

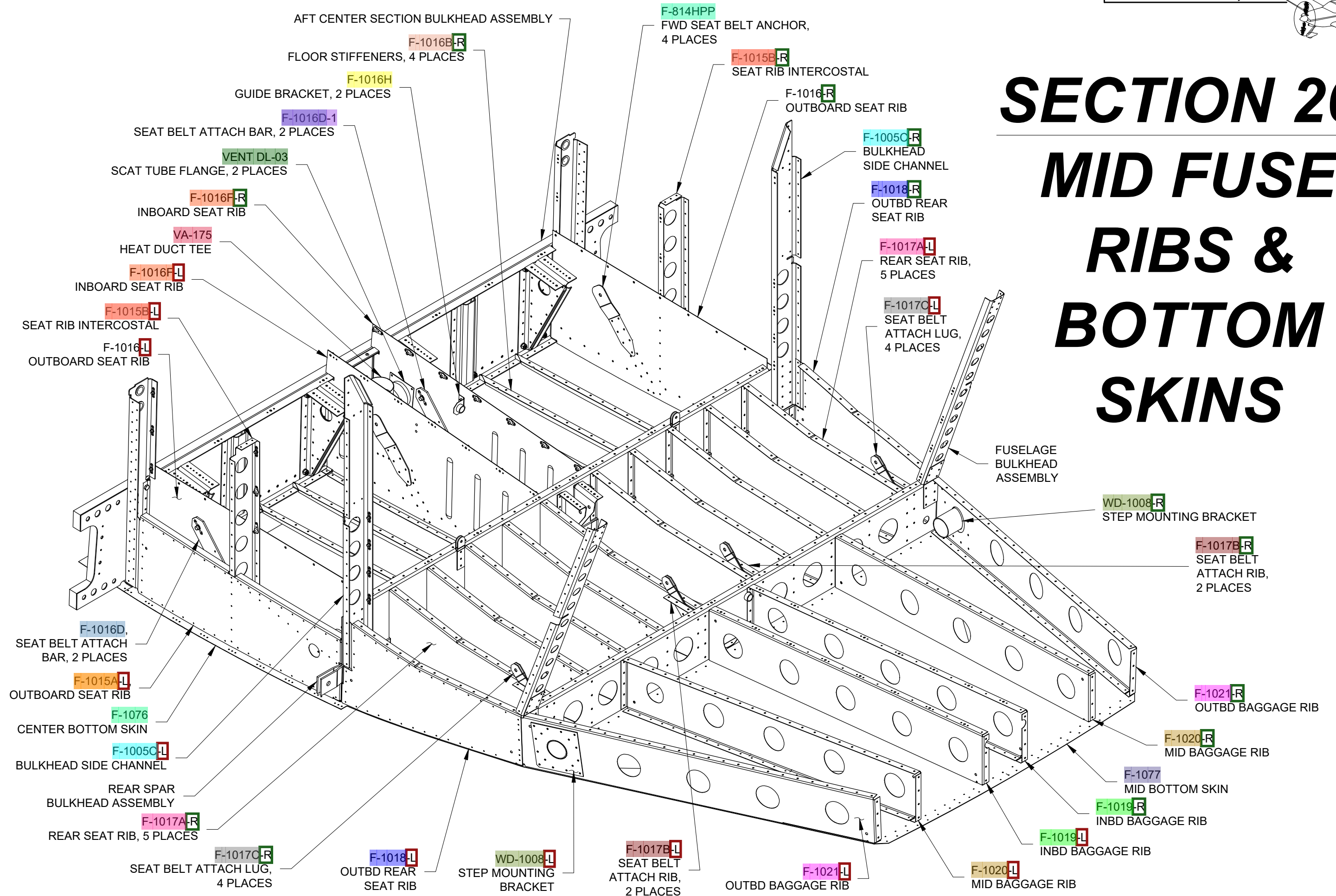
SECTION 26:

MID FUSE

RIBS &

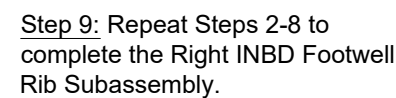
BOTTOM

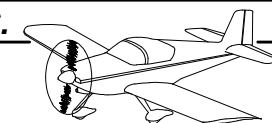
SKINS





Prime parts if/as desired.





Step 1: Cleco the F-1016D Seat Belt Attach Bar, and F-814HPP Fwd Seat Belt Anchor to the F-1016-L Outboard Seat Rib as shown in Figure 1.

Step 2: Final-Drill 1/4 the hole in the F-814HPP, F-1016-L and F-1016D.

Step 3: Cut apart the F-1015EF Spacers into two F-1015E and two F-1015F Spacers. Label each part (the two parts with seven holes in them are F-1015E Spacers).

Step 4: Cleco the F-1015B-L Seat Rib Intercostal and F-1015E Spacer to the F-1016-L Outboard Seat Rib as shown in Figure 2. Final-Drill #40 the holes common between these three parts. Final-Drill #40 the nutplate attach holes and #19 the screw holes in the inboard flange of the seat rib intercostal.

Final-Drill #19 the open screw holes along the upper edge of the outboard seat rib to create the Left Outboard Seat Rib Subassembly. Dimple the lower six #40 holes in the outboard flange of F-1015B-L (see Figure 2).

Step 5: Repeat Steps 1, 2, and 4 to create the Right Outboard Seat Rib Subassembly. The right is a mirror of the left.

Step 6: Disassemble both Right and Left Outboard Seat Rib

Subassemblies. Deburr the edges and holes of all parts. Place the flush side of the following dimples on the inbd side of the subassembly.

Dimple both nutplate attach holes in the F-1016-L & -R Outboard Seat Ribs. Machine countersink the F-1016D Seat Belt Attach Bars for the dimples in the outboard seat ribs. See Figure 1.

Dimple the screw holes in the inboard flange of the seat rib intercostals that correspond to the flush nutplates and the screw holes along the upper edge of the outboard seat rib for a #8 screw.

Dimple the holes common to the outboard seat ribs, F-1015E Spacers and F-1015B-L & -R Seat Rib Intercostals. Dimple the nutplate attach holes in the inboard flange of the seat rib intercostals.

Dimple the two rivet holes in the lower flange of the outboard seat ribs that are below the lower edge of the seat belt attach bars (see Figure 2). Flute the bottom flange of both the outboard seat rib subassemblies. Prime all parts if/as desired.

Step 7: Dimple the K1000-08, K1100-08 and MS21053-L08 nutplates.

Rivet the nutplates to the inboard flange of the F-1015B-L & -R Seat Rib Intercostals per the callouts in Figure 2.

Step 8: Cleco the K1000-4 nutplates and F-1016D Seat Belt Attach Bars onto the F-1016-L & -R Outboard Seat Ribs.

Rivet the K1000-4 nutplates in place per the callouts in Figure 1. Cleco the rest of the parts together per Step 2 and Step 4 to form the Left and Right Outboard Seat Rib Subassemblies.

Step 9: Rivet the F-1016D Seat Belt Attach Bar, and F-814HPP Fwd Seat Belt Anchor to the F-1016-L Outboard Seat Rib per the call-outs in Figure 1 (leave the holes open where indicated).

Rivet the F-1015B-L Seat Rib Intercostal and F-1015E Spacer to the F-1016-L Outboard Seat Rib per the call-outs in Figure 2 to finish the Left Outboard Seat Rib Subassembly.

Repeat this step to finish the Right Outboard Seat Rib Subassembly.

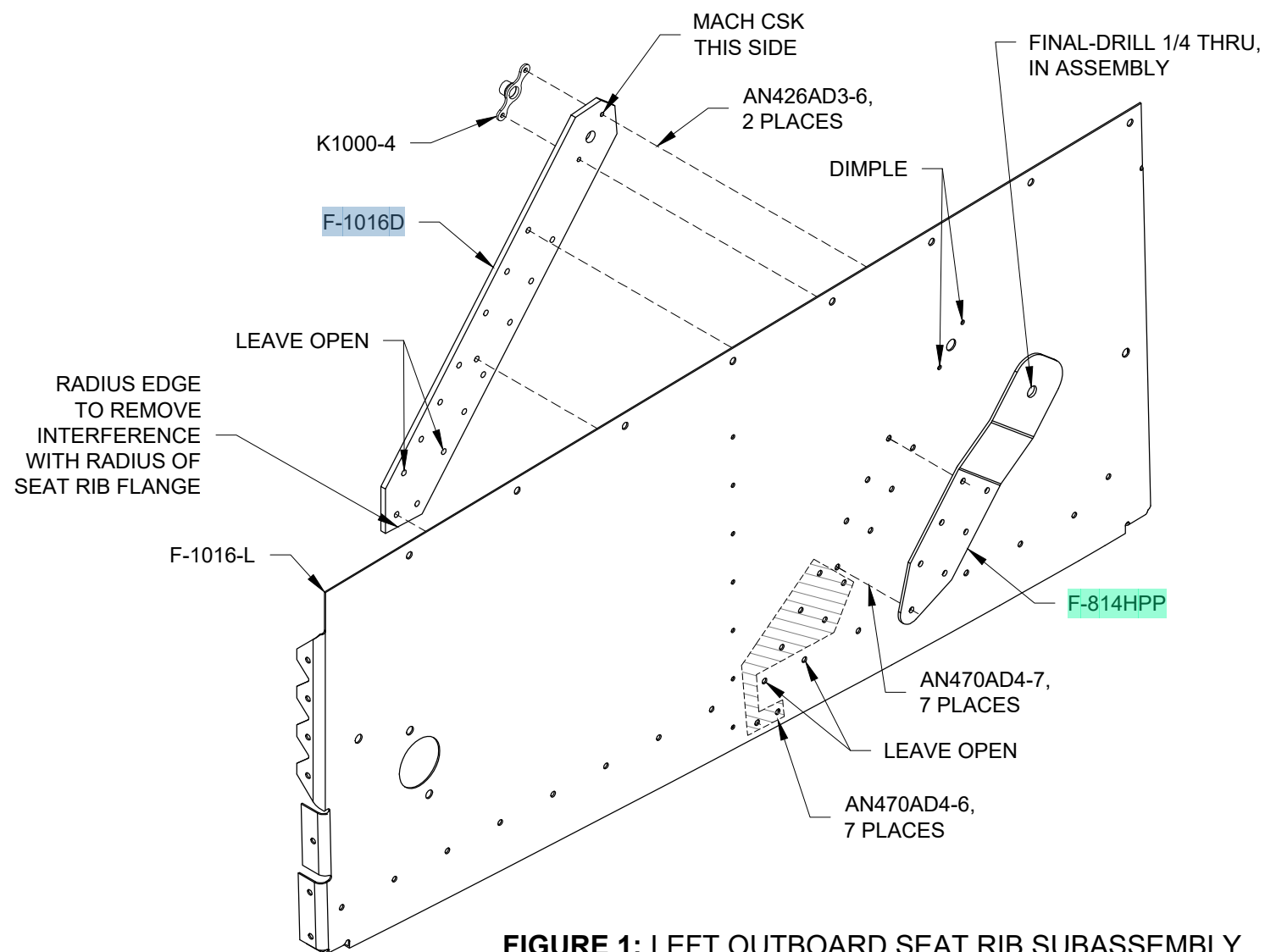


FIGURE 1: LEFT OUTBOARD SEAT RIB SUBASSEMBLY
(FLANGES FACE OUTBOARD)

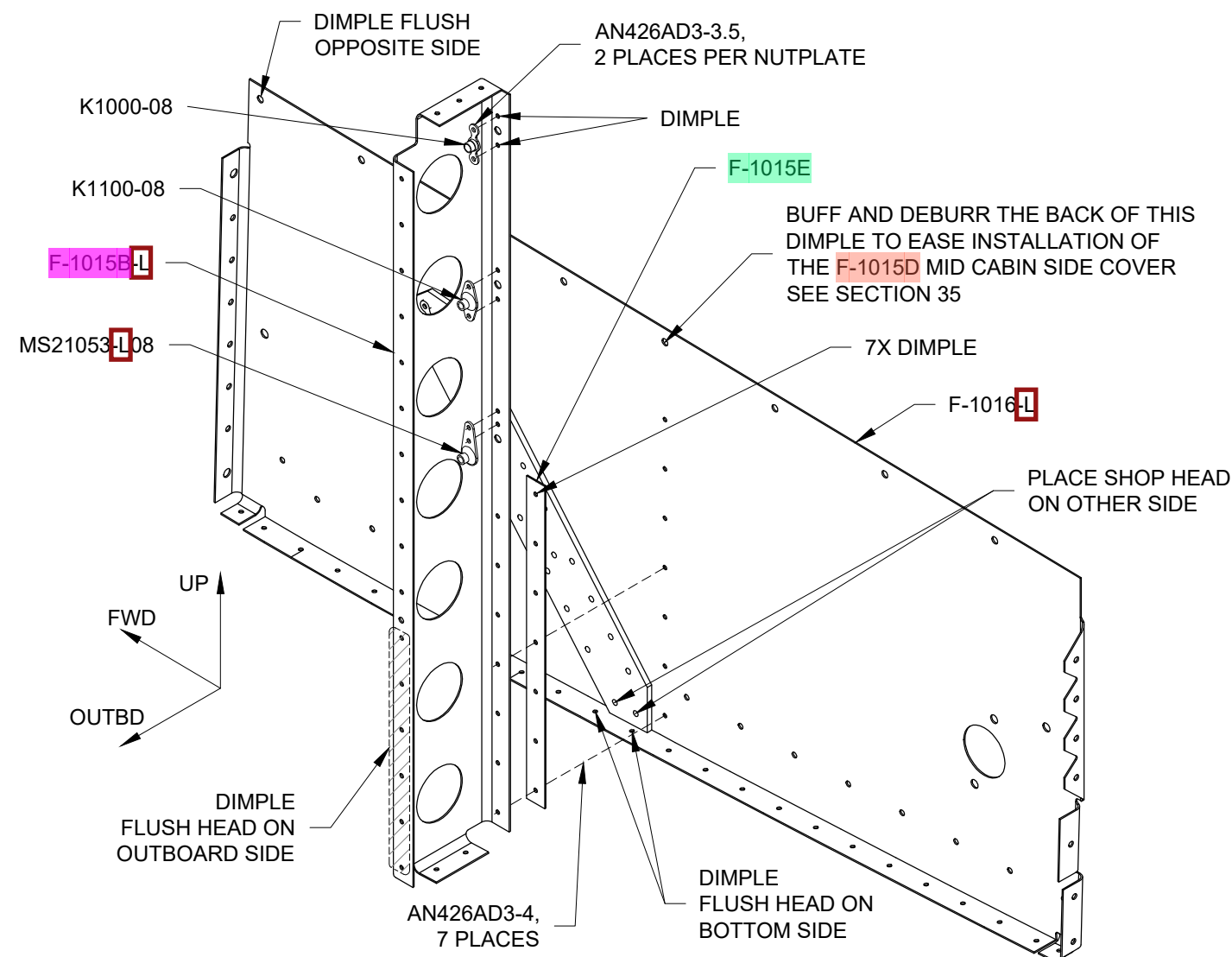


FIGURE 2: LEFT OUTBOARD SEAT RIB SUBASSEMBLY

Step 1: Break apart the **F-1016G** Inboard Seat Rib Spacers into two parts. See Figure 1.

Step 2: Cleco the left and right, inboard and outboard seat rib subassemblies and inboard seat rib spacers to the Aft Center Section Bulkhead Assembly as shown in Figure 2.

Step 3: Final-Drill #30 all the holes common between the seat rib subassemblies and the Aft Center Section Bulkhead Assembly.

Step 4: Match-Drill #12 the upper and lower holes in the forward flanges of the seat rib subassemblies and inboard seat rib spacers using holes in the Aft Center Section Bulkhead Assembly as drill guides.

Step 5: Disassemble and deburr all parts.

Prime the parts if/as desired.

Step 6: Insert the **VA-175** Heat Duct Tee into the **VENT DL-03** Scat Tube Flanges on the inboard seat rib subassemblies as shown in Figure 2.

Step 7: Cleco the seat rib subassemblies to the Aft Center Section Bulkhead Assembly.

Step 8: Bolt the seat rib subassemblies to the Aft Center Section Bulkhead Assembly as shown in Figure 2.

Step 9: Rivet the seat rib subassemblies to the Aft Center Section Bulkhead Assembly as shown in Figure 2.

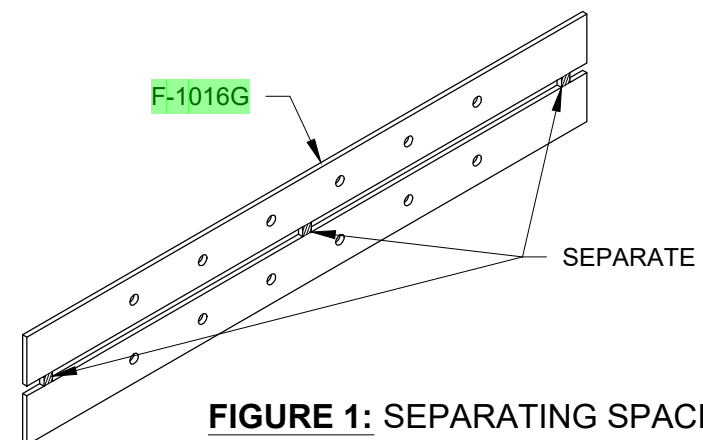


FIGURE 1: SEPARATING SPACERS

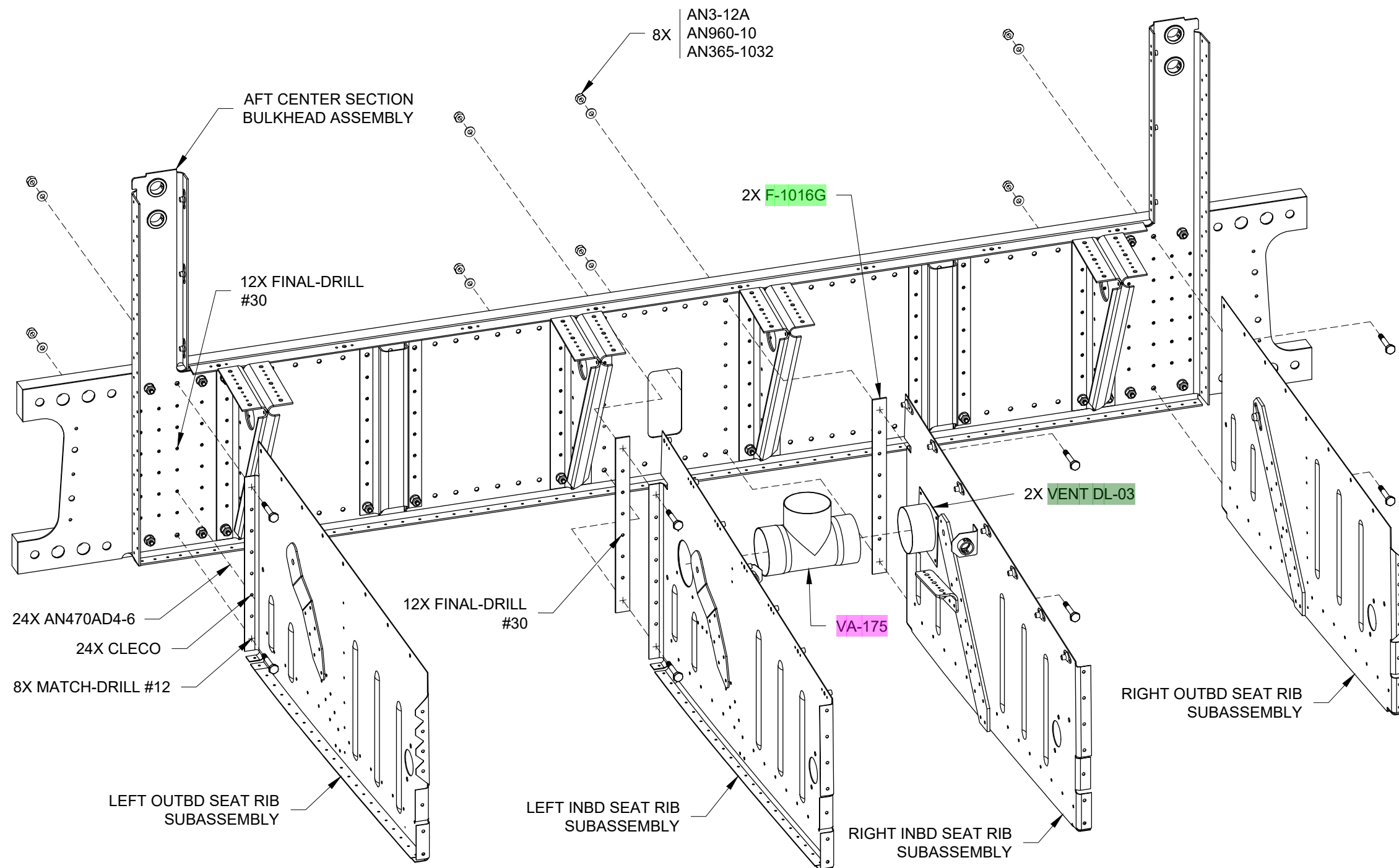
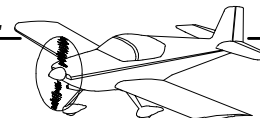


FIGURE 2: ATTACHING SEAT RIB SUBASSEMBLIES TO AFT CENTER SECTION BULKHEAD SUBASSEMBLY



Step 1: Dimple all #40 holes in the web of the **F-1015A-L** Outboard Seat Ribs. Flute the lower flange of the F-1015A-L ribs until the holes in the rib match the corresponding holes in the **F-1076** Center Bottom Skin. Cleco the outboard seat ribs and Inboard Seat Rib Subassemblies to the Rear Spar Bulkhead Assembly as shown in Figure 2 and Figure 3. Final-Drill #30 all the holes common between the ribs and the rear spar bulkhead. Uncleco the outboard seat ribs and inboard seat rib subassemblies.

Step 2: Uncleco the **F-1005C-L** and **R** Bulkhead Side Channels from the Rear Bulkhead Assembly. Cleco then final-drill #30 Left and Right Outboard Seat Rib Subassemblies to the rear spar bulkhead assembly as shown in Figure 3. Uncleco the outboard seat rib subassemblies from the rear spar bulkhead assembly. Note that the rivets that attach this flange to the rear spar bulkhead assembly are AN426AD4 rivets and that the flush head goes on the aft side of the rear spar bulkhead assembly underneath the **F-1005C-L** and **R** Bulkhead Side Channels, see Figure 2. Deburr and dimple these holes now for the head of an AN426AD4 rivet. Cleco the bulkhead side channels back in place.

Step 3: Break apart **F-1017B** to make the **F-1017B-L** and **R** Seat Belt Attach Ribs. Cut apart **F-1017C** to make the **F-1017C-L** and **-R** Seat Belt Attach Lugs.

Step 4: Cleco then final-drill #30 the **F-1017B-L** Seat Belt Attach Rib and **F-1017C-L** and **R** Seat Belt Attach Lugs to the **F-1017A-R** Rear Seat Rib as shown in Figure 1. This will form a Left Rear Seat Rib Subassembly. Repeat this step to form another Left Rear Seat Rib Subassembly and two Right Rear Seat Rib Subassemblies. The right assembly is a mirror of the left.

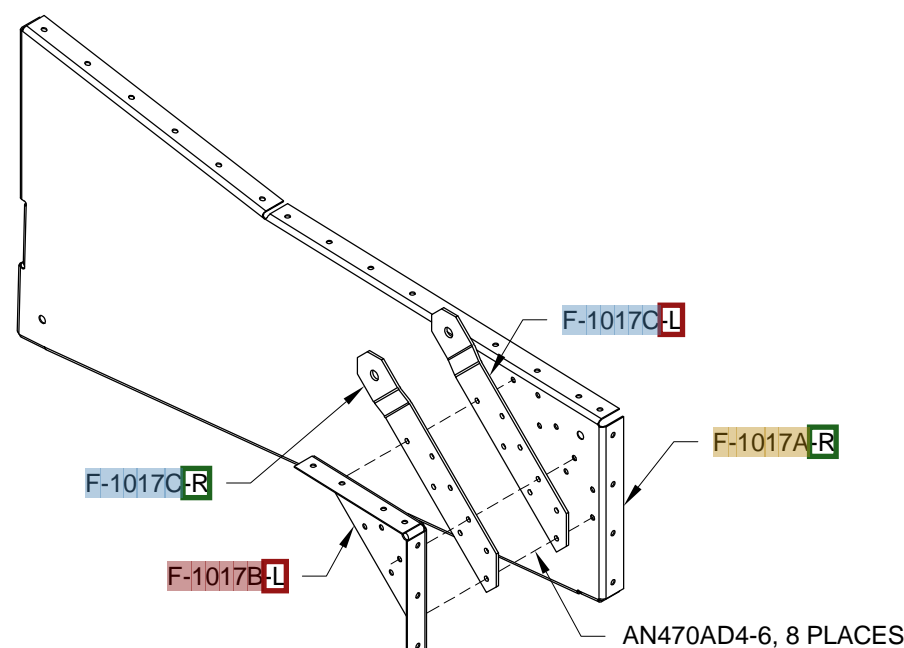


FIGURE 1: REAR SEAT RIB SUBASSEMBLY

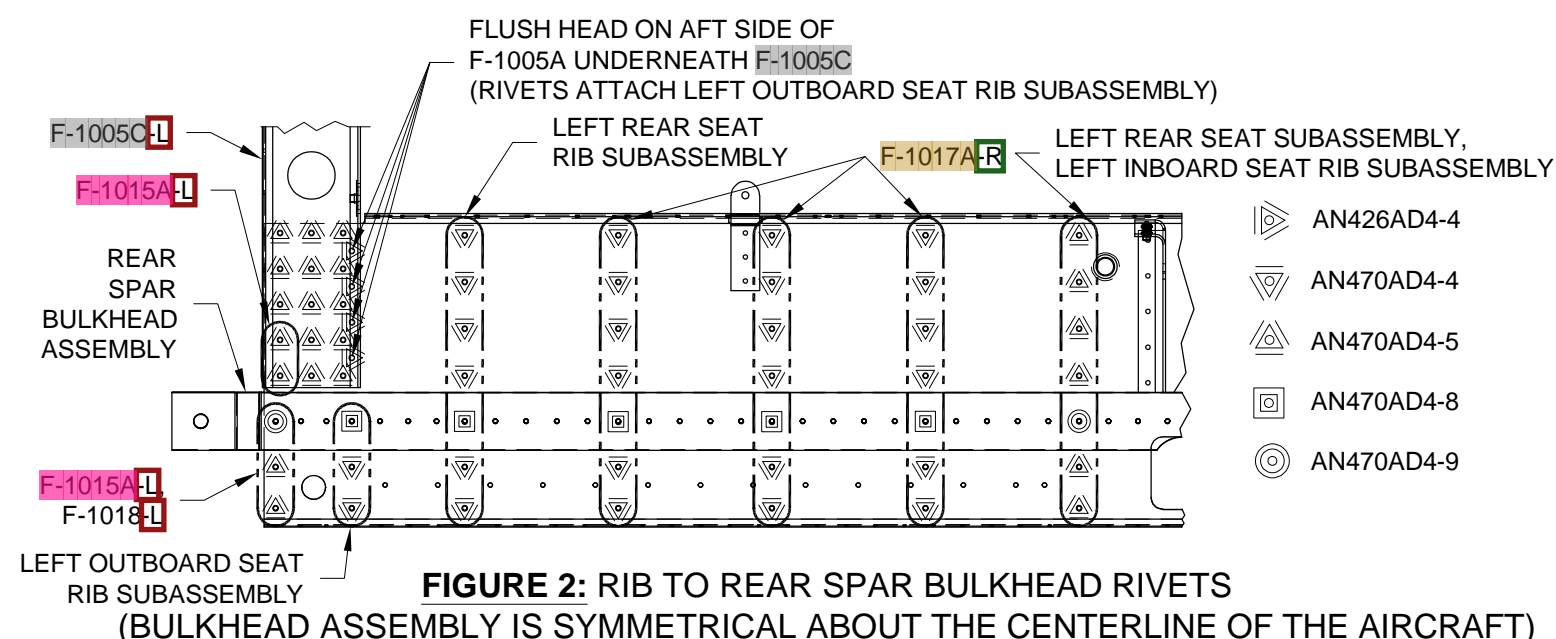


FIGURE 2: RIB TO REAR SPAR BULKHEAD RIVETS
(BULKHEAD ASSEMBLY IS SYMMETRICAL ABOUT THE CENTERLINE OF THE AIRCRAFT)

Step 5: Cleco the **F-1017A-L** and **R** Rear Seat Ribs, Left and Right Rear Seat Rib Subassemblies and **F-1018-L** and **R** Outboard Rear Seat Ribs to the Rear Spar Bulkhead Assembly as shown in Figure 2 and Figure 3. Final-Drill #30 all the holes common between the ribs and the rear spar bulkhead.

Step 6: Disassemble and deburr all parts. Final-Drill #40 and dimple the 3/32 holes in the web of the **F-1018-L** and **R** Outboard Rear Seat Ribs **except** the holes common to the **F-1005C-L** and **R** Bulkhead Side Channels and the aft row of holes. Dimple the three #30 holes in the web of **F-1018-L** and **R** as shown in Figure 3. Prime parts if/as desired.

Step 7: Cleco the Left and Right Rear Seat Rib Subassemblies together per Step 4 then rivet them together per the callouts in Figure 1.

Step 8: Cleco the Outboard Seat Rib Subassemblies to the Rear Spar Bulkhead Assembly then rivet them together per the callouts in Figure 2.

Step 9: Cleco the **F-1005C-L** and **R** Bulkhead Side Channels to the Rear Spar Bulkhead Assembly then rivet (all but the two rivet locations that will attach the **F-1015A-L** and **R** Outboard Seat Ribs) them together per the callouts in Figure 2.

Step 10: Cleco the **F-1015A-L** and **R** Outboard Seat Ribs and **F-1018-L** and **-R** Outboard Rear Seat Ribs to the Rear Spar Bulkhead Assembly then rivet them together per the callouts in Figure 2.

Step 11: Cleco (see Figure 3) then rivet remaining ribs working outboard to inboard to the Rear Spar Bulkhead Assembly per the callouts in Figure 2.

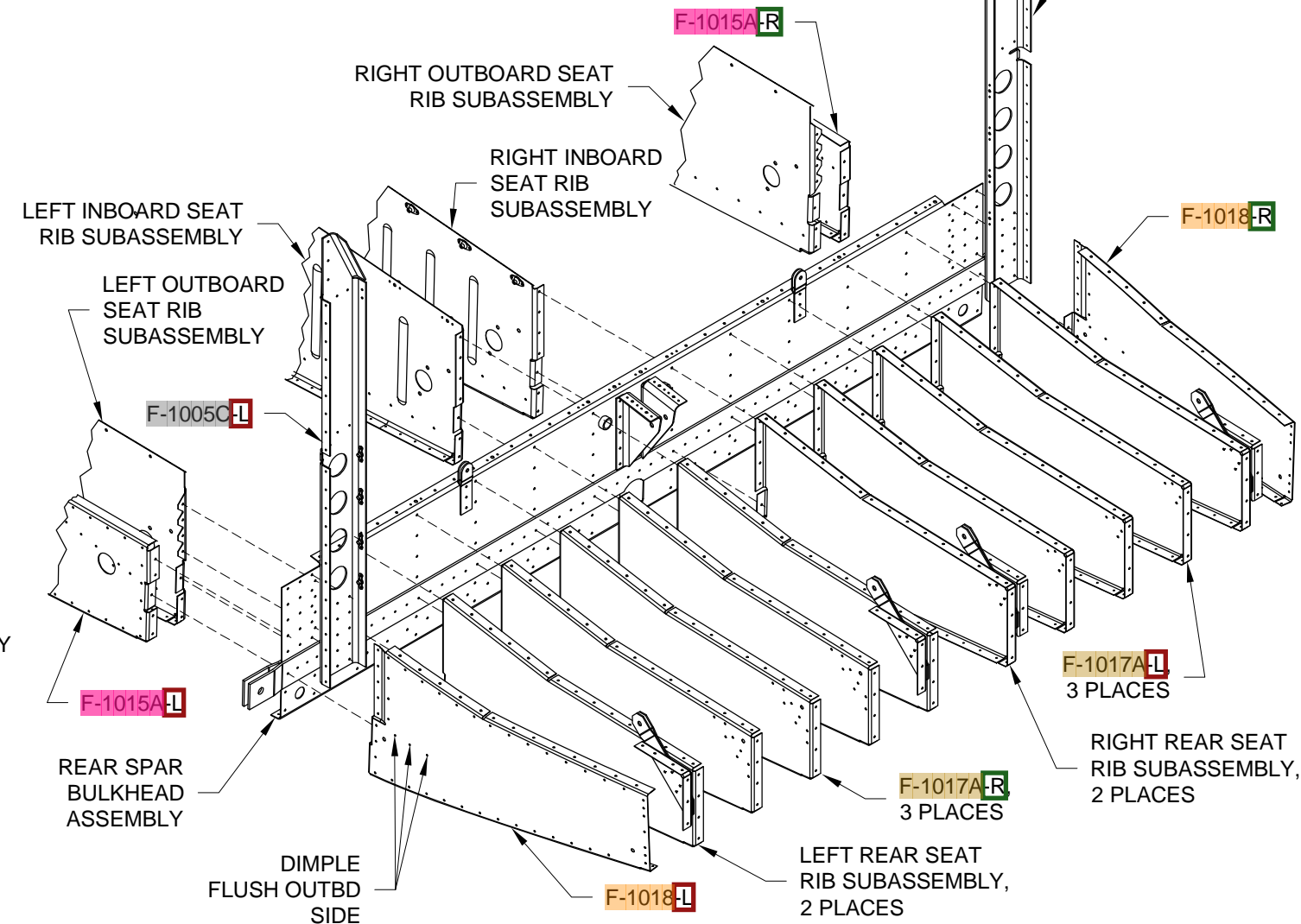
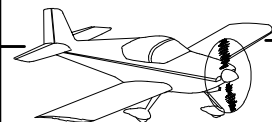


FIGURE 3: RIB ATTACH TO REAR SPAR BULKHEAD



Step 1: Cleco the Left and Right Rear Seat Rib Subassemblies and **F-1017A-L** and **R** Rear Seat Ribs to the Fuselage Bulkhead Assembly as shown in Figure 1. Final-Drill #30 the holes common between the parts just clecoed together. Cleco the **F-1019-L** and **R** Inbd Baggage Ribs and **F-1020-L** and **-R** Mid Baggage Ribs to the fuselage bulkhead assembly as shown in Figure 1. Final-Drill #30 the holes common between the parts just clecoed together.

Step 2: Cleco the **F-1021-L** Outbd Baggage Rib between the **F-1018-L** Outbd Rear Seat Rib and the Fuselage Bulkhead Assembly (See isometric view on Page 26-1). Final-Drill #40 the holes common to the outbd seat rib, outbd baggage rib and the fuselage bulkhead assembly. Repeat this step for the **F-1021-R** Outbd Baggage Rib. Cleco then final-drill #30 the **WD-1008-L** and **-R** Step Mounting Brackets to the outbd baggage ribs as shown in Figure 1.

Step 3: Final-Drill #30 then dimple all the holes in the upper flanges of the **F-1020-L** and **R** Mid Baggage Ribs and **F-1021-L** and **R** Outbd Baggage Ribs.

Step 4: Final-Drill #40 the hole in the aft lower tabs on the **F-1019-L** and **R** Inbd Baggage Rib, mid baggage rib and outbd baggage rib. See Figure 1.

Step 5: Disassemble and deburr parts as required. Dimple the holes final-drilled #40 in Step 2. Prime parts if/as desired.

Step 6: Dimple the holes common between the upper flange of the inboard most Left and Right Rear Seat Subassemblies and the upper flange of the **F-1034A** Fuselage Bulkhead. See Figure 1.

Step 7: Cleco then rivet the Left and Right Rear Seat Rib Subassemblies and **F-1017A-L** and **R** Rear Seat Ribs to the **F-1034** Fuselage Bulkhead Assembly as shown in Figure 1. Cleco then rivet the **F-1019-L** and **R** Inbd Baggage Rib and **F-1020-L** and **R** Mid Baggage Rib to the fuselage bulkhead assembly as shown in Figure 1.

Step 8: Cleco then rivet the **WD-1008-L** and **R** Step Mounting Brackets to the **F-1021-L** and **R** Outbd Baggage Ribs per the callout in Figure 1.

Step 9: Cleco per Step 2 then rivet the **F-1021-L** and **R** Outbd Baggage Ribs to the **F-1018-L** and **R** Outbd Rear Seat Ribs and the Fuselage Bulkhead Assembly with two keeper rivets per outbd baggage rib as shown in Figure 1.

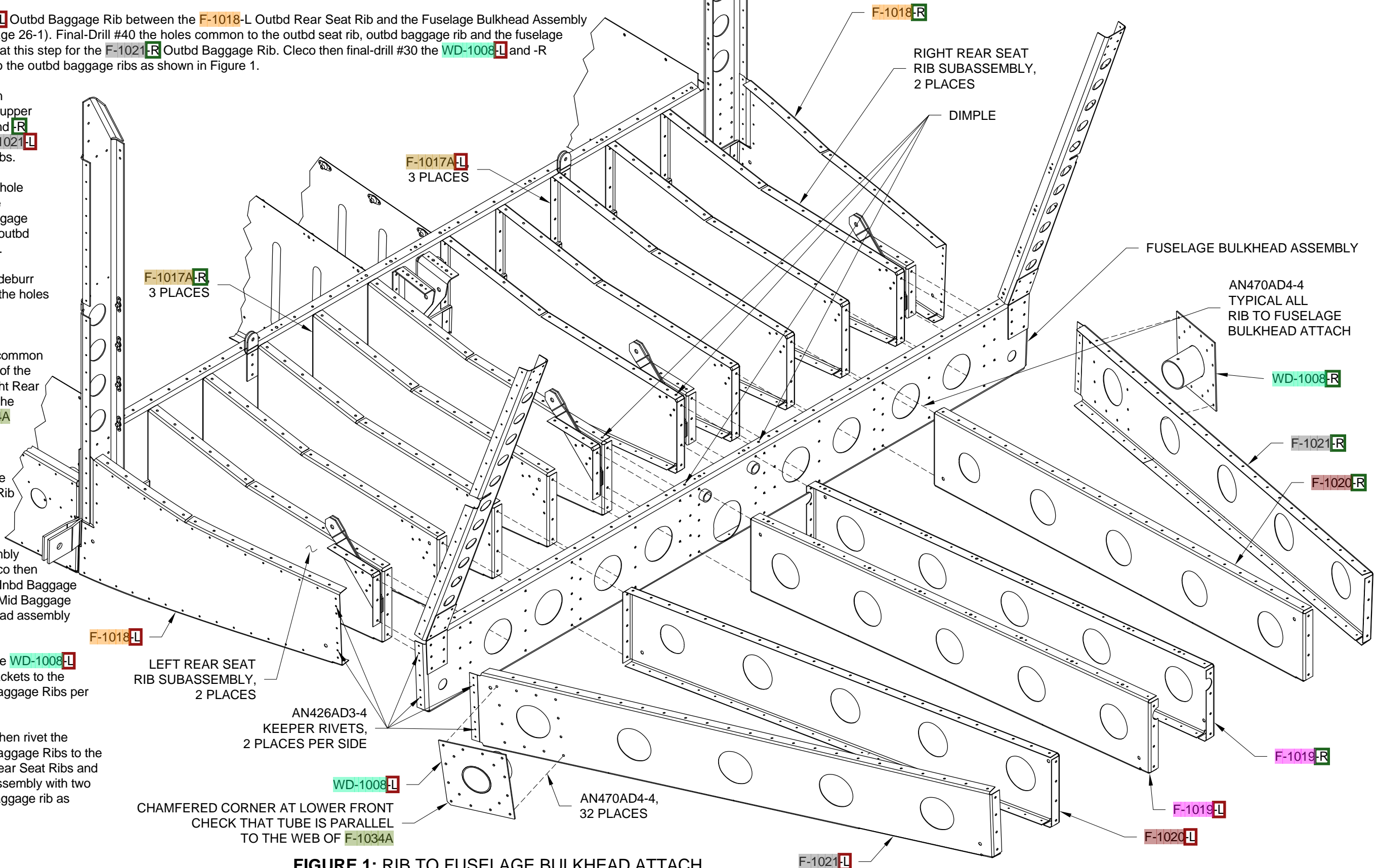
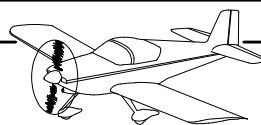


FIGURE 1: RIB TO FUSELAGE BULKHEAD ATTACH



Step 1: Cleco the F-1077 Mid Bottom Skin then the F-1076 Center Bottom Skin to the ribs and bulkheads as shown in Figure 1.

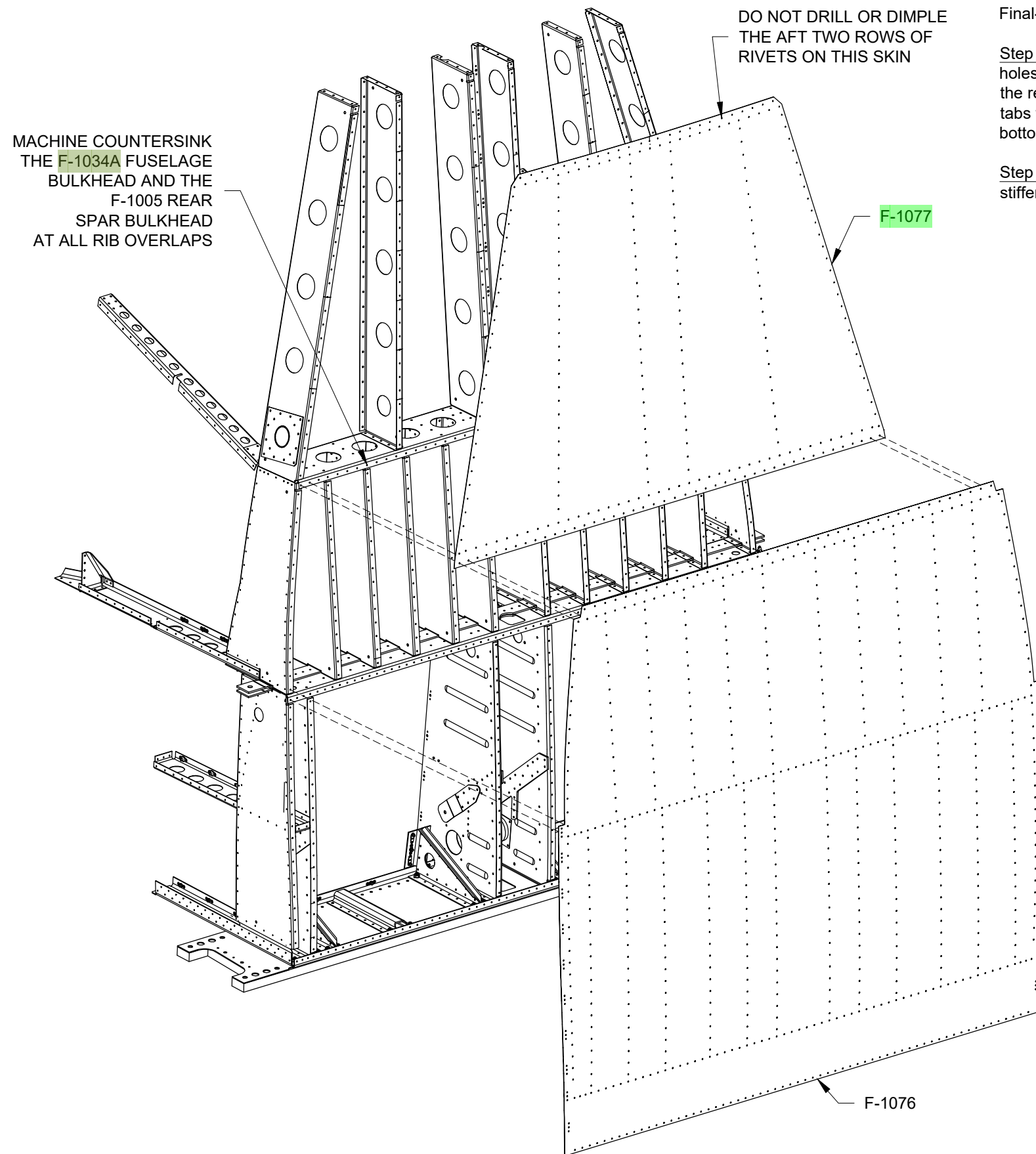


FIGURE 1: BOTTOM SKINS

Step 2: Cleco the F-1016B-L and R Floor Stiffeners to the F-1076 Center Bottom Skin, Aft Center Section Bulkhead Assembly, and Rear Spar Bulkhead Assembly (see Figure 2). Final-Drill #40 all holes common between the F-1076 Center Bottom Skin or the F-1077 Mid Bottom Skin and the underlying ribs and bulkheads. Final-Drill #30 the holes in the upper flanges of the floor stiffeners.

Step 3: Disassemble the F-1016B-L and R Floor Stiffeners, F-1076 Center Bottom Skin and F-1077 Mid Bottom Skin. Deburr the holes and edges. Machine countersink the Aft Center Section Bulkhead Assembly holes common to the center bottom skin. Dimple the remaining common holes in the center bottom skin, mid bottom skin, ribs and bulkheads (except the holes that correspond to tabs that overlay the F-1034A Fuselage Bulkhead and F-1005A Rear Spar Bulkheads lower flange). Dimple the holes in the top and bottom flanges of the stiffeners except the holes in the lower tabs. Prime parts if/as desired.

Step 4: Repeat Step 1, cleco the F-1016B-L and R Floor Stiffeners in place then rivet the skins to the ribs, bulkheads and floor stiffeners per the rivet callouts in Page 26-8, Figure 1 and Page 26-8, Figure 2.

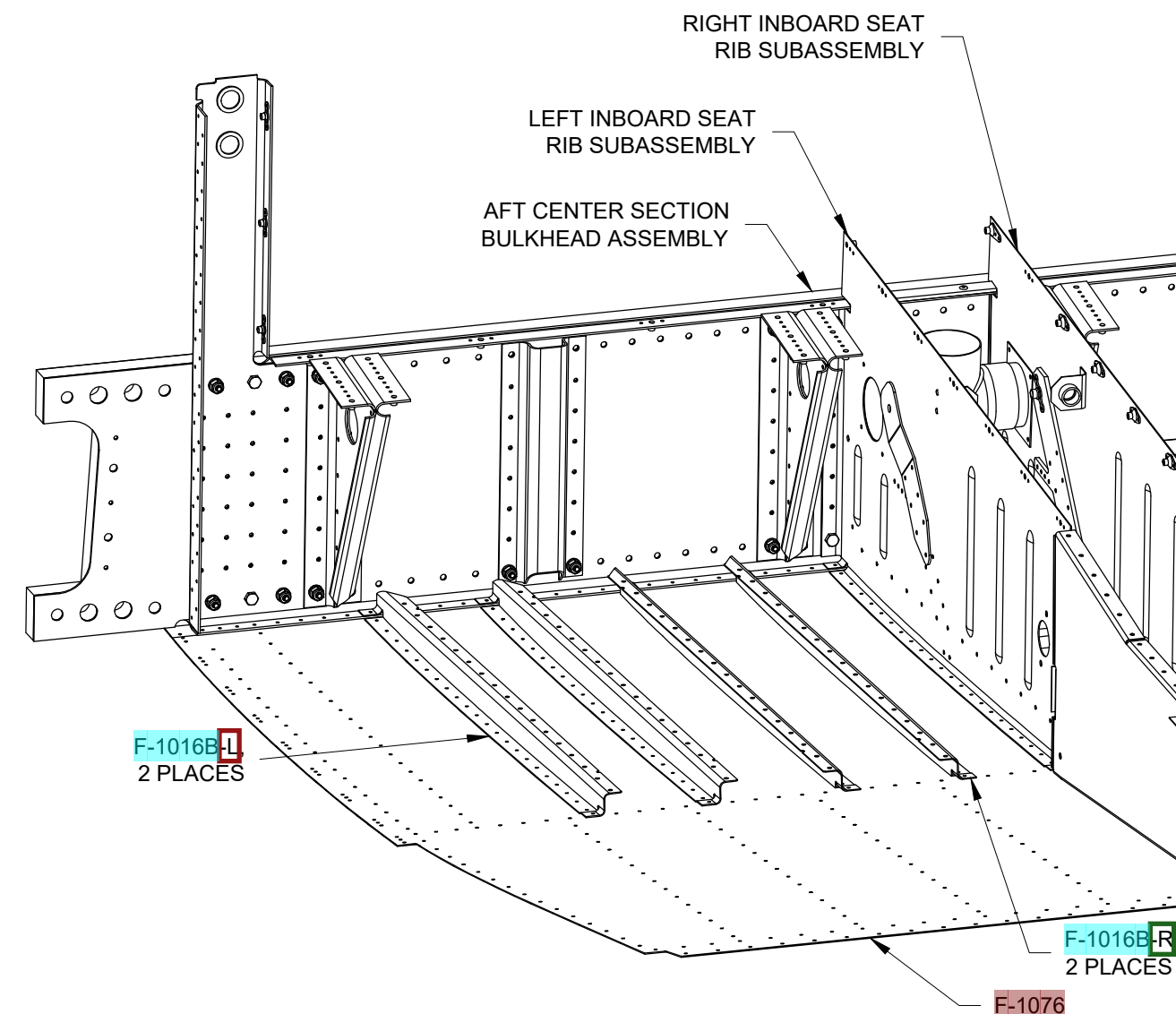


FIGURE 2: FLOOR STIFFENER INSTALLATION
(SOME PARTS NOT SHOWN FOR CLARITY,
LEFT SIDE OF AIRCRAFT SHOWN, CALLOUTS FOR
THE RIGHT SIDE ARE A MIRROR OF THE LEFT)

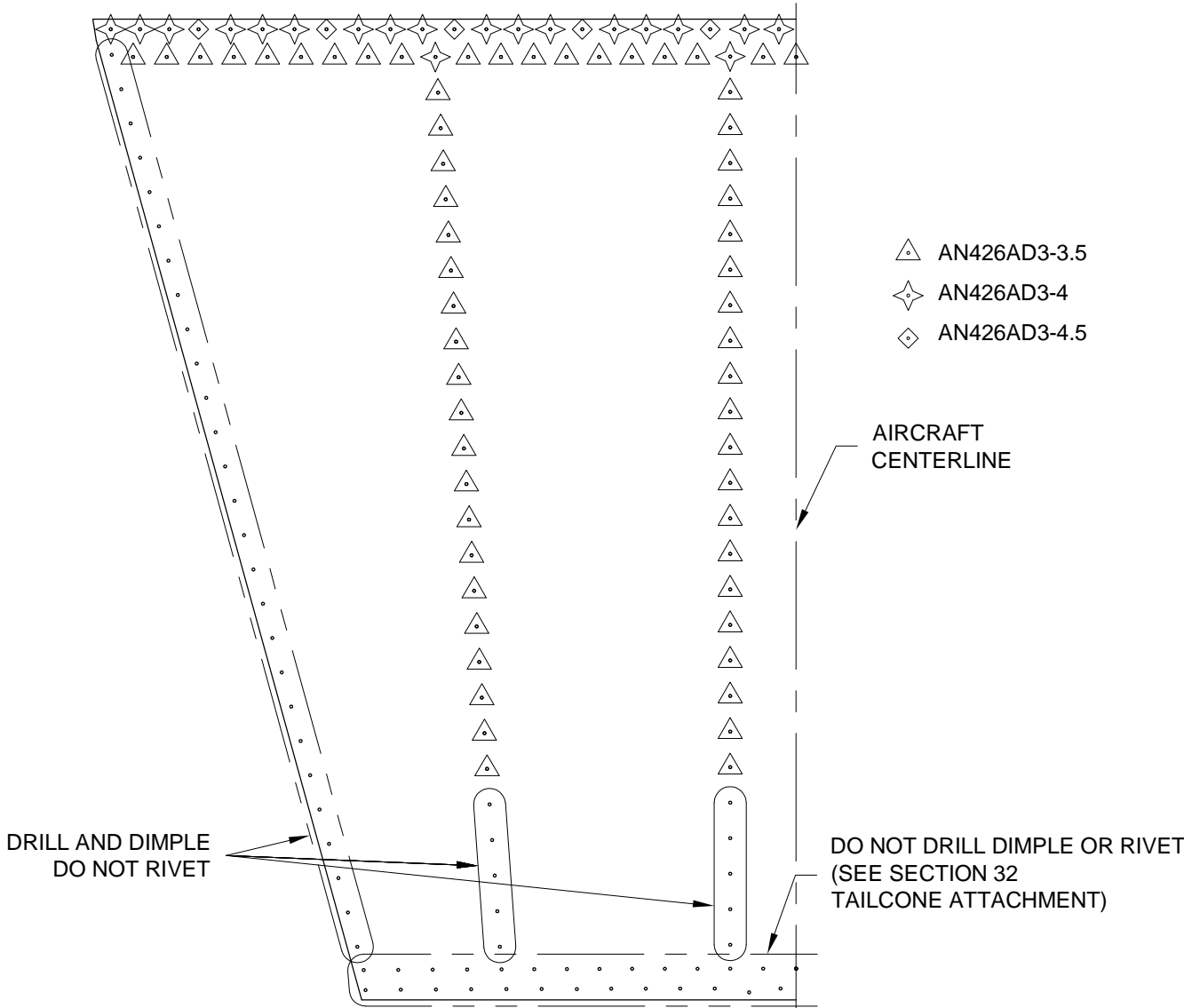
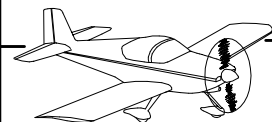


FIGURE 1: MID BOTTOM SKIN RIVET CALLOUTS
(CALLOUTS ARE SYMMETRICAL ABOUT THE AIRCRAFT CENTERLINE)

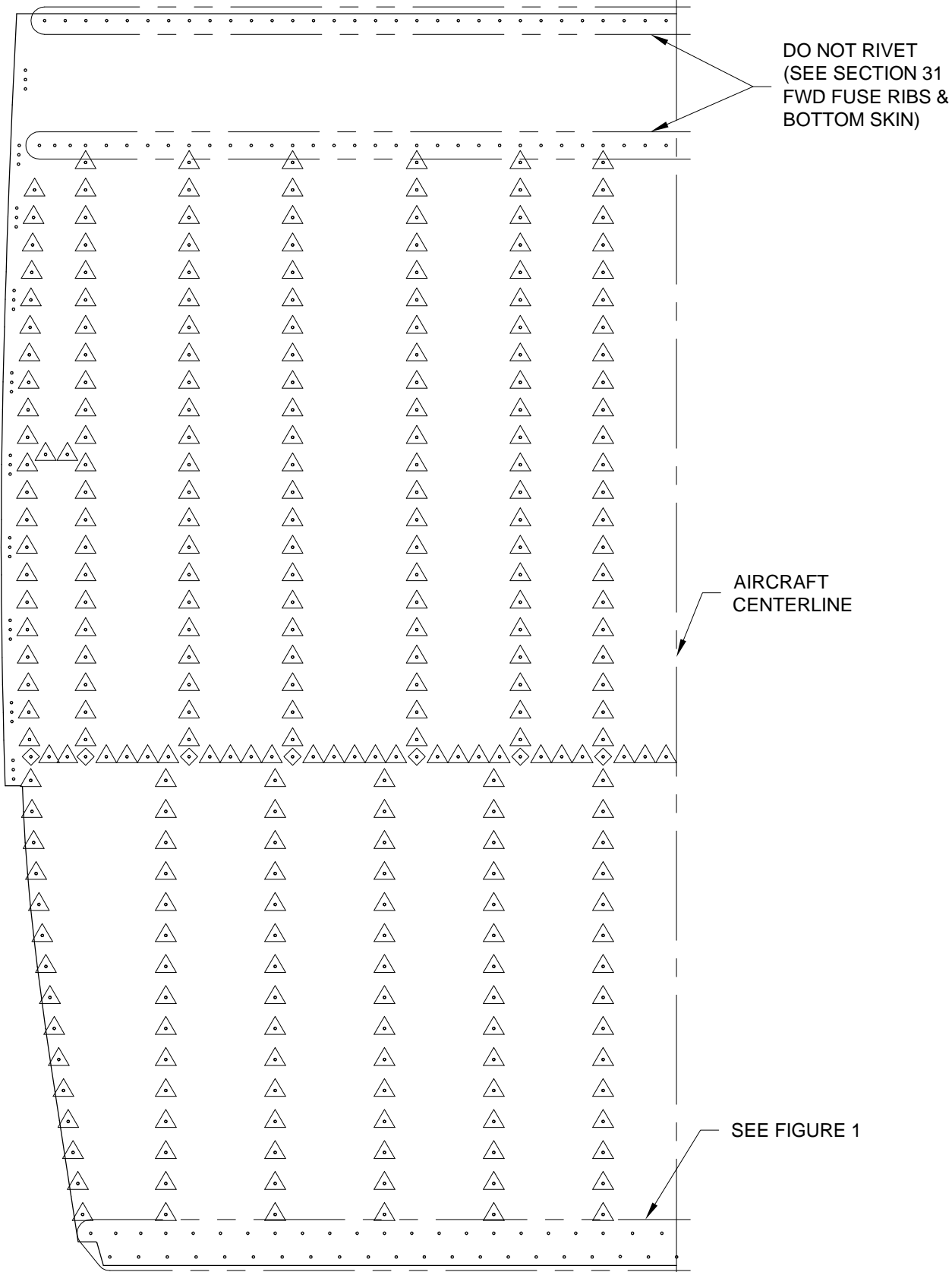


FIGURE 2: CENTER BOTTOM SKIN RIVET CALLOUTS
(CALLOUTS ARE SYMMETRICAL ABOUT THE AIRCRAFT CENTERLINE)