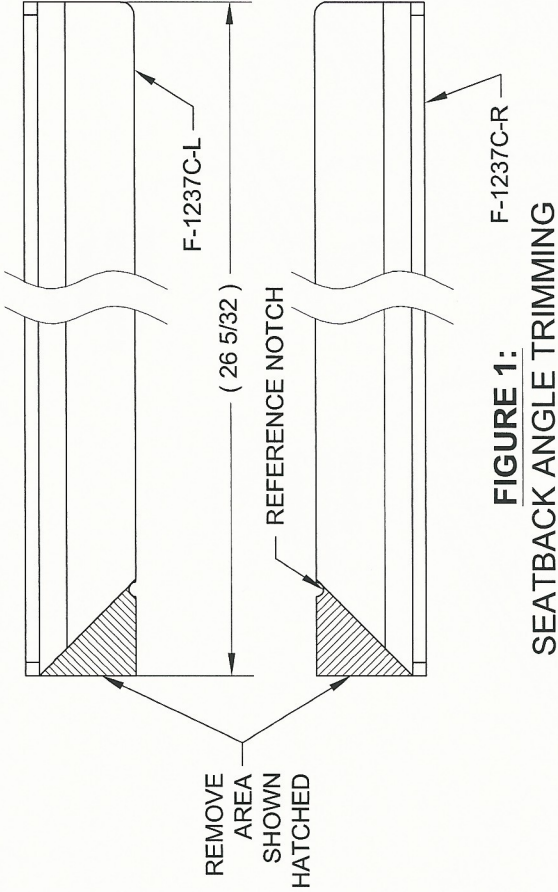
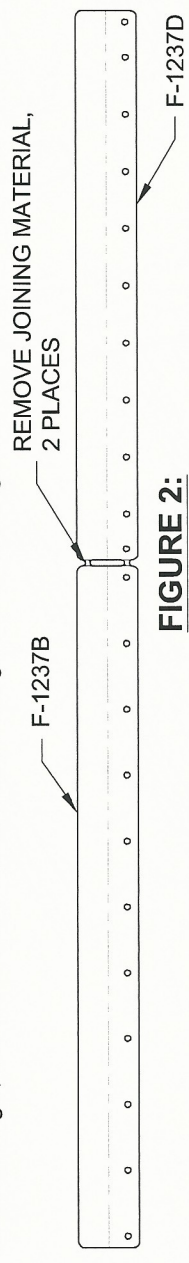


**NOTE:** The instructions in this section pertain to the assembly of one seatback only. Unless otherwise specified, all instructions given for one seatback apply to both. To help prevent mistakes and speed up the construction process, assemble both seatbacks at the same time.

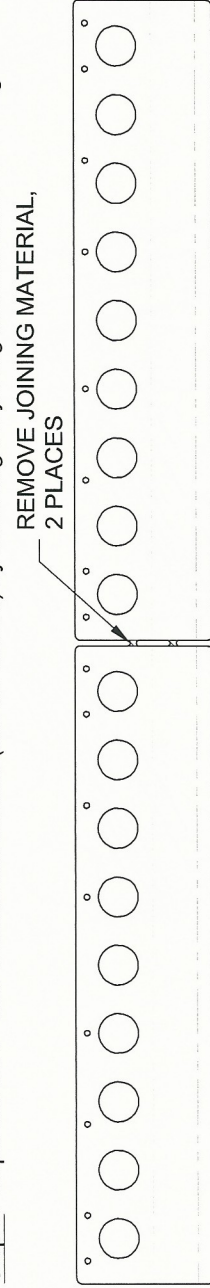
**Step 1:** Trim the bottom corners of F-1237C-L and F-1237C-R Seatback Angles to the reference notch as shown in Figure 1.



**Step 2:** Remove the joining material of the F-1237BD Seatback Angle (shown unbent) to separate the F-1237B Upper Seatback Angle, and the F-1237D Lower Seatback Angle called out in Figure 2.



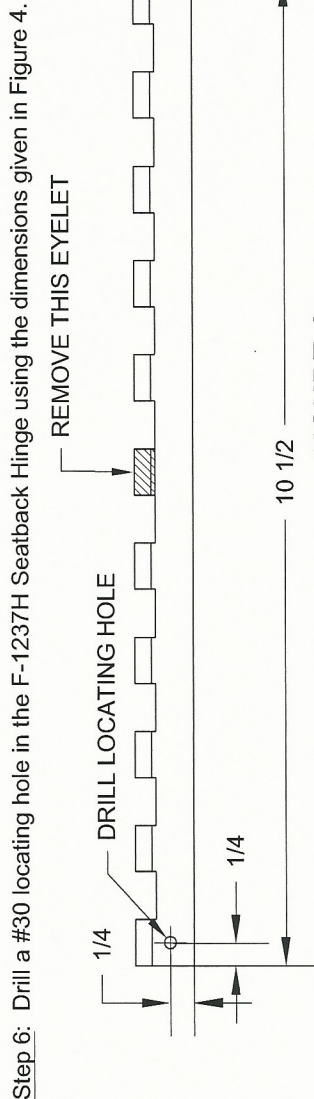
**Step 3:** Separate the F-1237G Seatback Braces (shown unbent) by removing the joining material called out in Figure 3.



**FIGURE 3:**  
F-1237G SEATBACK BRACE SEPARATION

**Step 4:** Pull the hinge pin from an AN257-P3 hinge. Set the pin aside to be used on Page 26-04.

**Step 5:** From the AN257-P3 hinge halves, make an F-1237H Seatback Hinge using the dimension given in Figure 4, and remove the center eyelet as shown in Figure 4.

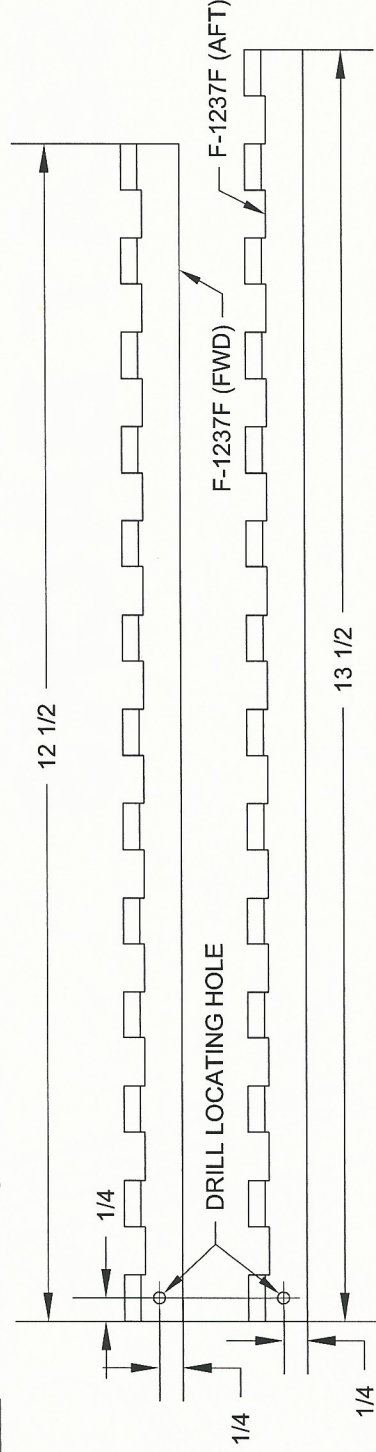


**FIGURE 4:**  
F-1237H SEATBACK HINGE PREPARATION

**Step 7:** Remove the hinge pin from an AN257-P2 hinge. Set the pin aside to be used on Page 26-04.

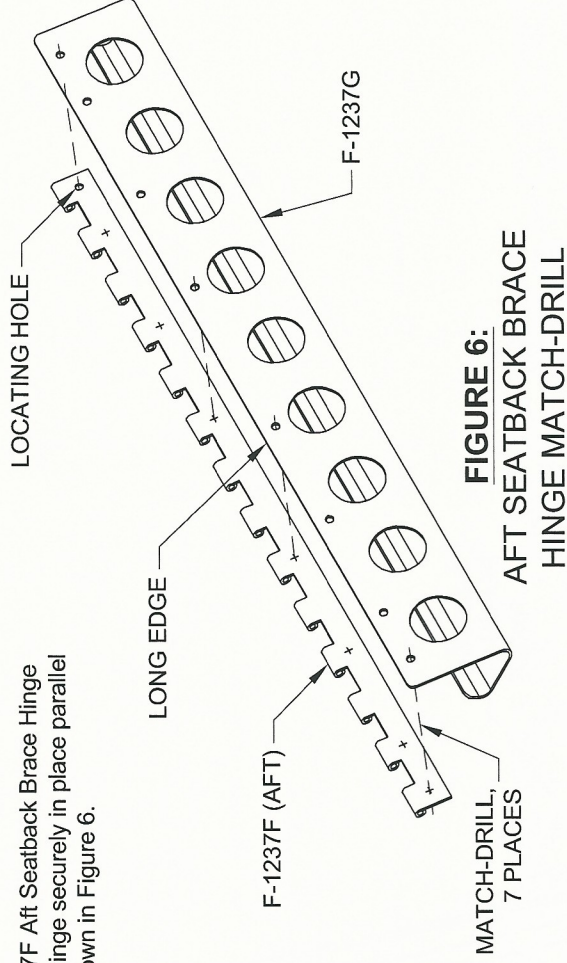
**Step 8:** From the AN257-P2 hinge halves, make the F-1237F Fwd and Aft Seatback Brace Hinges per dimensions given in Figure 5.

**Step 9:** Drill a #30 locating hole in the F-1237F Fwd and Aft Seatback Brace Hinges using the dimensions called out in Figure 5.



**FIGURE 5:**  
F-1237F FWD AND AFT  
SEATBACK BRACE HINGES

**Step 10:** Cleco the locating hole of the F-1237F Aft Seatback Brace Hinge to the F-1237G Seatback Brace. Clamp the hinge securely in place parallel to the long edge of the seatback brace as shown in Figure 6.



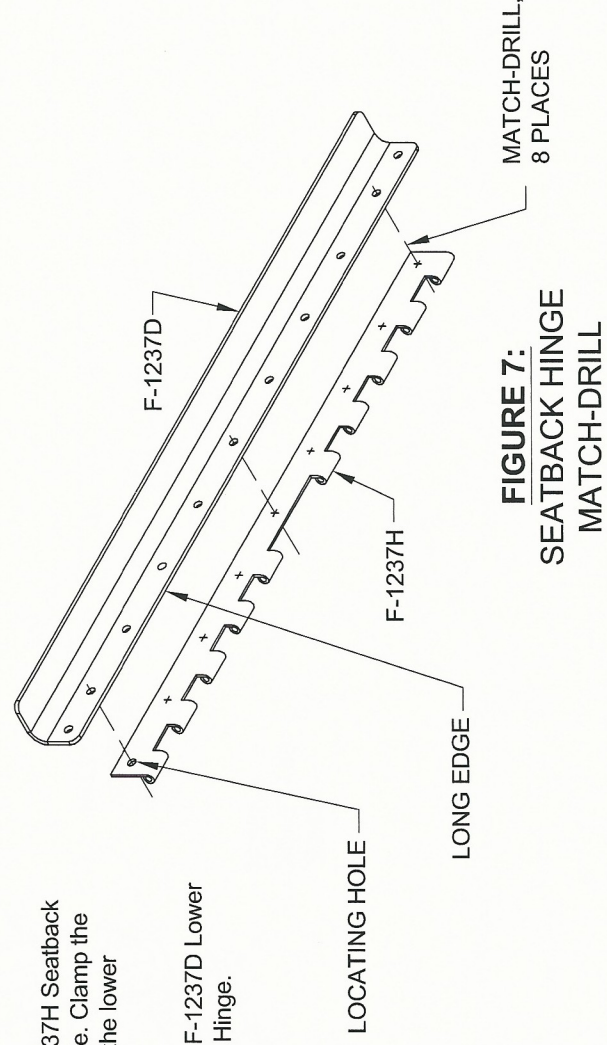
**Step 11:** Match-Drill #30 the holes from the F-1237G Seatback Brace into the F-1237F Aft Seatback Brace Hinge.

Mark parts, disassemble and deburr, cleco back together.

**Step 12:** Cleco the locating hole in the F-1237H Seatback Hinge to the F-1237D Lower Seatback Angle. Clamp the seatback hinge parallel to the long edge of the lower seatback angle as shown in Figure 7.

**Step 13:** Match-Drill #30 the holes from the F-1237D Lower Seatback Angle into the F-1237H Seatback Hinge.

Mark parts, disassemble and deburr, then cleco back together.



**FIGURE 7:**  
SEATBACK HINGE  
MATCH-DRILL