



Step 1: Rivet the F-1202L Gussets to the F-1202E-L & -R Bulkhead Side Channels as shown in Figure 1.

Step 2: Cleco the F-1270-L & -R Fuselage Side Skins (double check left and right), and the F-1270A and F-1270D Side Skin Doublers to the fuselage skeleton. Align the aft edge of the F-1234-L & -R Canopy Decks with the forward edge of the F-1205B Roll Bar Attach Plates.

Align the vertex of the F-1255-L & -R Longerons with the upper edge of the fuselage side skin. Clamp the longeron to the fuselage side skin. Align the outboard edge of the F-1205B Roll Bar Attach Plates with the vertex of the longeron. Clamp the roll bar attach plates to the longeron.

Step 3: Match-Drill #30 and cleco all holes common between the F-1270-L & -R Fuselage Side Skins, the F-1270A and F-1270D Side Skin Doublers and the F-1255-L & -R Longerons. Match-Drill #30 all holes common between the F-1205B Roll Bar Attach Plates and the longerons.

Step 4: Countersink hole locations in F-1270D Side Skin Doublers that use flush rivets (one for left and one for right installation). See Page 23-09 Figure 2 for locations.

Step 5: Remove, deburr and prime the F-1255-L & -R Longerons, F-1270-L & -R Fuselage Side Skins, and the F-1270A and F-1270D Side Skin Doublers. Trim the tab from the aft edge of the fuselage side skins as shown in the detail view in Figure 1. Break the bottom and aft edge of both side skins (See Section 5K).

Step 6: Dimple the nutplate holes around the triangular opening in the F-1270-L & -R Fuselage Side Skins (flush outboard side). The top center nutplate hole is inaccessible with a 3" yoke. Dimple these holes using the dies only. Place one die against a solid surface and hit the other with a hammer. Rivet nutplates to these holes as called out in Figure 1. Dimple nutplate attach holes at forward top corner of fuselage side skins as shown in Figure 1.

Step 7: Reassemble the F-1255-L & -R Longerons, F-1234-L & -R Canopy Decks, F-1270-L & -R Fuselage Side Skins and the F-1270A and F-1270D Side Skin Doublers into the fuselage.

CAUTION: Do not rivet the holes marked with a triangle in Figure 1! Cleco these holes for later assembly.

Step 8: Rivet the F-1270-L & -R Fuselage Side Skins, F-1270A and F-1270D Side Skin Doublers, F-1255-L & -R Longerons, F-1205A Roll Bar Attach Plates and F-1234-L & -R Canopy Decks to the fuselage assembly as shown in Figure 1. See 23-09 Figure 1 for rivet locations.

Step 9: Cut apart the two F-1256 Skin Stiffeners. Rivet the skin stiffeners to the F-1270-L and -R Fuselage Side Skins.

DO NOT RIVET!
 ▽ CLECO ONLY, ALL HOLES MARKED WITH A TRIANGLE.

FIGURE 1: INSTALLING THE SIDE SKINS
 (RIVETS TO BE LEFT OPEN ARE SYMMETRICAL ABOUT THE FUSELAGE CENTERLINE)