



SECTION 42: REAR SEAT BACKS

F-637B-R
RIGHT ANGLE

F-637A
SEATBACK

F-637B-L
LEFT ANGLE

F-10103A-R
RIGHT LOWER SEAT
HINGE HALF

F-10103A-L
LEFT LOWER SEAT
HINGE HALF

F-637C ANGLE
2 PLACES / SEAT

Step 1: Fabricate two F-637B-R Right Angles and two F-637B-L Left Angles using AA6-125X3/4X3/4 and the information given in Figures 1 and 2.

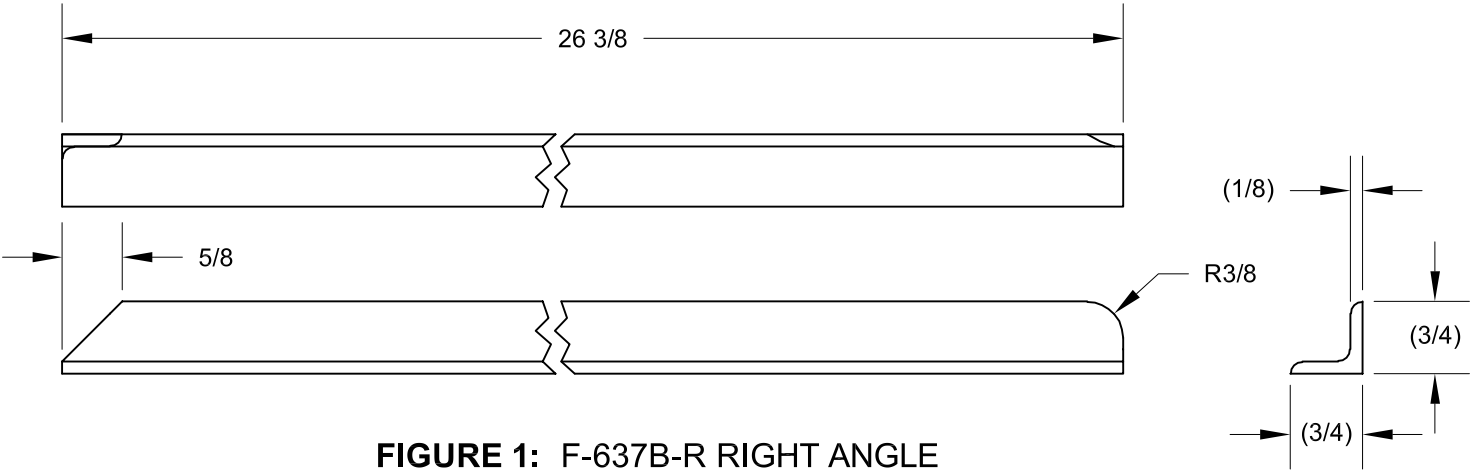


FIGURE 1: F-637B-R RIGHT ANGLE

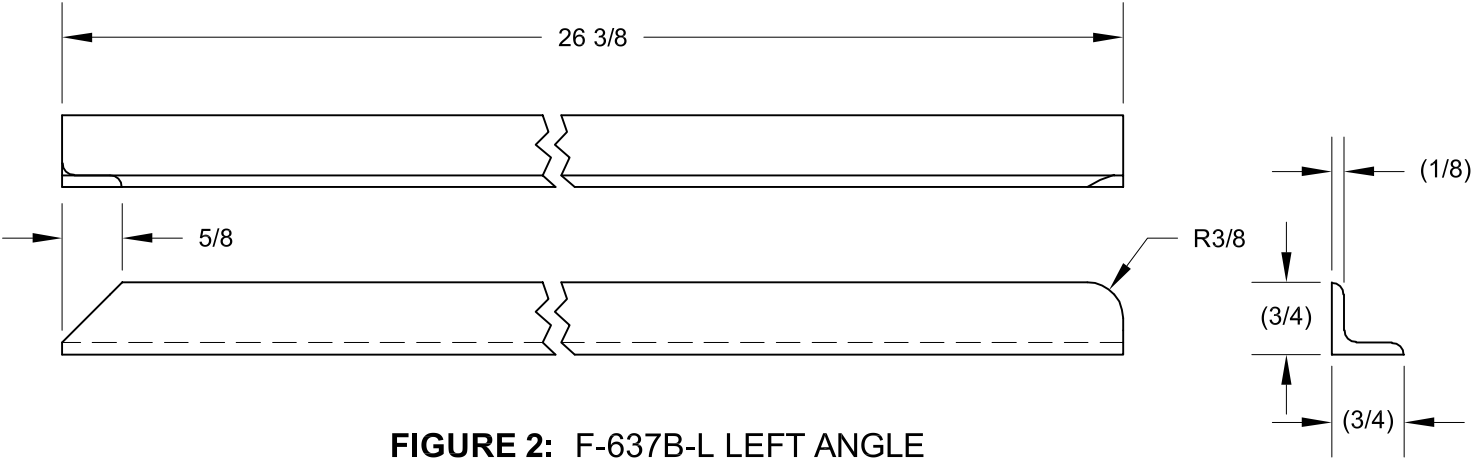


FIGURE 2: F-637B-L LEFT ANGLE

Step 2: Fabricate four F-637C Angles using AA6-063X3/4X3/4 and the information given in Figure 3.

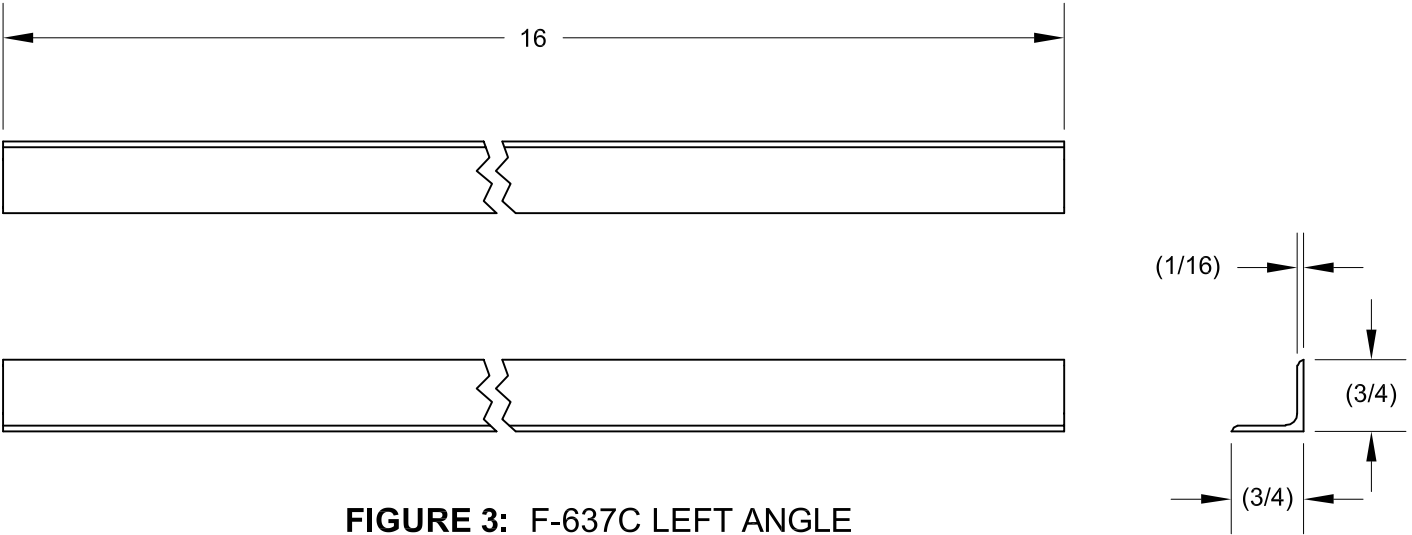


FIGURE 3: F-637C LEFT ANGLE

Step 3: Drill 1/8" holes into both F-637A Seat Backs using the dimensions given in Figure 4.

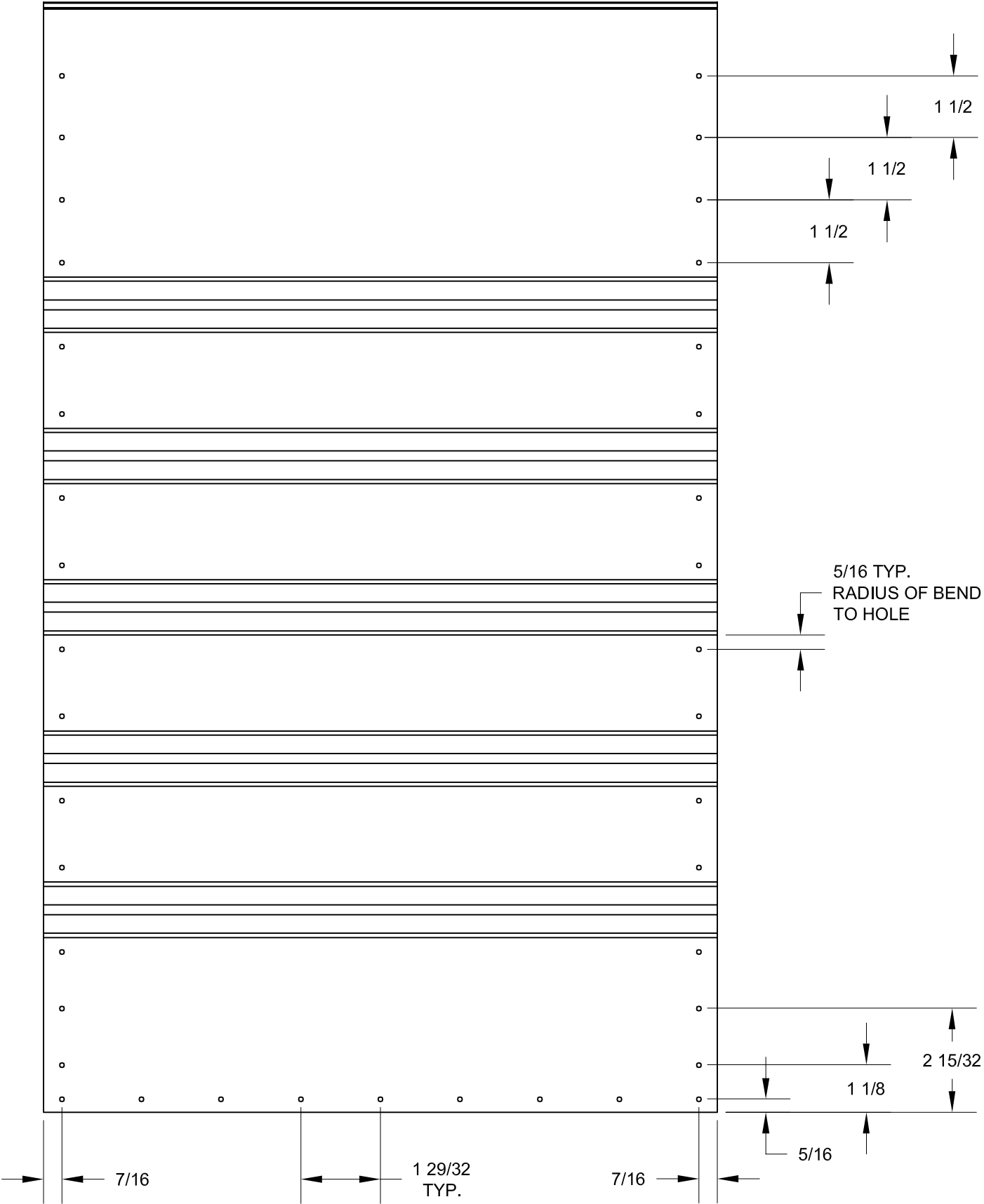
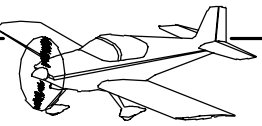


FIGURE 4: DRILLING THE F-637A SEAT BACKS



Step 1: As shown in Figure 1, align the bottom edge of the F-637B Left and Right Angles with the bottom edge of one of the F-637A Seat Backs. Align the vertex of the left and right angles with the side edges of the seat backs. Clamp the parts in position, then match-drill #30 the holes along the sides of the seat backs into the left and right angles. Repeat this step with the remaining seat back and the remaining left and right angles.

Step 2: Drill 1/8" holes into two of the F-637C Angles using the dimensions given in Figure 1.

Step 3: Nest one of the F-637C Angles, drilled in Step 2, under the flanges of one of the F-637A Seat Backs. The vertex of the angle will have to be filed to fit into the radius of the seat back. Align the ends of the angle with the edges of the seat back, then match-drill #30 the holes in the angle into the seat back (notice that the end holes in the angle will also be match-drilled into the tops of the F-637B Left and Right Angles).

Repeat this step with the remaining seat back and angle.

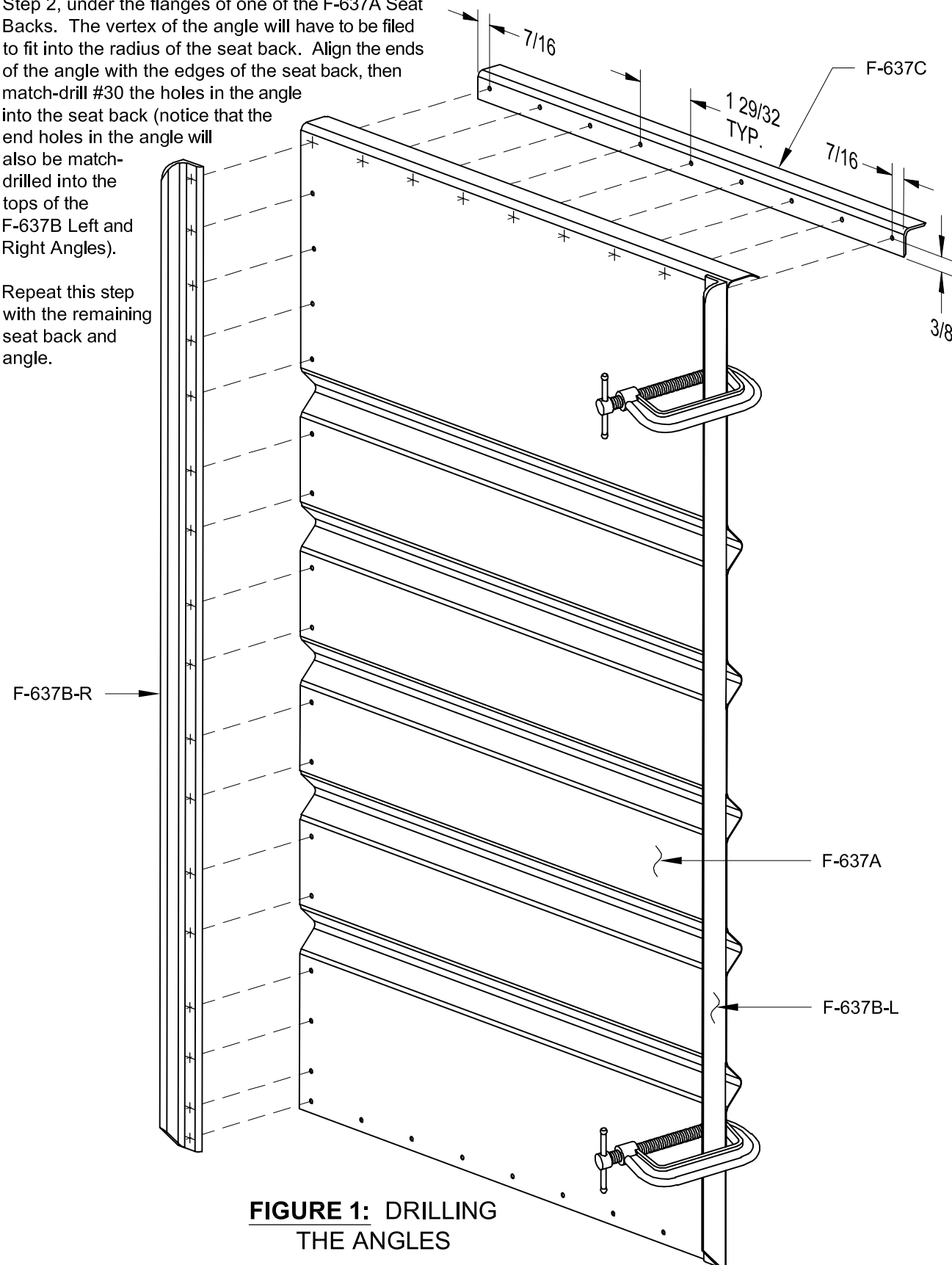


FIGURE 1: DRILLING THE ANGLES

Step 4: Remove the eyes indicated in Figures 3 and 4 from the F-10103B-R Right Upper Seat Hinge Half and the F-10103B-L Left Upper Seat Hinge Half. These are the hinge halves that were set aside on Page 33-2, Step 5.

Step 5: Make the Right Seat Back Assembly by aligning the bottom edge of one of the F-637A Seat Backs with the F-10103B-R Right Upper Seat Hinge Half and one of the remaining the F-637C Angles. See Figures 2 and 3.

Clamp the parts in position, then match-drill #30 the holes shown in Figure 3 into the right upper seat hinge half and the angle.

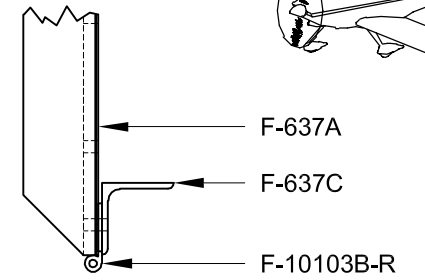


FIGURE 2: SEAT BACK ASSEMBLY ALIGNMENT

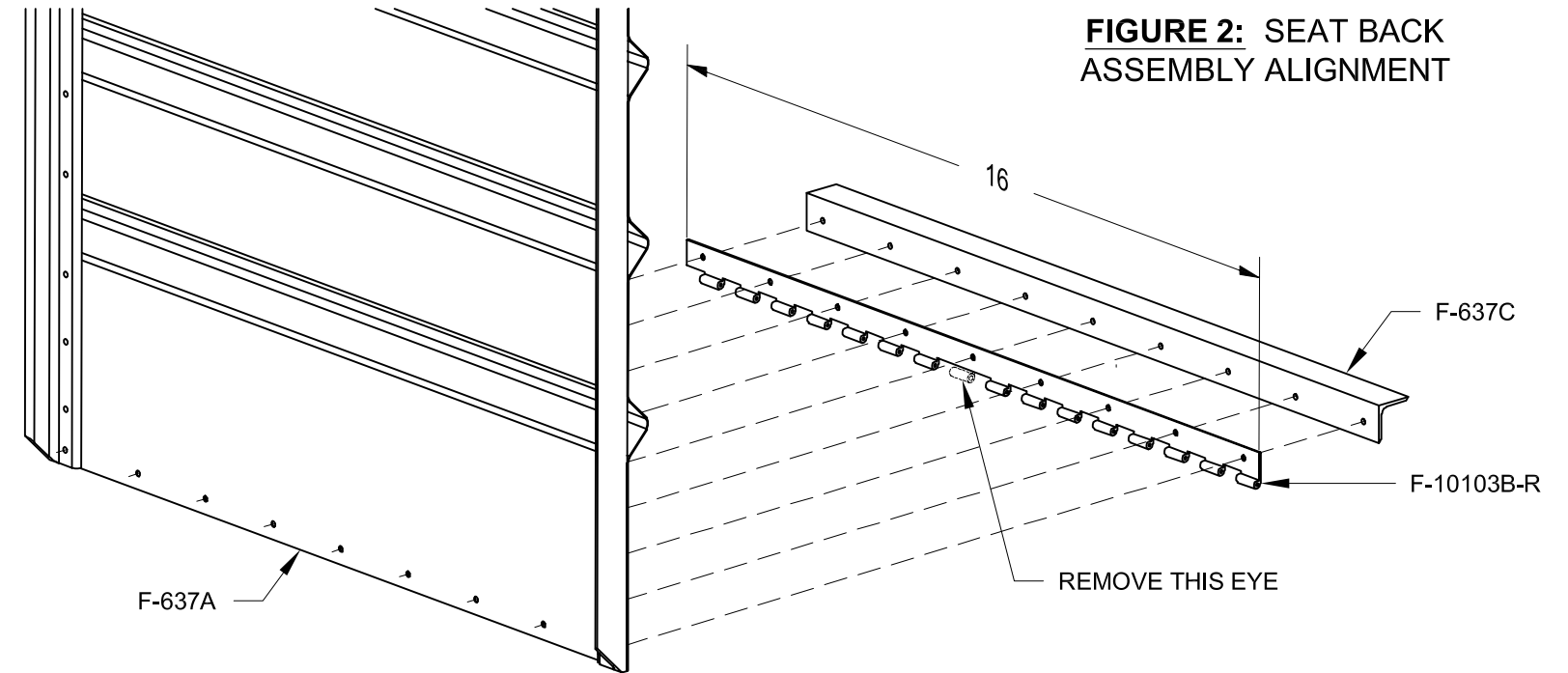


FIGURE 3: MATCH-DRILLING THE RIGHT SEAT BACK ASSEMBLY

Step 6: Make the Left Seat Back Assembly (shown in Figure 4) by repeating Step 5 with the remaining F-637A Seat Back, the remaining F-637C Angle, and the F-10103B-L Left Upper Seat Hinge Half.

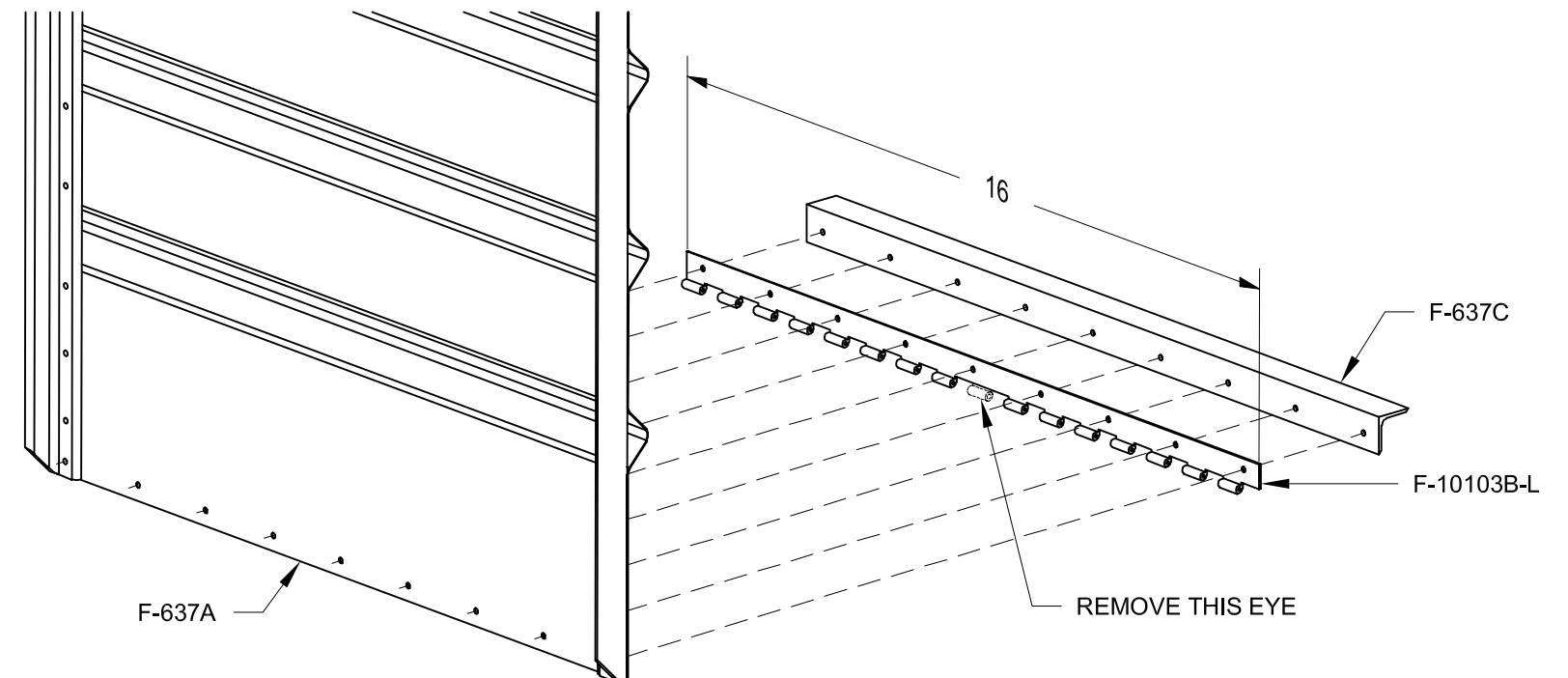
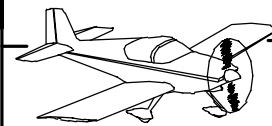


FIGURE 4: MATCH-DRILLING THE LEFT SEAT BACK ASSEMBLY

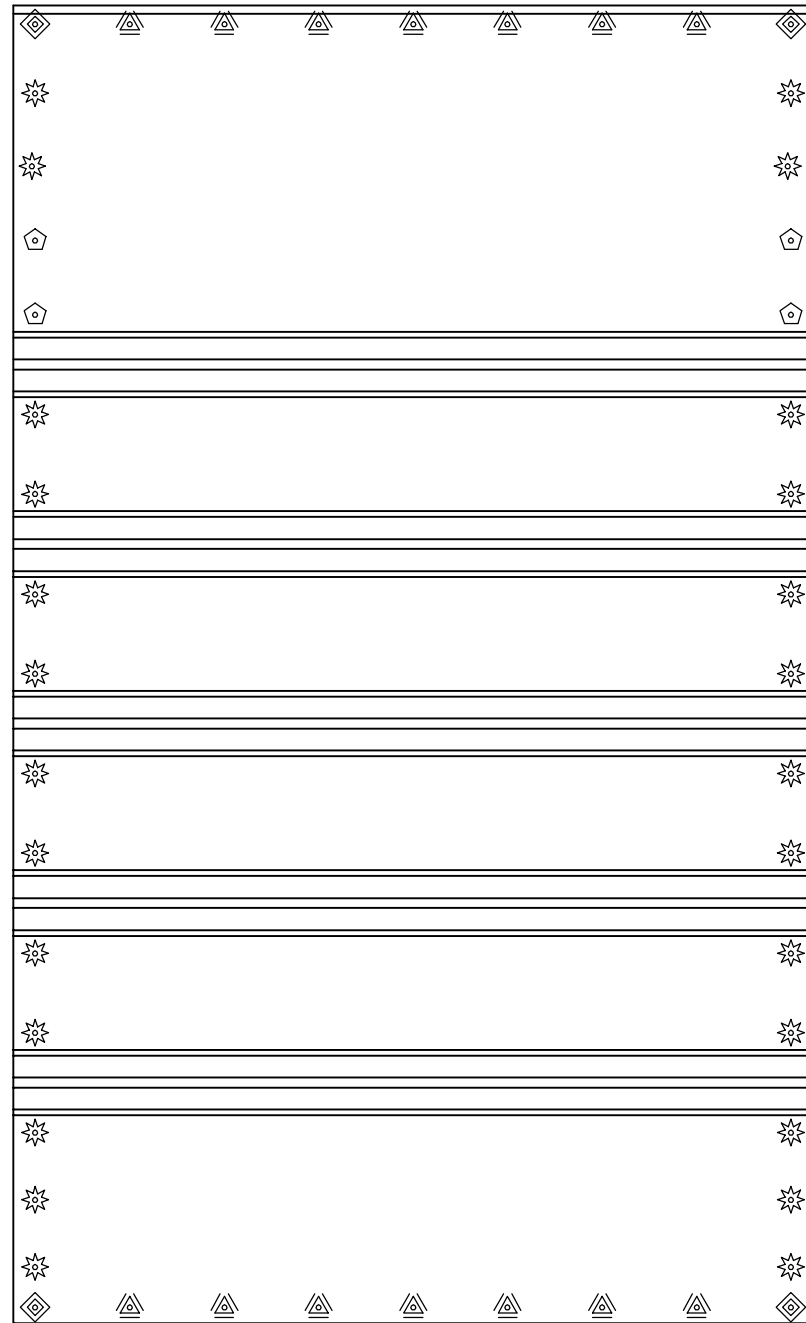


Step 1: Remove the parts from the Seat Back Assemblies and deburr all the holes.

Step 2: Dimple the holes in the F-637A Seat Back (flush on the back side) and machine countersink the corresponding holes in the F-637B Angles for the four flush rivets called out in Figure 1.

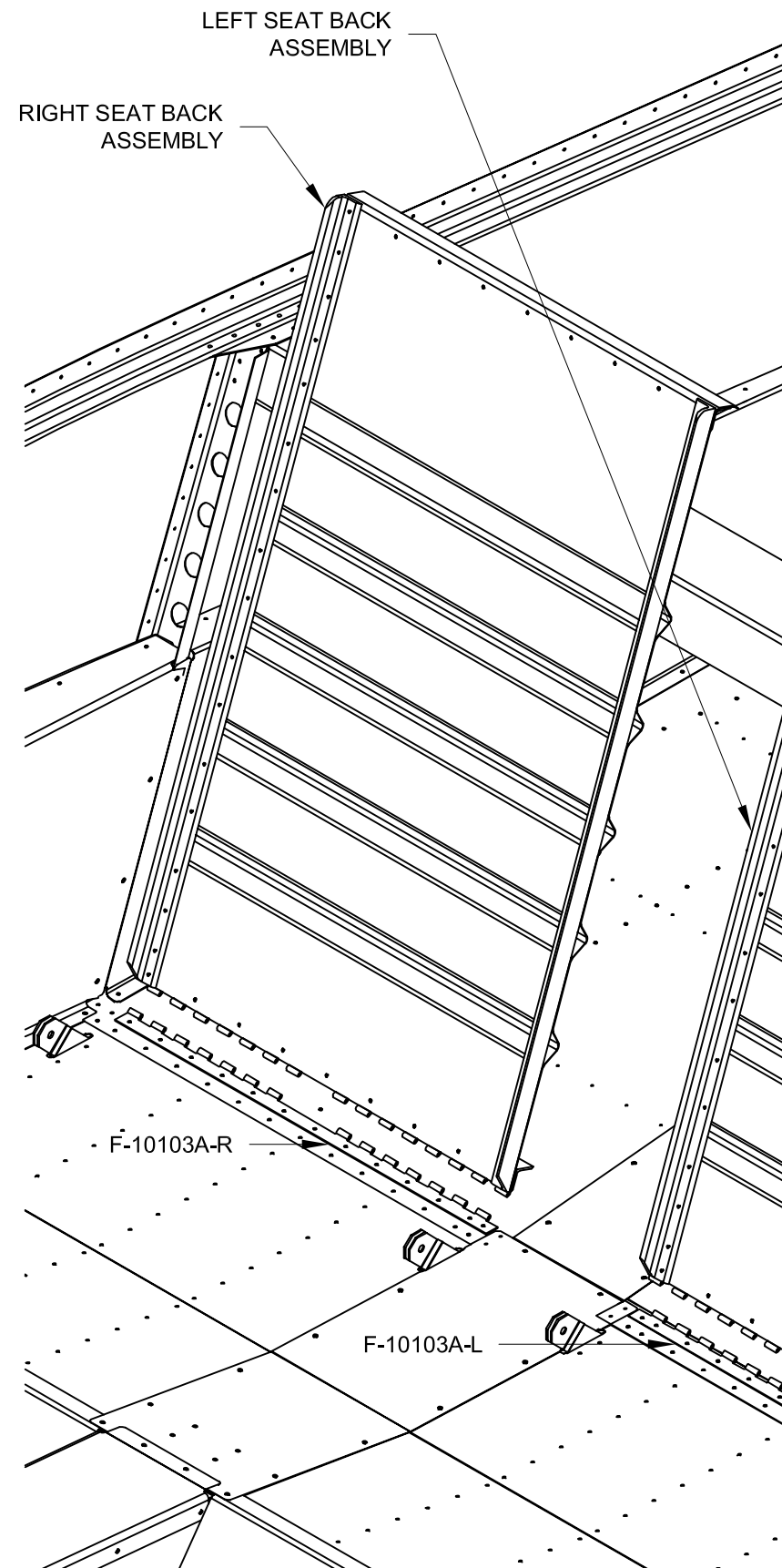
Step 3: Prime the parts if/as desired, then reassemble the Left and Right Seat Back Assemblies. Rivet them using the rivets called-out in Figure 1.

- ◇ AN426AD4-6
- △ AN470AD4-5
- ☆ AN470AD4-6
- ◇ AN470AD4-7



**FIGURE 1: SEAT BACK
ASSEMBLY RIVET CALL-OUT**

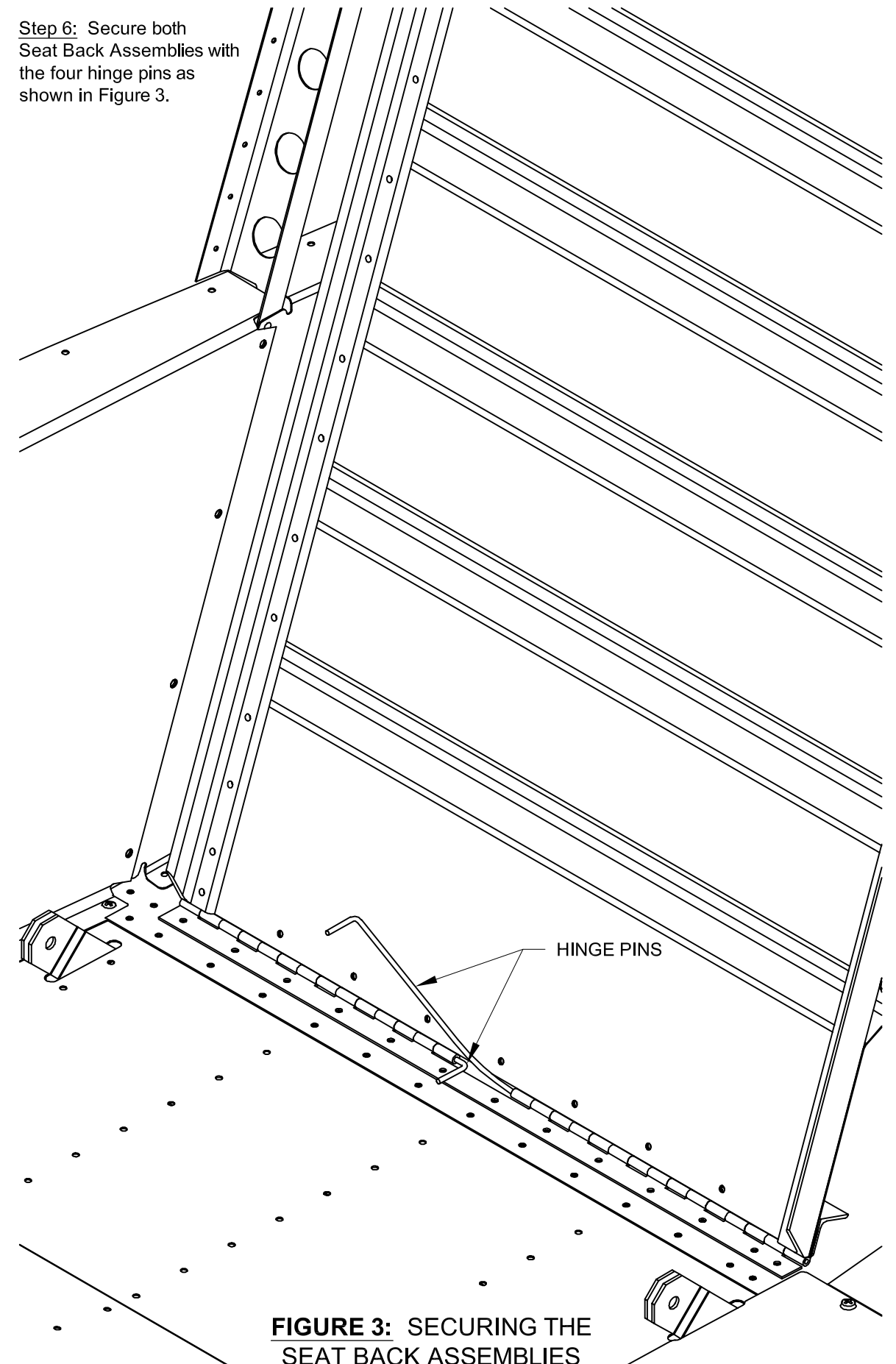
Step 4: Place the Left and Right Seat Back Assemblies into position on the F-10103A Lower Seat Hinge Halves as shown in Figure 2.



**FIGURE 2: POSITIONING THE
SEAT BACK ASSEMBLIES**

Step 5: Locate the two hinge pins set aside on Page 33-2, Step 5, and cut them both in half. (This should result in four 8" long hinge pins. If the pins are not at least this long, you will have to make new ones). Make a 90° bend in all four pins 5/8" from one end. Grind the other end to a dull point.

Step 6: Secure both Seat Back Assemblies with the four hinge pins as shown in Figure 3.



**FIGURE 3: SECURING THE
SEAT BACK ASSEMBLIES**