



Step 1: Cleco the Top Tank Skin Assembly to the Fuel Tank Assembly as shown in Figure 1.

Temporarily bolt the Fuel Tank Assembly to the Center Section Assembly and the F-1207J Attach Angle using the hardware call-outs in Figure 1.

Step 2: Use two hose clamps and the T-1212 Fuel Neck Collar to join the T-1211 Fuel Neck and Top Tank Skin Assembly together as shown in Figure 1.

Center the fuel neck on the skin fuel opening as shown in Figure 1. For the best fit of the fuel neck (between the Fuel Tank Assembly and the F-1277-R Fwd Turtle Deck Skin) it may be necessary to adjust the length by loosening the hose clamps and extending or shortening the assembly.

Bend the upper flange of the fuel neck as required for a best fit against the fwd turtle deck skin (small gaps can be filled with fuel tank sealant).

Step 3: Once satisfied with the fit and position of the T-1211 Fuel Neck, match-drill #30 the holes in the F-1277-R Fwd Turtle Deck Skin into the flange of the fuel neck, cleco as you go. Remove the fuel neck and deburr holes.

Step 4: Remove the fuel tank from the fuselage. Remove the Top Tank Skin Assembly from the Fuel Tank Assembly.

Step 5: Check to be thoroughly sure that no chips or construction debris remain in the Fuel Tank Assembly.

Step 6: Fabricate two T-1216 Clips per Figure 2.

**NOTE: Cleco the Top Tank Skin Assembly to the Fuel Tank Assembly for reference.**

Step 7: Fabricate the T-1215 Fuel Return Line using a 34 1/4 inch length of AT0-032X1/4 soft aluminum tube. Install a nut and sleeve on one end of the fuel return line and flare that end.

From the bulkhead fitting, route the fuel return line up to the Top Tank Skin Assembly, then aft (near the rivet holes for the T-1216 Clips), then the remainder up through the fuel tank opening.

Capture the fuel return line with the clips and rivet the clips to the top tank skin per the call-out in Figure 1.

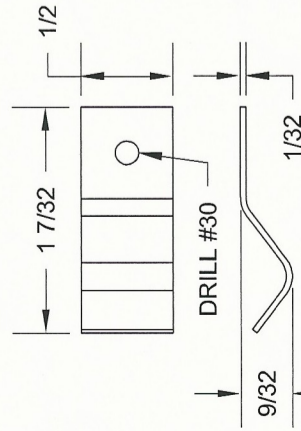
Step 8: Rivet the Top Tank Skin Assembly to the Fuel Tank Assembly per the call-out in Figure 1.

Install the T-1215 Fuel return line to the AN832-4D bulkhead fitting.

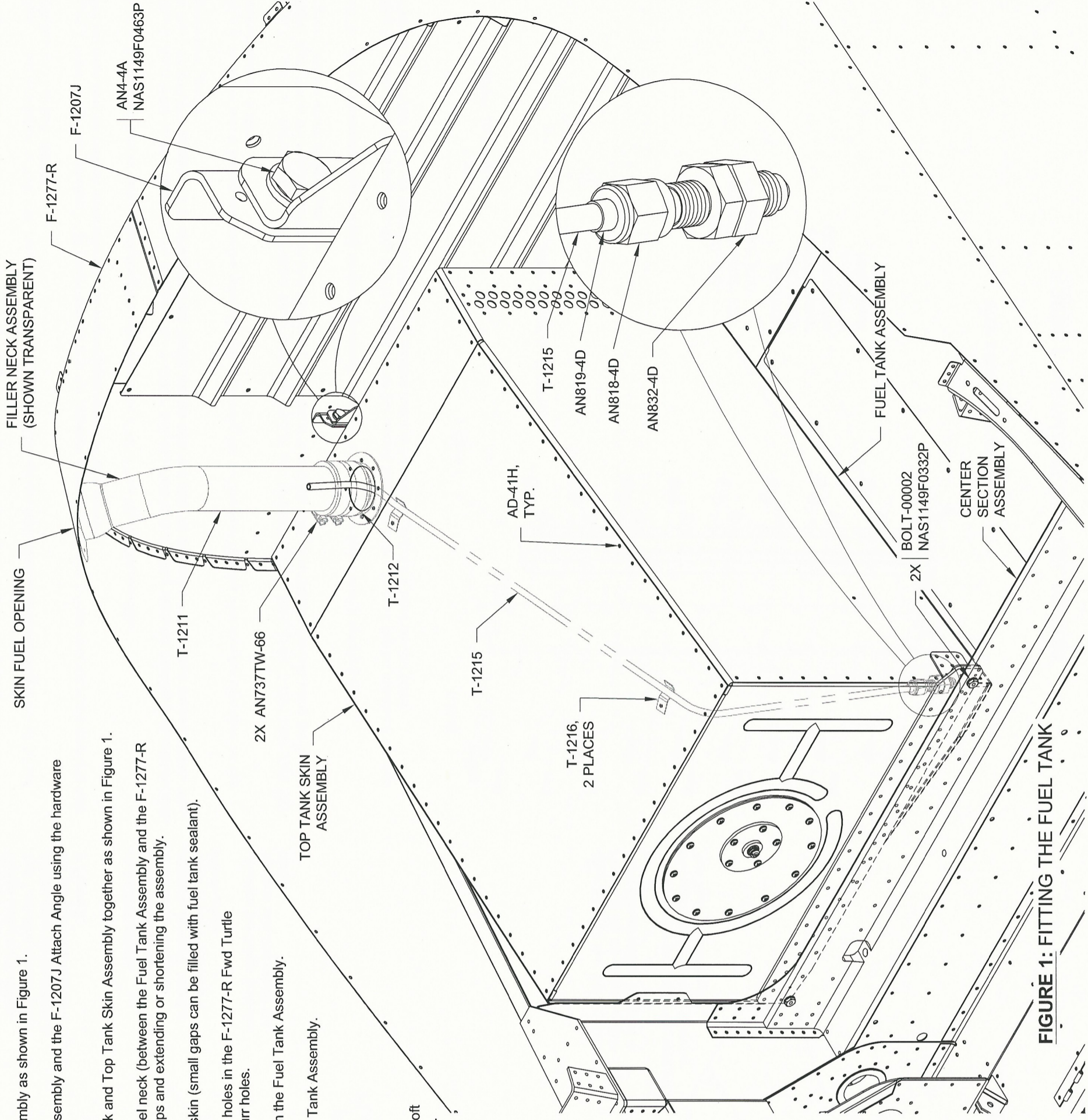
Step 9: Add sealant in any remaining areas, corners cracks and crannies as necessary.

Install the T-1209 Res Sender Plate and IE F-385B Sending Unit with sealant using the hardware called out on Page 37-04, Figure 3.

Use a 1/16 inch thick layer of sealant between the res sender plate and the T-1202 Fwd Tank Bulkhead and in place of the IE F-385 Gasket. Tighten screws just enough to cause sealant to bulge evenly from underneath the perimeter of the sender plate.



**FIGURE 2: T-1216 FABRICATION**



**FIGURE 1: FITTING THE FUEL TANK**