



Step 1: Using the locating holes drilled on Page 21-6 Step 7, cleco the F-1237E Seatback Hinges to the F-1225-L & -R Seat Floors as shown in Figure 1. Center the lines drawn on Page 21-6 Step 8 on the holes in the seat floors, then match-drill #30 the holes into the seatback hinges. Remove and deburr the holes.

Step 2: Except for the holes that will be used to attach the seat floor ribs (indicated in Figure 1), rivet the F-1237E Seatback Hinges to the F-1225-L & -R Seat Floors using the rivets called out.

Step 3: In both F-1225-L & -R Seat Floors, dimple the four holes in the aft flanges and the holes along the forward and inboard edges as indicated in Figure 1.

Step 4: Dimple the six nutplates, shown in Figure 1, along the forward edge of the F-1225-L & -R Seat Floors, then rivet them to the seat floors using the rivets called out.

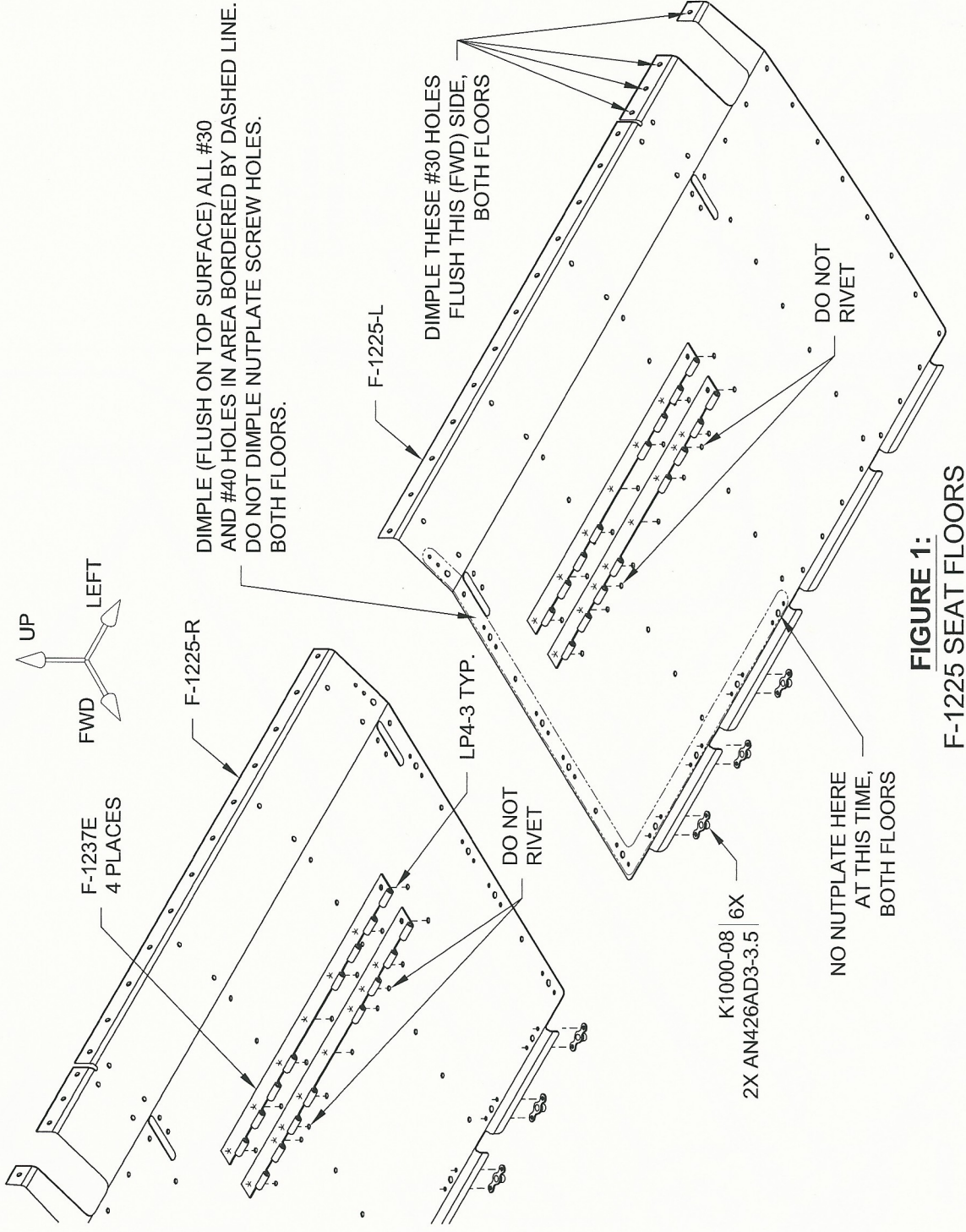


FIGURE 1:  
F-1225 SEAT FLOORS

Step 5: Separate the F-1253 Seat Floor Support by removing the hatched areas shown in Figure 2.

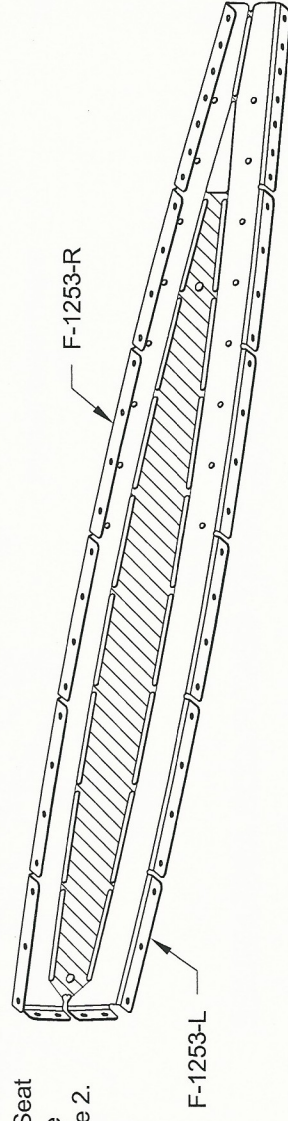


FIGURE 2: SEPARATE F-1253 SEAT FLOOR SUPPORT

Step 6: Rivet the F-1225-L Seat Floor to the remaining Left Seat Rib Assembly (except for the hole indicated) and the Flaperon Mixer Bracket / Seat Rib Assembly using the rivets called out in Figure 3.

Step 7: Dimple the nutplates shown in Figure 3, then rivet them to the Flaperon Mixer Bracket / Seat Rib Assembly and to the F-1225-L Seat Floor using the rivets called out. Temporarily install an 8-32 screw in the MS21051-L08 nutplate to prevent misalignment while riveting.

Step 8: Using the rivets called out in Figure 3, rivet the F-1253-L Seat Floor Support to the bottom of the F-1225-L Seat Floor as shown. Do not install a rivet in the aft most and forward most hole as indicated.

Step 9: Install the snap bushings called out in Figure 3.

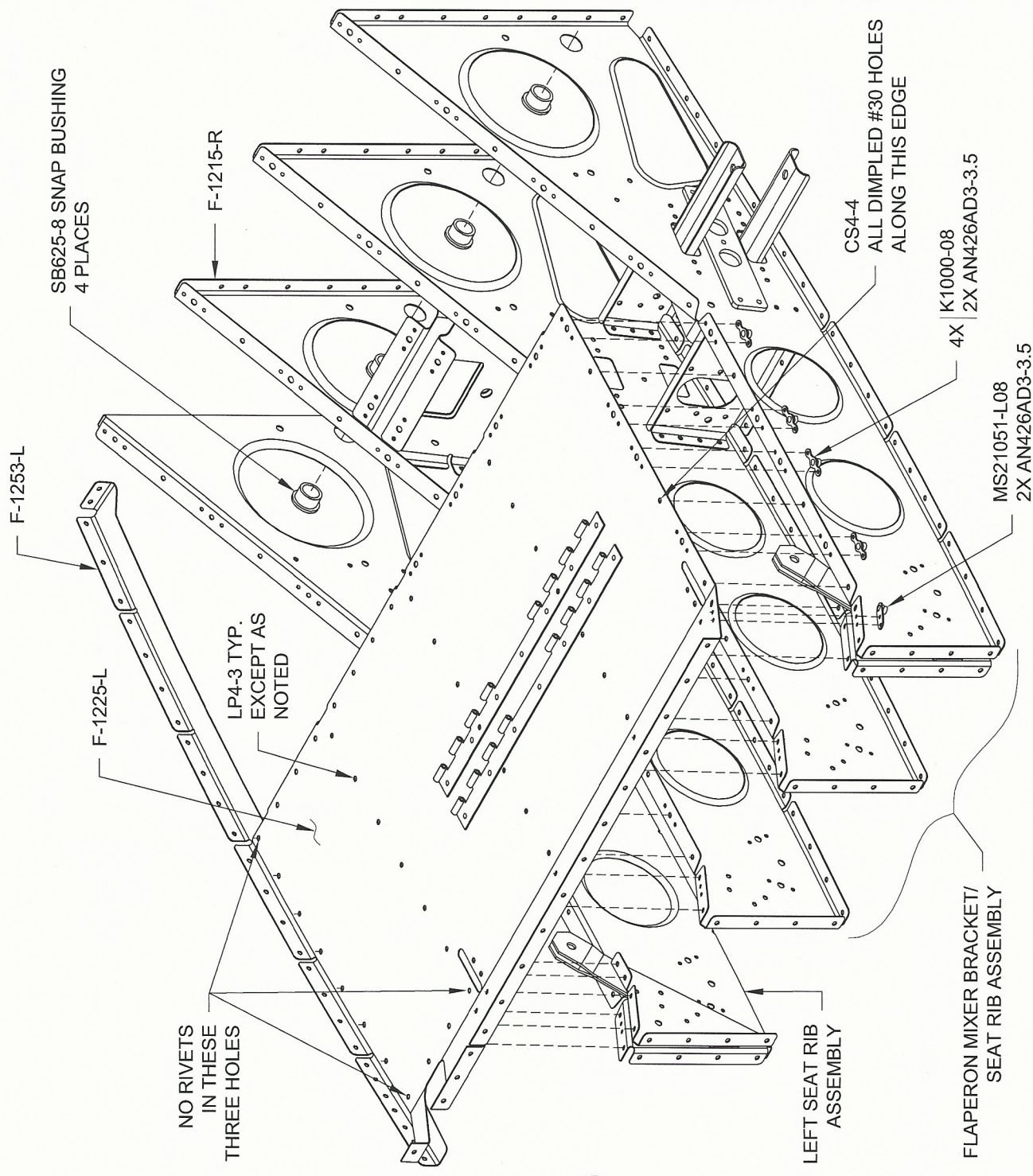


FIGURE 3: LEFT SEAT FLOOR ASSEMBLY