

SECTION 33: BAGGAGE AREA

F-1080
RIGHT BAGGAGE
COVER

F-1022A-R
BAGGAGE
FLOOR

F-10103A-R
LOWER SEAT
HINGE HALF

F-1024-R
SEAT FLOOR

F-1006E
UPPER BAGGAGE
BULKHEAD CORRUGATION

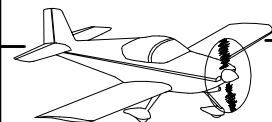
F-1006F
LOWER BAGGAGE
BULKHEAD CORRUGATION

F-1031
UPPER BAGGAGE DOOR
SEAL CHANNEL

F-1026
LOWER BAGGAGE DOOR
SEAL CHANNEL

F-1022A-L
BAGGAGE FLOOR

F-1024-L
SEAT FLOOR



NOTE: Complete this page for the Standard Kit only.

Step 1: Cleco the F-1024-R Seat Floor to the F-1005A Rear Spar Bulkhead, the five F-1017A-R Rear Seat Ribs, and the F-1018-R Outboard Rear Seat Rib, as shown in Figure 1.

Similarly, cleco the F-1024-L Seat Floor to the rear spar bulkhead and rear seat ribs on the left side.

Step 2: Match-Drill #40 the 3/32" nutplate attachment rivet holes along the inboard edge of the F-1024 Seat Floors into the underlying F-1017A Rear Seat Ribs.

Final-Drill #40 all the remaining 3/32" nutplate attachment rivet holes in both seat floors.

Step 3: Final-Drill #19 the center screw holes in the four nutplate hole patterns along the inboard edge of both F-1024 Seat Floors.

Step 4: Except for the holes indicated in Figure 1, final-drill #30 all the 1/8" holes in both seat floors.

F-1018-R

F-1017A-R
5 PLACES

F-1005A

F-1024-L

F-1024-R

DO NOT FINAL-DRILL
THESE 1/8" HOLES.
BOTH FLOORS
(STEP 4)

FIGURE 1: CLECOING THE SEAT FLOORS

Step 5: Cut two 16" lengths of AN257-P3 and remove the pins. Make the F-10103A-L and -R Lower Seat Hinge Halves using the information given in Figure 2 (don't forget to remove the two eyes indicated in the figure) The information is for the right hinge half, the left hinge half is the mirror of the right.

Save the pins and unused hinge halves, they are used in Section 42.

Step 6: Locate the F-10103A-R Right Lower Seat Hinge Half on the F-1022-R Baggage Floor as shown in Figure 2, then Match-Drill the holes of the seat floor into the hinge half using an 1/8" drill.

Repeat this step for the F-10103A-L Left Lower Seat Hinge Half and the F-1022-L Baggage Floor.

F-1022-R

REMOVE THESE
TWO EYES

F-10103A-R
(MAKE FROM AN257-P3)

**FIGURE 2: MAKING THE
LOWER SEAT HINGE HALVES**

Step 7: Cleco the F-1022A-L and -R Baggage Floors to the F-1006B Bulkhead, the F-1023-L and -R Baggage Floor Angles, the F-1019, -1020, and -1021 Baggage Ribs, and the F-1024-L and -R Seat Floors as shown in Figure 3.

Cleco the F-10103A Lower Seat Hinge Halves to the baggage floors and the F-1034A Bulkhead.

F-1022A-R

F-10103A-R

F-1023-R

F-1021-R

F-1020-R

F-1019-R

F-1034A

F-1024-R

F-1006B

F-1006A

F-1022A-L

FIGURE 3: CLECOING THE BAGGAGE FLOORS

Step 8: Final-Drill #40, deburr, and dimple the holes in the vertical flange of the two F-1023B Baggage Floor Angles which are common to the F-1070 Mid Side Skins.

Cleco the baggage floor angles to the mid side skins and F-1022A Baggage Floors as shown in Figure 4 (only the F-1023B-R Baggage Floor Angle is shown).

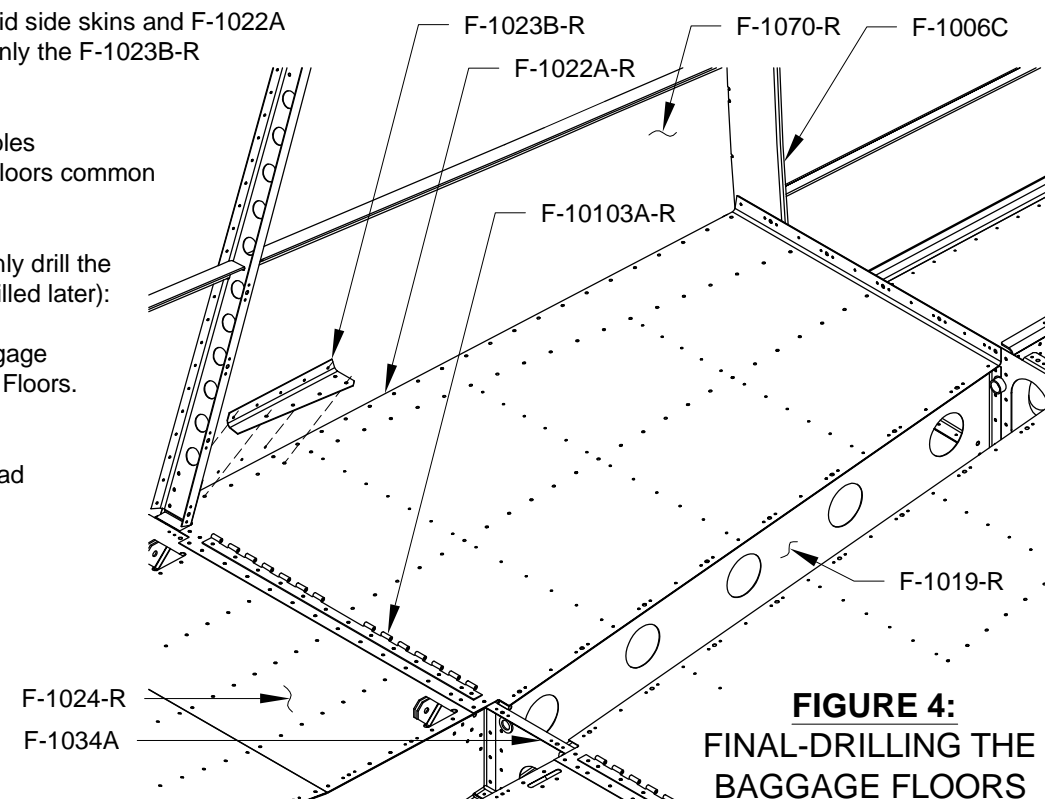
Step 9: Final-Drill #40 all of the 3/32" holes along the inboard edge of the baggage floors common to the F-1019 Inbd Baggage Ribs.

Step 10: Final-Drill #30 the following (only drill the holes specified, all other holes will be drilled later):

The holes common to the F-1023B Baggage Floor Angles and the F-1022A Baggage Floors.

The row of holes common to both baggage floors and the F-1034A Bulkhead (including the F-10103A Lower Seat Hinge Halves).

The row of holes along the forward edge of the F-1022A Baggage Floors common to the F-1024 Seat Floors.

**FIGURE 4:
FINAL-DRILLING THE
BAGGAGE FLOORS**

Step 1 (Quick Build): Separate the F-10100 Baggage Door Shim, shown in Figure 1, into its component parts; the F-10100A and F-10100B. (The F-10100A has already been installed as part of the quick build kit and can be discarded.) Remove any remaining stubs from the edge of the F-10100B.

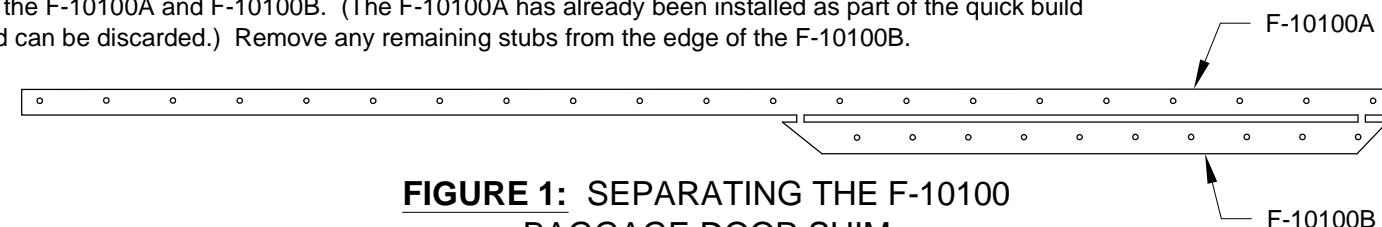


FIGURE 1: SEPARATING THE F-10100 BAGGAGE DOOR SHIM

NOTE: Complete the rest of this page for both the Standard and Quickbuild Kits.

Step 2: Final-Drill #40 and dimple the holes in the F-10100B Baggage Door Shim and F-1026 Lower Baggage Door Seal Channel which are common to the F-1070-L and F-1073-L Side Skins. See Figure 2. The baggage door shim is not symmetrical, be sure to dimple in the correct direction.

Step 3: Cleco the F-1026 Lower Baggage Door Seal Channel and the F-10100B Baggage Door Shim to the F-1070-L and F-1073-L Side Skins as shown in Figure 2. Cleco the two end-tabs of the lower baggage door seal channel to the F-1006A Bulkhead and the F-1022A-L Baggage Floor.

Step 4: There are two holes in the bottom end-tab of the F-1026 Lower Baggage Door Seal Channel. Match-Drill #30 the inboard hole into the F-1022A-L Baggage Floor and final-drill the outboard hole.

Final-Drill #30 the two holes common to the top end-tab of the lower baggage door seal channel and the F-1006A Bulkhead.

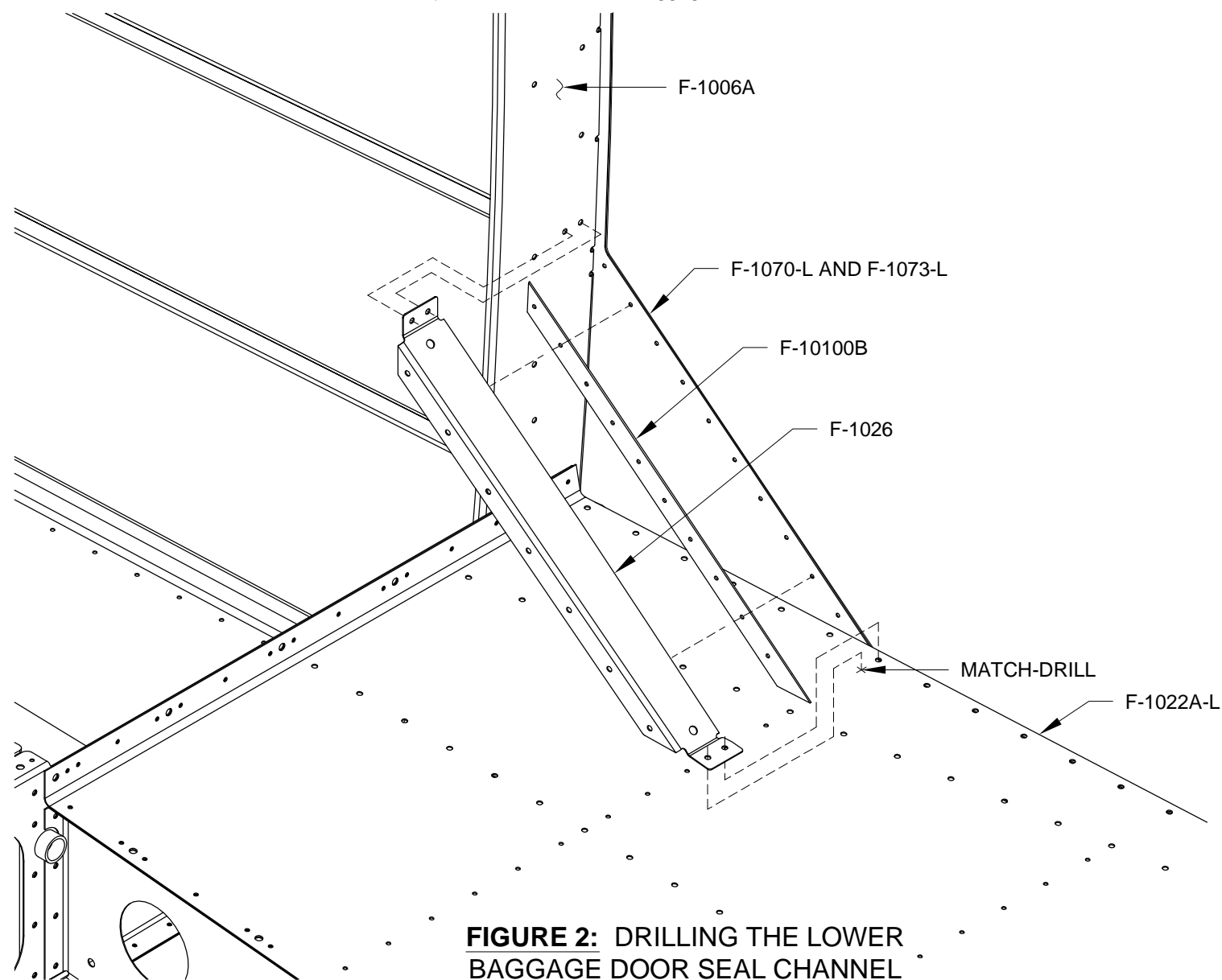


FIGURE 2: DRILLING THE LOWER BAGGAGE DOOR SEAL CHANNEL

Step 5: Trim the shaded area shown in Figure 3 from the F-1031 Upper Baggage Door Seal Channel.

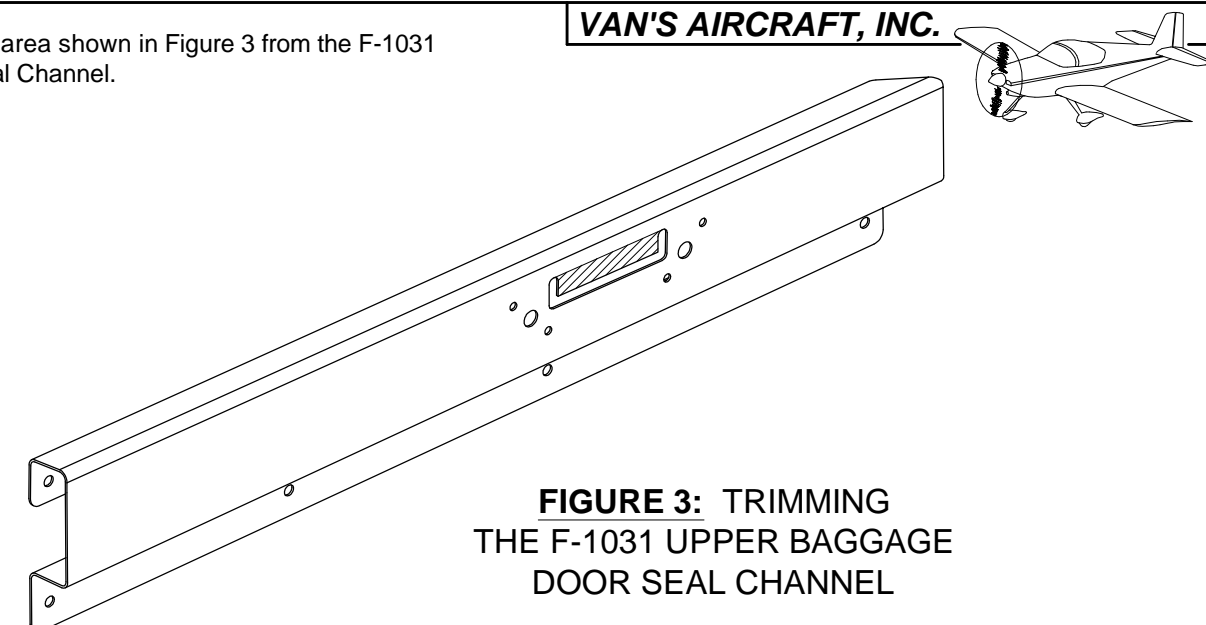


FIGURE 3: TRIMMING THE F-1031 UPPER BAGGAGE DOOR SEAL CHANNEL

Step 6: Final-Drill #30 the hole in the outboard flange of the F-1031 Upper Baggage Door Seal Channel which is common to the outboard hole in the end tab of the F-1026 Lower Baggage Door Seal Channel. See Figure 4.

Step 7: Cleco the F-1031 Upper Baggage Door Seal Channel to the F-1006A Bulkhead and F-1026 Lower Baggage Door Seal Channel as shown in Figure 4.

Step 8: Cleco the F-1027 Close-Out Panel to the F-1026 Lower Baggage Door Seal Channel and the F-1006A Bulkhead.

Step 9: Match-Drill #30 the holes in the lower flange of the F-1027 Close-Out Panel into the F-1022A-L Baggage Floor.

Final-Drill #30 the holes common to the vertical flange of the close-out panel and the F-1006A Bulkhead, and the holes common to the close-out panel and the F-1026 Lower Baggage Door Seal Channel.

Step 10: Final-Drill #30 the holes common to the F-1031 Upper Baggage Door Seal Channel and the F-1006A Bulkhead.

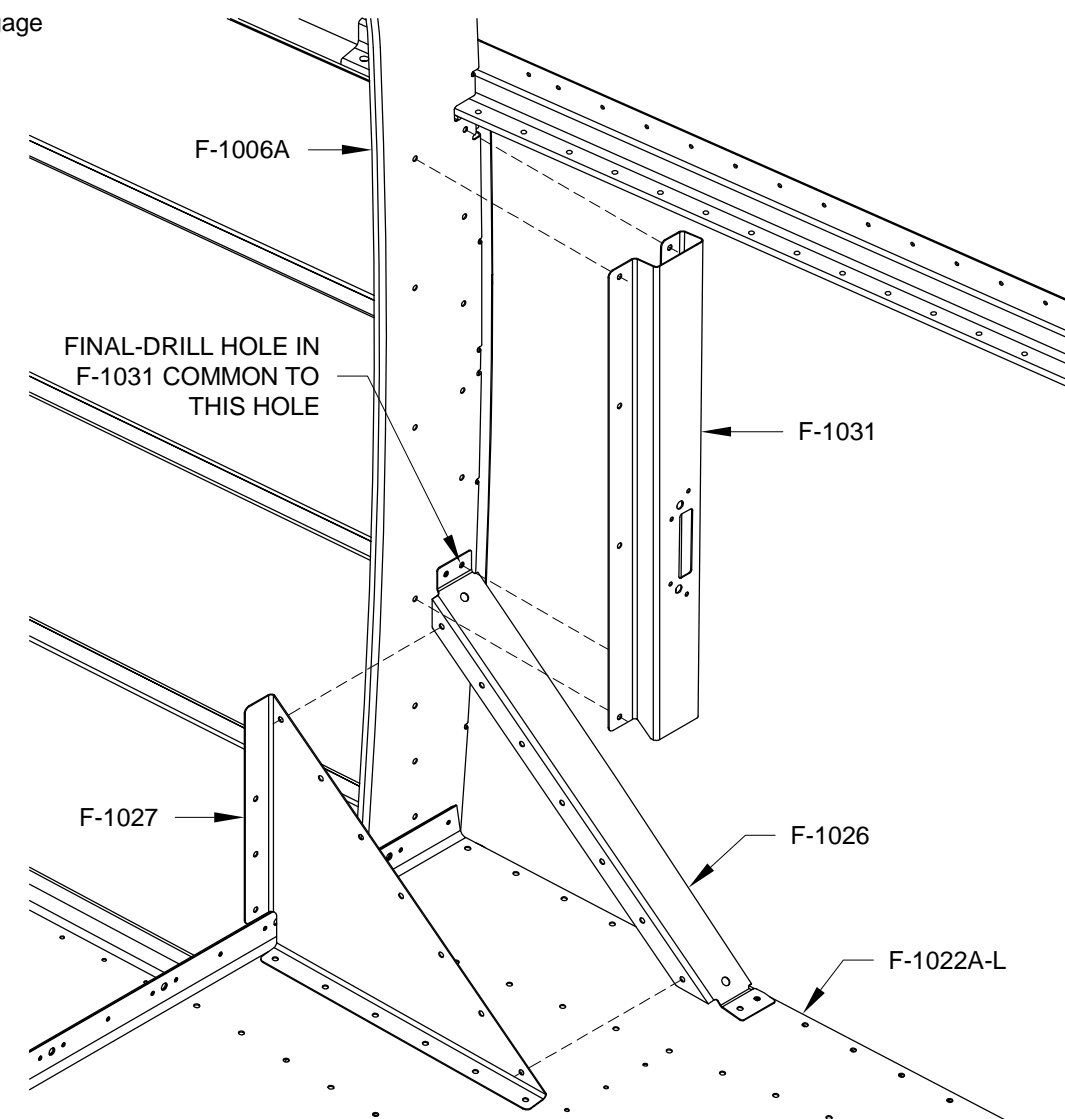


FIGURE 4: UPPER BAGGAGE DOOR SEAL CHANNEL AND CLOSE-OUT PANEL



Step 1 (Standard Kit): One of the two F-1022 Baggage Floor Stiffeners is shown (unbent) in Figure 1. Separate them into their component parts (F-1022B, C, D, E, F, and G) by removing the shaded areas depicted in the figure.

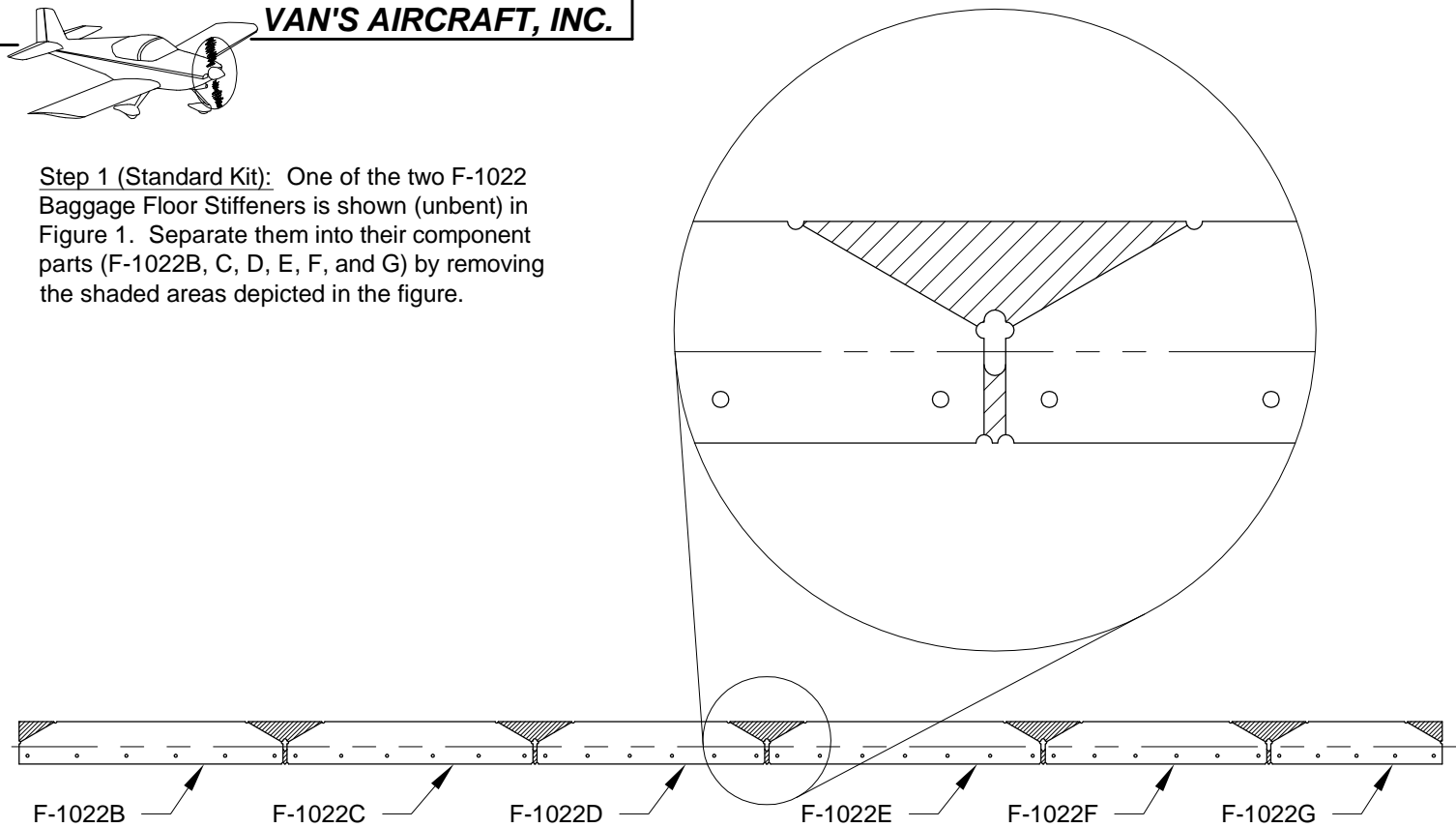


FIGURE 1: SEPARATING THE F-1022 BAGGAGE FLOOR STIFFENERS

Step 2 (Standard and Quickbuild Kit): Remove from the fuselage all of the parts clecoed in this section.

NOTE: Complete the rest of this page for the Standard Kit only.

Step 3: As shown in Figure 2, cleco the F-1022 Baggage Floor Stiffeners to the bottom of the F-1022A-L and -R Baggage Floors (only the right baggage floor is shown in the figure), then final-drill #40 the holes common to the parts.

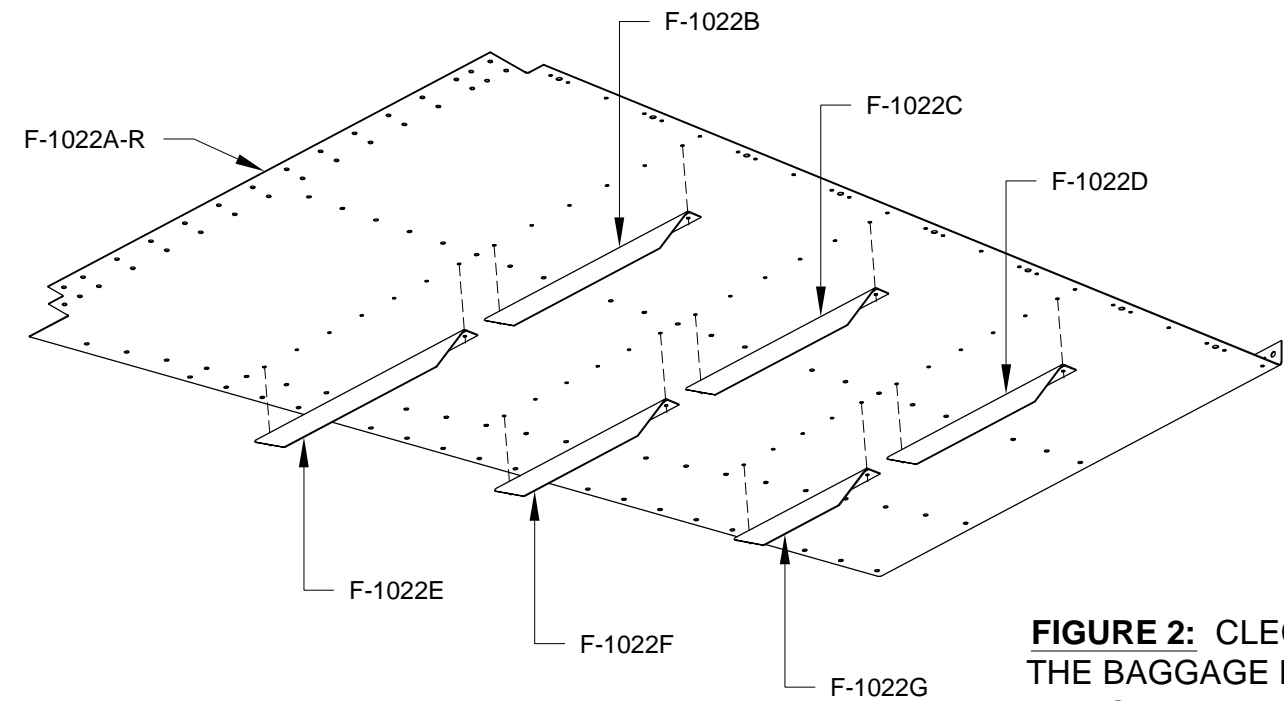


FIGURE 2: CLECOING THE BAGGAGE FLOOR STIFFENERS

Step 4: Final-Drill #40 the 3/32" holes in the aft flange of both F-1022A Baggage Floors.

Step 5: Final-Drill #30 the three rows of holes in both F-1022A Baggage Floors indicated in Figure 3.

Step 6: Deburr the holes of all parts drilled in this section.

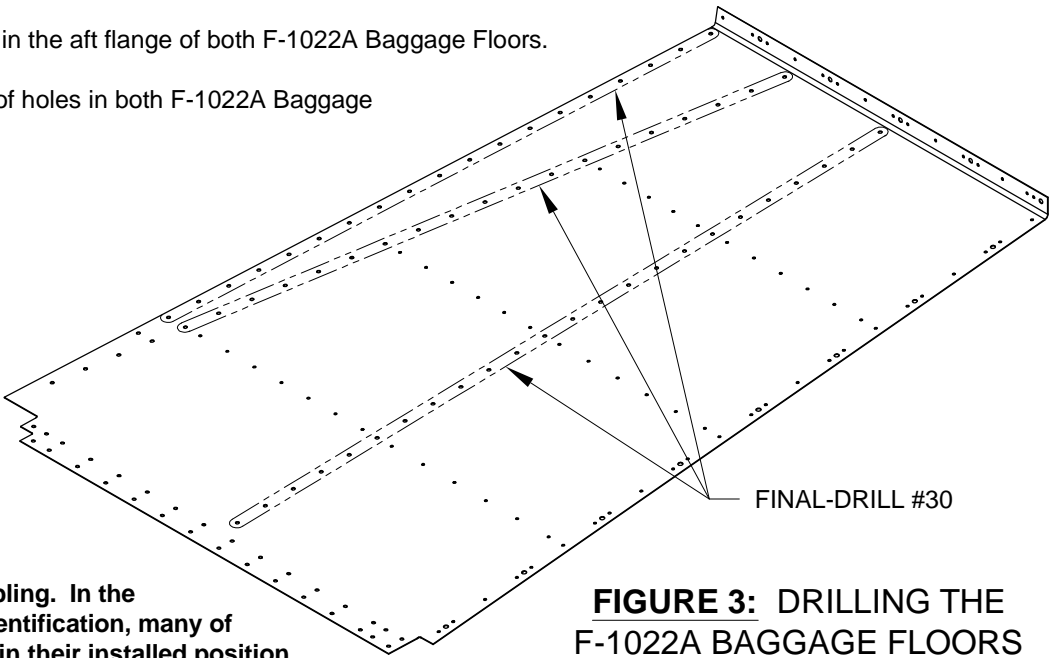


FIGURE 3: DRILLING THE F-1022A BAGGAGE FLOORS

NOTE: Now begins the task of dimpling. In the following steps, to facilitate hole identification, many of the parts being dimpled are shown in their installed position.

Step 7: Dimple the #40 nutplate attachment rivet holes near the outboard edge of both F-1024 Seat Floors (see Figure 4). Do not dimple the #19 holes.

Step 8: Dimple the holes along the forward edge of both F-1024 Seat Floors (see Figure 4) and the common holes in the underlying flange of the F-1005A Rear Spar Bulkhead. The #19 holes are dimpled for AN509 flush head screws.

Step 9: Dimple the #30 and #40 holes along the inboard edge of both F-1024 Seat Floors (see Figure 4) and the common holes in the underlying flange of the F-1017A Rear Seat Ribs. Do not dimple the #19 holes.

Step 10: There are nutplate hole patterns punched in the top flange of the F-1005A and F-1034A Bulkheads between the F-1024 Seat Floors. Of these holes, dimple the #40 holes in the F-1034A Bulkhead and the #40 and #19 holes in the F-1005A bulkhead.

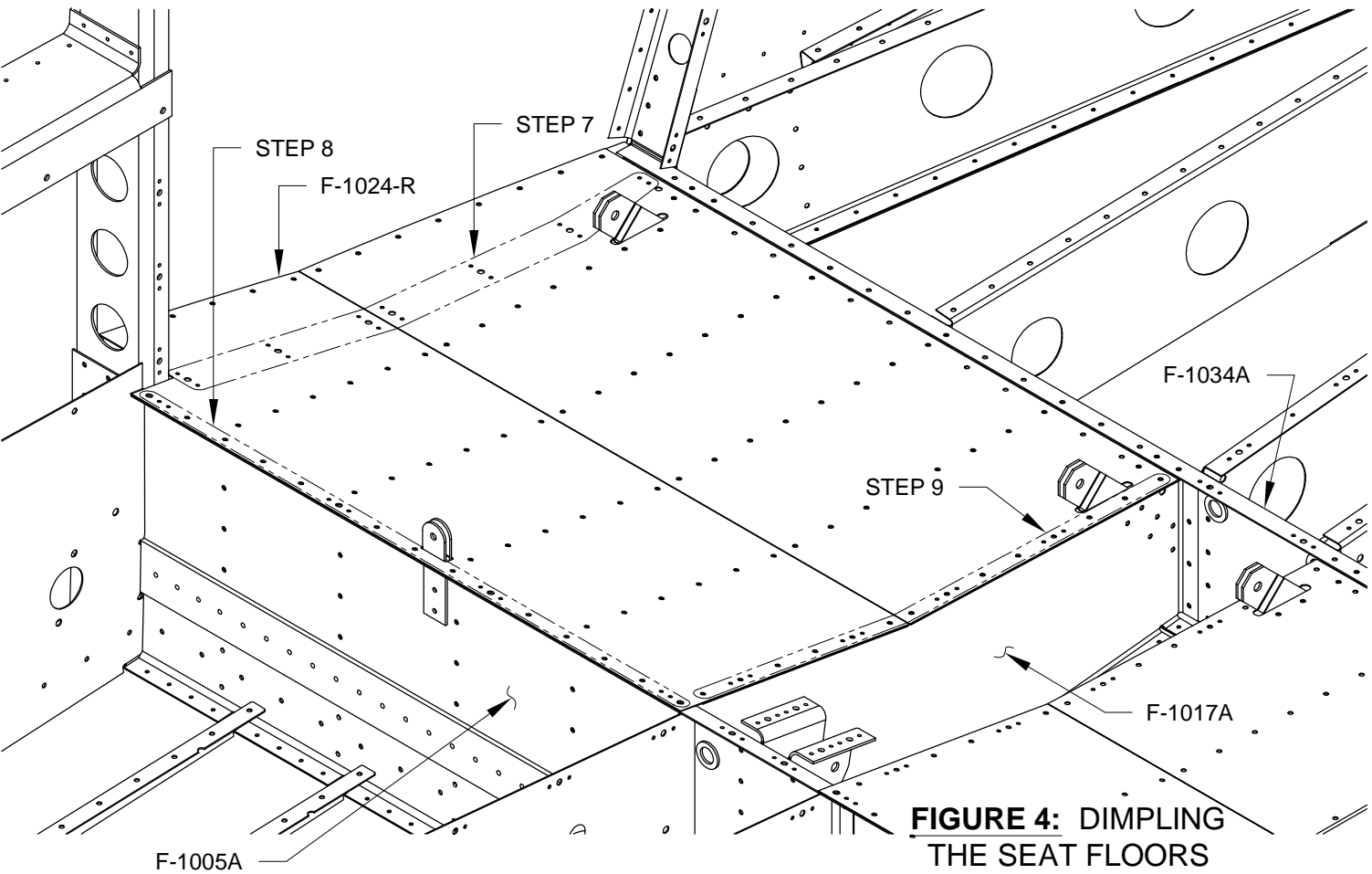
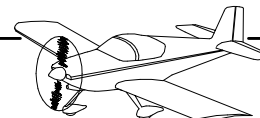


FIGURE 4: DIMPLING THE SEAT FLOORS



Step 1 (Standard Kit): Dimple the #30 and #40 holes in both baggage floors (including the holes in the aft flange) except for the following:

Do not dimple the holes in the F-1022A-L Baggage Floor which are common to the bottom flange of the F-1027 Close-Out Panel (see Figure 2 below), or the single hole indicated on the bottom of Page 33-6, Figure 2.

Do not dimple the holes in both baggage floors indicated in Figure 1.

Step 2 (Standard Kit): Dimple the #19 holes along the inboard edge of both F-1022A Baggage Floors (common to the F-1019 Inbd Baggage Ribs) for AN509 flush head screws.

Step 3 (Standard Kit): Dimple all of the holes in the top flange of the F-1019 Inbd Baggage Ribs for the dimples in the F-1022A Baggage Floors.

Step 4 (Standard Kit): Dimple the #30 holes in the F-1023B Baggage Floor Angles which are common to the F-1022A Baggage Floor.

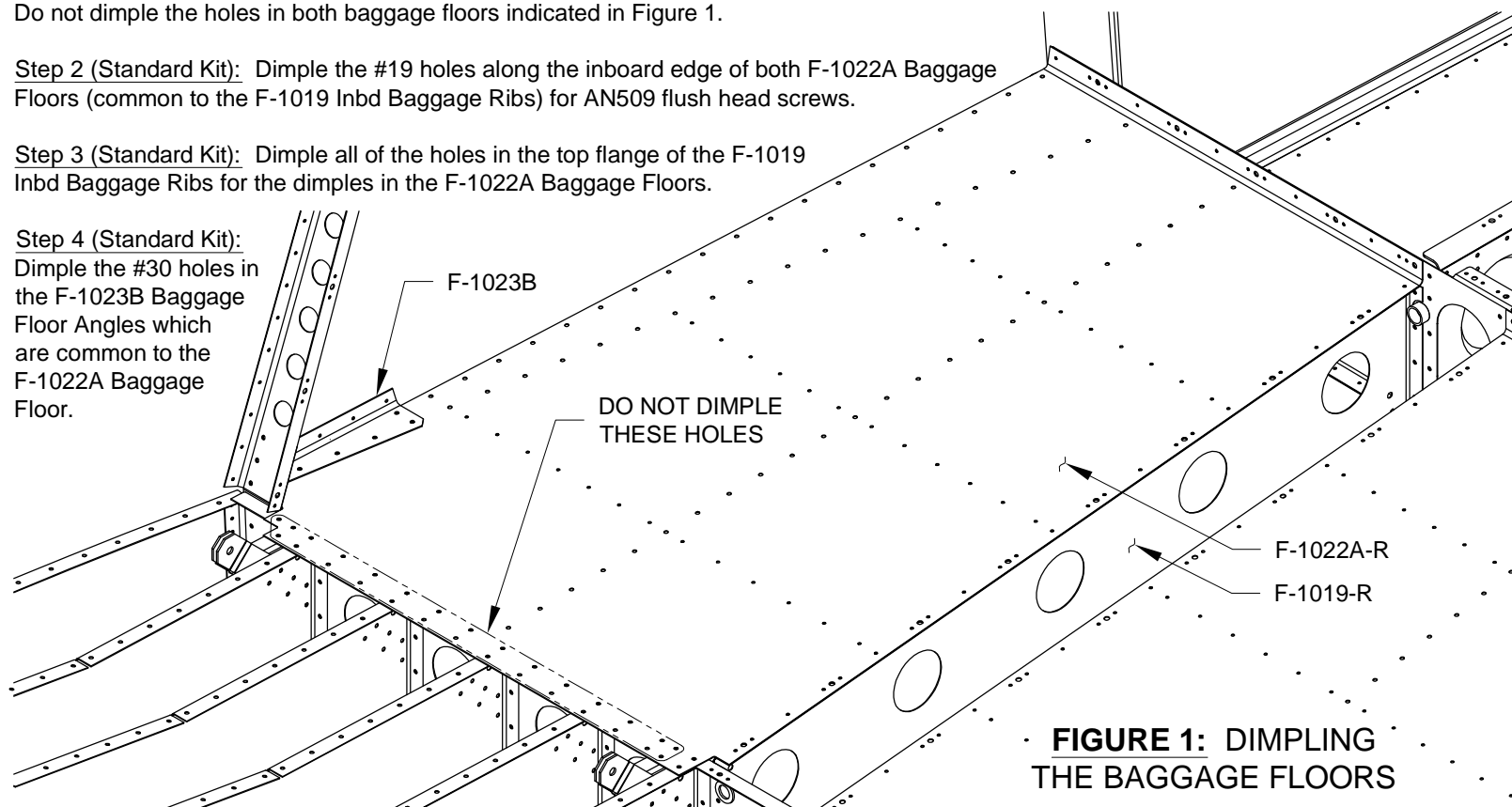


FIGURE 1: DIMPLING THE BAGGAGE FLOORS

Step 5 (Standard and Quickbuild Kit): Dimple (flush on the forward side) the three holes in the vertical flange of the F-1027 Close-Out Panel, the four holes in the inboard vertical flange of the F-1031 Upper Baggage Door Seal Channel, and the holes in the F-1006A Bulkhead which are common to these holes.

Step 6 (Standard and Quickbuild Kit): Final-Drill #40 and machine countersink (flush on the forward side for AN426AD3 rivets) the four 3/32" nutplate attachment rivet holes in the F-1031 Upper Baggage Door Seal Channel.

Step 7 (Standard and Quickbuild Kit): Dimple the two holes in the lower end-tab of the F-1026 Lower Baggage Door Seal Channel.

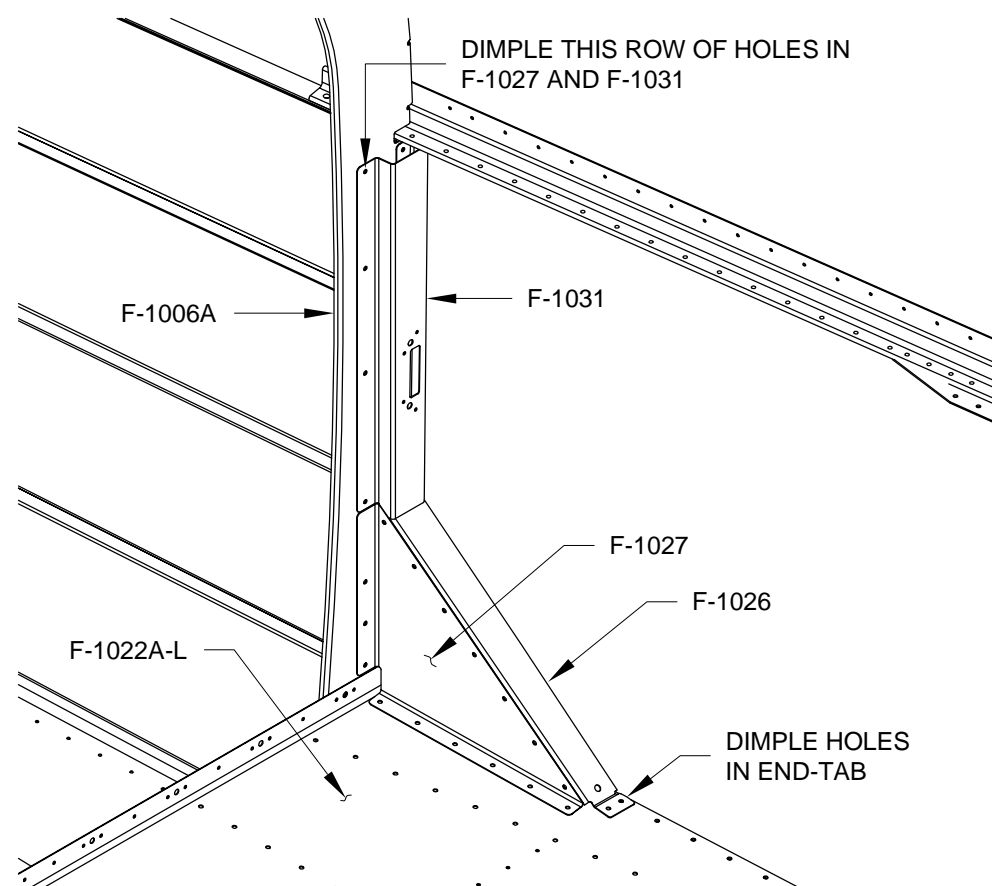


FIGURE 2: DIMPLING THE UPPER AND LOWER BAGGAGE DOOR SEAL CHANNELS AND CLOSE-OUT PANEL

Step 8 (Standard Kit): Dimple the holes in the F-1022 Baggage Floor Stiffeners.

Step 9 (Standard and Quickbuild Kit): Prime all of the parts that have been drilled and dimpled up to this point if/ as desired.

NOTE: The seat and baggage floors will now be riveted. Although possible later, now is a good time to run any cables or wires that need to pass under the seat and baggage floors.

Step 10 (Standard Kit): Rivet the F-1022 Baggage Floor Stiffeners to the F-1022A -L and -R Baggage Floors using the rivets called-out in Figure 3.

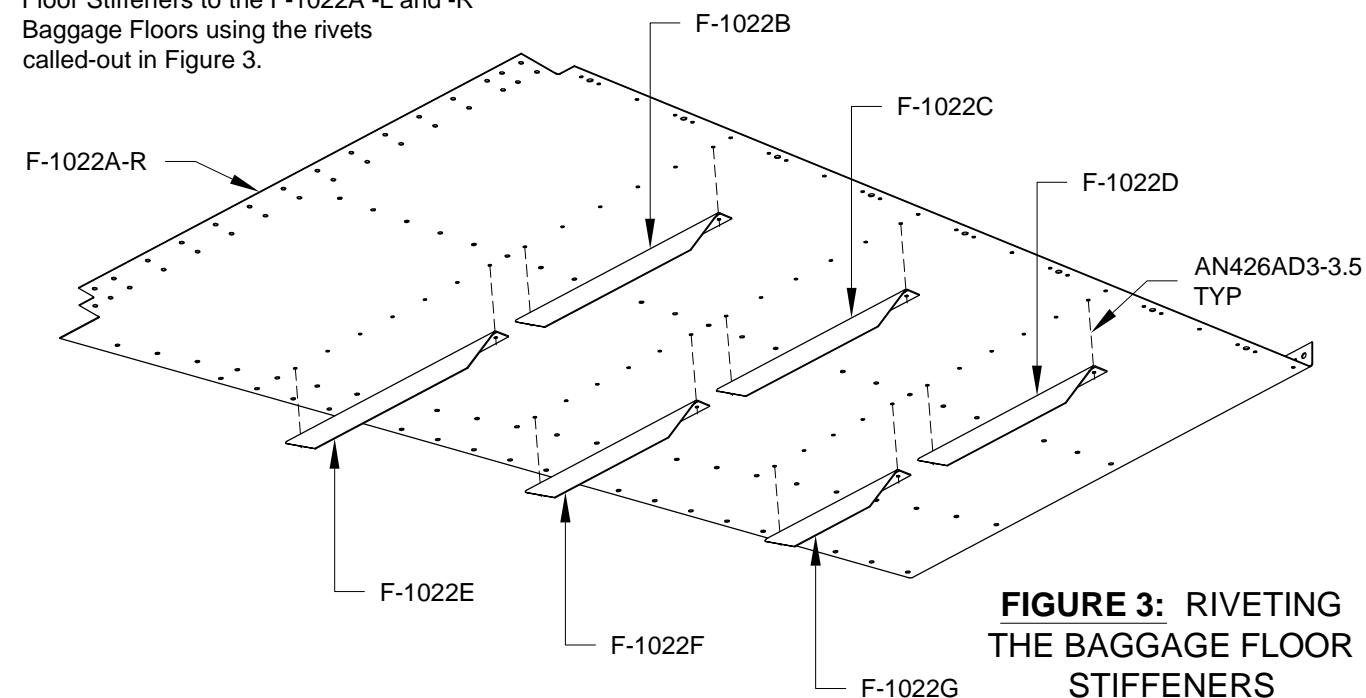


FIGURE 3: RIVETING THE BAGGAGE FLOOR STIFFENERS

Step 11 (Standard Kit): Rivet the nutplates shown in Figure 4 to the bottom of both F-1024 Seat Floors using the rivets called-out.

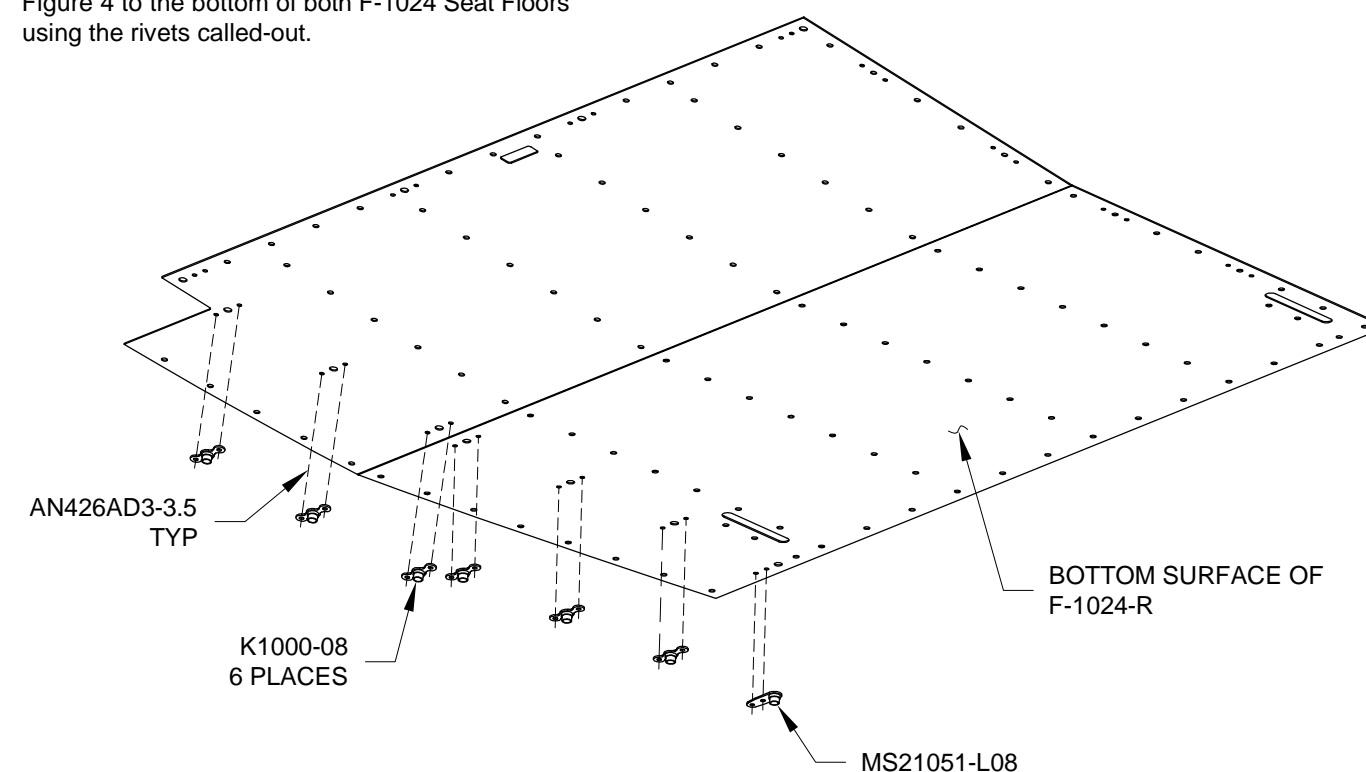


FIGURE 4: RIVETING NUTPLATES TO THE SEAT FLOORS



NOTE: The remainder of this section is to be completed for both the Standard and Quickbuild Kits.

Step 1: Rivet the two nutplates to the F-1031 Upper Baggage Door Seal Channel using the rivets called-out in Figure 4.

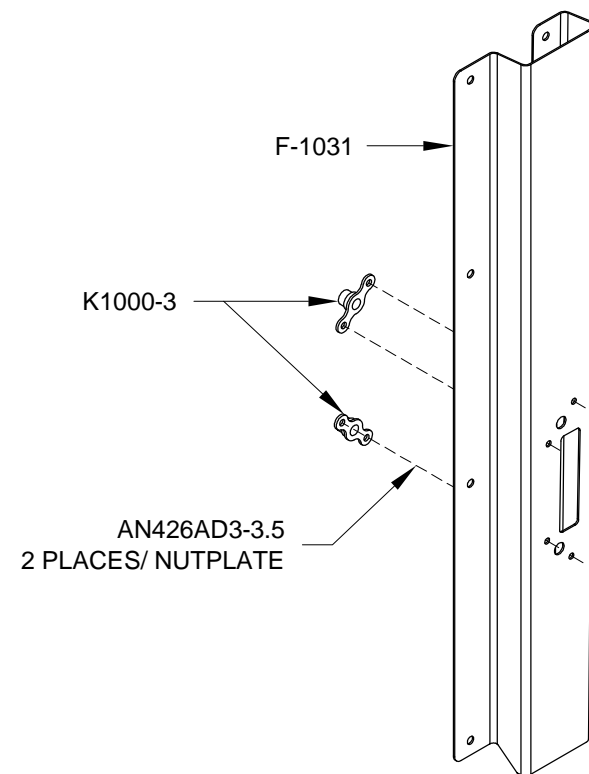


FIGURE 1: RIVETING NUTPLATES TO THE UPPER BAGGAGE DOOR SEAL CHANNEL

Step 2: Rivet in place the F-1024 Seat Floors, the F-1022A Baggage Floors, and the F-10103A Lower Seat Hinge Halves using only the rivets called-out in Figure 1. The remainder of the seat floors are riveted in a later section.

F-1024-R

- LP4-3
- CS4-4
- AN426AD3-3.5

F-1024-L

F-10103A-R

F-10103A-L

F-1022A-R
F-1022A-L

DO NOT DIMPLE
OR RIVET THIS HOLE

FIGURE 2: RIVETING THE BAGGAGE AND SEAT FLOORS



Step 1: Install the nutplates shown in Figure 1 using the rivets called-out.

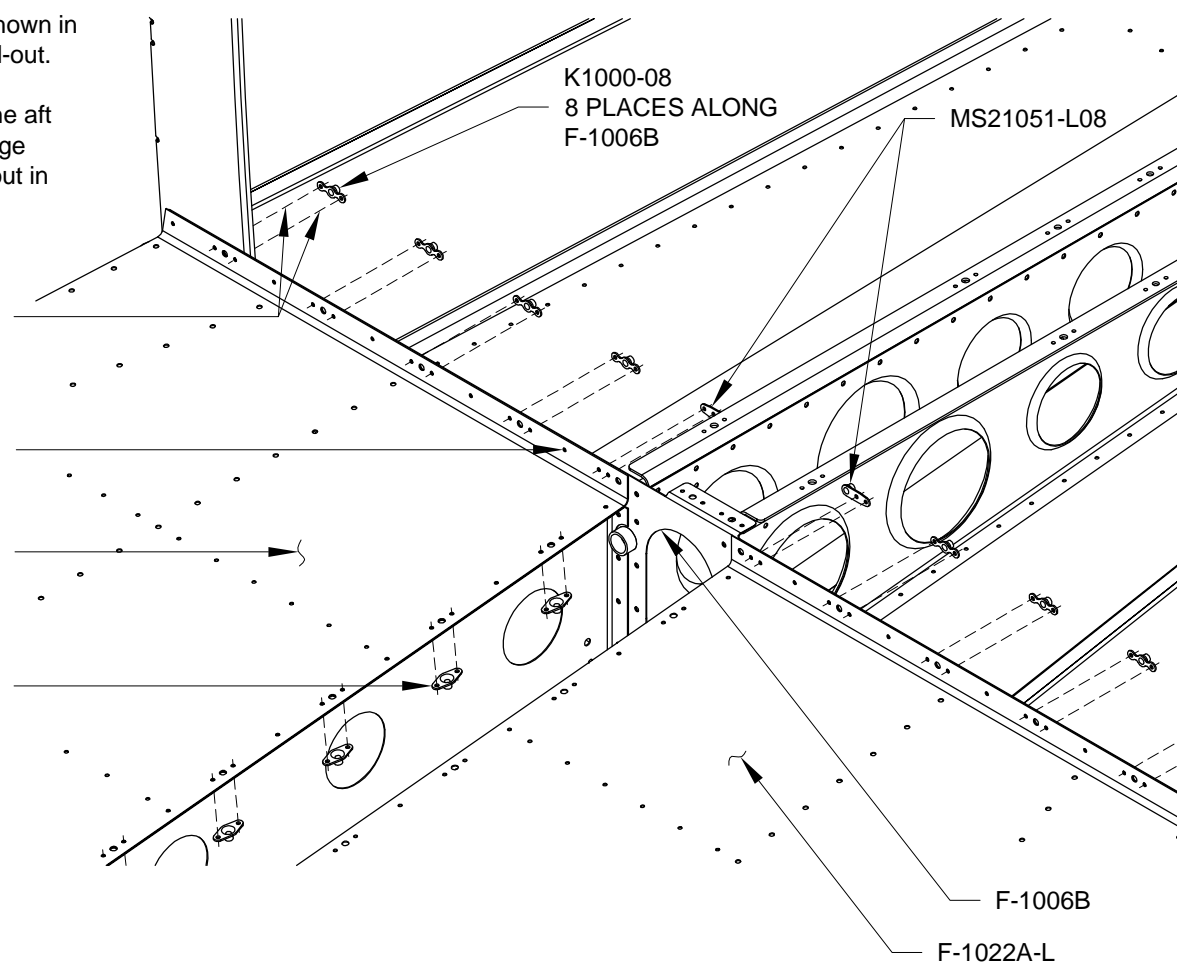
Step 2: Set the five rivets in the aft flange of both F-1022A Baggage Floors using the rivets called-out in Figure 1.

AN426AD3-4.5
BOTH ENDS OF F-1006B.
ALL OTHER NUTPLATE
ATTACH RIVETS
AN426AD3-4

AN426AD3-3.5
5 PLACES/ FLOOR

F-1022A-R

K1100-08
ALONG INBOARD
EDGES OF BOTH
F-1022A



Step 2: Rivet the two F-1023B Baggage Floor Angles to the F-1022A Baggage Floors and F-1070 Mid Side Skins using the rivets called-out in Figure 2.

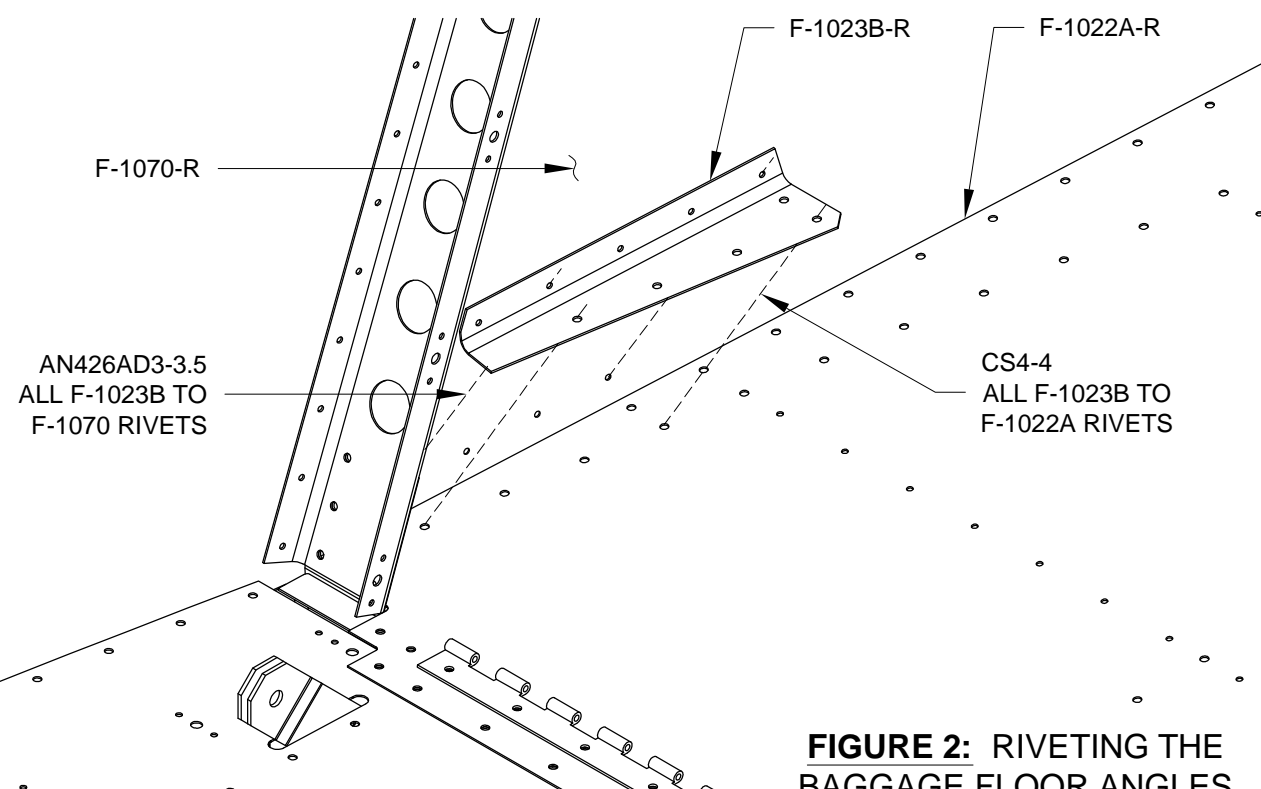


FIGURE 2: RIVETING THE BAGGAGE FLOOR ANGLES

Step 3: Rivet the F-1026 Lower Baggage Door Seal Channel and the F-10100B Baggage Door Shim to the F-1070-L and F-1073-L Side Skins using the rivets called-out in Figure 3.

Rivet the bottom end-tab of the lower baggage door seal channel to the F-1022A-L Baggage Floor and the top end-tab to the F-1006A Bulkhead using the rivets called-out in the figure. Do not set a rivet in the outboard hole of the top end-tab.

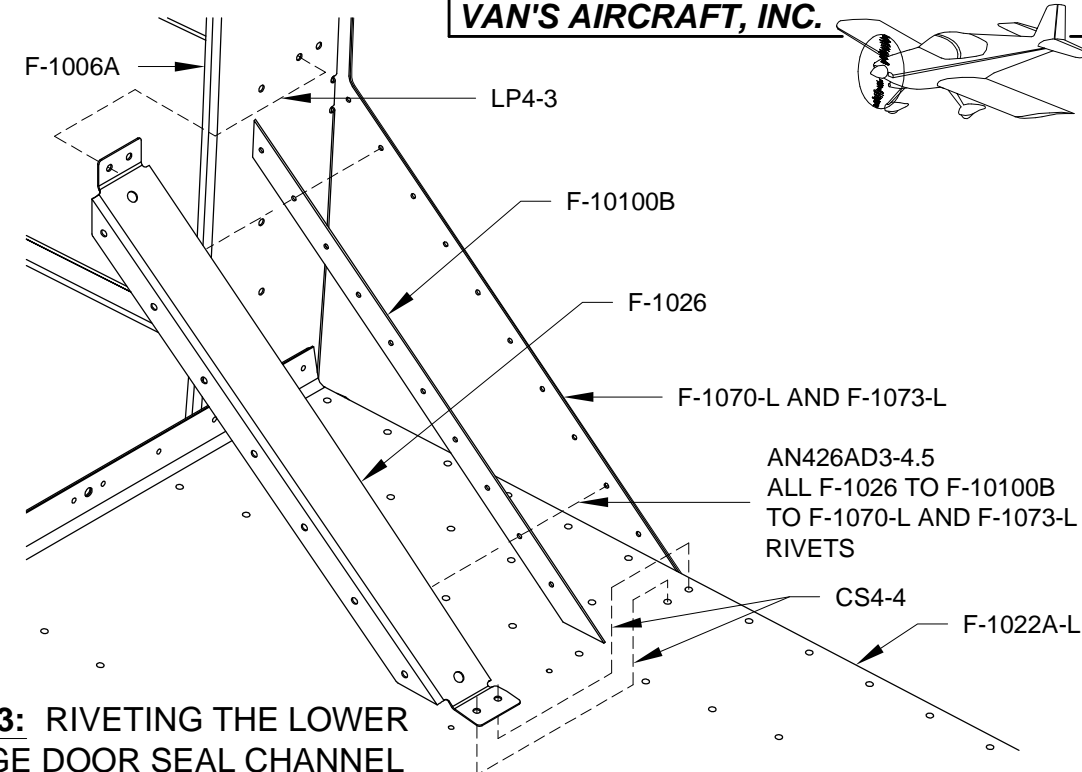


FIGURE 3: RIVETING THE LOWER BAGGAGE DOOR SEAL CHANNEL

Step 4: Rivet the F-1031 Upper Baggage Door Seal Channel to the F-1006B Bulkhead and to the top end-tab of the F-1026 Lower Baggage Door Seal Channel using the rivets called-out in Figure 4.

Step 5: Rivet the F-1027 Close-Out Panel to the F-1026 Lower Baggage Door Seal Channel, to the F-1022A-L Baggage Floor, and to the F-1006A Bulkhead using the rivets called-out in Figure 4.

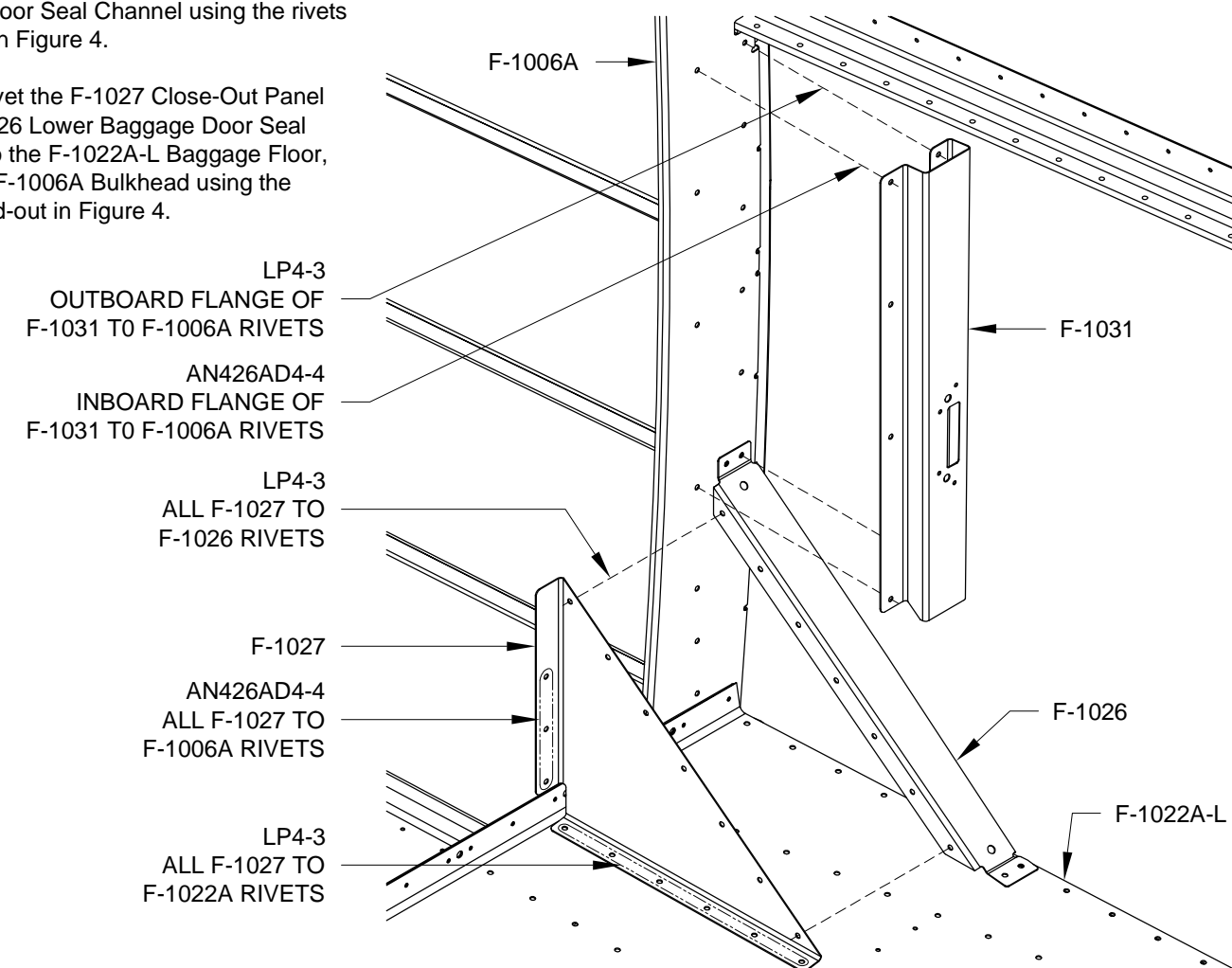
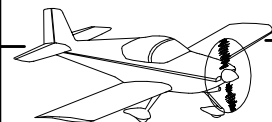


FIGURE 4: UPPER BAGGAGE DOOR SEAL CHANNEL AND CLOSE-OUT PANEL



Step 1: Remove the tab from the top flange of the F-1080 Right Baggage Cover as indicated in the blowup of Figure 1 (for clarity the F-1034B Seatback Brace is not shown).

Step 2: Cleco the forward end of the F-1080 Right Baggage Cover to the F-1034C-R Fuselage Bulkhead.

Step 3: There are four holes in the forward flange of the F-1028 Baggage Bulkhead Channel. Draw a line down the entire flange centered on these holes, then dimple the holes for the dimples in the F-1006D Bulkhead.

Step 4: Using only the top two holes in the forward flange of the F-1028 Baggage Bulkhead Channel, cleco the flange to the F-1006D Bulkhead. Rivet the bottom end of the baggage bulkhead channel to the F-1029-R Bellcrank Rib using the rivets called-out in the blow-up of Figure 1. (The top end is riveted after the Cabin Cover is installed in a later section.)

Step 5: Cleco the F-1074 Tailcone Forward Top Skin in place.

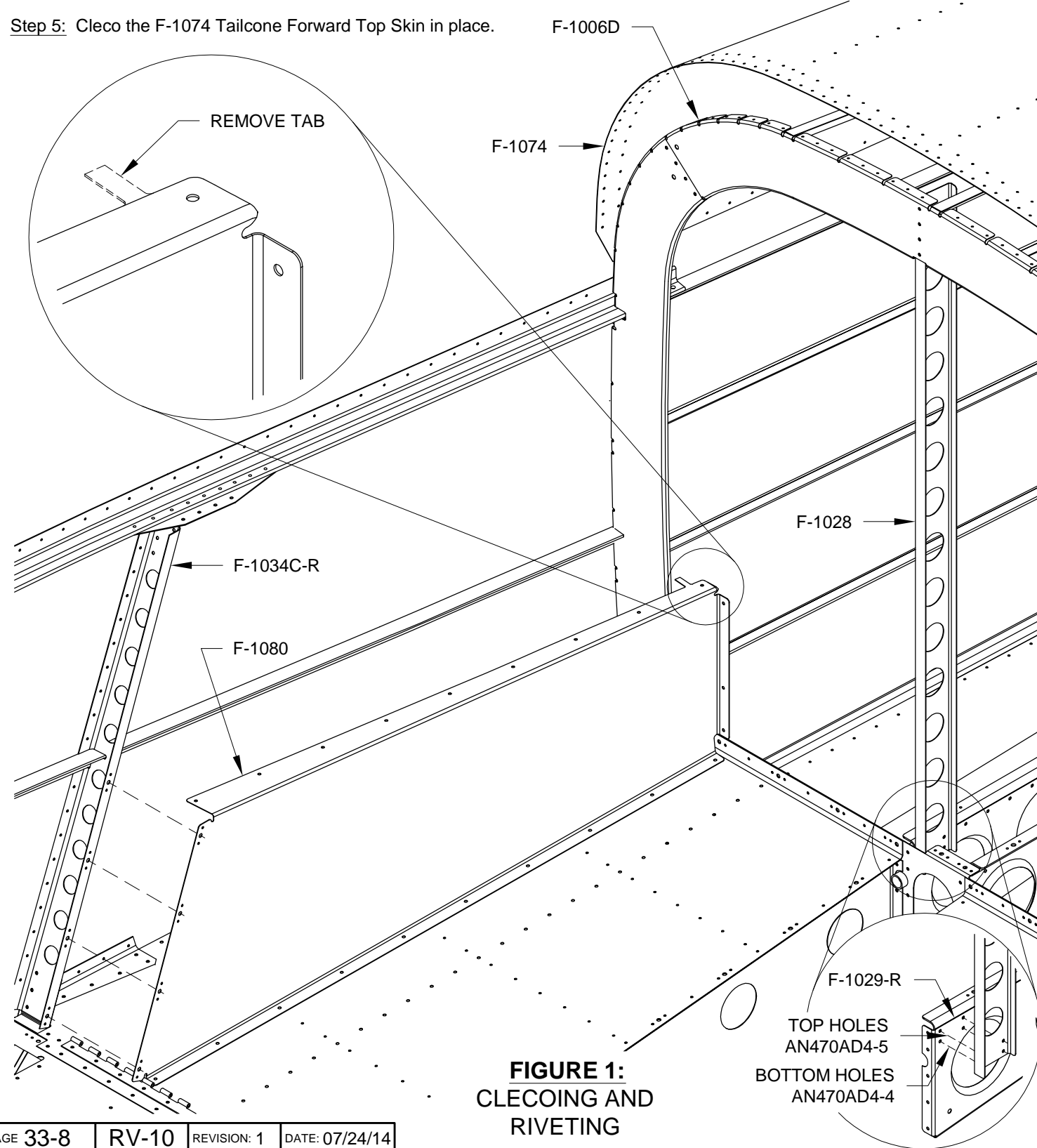


FIGURE 1:
CLECOING AND
RIVETING

Step 6: Temporarily secure the bottom of the F-1006F Lower Baggage Bulkhead Corrugation to the aft flange of the F-1022A Baggage Floors using the screws called-out in Figure 2.

Step 7: Match-Drill #19 the holes along the left side of the F-1006F Lower Baggage Bulkhead Corrugation (the right side is drilled later) into the F-1027 Close-Out Panel, the F-1031 Upper Baggage Door Seal Channel, and the F-1006A Bulkhead. Cleco a few of these holes to secure the lower baggage bulkhead corrugation to the bulkhead.

Match-Drill #19 the three holes of the lower baggage bulkhead corrugation into the F-1028 Baggage Bulkhead Channel. Be sure the line which was drawn on the forward flange of the baggage bulkhead channel remains centered in the holes of the lower baggage bulkhead corrugation while drilling.

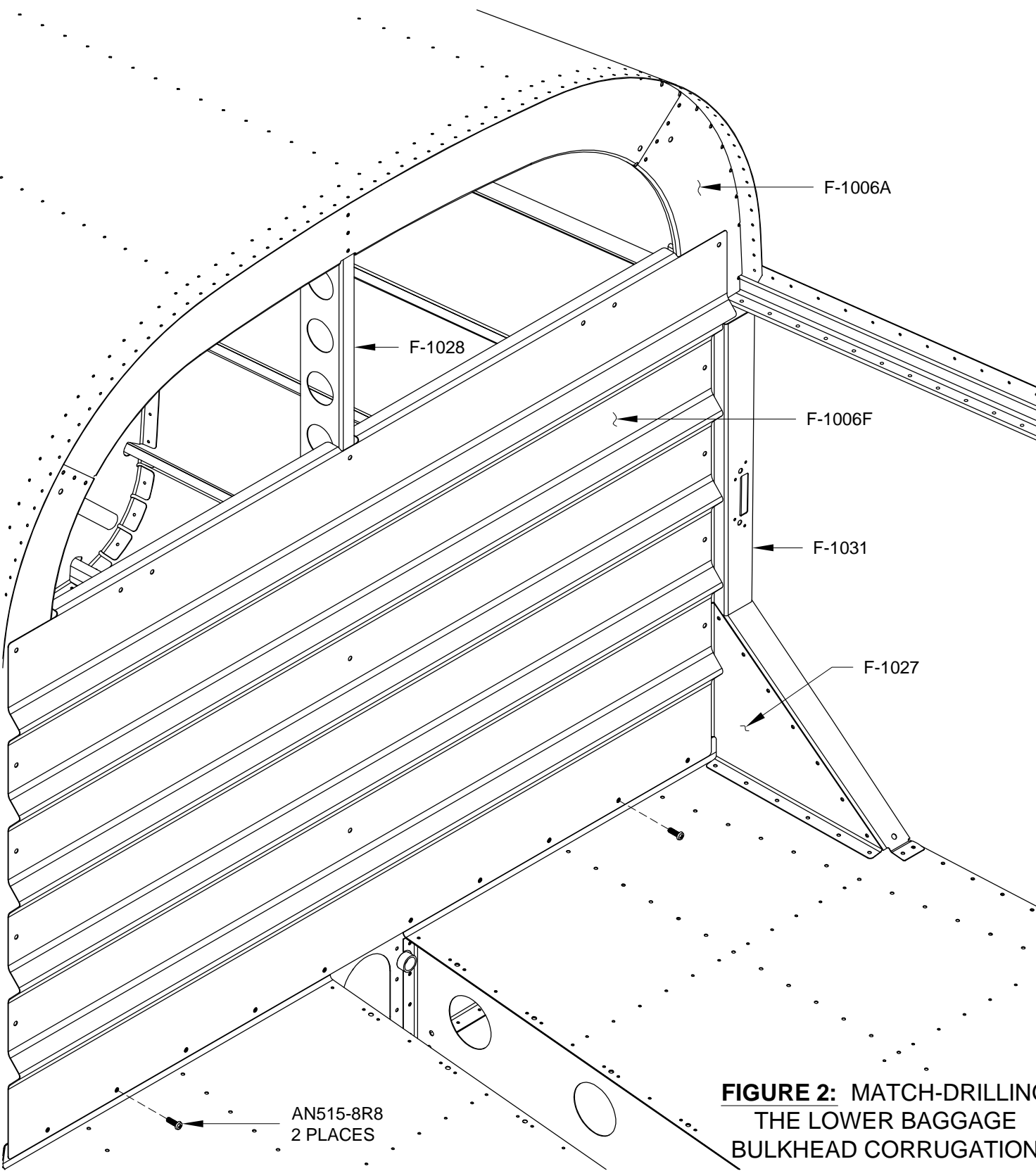


FIGURE 2: MATCH-DRILLING
THE LOWER BAGGAGE
BULKHEAD CORRUGATION



Step 1: If necessary, adjust the aft end of the F-1080 Right Baggage Cover so that it is aligned with the edge of the F-1006F Lower Baggage Bulkhead Corrugation. Match-Drill #30 the holes in the bottom flange of the right baggage cover into the F-1022A-R Baggage Floor, then match-drill #30 the holes in the top flange into the F-1013-R Fwd Fuse Longerons.

Step 2: Match-Drill #19 the holes along the right edge of the F-1006F Lower Baggage Bulkhead Corrugation into the aft flange of the F-1080 Right Baggage Cover and into the F-1006C Bulkhead.

Step 3: Final-Drill #40 the nutplate attachment rivet holes common to the F-1080 Right Baggage Cover and the F-1034C-R Fuselage Bulkhead.

Step 4: As shown in Figure 2, cleco the F-1006E Upper Baggage Bulkhead Corrugation to the F-1006F Lower Baggage Bulkhead Corrugation.

Match-Drill #19 the holes of the upper baggage bulkhead corrugation into the F-1006A, C, and D Bulkheads.

Step 5: Remove the F-1006E and F Baggage Bulkhead Corrugations and the F-1074 Tailcone Forward Top Skin.

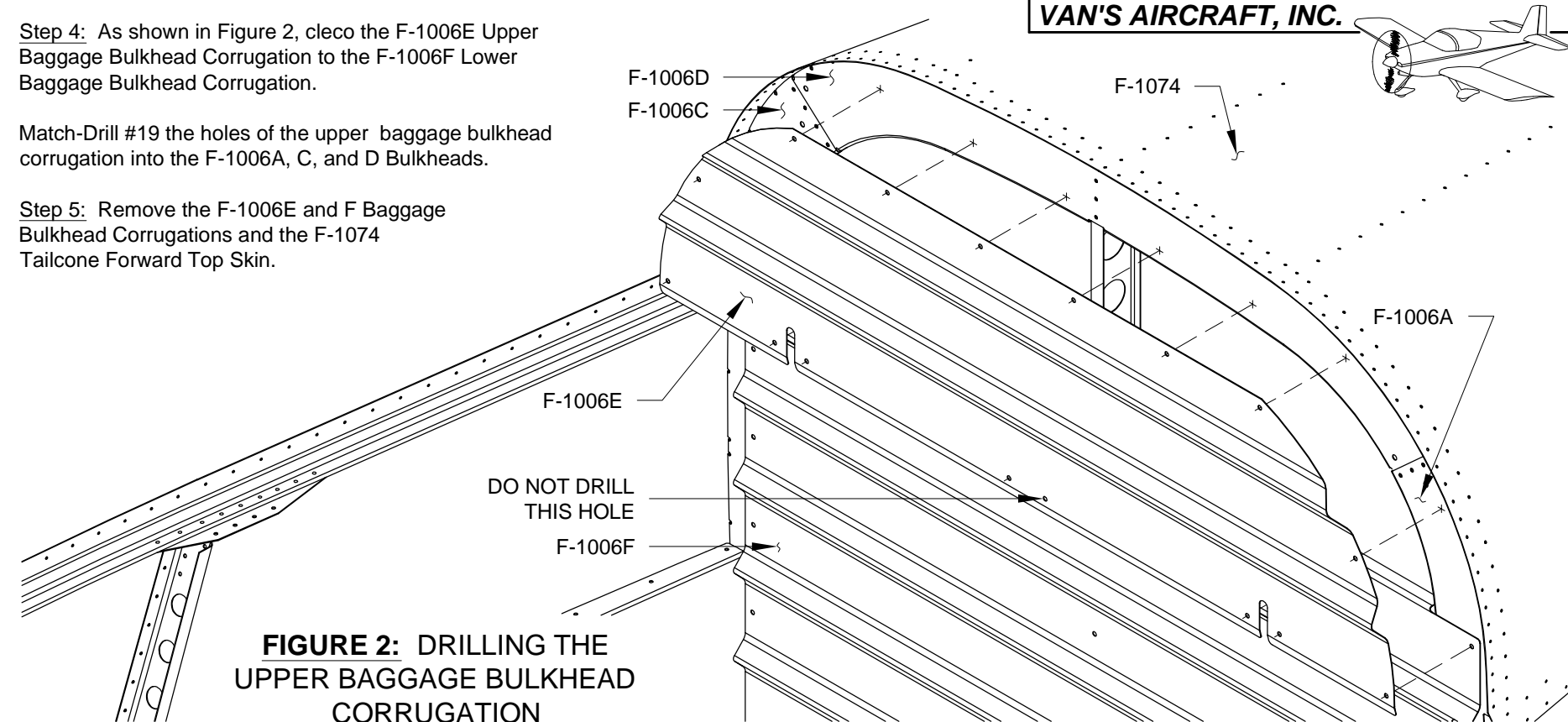


FIGURE 2: DRILLING THE UPPER BAGGAGE BULKHEAD CORRUGATION

Step 6: As shown in Figure 3, cleco the #19 hole in the aft flange of the F-1080 Right Baggage Cover. With the top and bottom flanges clecoed in place, match-drill #30 the three remaining 1/8" holes in the aft flange into the F-1006C Bulkhead.

Step 7: Match-Drill #40 the nutplate attachment rivet holes, for the nutplate shown in Figure 3, into the F-1006C Bulkhead and into the F-1080 Right Baggage Cover.

Step 8: Remove the F-1080 Right Baggage Cover and deburr the holes in the baggage cover and all the accessible, corresponding holes in the other parts.

Step 9: Dimple the #40 nutplate attachment rivet holes in the F-1080 Right Baggage Cover and the corresponding holes in the mating parts. Prime if/ as desired.

Step 10: Rivet the F-1080 Right Baggage Cover to the F-1013-R Fwd Fuse Longerons, the F-1022A-R Baggage Floor, and the F-1006C Bulkhead using the rivets called-out in Figure 3.

Step 11: Install all of the nutplates shown in Figure 3 using the rivets called-out.

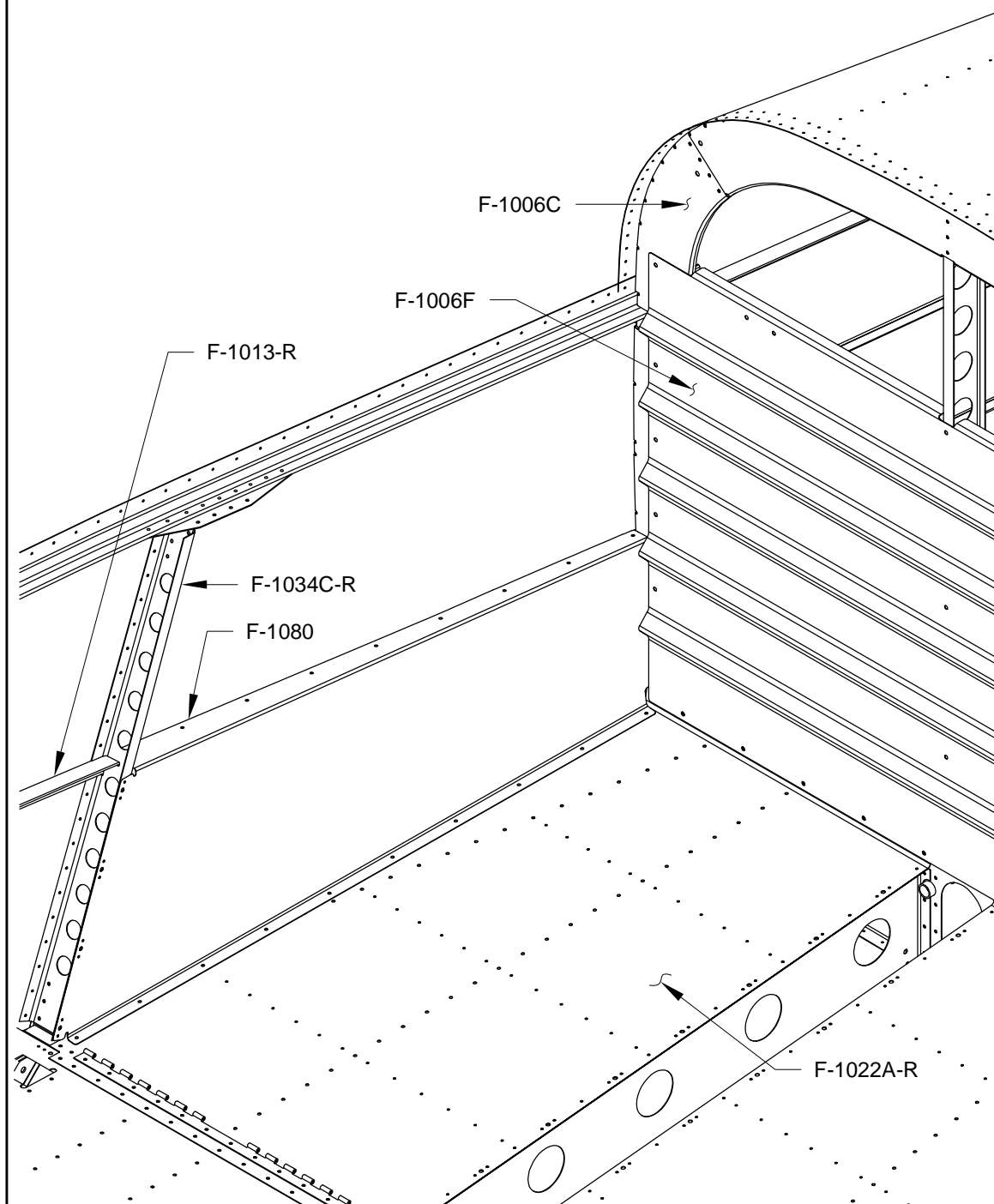


FIGURE 1: DRILLING THE RIGHT BAGGAGE COVER

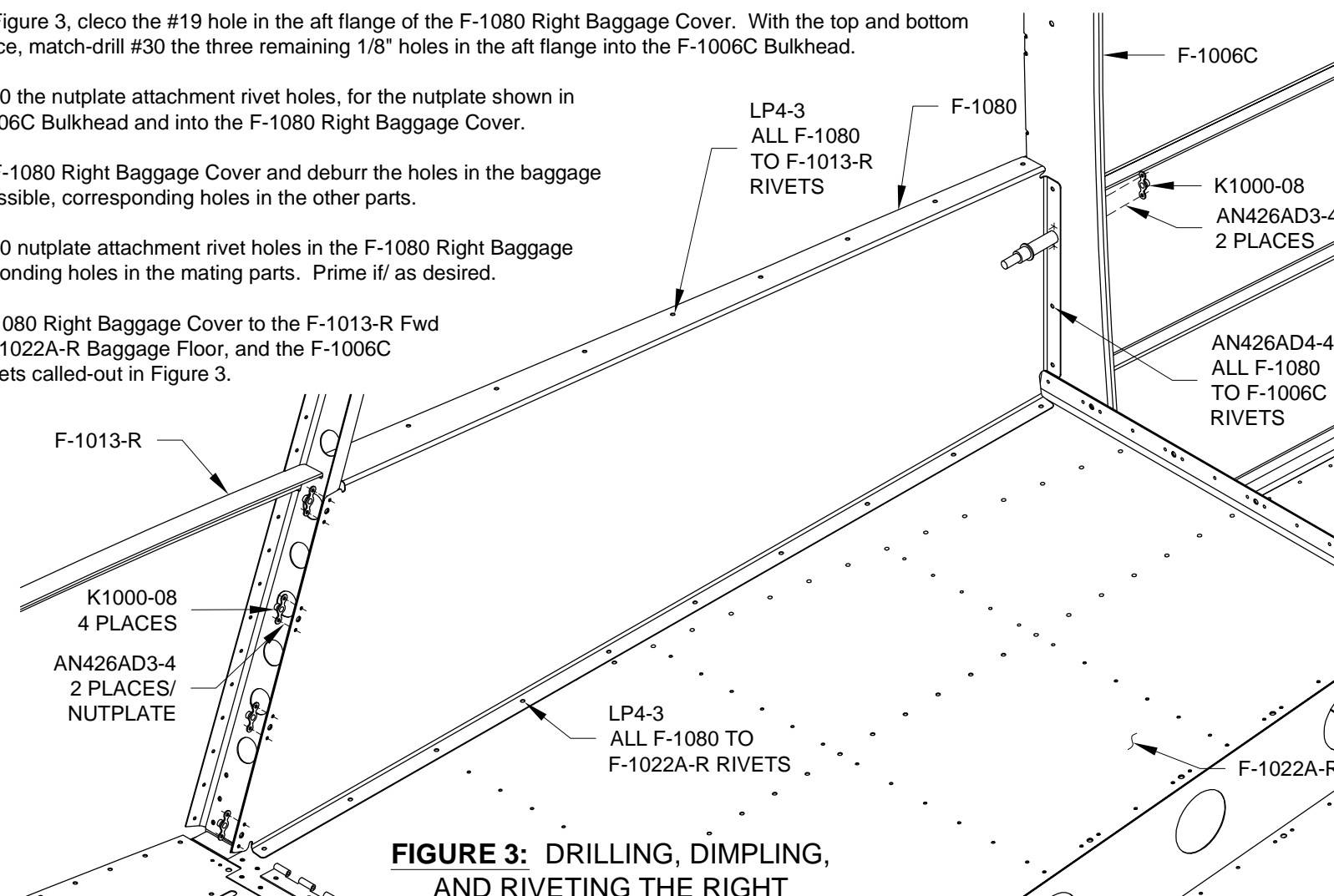
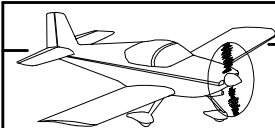


FIGURE 3: DRILLING, DIMPLING, AND RIVETING THE RIGHT BAGGAGE COVER



Step 1: Match-Drill #40 the nutplate attachment rivet holes for all the nutplates shown in Figure 1 into the F- 1006A, C, and D Bulkheads and into the F-1028 Baggage Bulkhead Channel. Deburr the holes.

Step 2: Dimple all of the nutplate attachment rivet holes drilled in Step 1 except for those associated with the F-1027 Close-Out Panel and the F-1031 Upper Baggage Door Seal Channel. Machine countersink the holes in these parts.

Step 3: Rivet the nutplates shown in Figure 1 to the F-1006A, C, and D Bulkheads and to the F-1028 Baggage Bulkhead Channel using the rivets called-out.

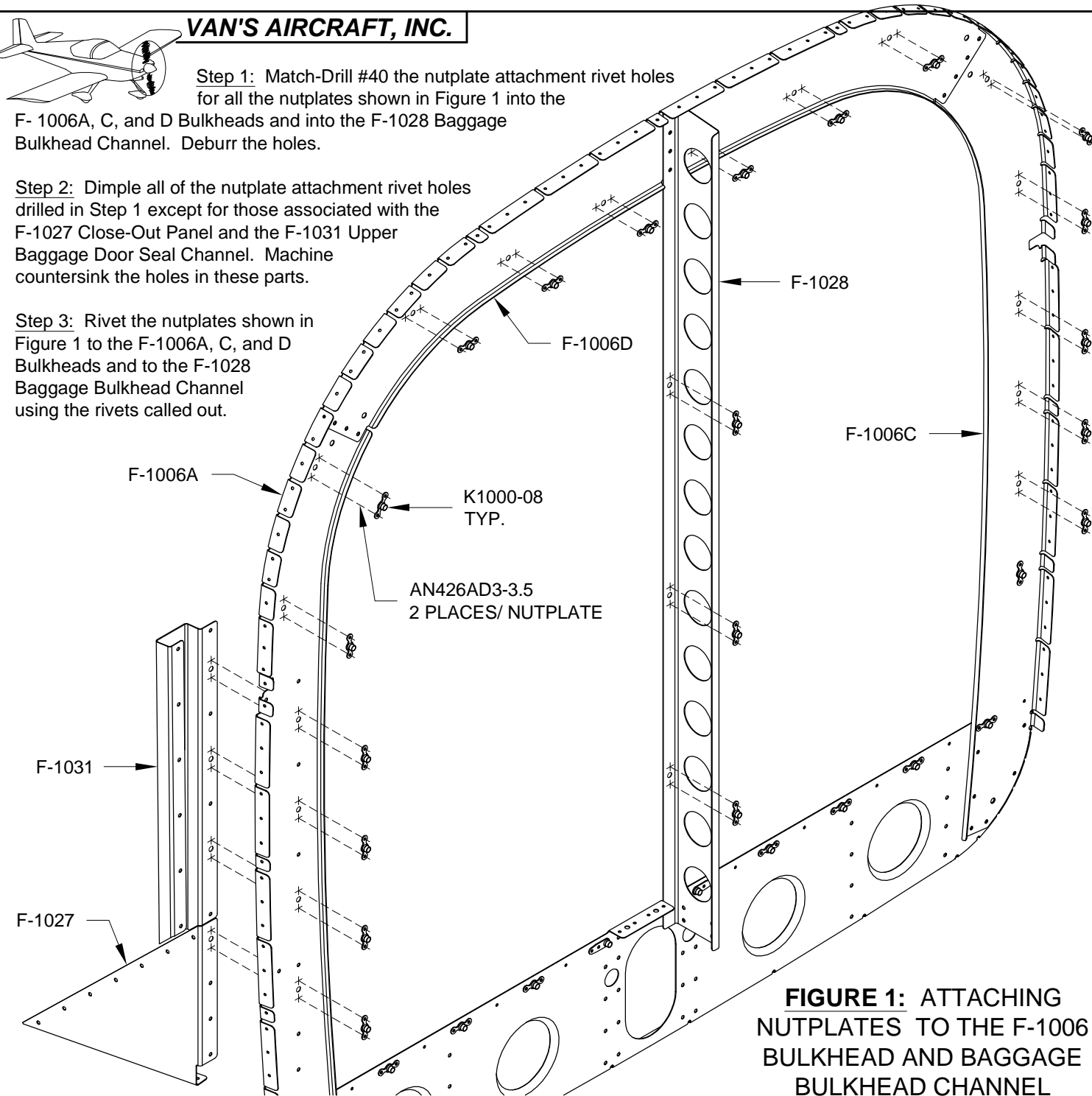


FIGURE 1: ATTACHING NUTPLATES TO THE F-1006 BULKHEAD AND BAGGAGE BULKHEAD CHANNEL

Step 4: Modify the two sets of F-6114B and C Wear Blocks using the dimensions given in Figures 2 and 3.

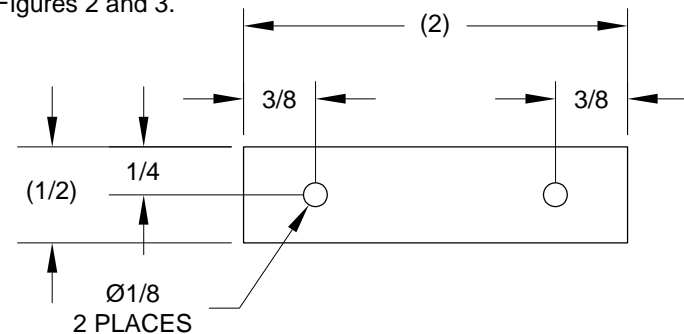


FIGURE 2: F-6114B WEAR BLOCK

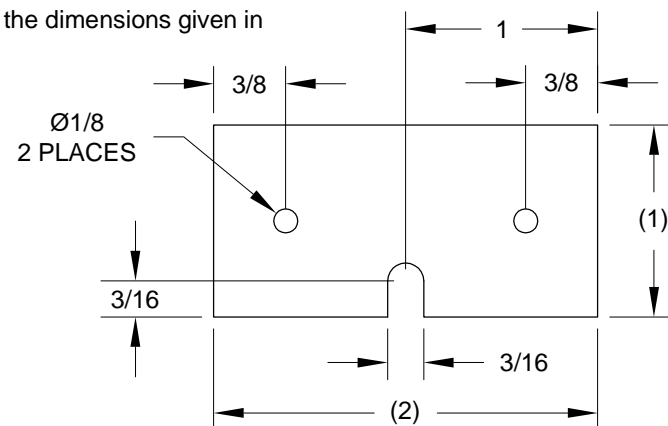


FIGURE 3: F-6114C WEAR BLOCK

Step 5: Cleco together the F-1006E and F Baggage Bulkhead Corrugations.

Step 6: Center the F-6114B and C Wear Blocks on the shoulder harness cable notches in both sides of the F-1006E Baggage Bulkhead Corrugation.

Step 7: Match-Drill #30 the 1/8" holes of the F-6114B and C Wear Blocks into the F-1006F and E Baggage Bulkhead Corrugations respectively. Separate the baggage bulkhead corrugations.

Step 8: Match-Drill #40 the nutplate attachment rivet holes, shown below the F-6114 Wear Blocks in Figure 4, into the F-1006F Lower Baggage Bulkhead Corrugation.

Step 9: Deburr the holes in the F-1006E and F Baggage Bulkhead Corrugations, dimple the #40 holes drilled in the previous step, and prime the parts if/ as desired.

Step 10: Rivet the nutplates shown in Figure 4 to both ends of the F-1006F Baggage Bulkhead Corrugation using the rivets called-out.

Step 11: Rivet the F-6114B Wear Block to the F-1006F Lower Baggage Bulkhead Corrugation using LP4-3 blind rivets. Install the rivets from the top of the wear block.

Step 12: Rivet the F-6114C Wear Block to the F-1006E Upper Baggage Bulkhead Corrugation using LP4-3 blind rivets. Install the rivets from the front of the baggage bulkhead corrugation, and back-up of the wear block with the washers shown.

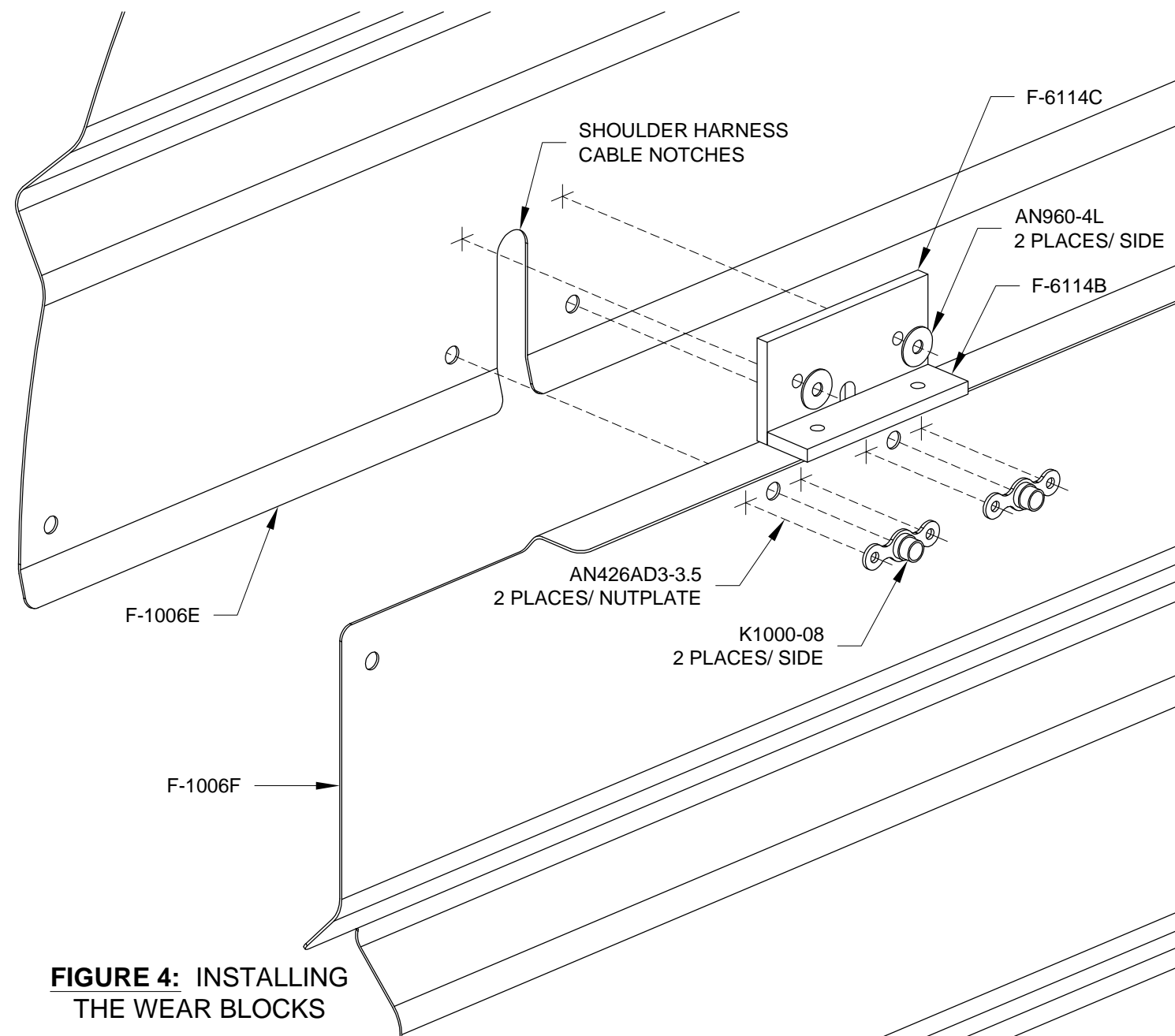


FIGURE 4: INSTALLING THE WEAR BLOCKS