



NOTE: Throughout this section prime any parts if/as desired except any area that will be inside the tank.

NOTE: Read Section 5S for more information on fuel tank sealant. The tank is assembled much like any other structure with two important differences: Apply sealant between scuffed and cleaned parts that comprise a seam through which fuel could conceivably leak. This includes every fastener. Spin fastener shanks in sealant to apply a thin even coating before they are inserted. Read through this section and scuff mating parts before beginning assembly. Set rivets slowly using a hand blind rivet puller, allowing the tank sealant to displace before the rivet is completely set.

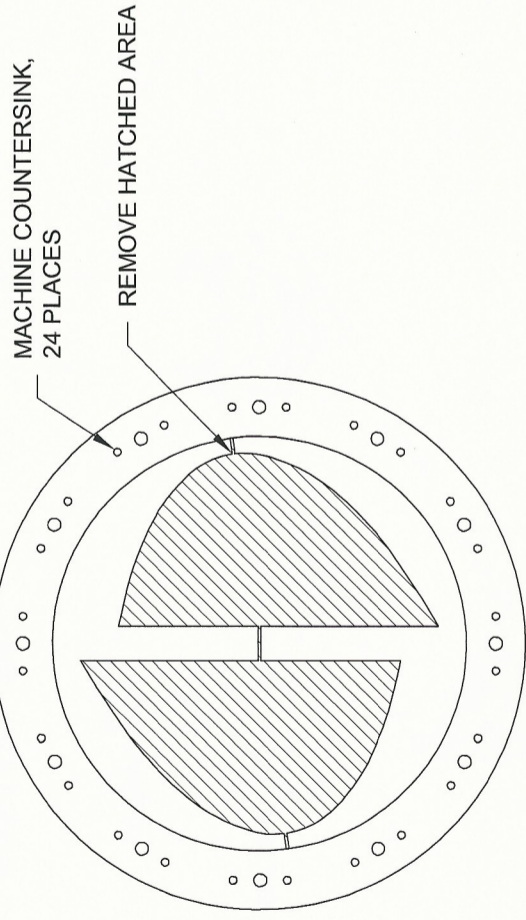


FIGURE 1: T-407/410

Step 1: Machine countersink the T-407 Ring nutplate attach holes.

Step 2: Remove and discard the area shown in Figure 1 hatched from the T-407 Ring.

Step 3: Adjust the joggled ends of the T-1202 Fwd Tank Bulkhead top flange to be parallel to the rest of the top flange as shown in Figure 2.

NOTE: The flanges of the T-1202 Fwd Tank Bulkhead are bent toward the aft face of the part.

Step 4: Dimple the T-1202 Fwd Tank Bulkhead, flush on the forward side, at the nutplate attach holes.

Step 5: Rivet the nutplates, T-407 Ring and T-1202 Fwd Tank Bulkhead together as shown in Figure 2. Refer to the fwd tank bulkhead and ring as the Fwd Bulkhead Assembly.

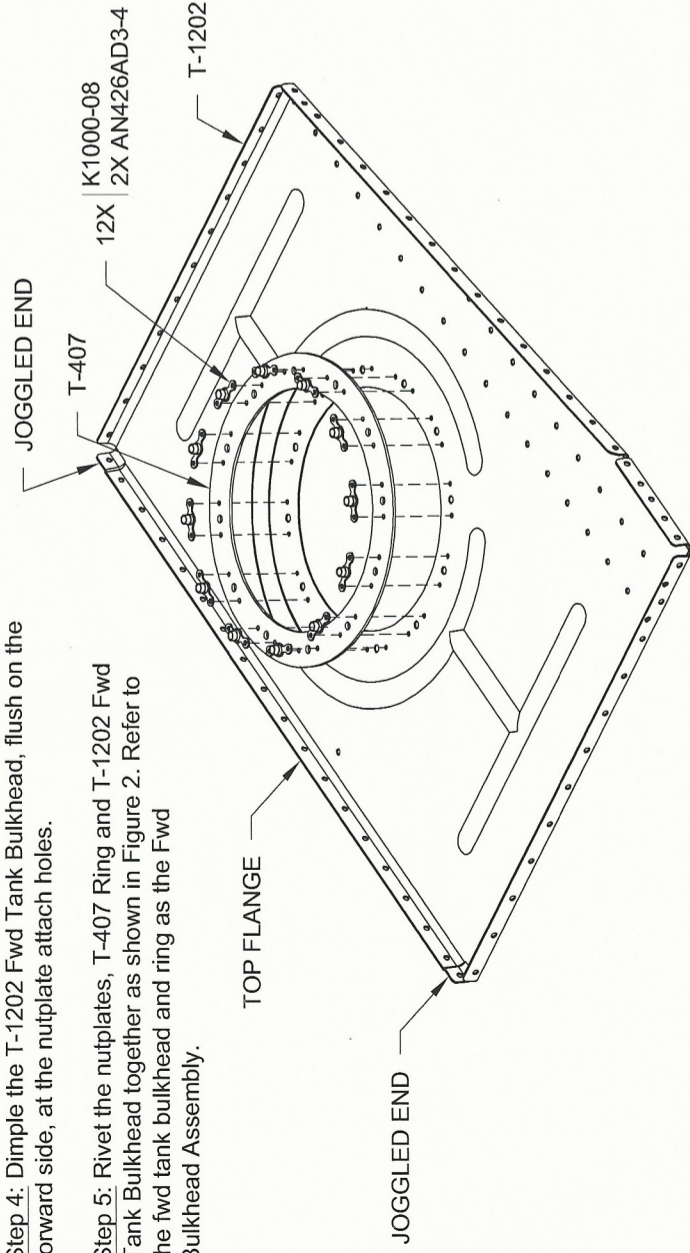


FIGURE 2: FWD BULKHEAD ASSEMBLY

Step 6: Machine countersink the #40 holes on the forward side of the T-1205 Fwd Tank Bracket for the rivets called out in Figure 3 and deburr.

Step 7: Machine countersink the lower row and right two top #30 holes on the forward side of the T-1205 Fwd Tank Bracket for the rivets called out in Figure 3. Deburr the edges of the fwd tank bracket.

Step 8: Rivet the VA-210 Fuel Flange and the T-1201 Main Tank Skin to the Fwd Bulkhead Assembly per call-outs in Figure 3.

Step 9: Install the AN832-4D bulkhead fitting to the T-1201 Main Tank Skin per call-outs in Figure 3.

Step 10: Rivet the T-1205 Fwd Tank Bracket to the Fwd Bulkhead Assembly using rivets called out in Figure 3.

Step 11: Rivet the T-00008 Inboard Clip and T-00009 Outboard Clip to the T-1201 Main Tank Skin as shown in Figure 3.

Coat the shop heads of the inboard and outboard clip rivets with fuel tank sealant.

Step 12: Rivet a nutplate to the T-1205 Fwd Tank Bracket and T-00008 Inboard Clip as shown in Figure 3.

Rivet a second nutplate to the fwd tank bracket and T-00009 Outboard Clip as shown in Figure 3.

NOTE: When installing fluid fittings with pipe threads do not use Teflon Tape! Use instead fuel lube or equivalent pipe thread sealing paste.

Step 13: After the sealant cures, install the VA-261 Fuel Strainer as shown in Figure 3.

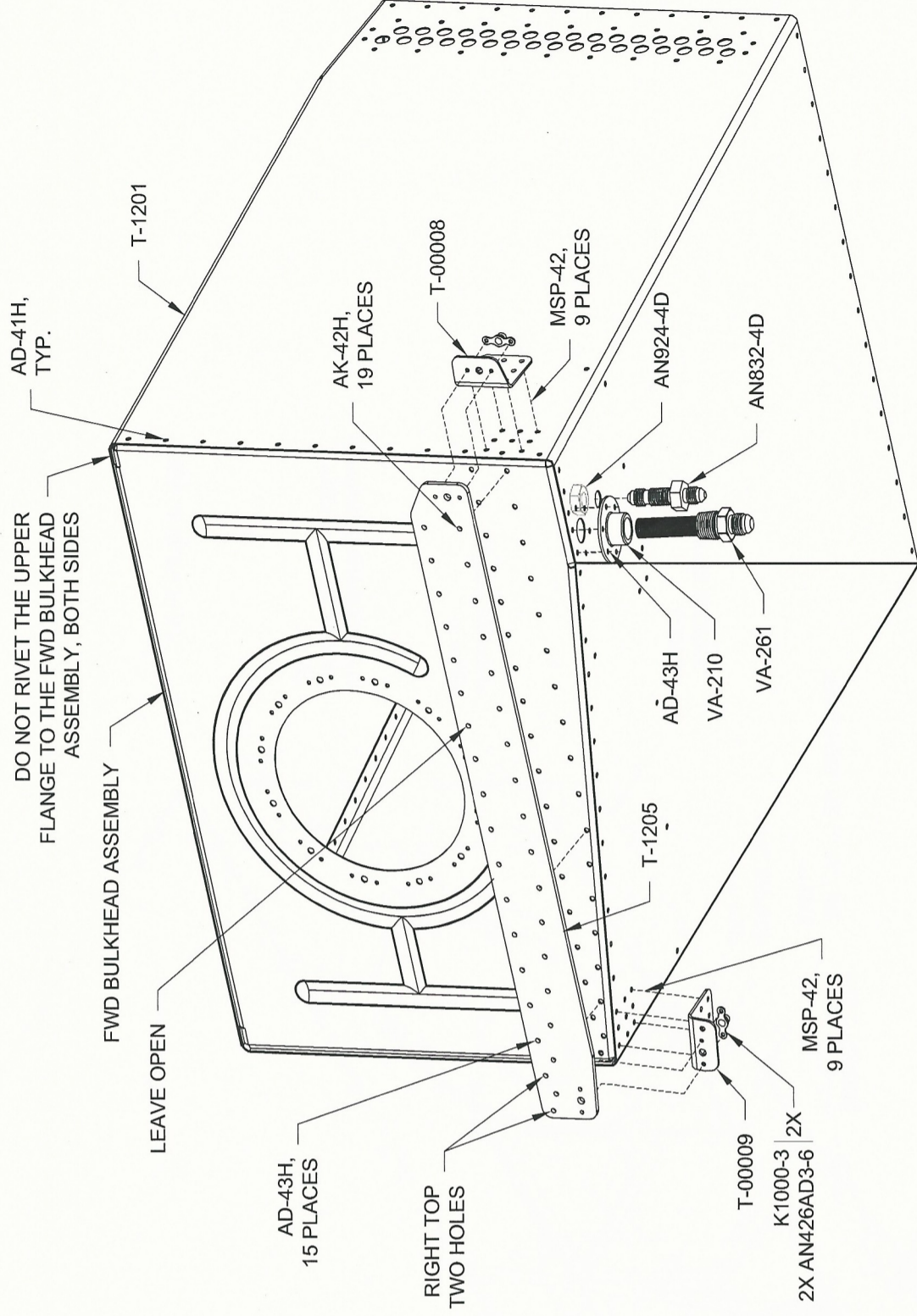


FIGURE 3: ADDING THE MAIN TANK SKIN