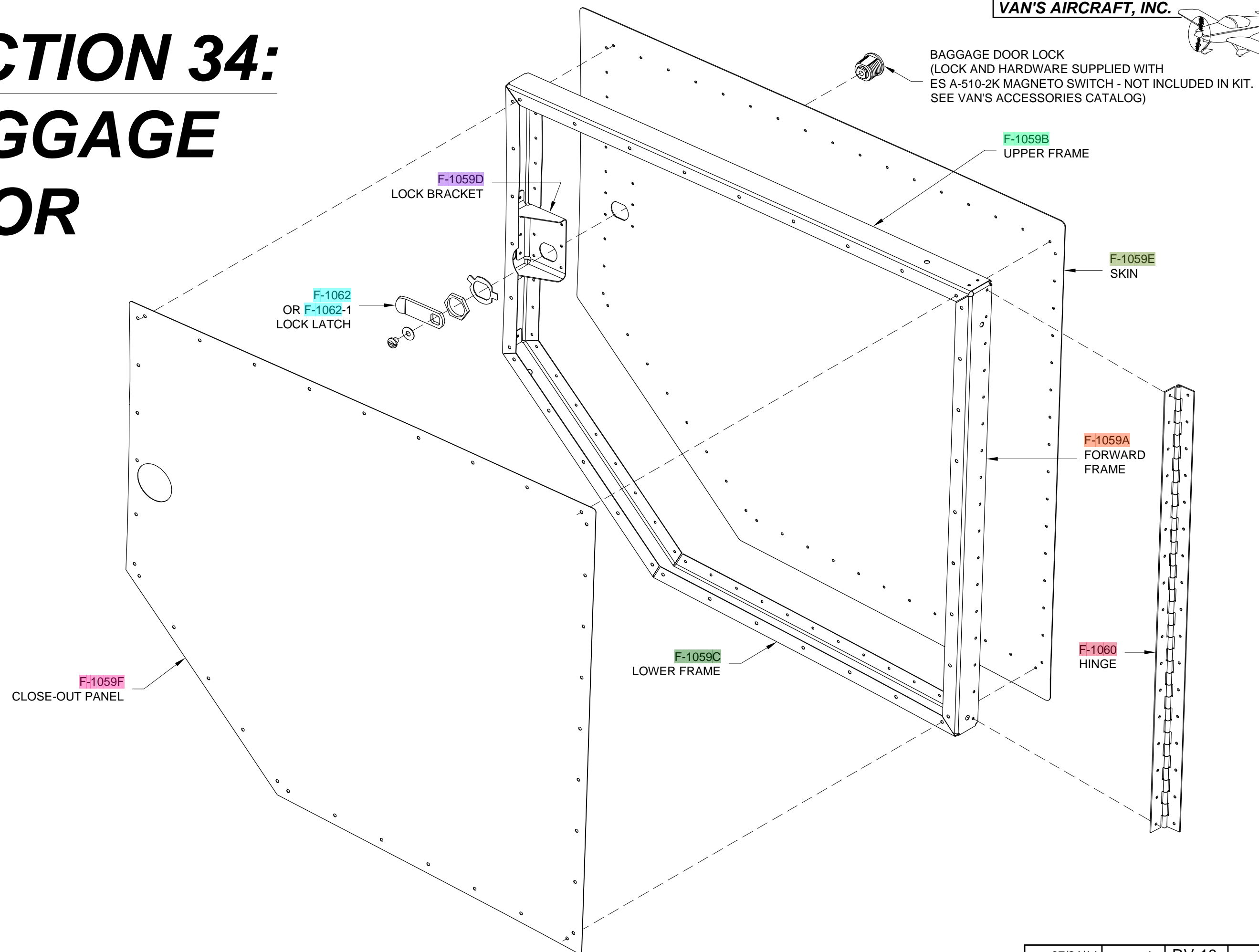




# SECTION 34: BAGGAGE DOOR





Step 1: Bend the F-1059B Upper Frame by hand as shown in Figure 1. The bend will form naturally between the notches.

Step 2: Cleco the F-1059B Upper Frame to the F-1059E Skin as shown in Figure 1.

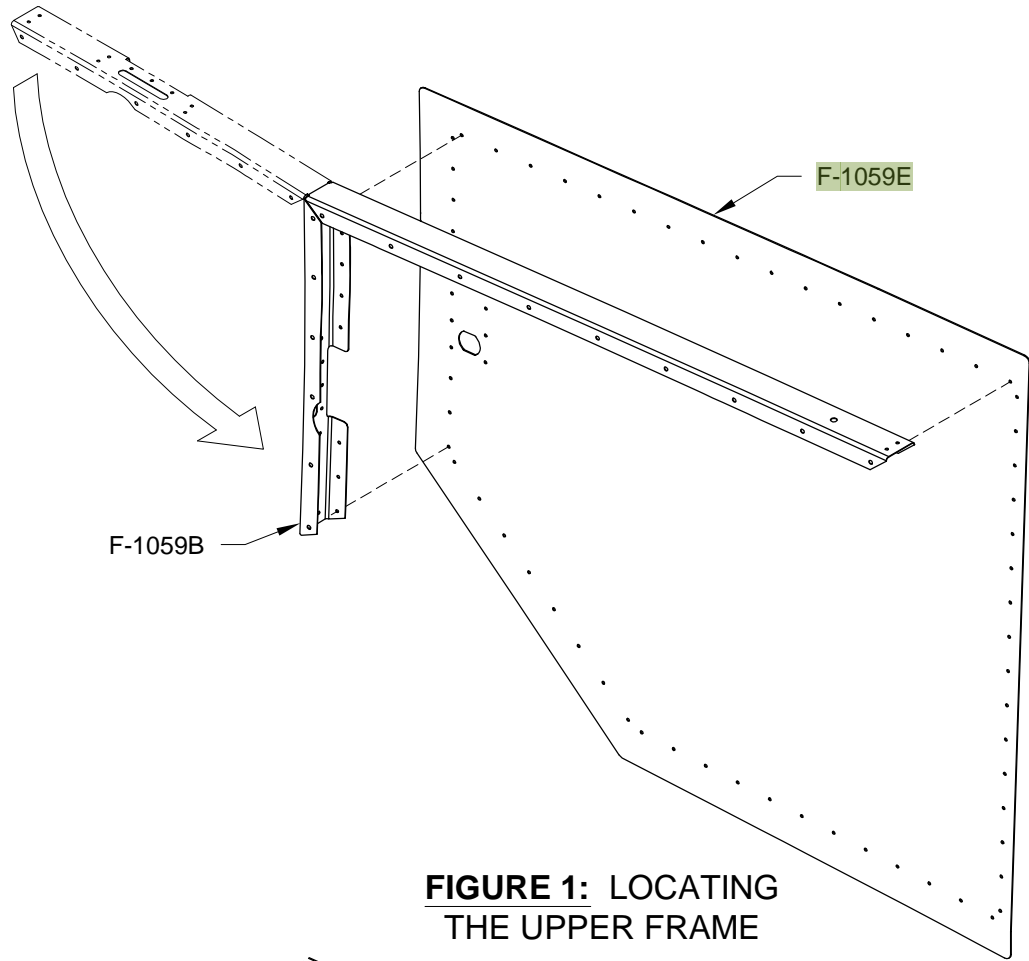


FIGURE 1: LOCATING THE UPPER FRAME

Step 3: Bend the F-1059C Lower Frame by hand as shown in Figure 2.

Step 4: Cleco the F-1059C Lower Frame to the F-1059E Skin as shown in Figure 2. Cleco the tab on the lower frame to the inside (between the flanges) surface of the F-1059B Upper Frame web.

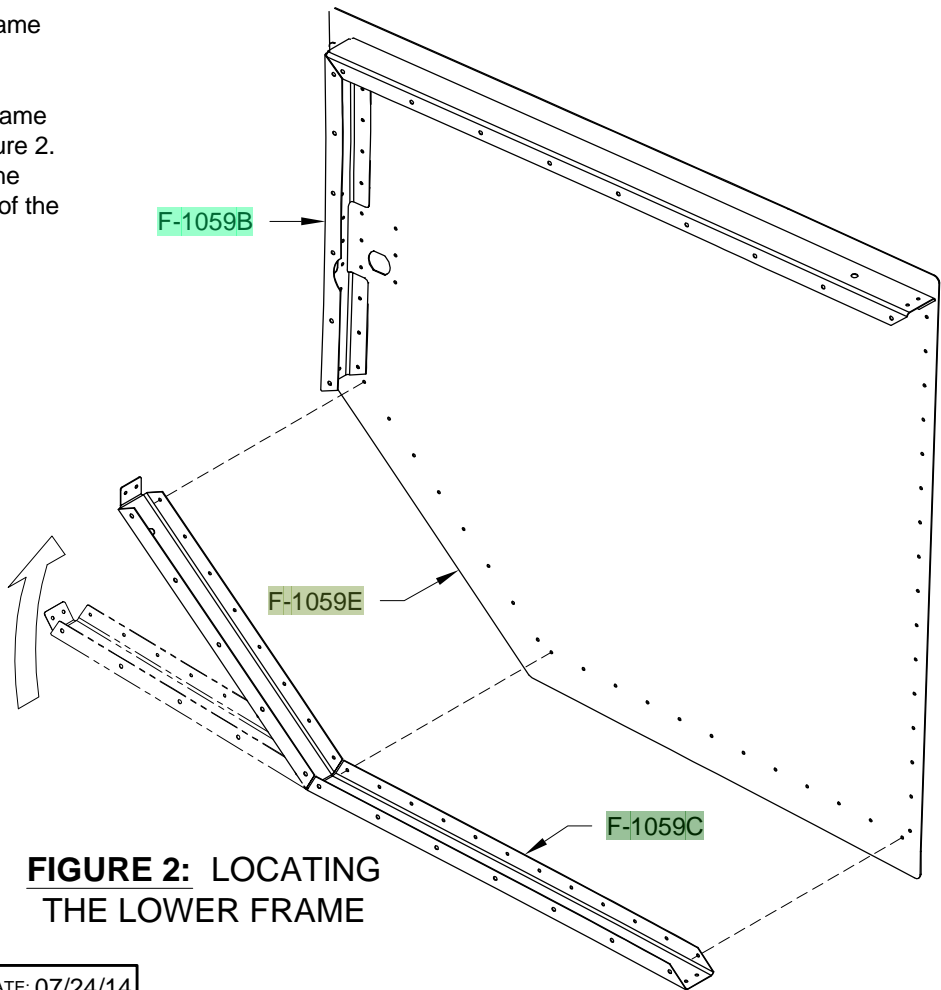


FIGURE 2: LOCATING THE LOWER FRAME

Step 5: Cleco the F-1059A Forward Frame to the F-1059E Skin as shown in Figure 3. Cleco the end tabs of the forward frame to the inside surface of the F-1059B and C Upper and Lower Frame webs.

Step 6: Cleco the F-1059D Lock Bracket to the F-1059E Skin as shown in Figure 3. Cleco the three flanges of the lock bracket to the web of the F-1059B Upper Frame.

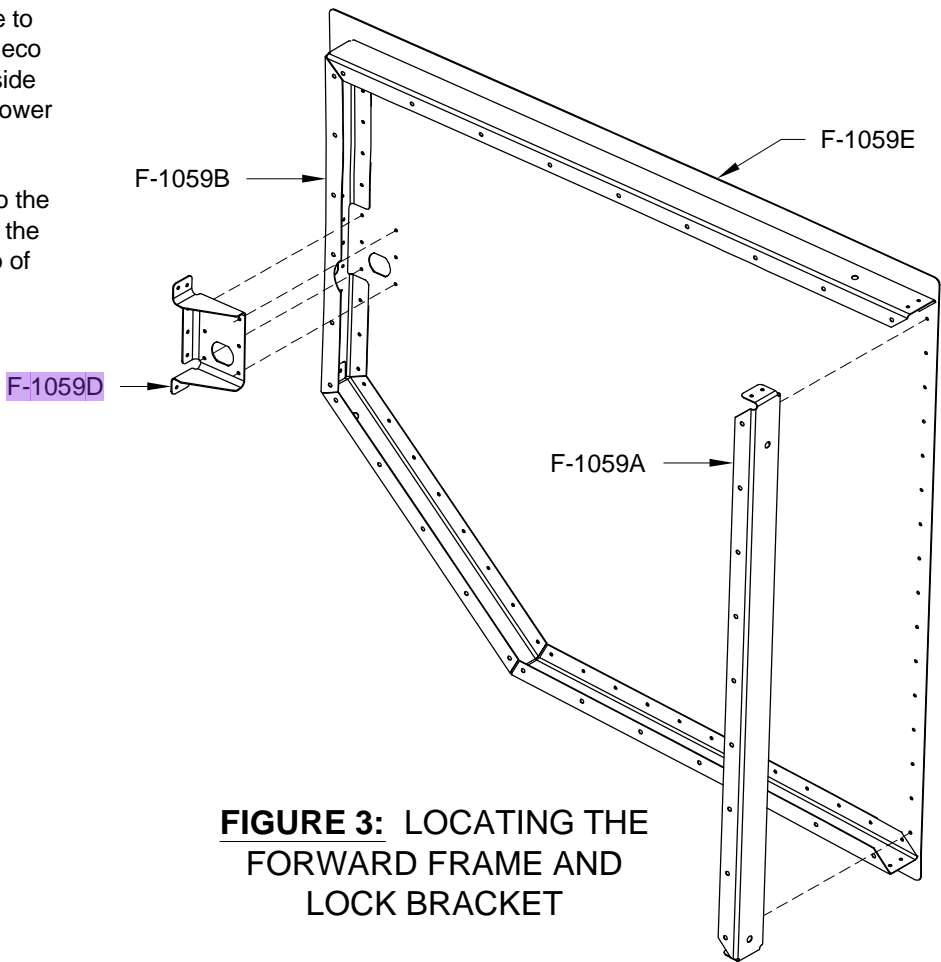


FIGURE 3: LOCATING THE FORWARD FRAME AND LOCK BRACKET

Step 7: Cleco the F-1059F Close-Out Panel to the F-1059A, B, and C Frames as shown in Figure 4.

Step 8: Final-Drill the 1/8" holes common to the F-1059F Close-Out Panel and the F-1059A, B, and C Frames using a #30 drill. Final-Drill the remaining 3/32" holes of all the parts using a #40 drill.

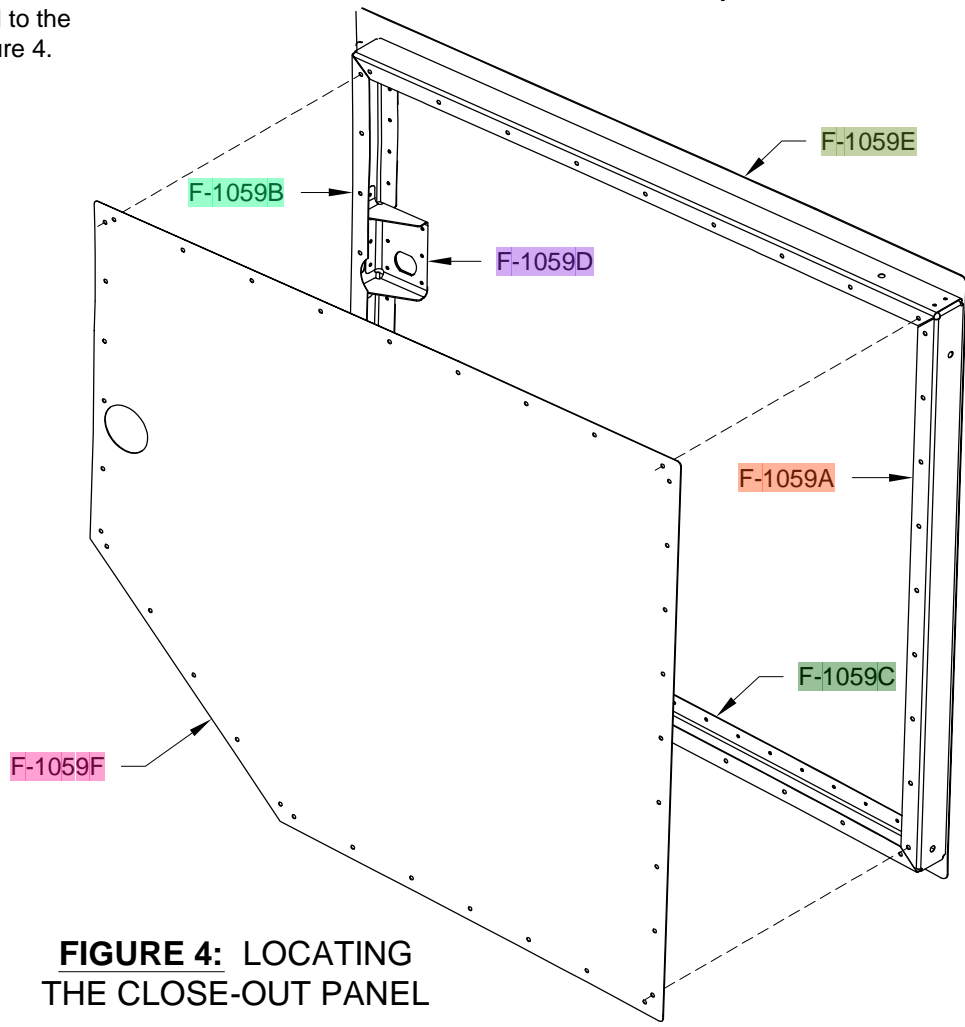
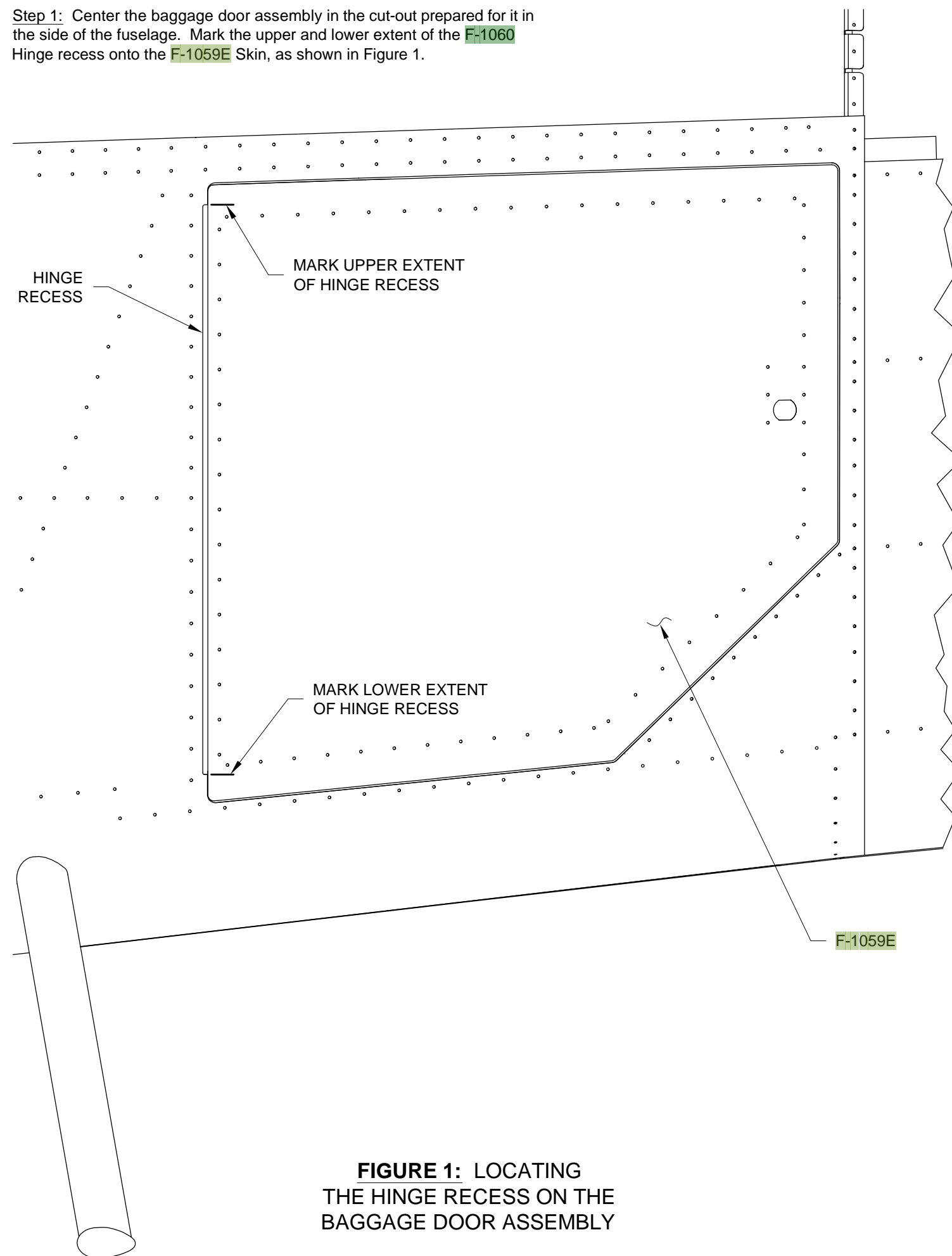


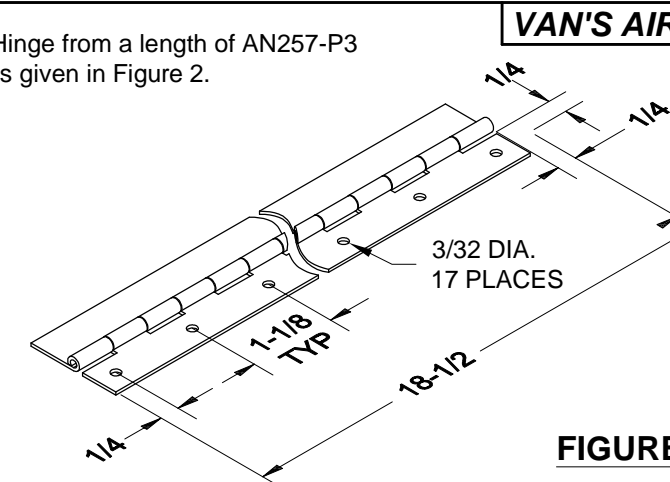
FIGURE 4: LOCATING THE CLOSE-OUT PANEL

Step 1: Center the baggage door assembly in the cut-out prepared for it in the side of the fuselage. Mark the upper and lower extent of the F-1060 Hinge recess onto the F-1059E Skin, as shown in Figure 1.



**FIGURE 1: LOCATING THE HINGE RECESS ON THE BAGGAGE DOOR ASSEMBLY**

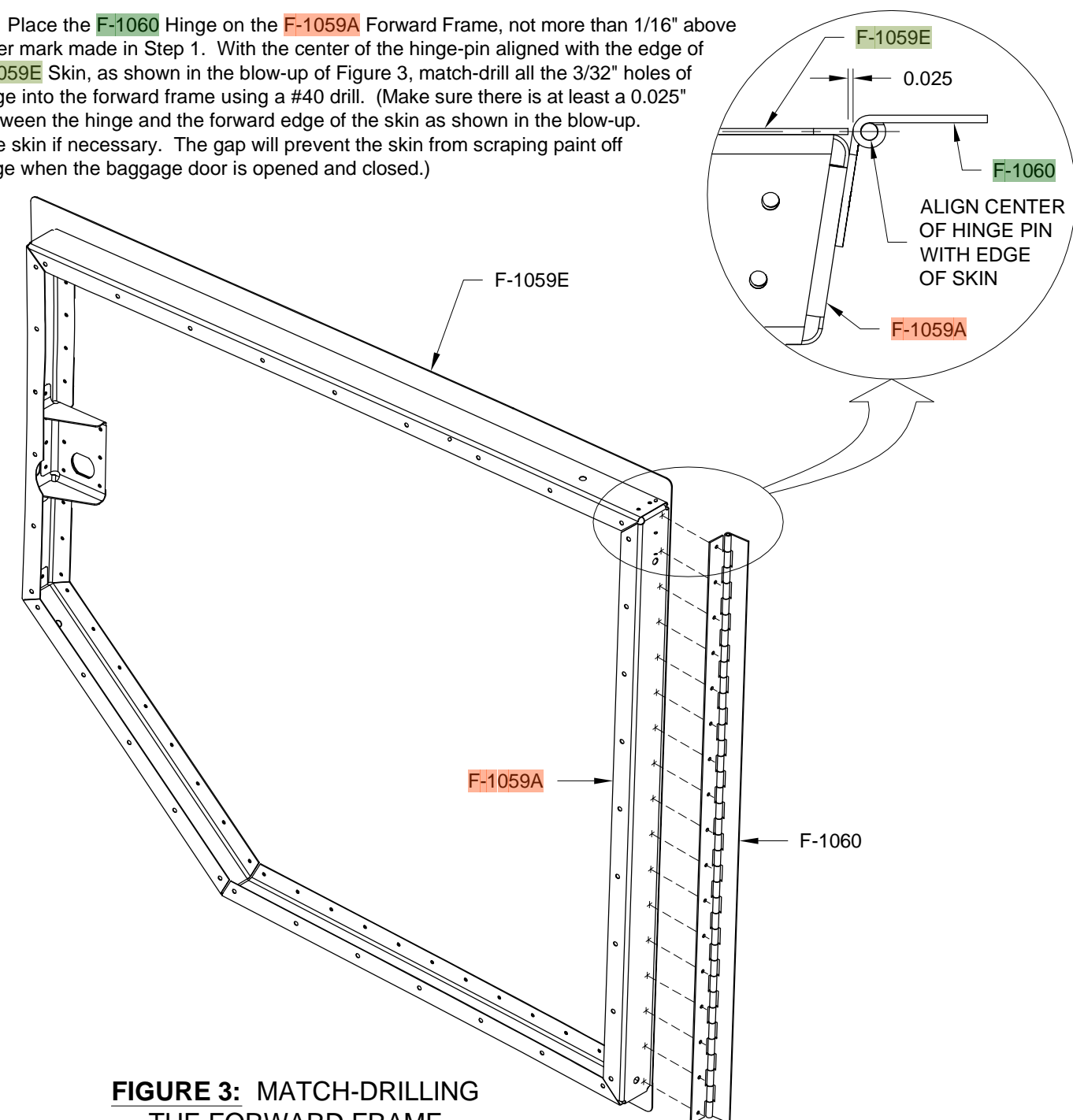
Step 2: Make the F-1060 Hinge from a length of AN257-P3 according to the dimensions given in Figure 2.



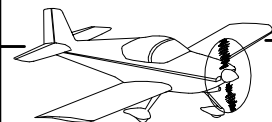
**FIGURE 2: F-1060 HINGE**

Step 3: Remove the F-1059F Close-Out Panel from the baggage door assembly.

Step 4: Place the F-1060 Hinge on the F-1059A Forward Frame, not more than 1/16" above the lower mark made in Step 1. With the center of the hinge-pin aligned with the edge of the F-1059E Skin, as shown in the blow-up of Figure 3, match-drill all the 3/32" holes of the hinge into the forward frame using a #40 drill. (Make sure there is at least a 0.025" gap between the hinge and the forward edge of the skin as shown in the blow-up. Trim the skin if necessary. The gap will prevent the skin from scraping paint off the hinge when the baggage door is opened and closed.)



**FIGURE 3: MATCH-DRILLING THE FORWARD FRAME**



Step 1: Completely disassemble the baggage door assembly, and then deburr the holes in all of the parts.

Step 2: Machine countersink the holes in the **F-1060** Hinge for the heads of AN426AD3 rivets.

Step 3: Dimple the #30 holes in the **F-1059F** Close-Out Panel and the corresponding holes in the underlying structure. Except for the #40 holes in the **F-1059A** Forward Frame which are common to the **F-1060** Hinge, dimple all #40 holes in the remaining parts.

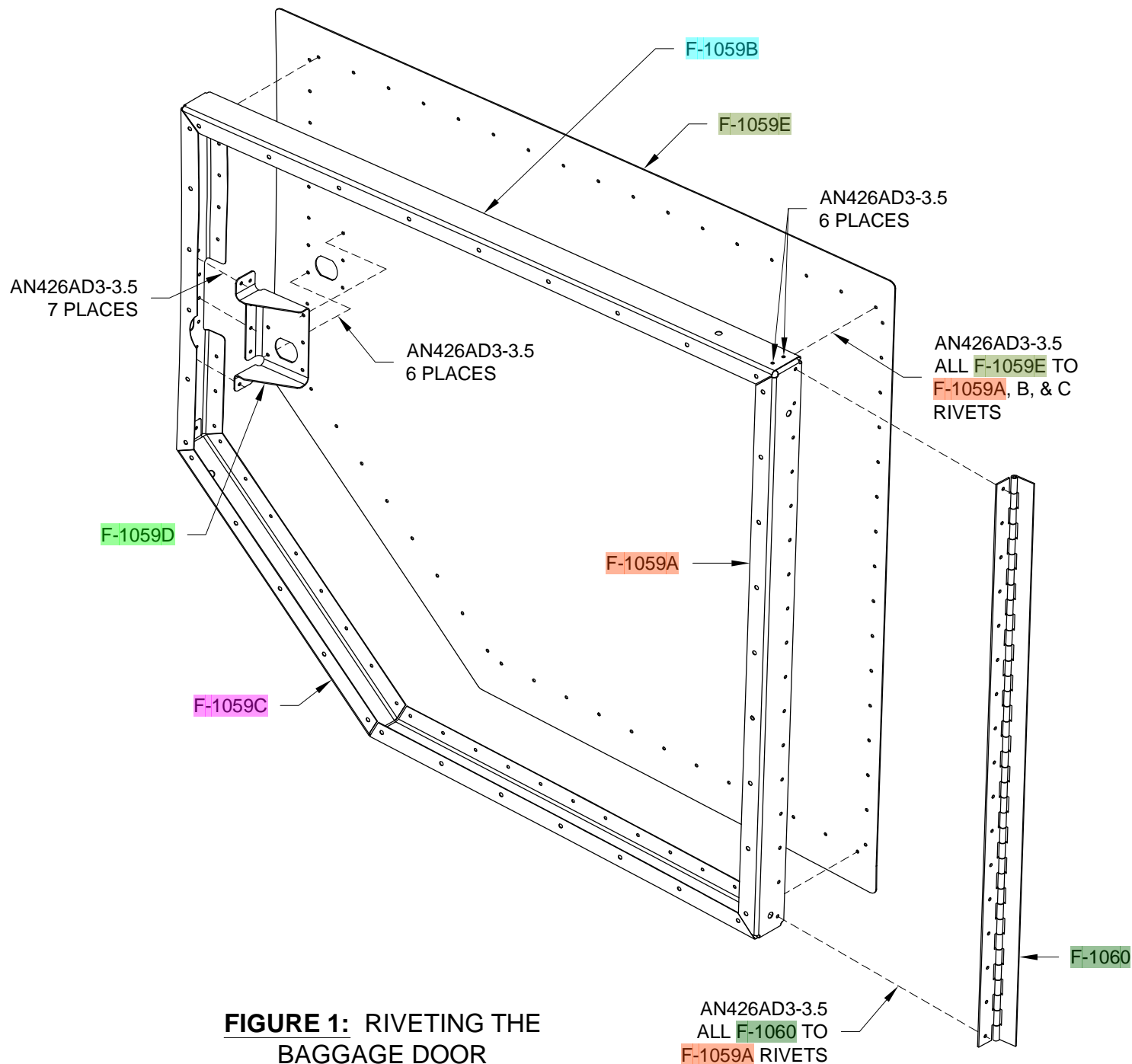
Step 4: Prime the parts if/as desired.

**NOTE:** Refer to Figure 1 for part number references and rivet call-outs required for Steps 5-7.

Step 5: Rivet the **F-1060** Hinge to the **F-1059A** Forward Frame.

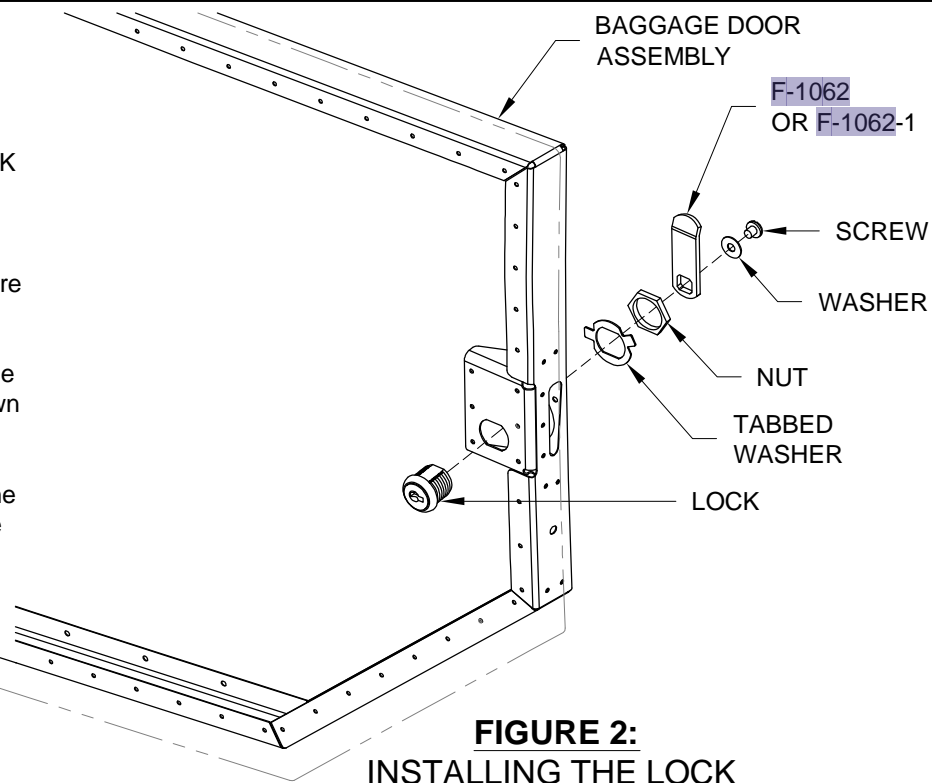
Step 6: Rivet the **F-1059A**, B, and C Frames to the F-1059E Skin and to each other.

Step 7: Rivet the **F-1059D** Lock Bracket to the F-1059E Skin and to the **F-1059B** Upper Frame.

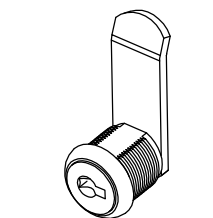


**FIGURE 1: RIVETING THE BAGGAGE DOOR**

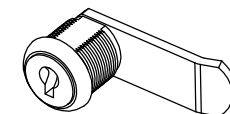
Step 8: Install the Lock and the **F-1062** Lock Latch as shown in Figure 2. (The lock and hardware, which is included with the ES A-510-2K Magneto Switch, is not supplied in the kit. They can be ordered from the Van's Accessories Catalog.) Be sure to install the lock in the Baggage Door Assembly so that a clockwise rotation of the key will lock the door as shown in Figures 3 and 4. Once the nut for the lock is tightened, bend up one of the tabs on the tabbed washer to prevent the nut from rotating. To prevent the screw from backing out, apply Locktite to the threads.



**FIGURE 2: INSTALLING THE LOCK**

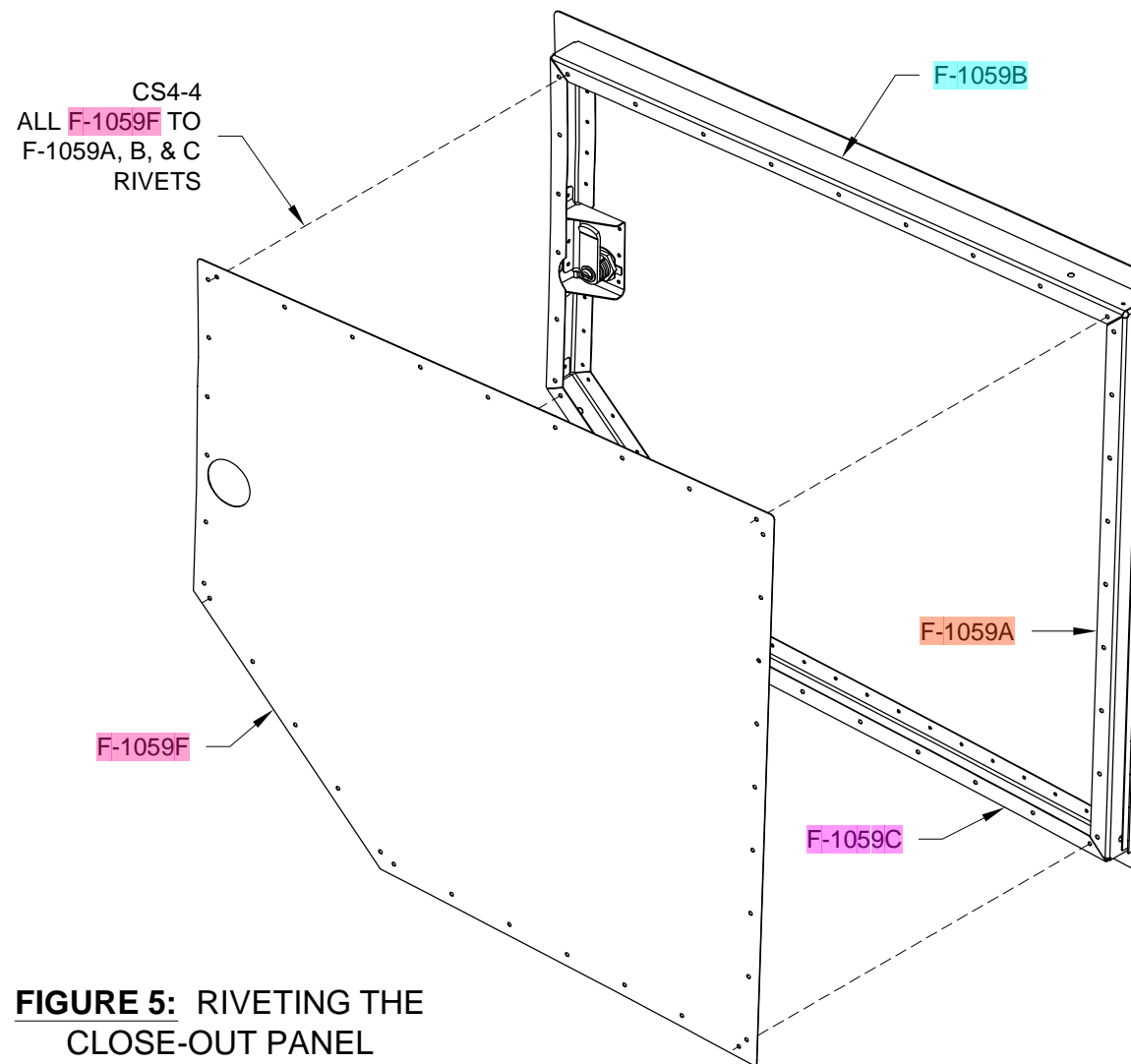


**FIGURE 3: UNLOCKED POSITION**



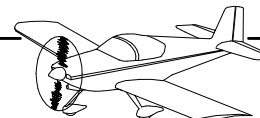
**FIGURE 4: LOCKED POSITION**

Step 9: Rivet the **F-1059F** Close-Out Panel to the F-1059A, B, and C Frames using the rivets called-out in Figure 5.



**FIGURE 5: RIVETING THE CLOSE-OUT PANEL**



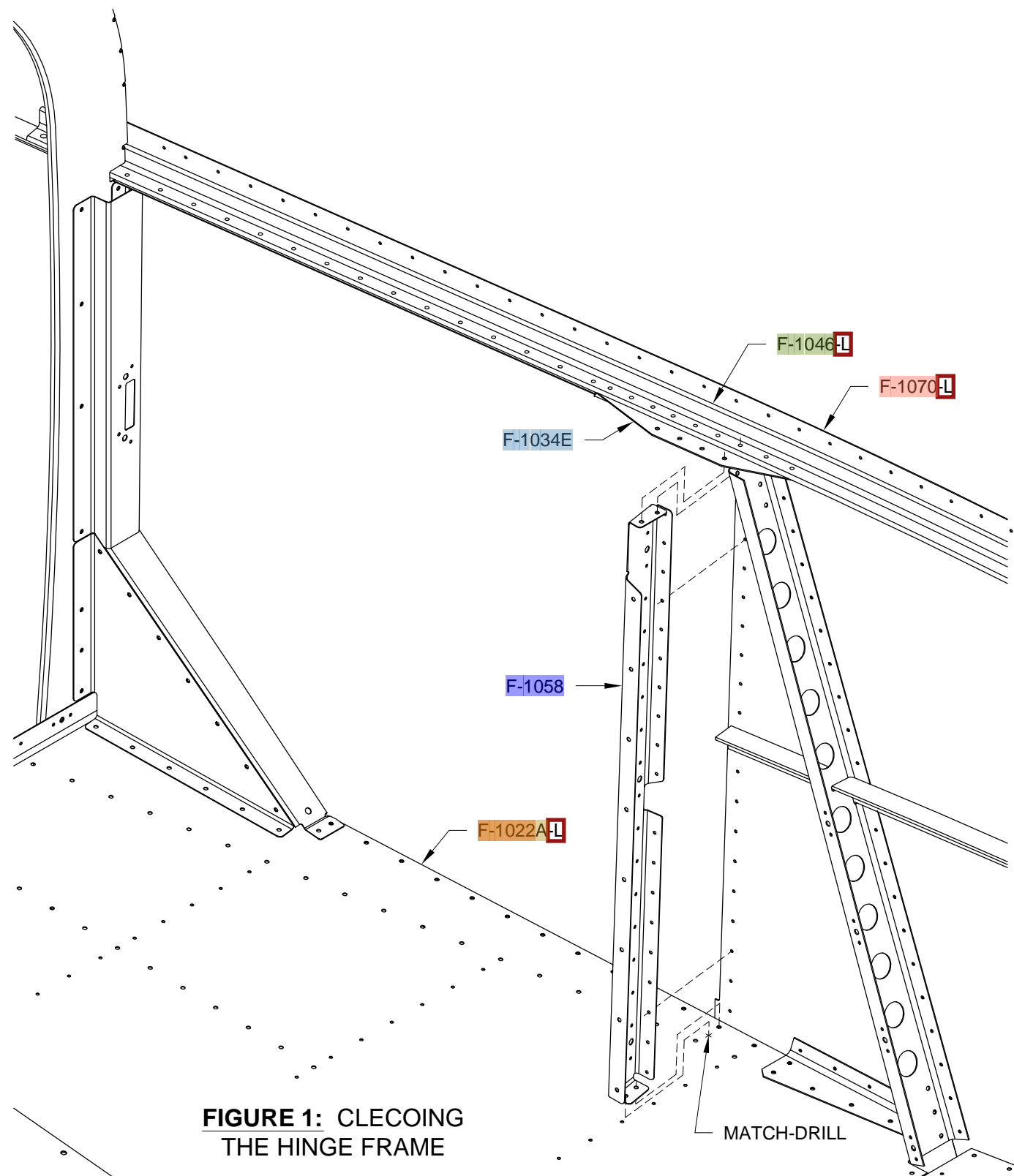


**Step 1:** Final-Drill #40 the holes in the F-1058 Hinge Frame which are common to the F-1070-L Mid Side Skin. Dimple these holes.

**Step 2:** As shown in Figure 1, cleco the side flange of the F-1058 Hinge Frame to the F-1070-L Mid Side Skin. Cleco the top flange to the F-1034E Seatback Brace Gusset, the F-1034B Seatback Brace (not shown), and the F-1046-L Mid Fuse Longerons. Cleco the outboard hole in the bottom flange to the F-1022A-L Baggage Floor.

**Step 3:** Match-Drill #30 the inboard hole in the bottom flange of the F-1058 Hinge Frame into the F-1022A-L Baggage Floor, cleco this hole, then final-drill #30 the outboard hole.

**Step 4:** Final-Drill #30 the holes in all the parts common to the two holes in the top flange of the F-1058 Hinge bracket.



**FIGURE 1: CLECOING THE HINGE FRAME**

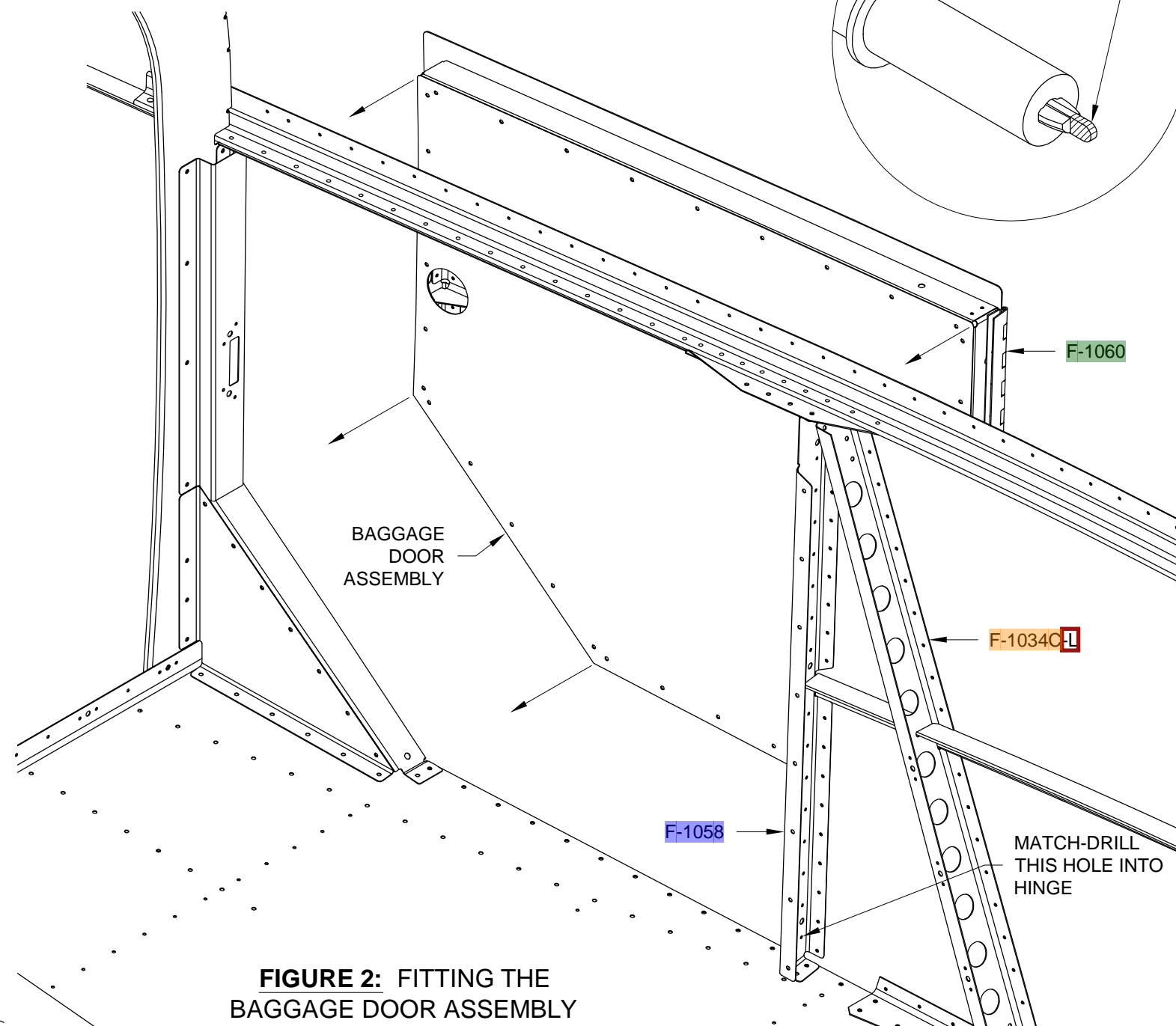
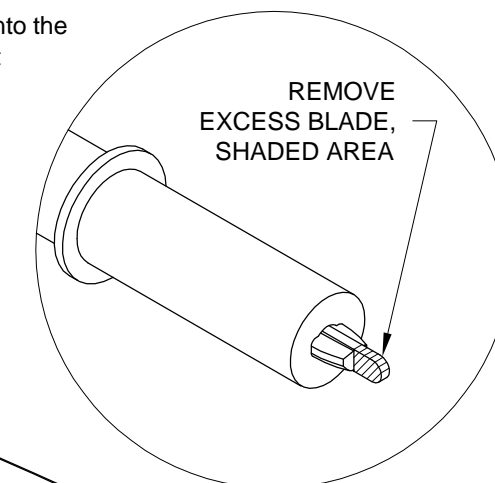
**Step 5:** Place the Baggage Door Assembly in the fuselage cut-out as shown in Figure 2 (for clarity, the F-1034B Seatback Brace is not shown).

With the F-1060 Hinge against the F-1058 Hinge Frame, center the baggage door vertically in the fuselage cut-out. If the hinge interferes with the F-1070-L Mid Side Skin, the ends of the hinge can be filed until it clears.

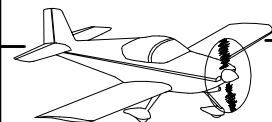
Flush the baggage door with the outside of the fuselage. Duct tape can be used to hold the door in position, and use .063" shims to fill the gap between the door skin and underlying structure. There is a .035" gap between the eyelets of the two hinge-halves. Slide the forward (free) hinge-half up the hinge pin to remove the gap, then tape it in place. This will prevent a .035" drop in the position of the baggage door when it is riveted in place.

**Step 6:** With a grinder or belt sander, remove the excess blade from two clecos as shown in the cleco detail of Figure 2.

**Step 7:** Using an angle drill, match-drill #40 the bottom most hole of the F-1058 Hinge Frame into the F-1060 Hinge. (Use a wedge between the two legs of the hinge to keep the forward leg against the hinge frame while drilling.) Cleco this hole, using one of the modified clecos from Step 6, then match-drill a second hole as close as possible to the other end of the hinge while keeping the angle drill clear of the F-1034C-L Fuselage Bulkhead. Cleco this hole with the second modified cleco, and recheck the alignment of the door.



**FIGURE 2: FITTING THE BAGGAGE DOOR ASSEMBLY**



Step 1: Remove the Baggage Door Assembly and the F-1058 Hinge Frame from the fuselage. Cleco the hinge frame to the F-1060 Hinge using the two holes drilled on Page 34-5, Step 7, then match-drill #40 the remaining holes of the hinge frame into the hinge. Deburr the holes of both parts.

Step 2: Machine countersink the hinge for the heads of AN426AD3 rivets.

Step 3: Rivet the F-1060 Hinge to the F-1058 Hinge Frame using the rivets called-out in Figure 1.

Step 4: Attach 1/8" thick x 1/4" wide seal material (door and window weather strip tape can be used) to the F-1059E Skin about an 1/8" from the edges of the skin as shown in Figure 1.

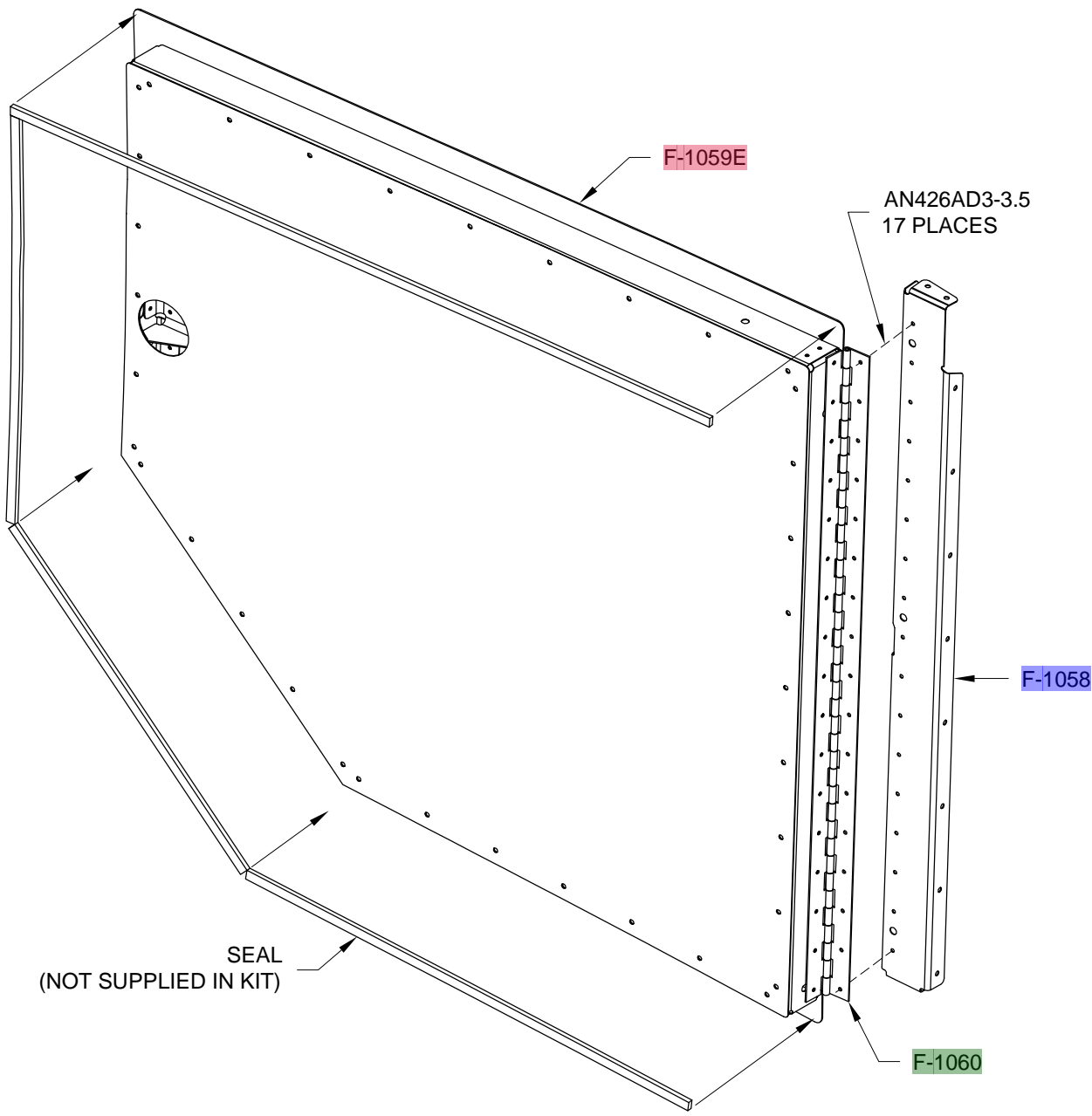


FIGURE 1: ATTACHING THE HINGE FRAME AND SEAL

Step 5: Separate the F-1058 Hinge Frame from the baggage door assembly by removing the hinge pin, then rivet the hinge frame to the fuselage using the rivets called-out in Figure 2 (the F-1034B Seatback Brace is not shown).

Step 6: Attach the Baggage Door Assembly to the F-1058 Hinge Frame by reinstalling the hinge pin.

Step 7: Attach the F-1061 Striker Plate to the F-1031 Upper Baggage Door Seal Channel using the hardware shown in Figure 2. Adjust the striker plate as needed to flush the aft end of the Baggage Door Assembly with the fuselage when the door is closed and locked.

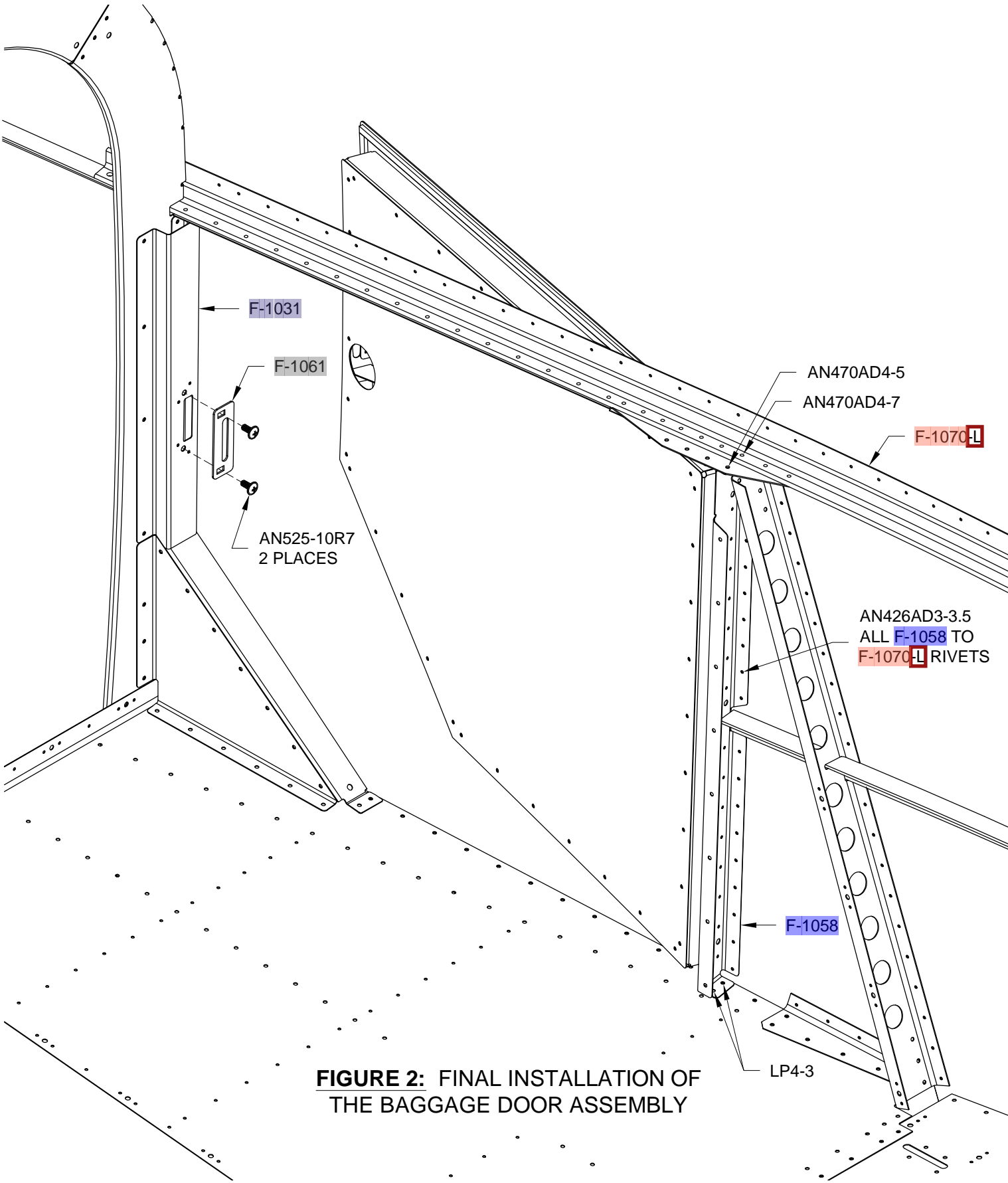


FIGURE 2: FINAL INSTALLATION OF THE BAGGAGE DOOR ASSEMBLY

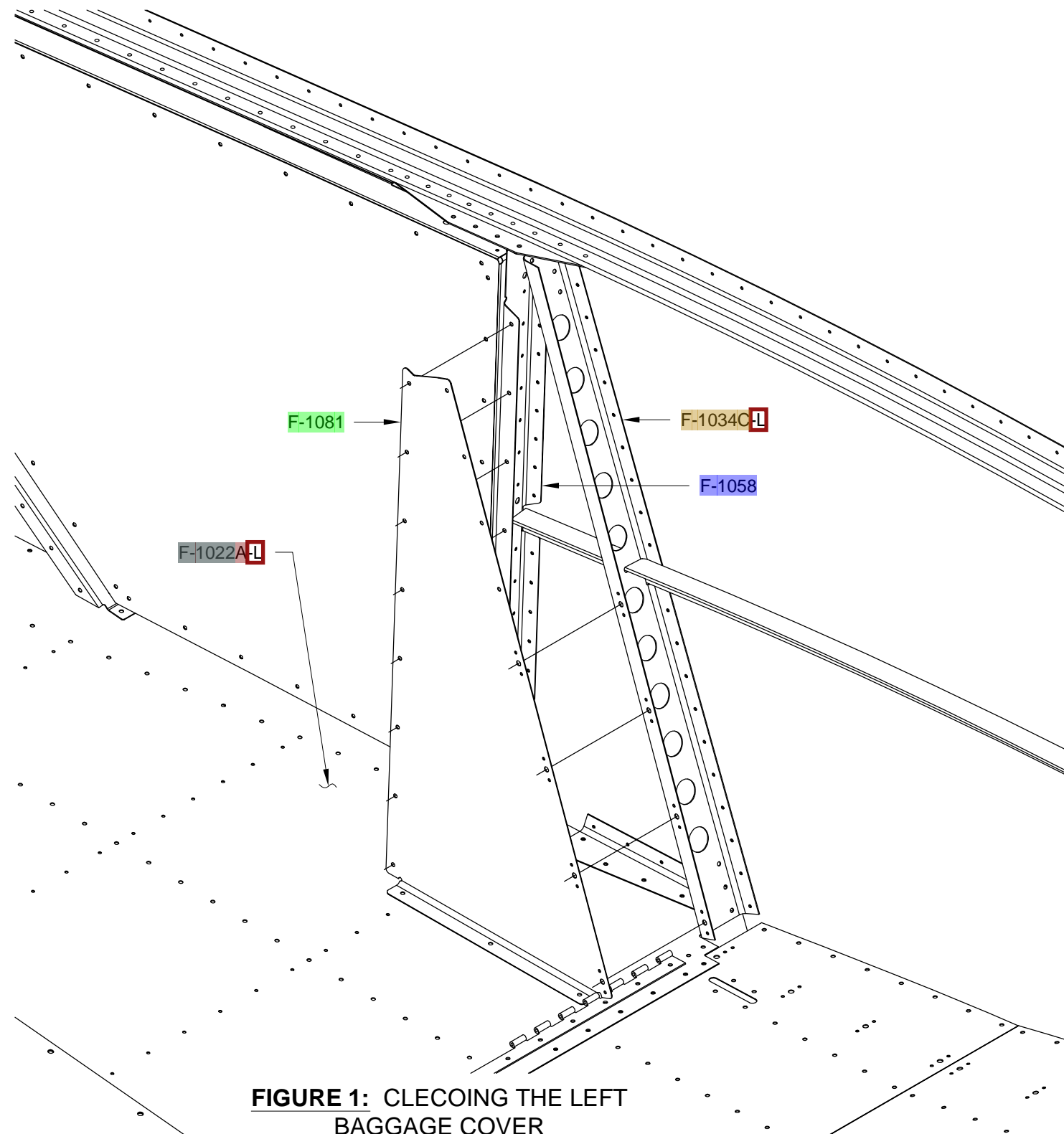
Step 1: Cleco the **F-1081** Left Baggage Cover to the **F-1034C-L** Fuselage Bulkhead and the **F-1058** Hinge Frame as shown in Figure 1.

Step 2: Match-Drill #30 the four 1/8" holes in the top of the **F-1081** Left Baggage Cover into the **F-1034C-L** Fuselage Bulkhead, and the three 1/8" holes in the flange of the left baggage cover into the **F-1022A-L** Baggage Floor.

Final-Drill #30 the holes common to the left baggage cover and the **F-1058** Hinge Frame.

Final-Drill #40 the nutplate attachment rivet holes common to the left baggage cover and the fuselage bulkhead.

Step 3: Remove the **F-1081** Left Baggage Cover, deburr the holes in all associated parts, then dimple the #40 holes in the left baggage cover and the **F-1034C-L** Fuselage Bulkhead.

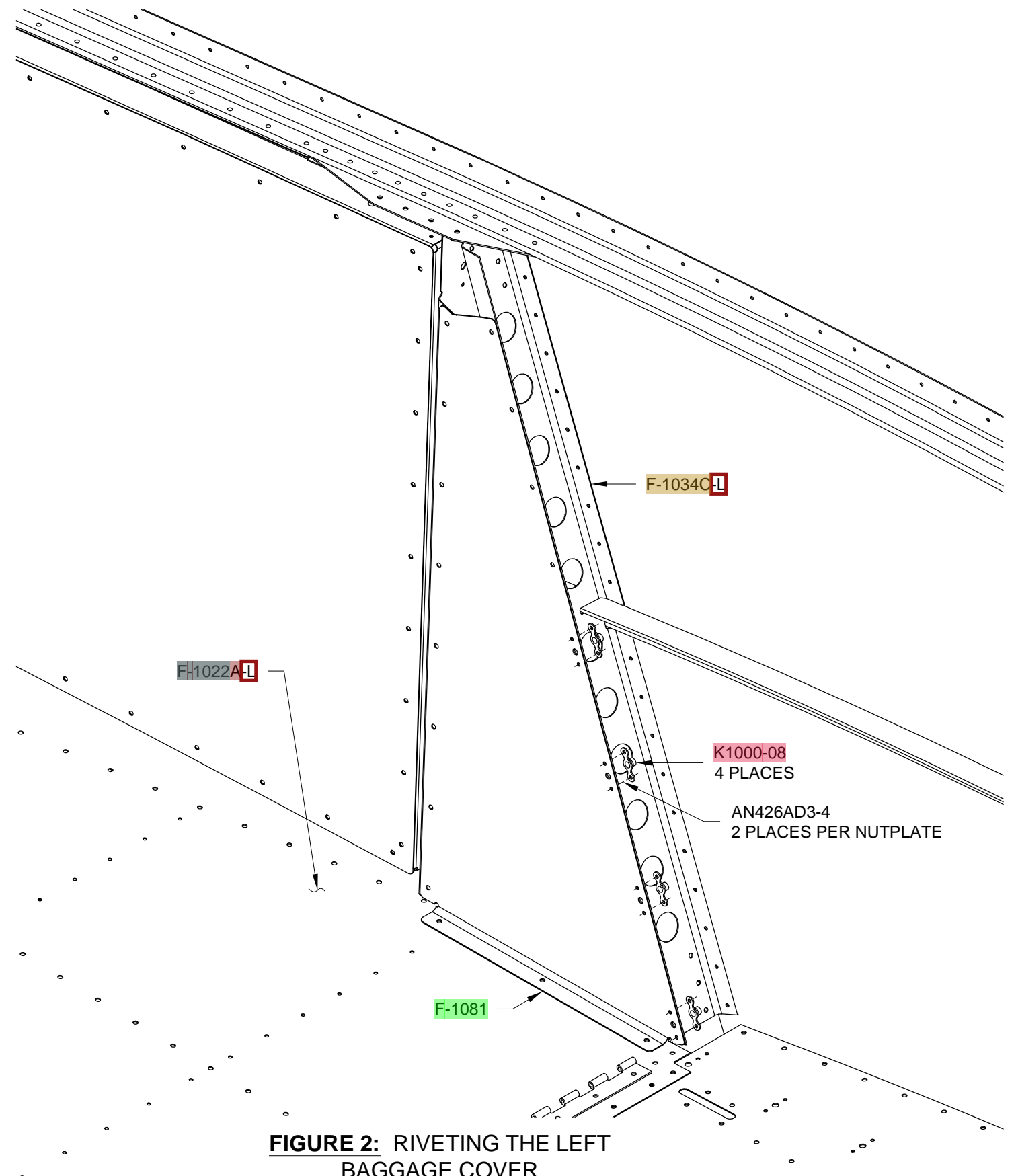


**FIGURE 1: CLECOING THE LEFT BAGGAGE COVER**

Step 4: Rivet the **F-1081** Left Baggage Cover to the **F-1058** Hinge Frame and **F-1022A-L** Baggage Floor using LP4-3 blind rivets.

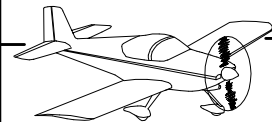
Rivet the top half of the left baggage cover to the **F-1034C-L** Fuselage Bulkhead using AN470AD4-4 rivets.

Step 5: Rivet the nutplates called-out in Figure 2 to the **F-1034C-L** Fuselage Bulkhead and the **F-1081** Left Baggage Cover.



**FIGURE 2: RIVETING THE LEFT BAGGAGE COVER**





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