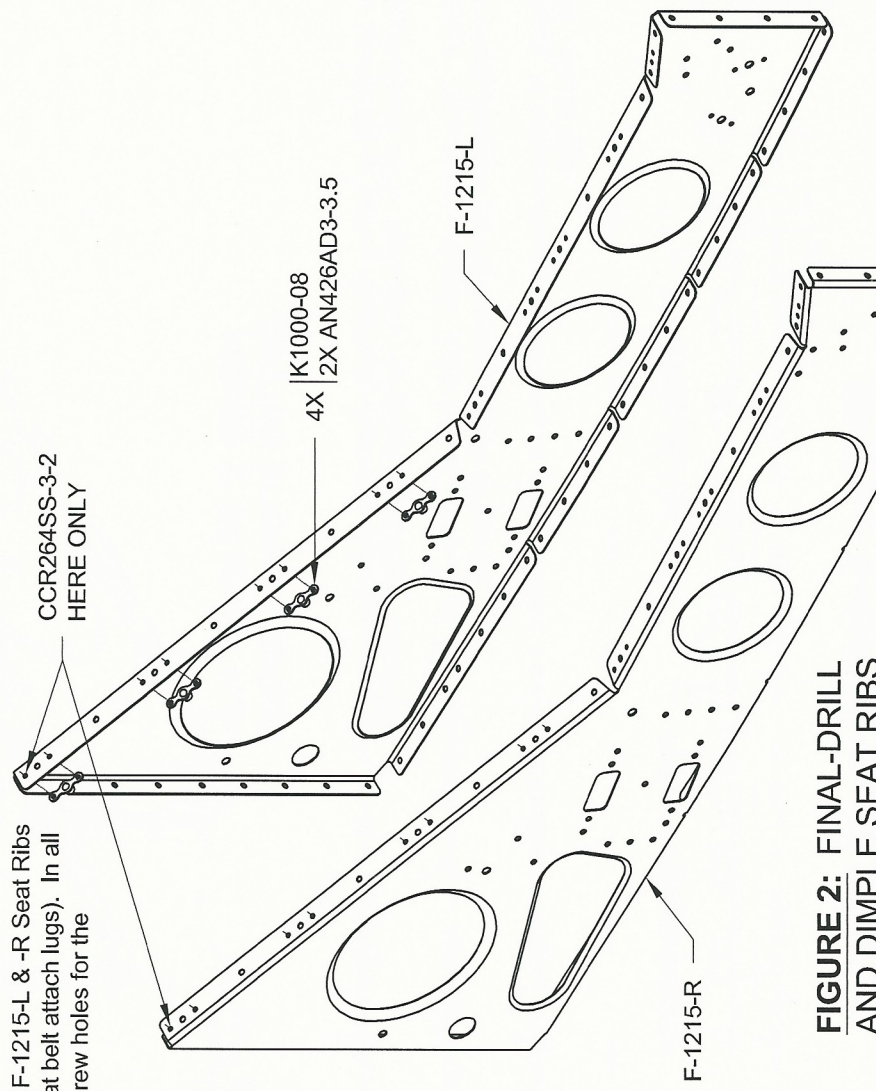


FIGURE 2: FINAL-DRILL AND DIMPLE SEAT RIBS

Step 7: Dimple the nutplates shown in Figure 3 and the corresponding holes in the Left Seat Rib Assembly (the left seat rib assembly from Figure 1), then rivet the nutplates in place using the rivets called out.

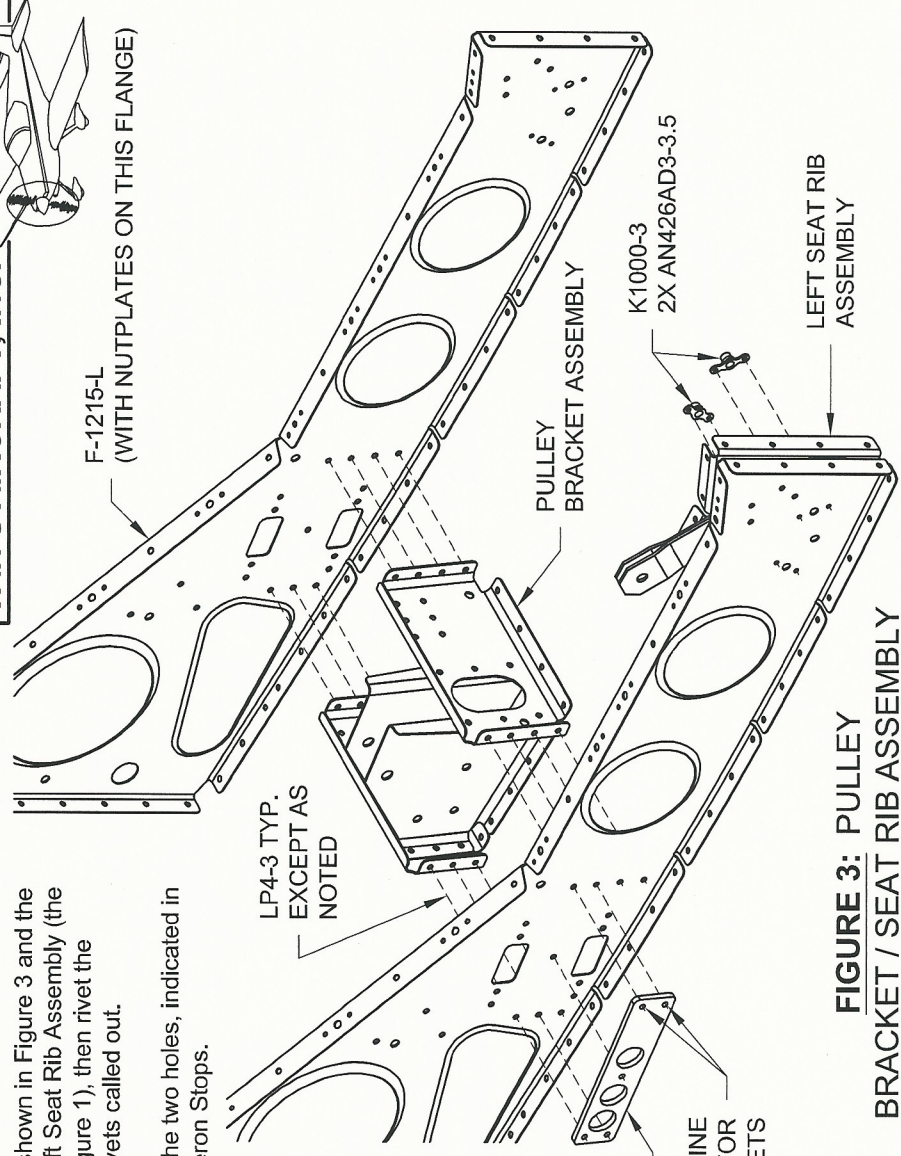
Step 8: Machine countersink the two holes, indicated in Figure 3, in both F-1252 Flaperon Stops.

Step 9: Rivet one of the F-1252 Flaperon Stops and the Pulley Bracket Assembly to the Left Seat Rib Assembly using the rivets called out in Figure 3.

Step 10: Rivet the F-1215-L Seat Rib that has the nutplates installed from Step 5, to the Pulley Bracket Assembly as shown in Figure 3.

F-1252
MACHINE
COUNTERSINK 120° FOR
CS4-4 RIVETS

FIGURE 3: PULLEY BRACKET / SEAT RIB ASSEMBLY



F-1215-R
(WITH NUTPLATES ON THIS FLANGE)

Step 11: Dimple the nutplates shown in Figure 4 and the corresponding holes in the Right Seat Rib Assembly (the right seat rib assembly from Figure 1), then rivet the nutplates in place using the rivets called out.

Step 12: Rivet the remaining F-1252 Flaperon Stop and the Flaperon Mixer Arm Assembly to the Right Seat Rib Assembly using the rivets called out in Figure 4.

NOTE: For autopilot bracket installation refer to Section 39.

Step 13: Rivet the F-1215-R Seat Rib that has the nutplates installed from Step 5, to the Flaperon Mixer Arm Assembly as shown in Figure 4.

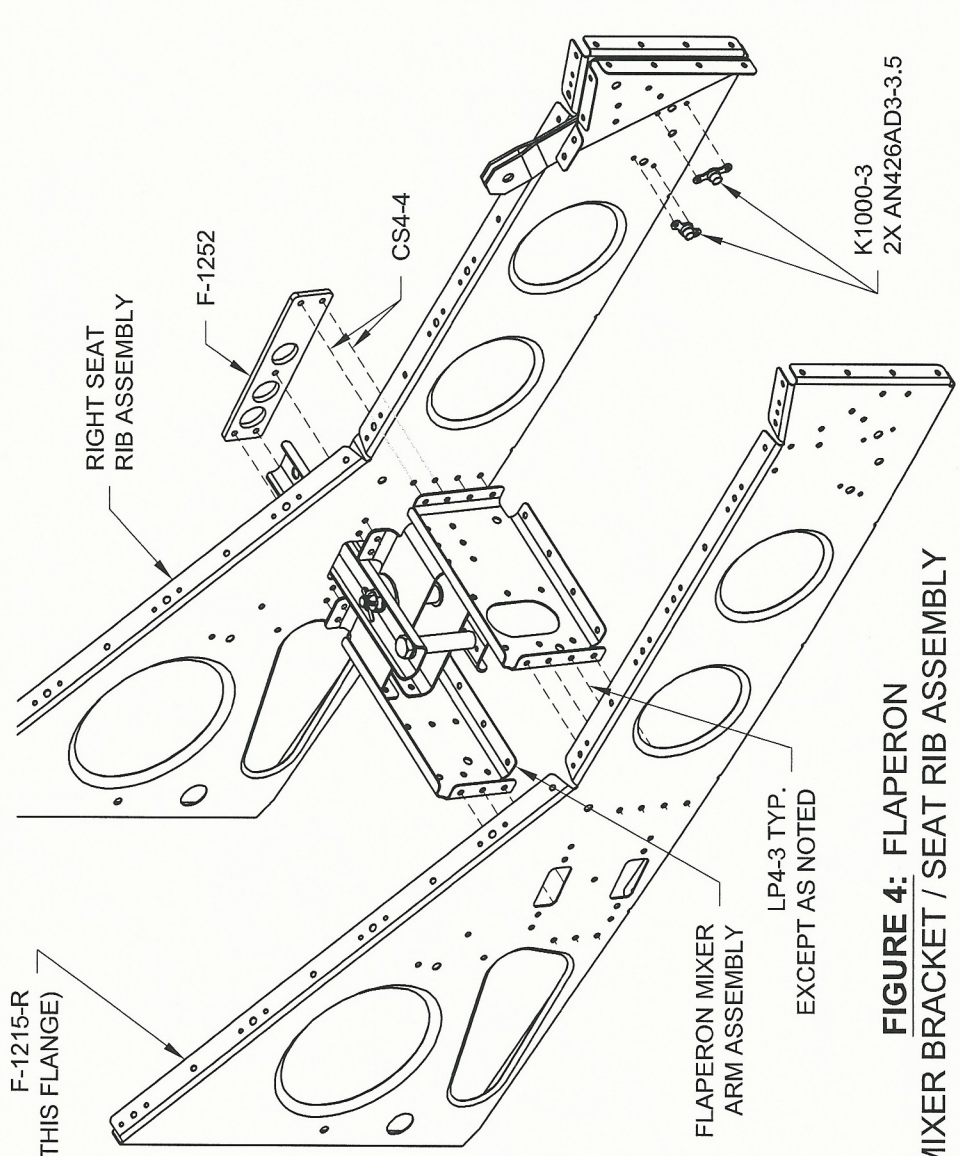


FIGURE 4: FLAPERON MIXER BRACKET / SEAT RIB ASSEMBLY