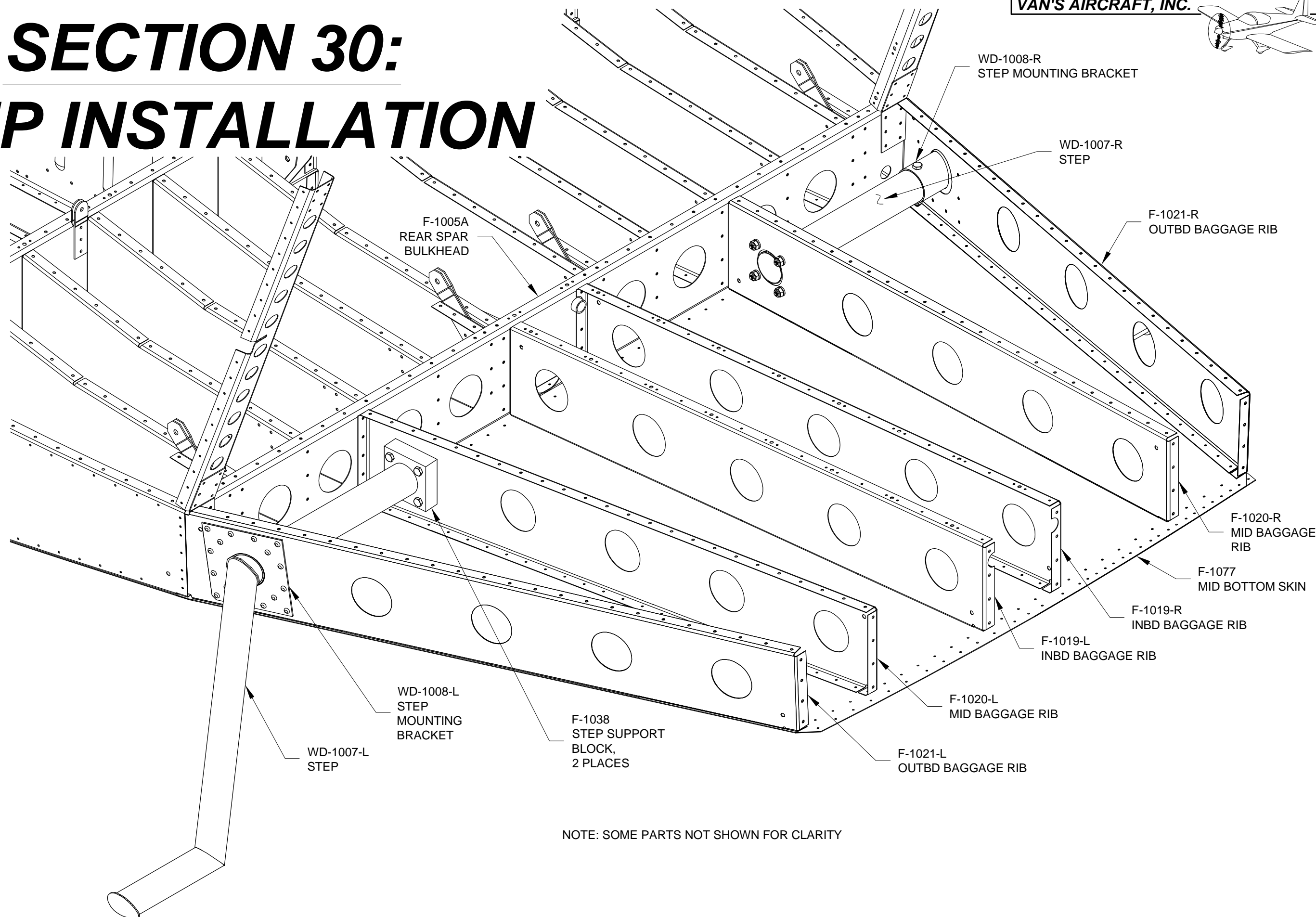
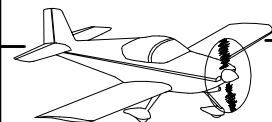


SECTION 30: STEP INSTALLATION



NOTE: SOME PARTS NOT SHOWN FOR CLARITY



Note: This entire section depicts the installation of the left step only. The right step installation is a mirror of the left.

Step 1: Drill the F-1038 Step Support Block per the callouts in Figure 1.

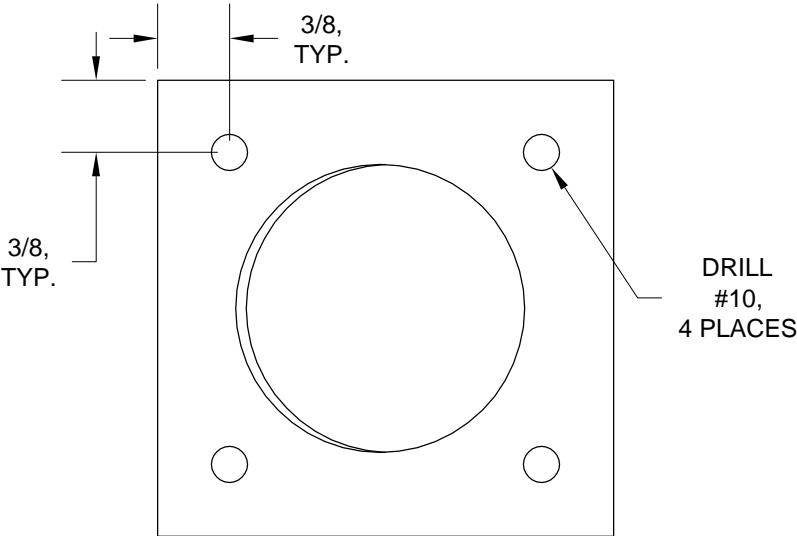


FIGURE 1: DRILLING THE STEP SUPPORT BLOCK

Step 2: Deburr the edge of the WD-1007-L Step as shown in Figure 2.

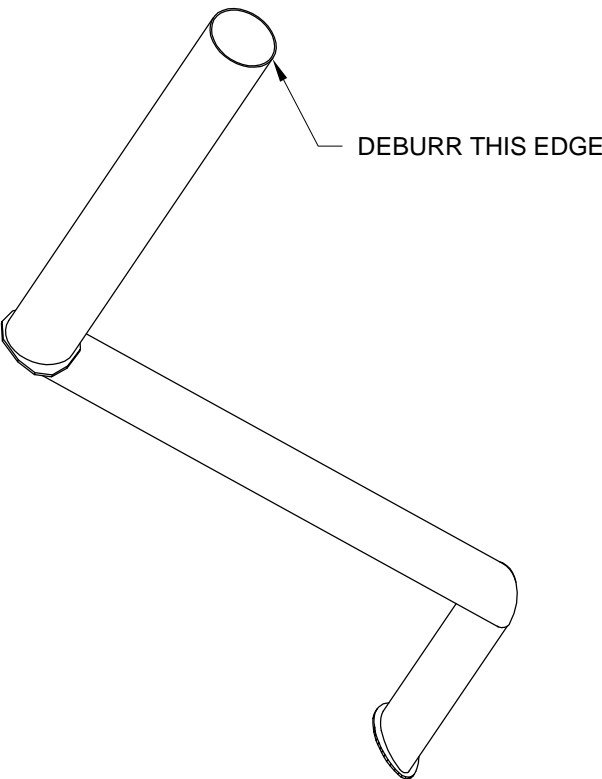


FIGURE 2: DEBURRING THE STEP

Step 3: Insert the round portion of the WD-1007-L Step into the WD-1008-L Step Mounting Bracket then slip the F-1038 Support Block over the end of the tube. Slide the support block inboard and rotate as required to flush the support block against the web of the F-1020-L Mid Baggage Rib.

Step 4: Cleco the forward portion of the F-1022A-L Baggage Floor to the fuselage as shown in Figure 3. To keep the free end the baggage floor out of the way cleco the aft flange to the holes along the lower edge of the F-1034B Seat Back Brace, see Section 29.

Step 5: Adjust the position of the F-1038 Support Block to make the round portion of the WD-1007-L Step parallel to both the upper edge and web of the F-1005A Rear Spar Bulkhead. Match-Drill #12 at least two of the holes drilled in Step 1 into the F-1020-L Mid Baggage Rib. Temporally bolt these holes to the mid baggage rib. Remove the step and match-drill #12 the remaining holes.

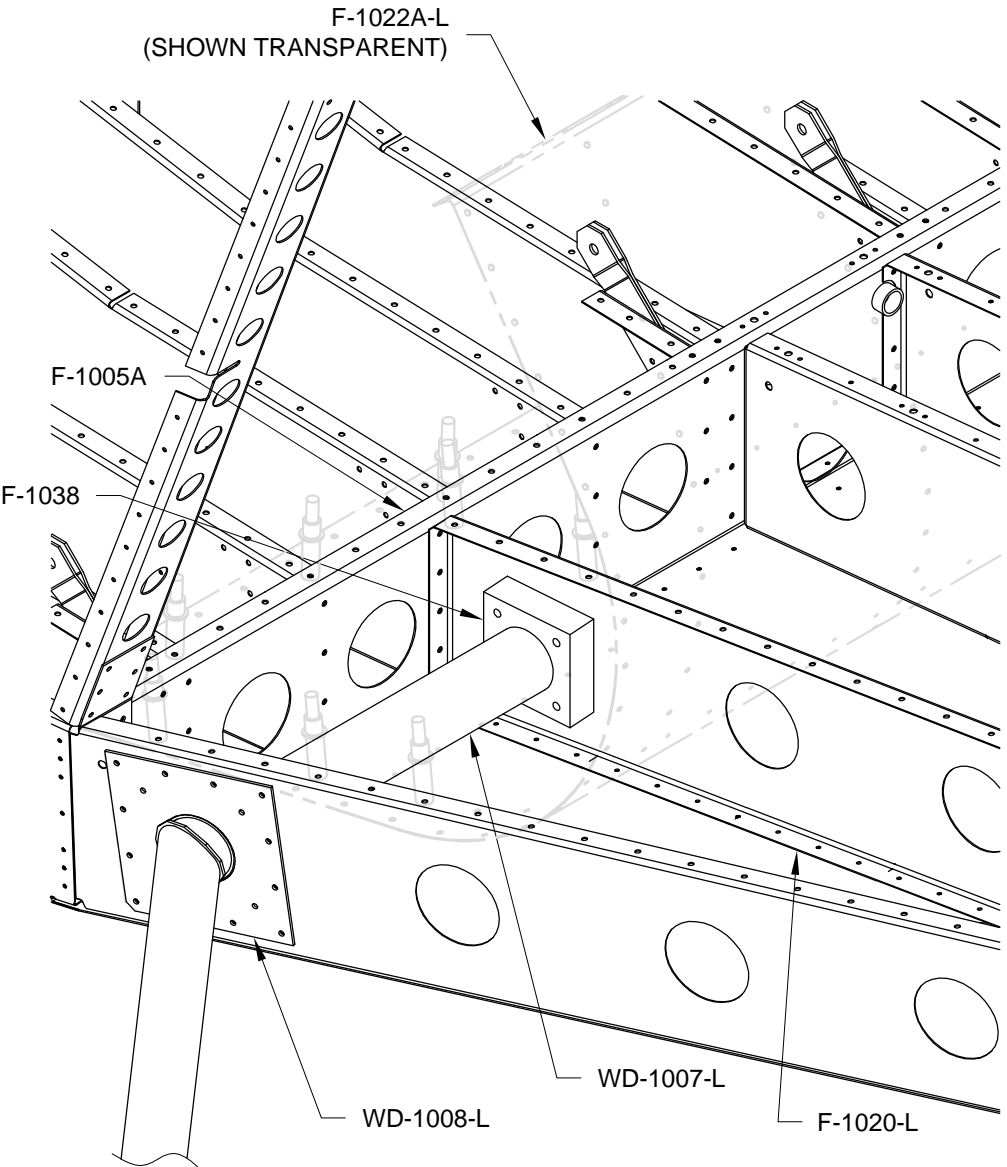


FIGURE 3: DRILLING THE SUPPORT BLOCK ATTACH HOLES

Step 6: Remove the F-1022A-L Baggage Floor. Mark the top, aft and outboard face of the F-1038 Support Block as shown in Figure 4. Remove the support block. Deburr the holes in the F-1020-L Mid Baggage Rib.

Step 7: Remove the WD-1007-L Step and set it aside. Bolt the F-1038 Support Block to the F-1020-L Mid Baggage Rib as shown in Figure 4.

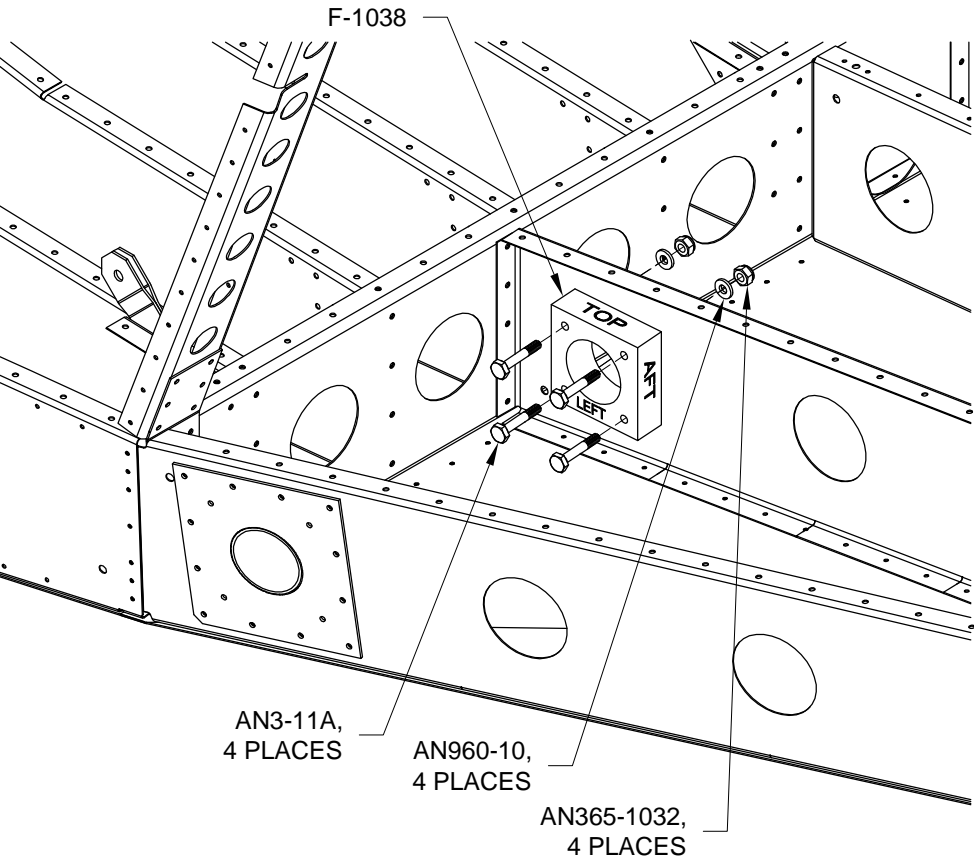
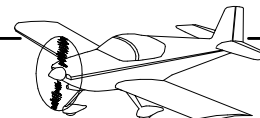


FIGURE 4: ATTACHING THE SUPPORT BLOCK



Step 1: Adjust the spanwise position of the WD-1007-L Step so the weld at the top of the step is flush with the F-1070-L Mid Side Skin as shown in Figure 1.

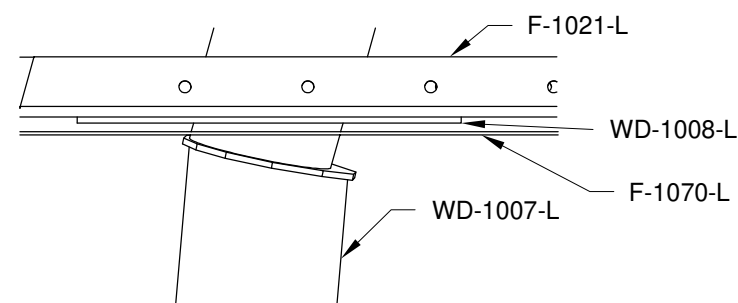


FIGURE 1: SETTING THE STEP SPANWISE POSITION

Step 2: Use the dimension given in Figure 2 to set the proper sweep back angle of the WD-1007-L Step. The dimension given is from the lower aft edge of the F-1004B Center Section Bulkhead stub to the leading edge of the step (not the leading edge of the step end plate).

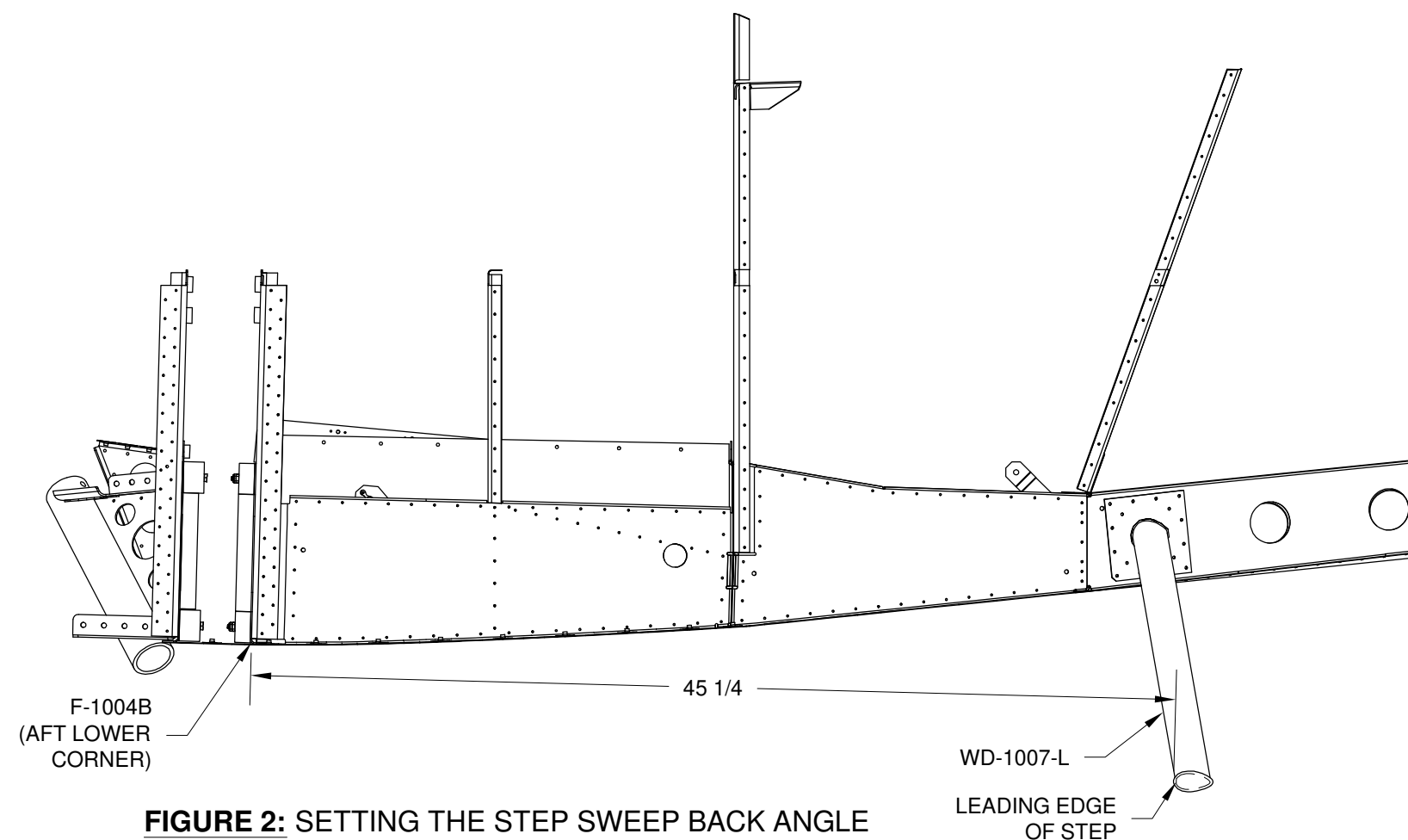


FIGURE 2: SETTING THE STEP SWEEP BACK ANGLE

Step 3: Once the sweep back angle of the WD-1007-L Step has been set, use the guide hole shown in Figure 3 to match-drill #30 through the step, WD-1008-L Step Mounting Bracket and F-1077 Mid Bottom Skin.

Step 4: Cleco the F-1022A-L Baggage Floor to the fuselage as shown in Figure 3. Match-Drill #30 from the bottom side of the aircraft through the baggage floor using the hole drilled in Step 3 as a guide. Step 3 and this step provide pilot holes that can be enlarged to gain access to the step attach hardware in the future if the WD-1007-L Step needs to be replaced. It is ok to leave the #30 hole in the bottom of the aircraft as a drain hole.

Step 5: Remove the F-1022A-L Baggage Floor and final-drill #12 the hole drilled in Step 3 through **just** the WD-1008-L Mounting Bracket and WD-1007-L Step.

Step 6: Remove the WD-1007-L Step and deburr all holes drilled in Step 3 through Step 5. Prime the step. Paint the step if desired.

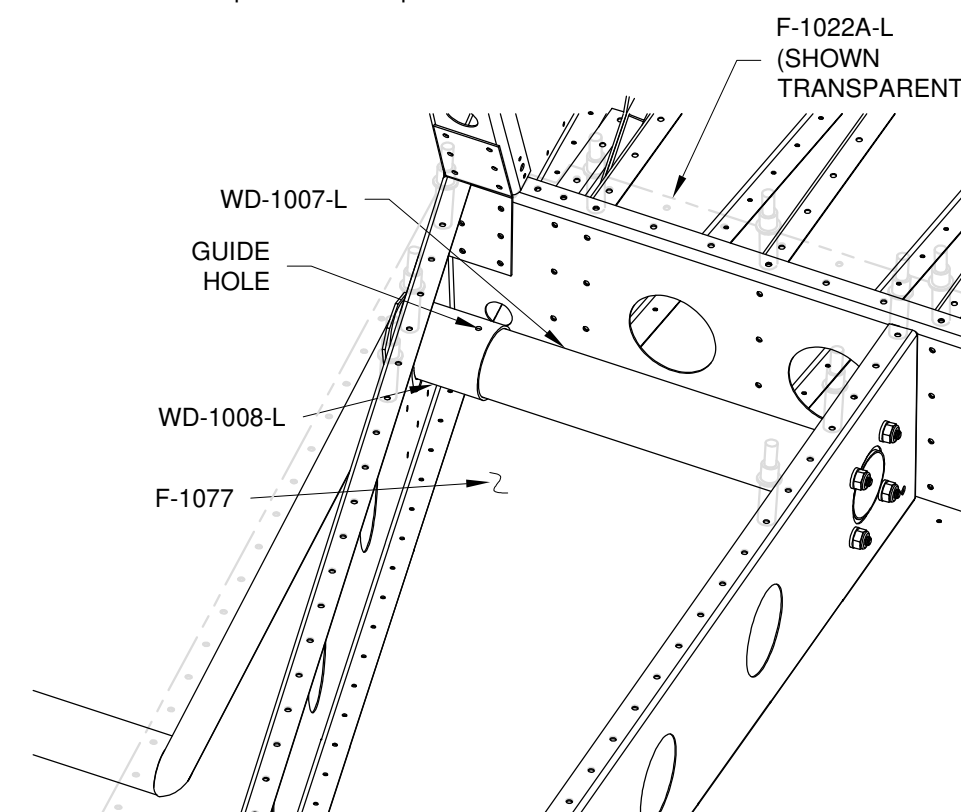
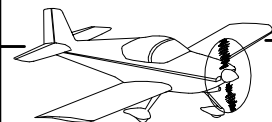


FIGURE 3: DRILLING THE STEP



Step 1: Bolt the WD-1007-L Step to the WD-1008-L Mounting Bracket as shown in Figure 1.

Step 2: Touch-up any primer that may have been scraped off the WD-1007-L Step.

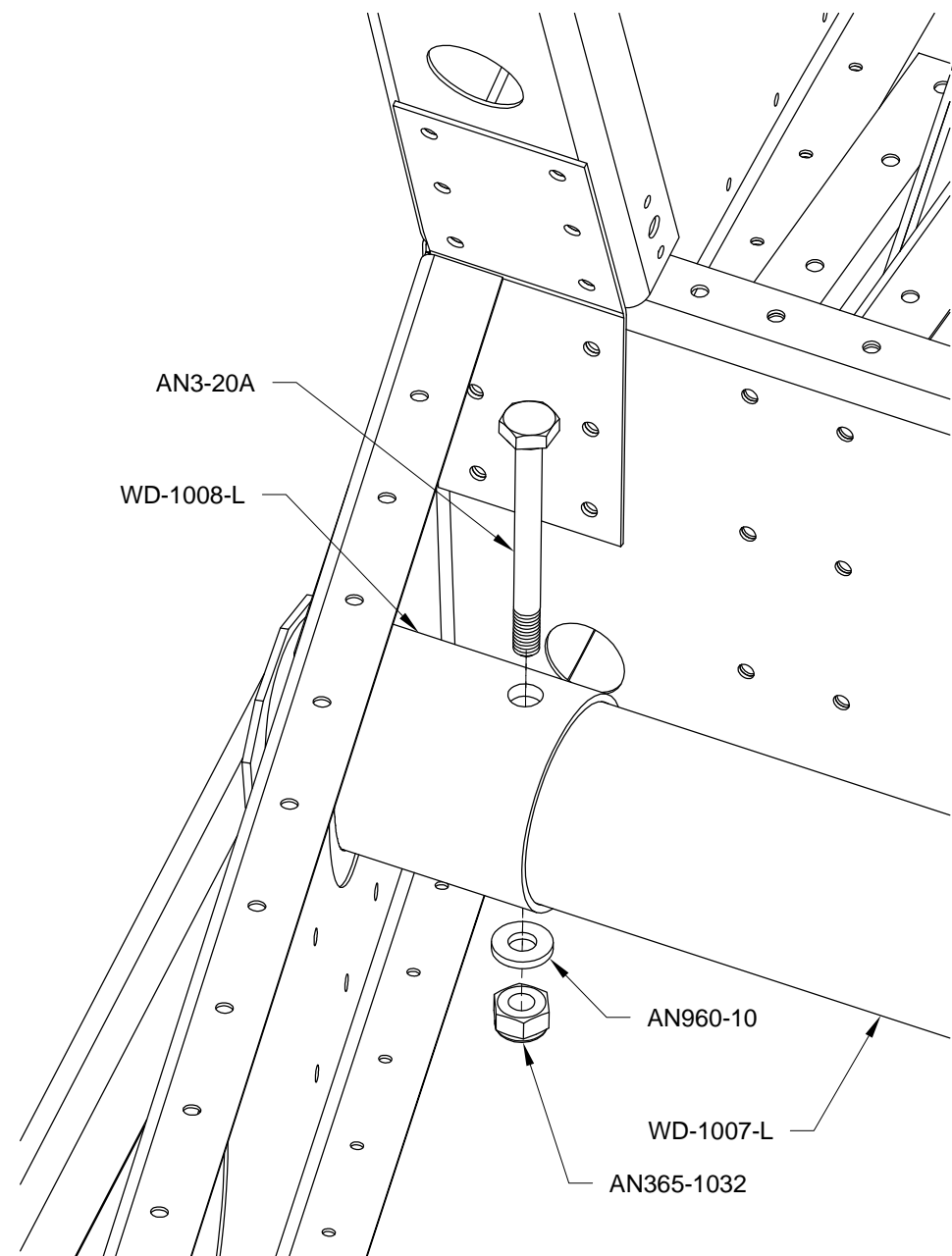


FIGURE 1: BOLTING THE STEP IN PLACE