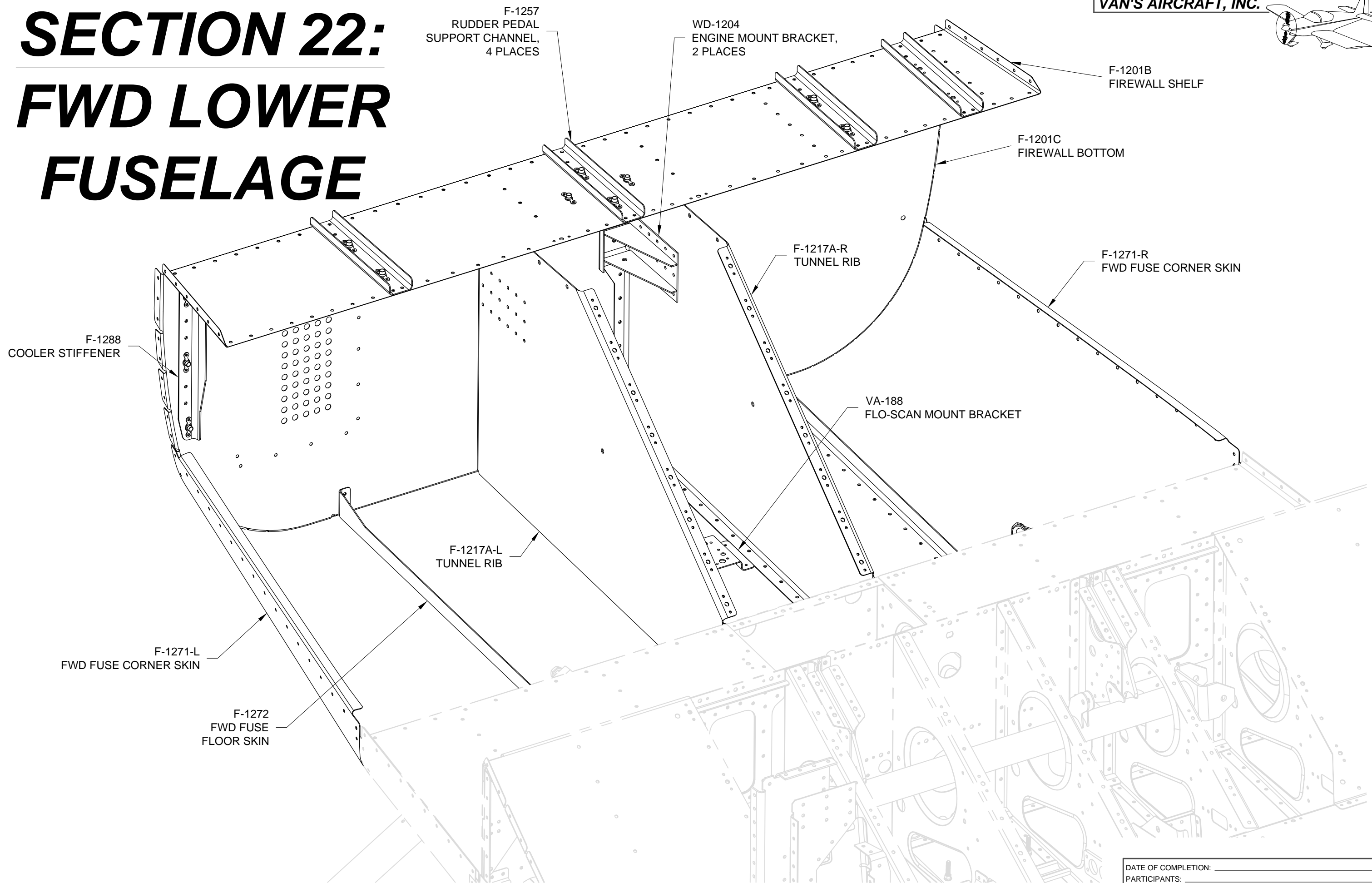


SECTION 22: FWD LOWER FUSELAGE



F-1257
RUDDER PEDAL
SUPPORT CHANNEL,
4 PLACES

WD-1204
ENGINE MOUNT BRACKET,
2 PLACES

F-1201B
FIREWALL SHELF

F-1201C
FIREWALL BOTTOM

F-1217A-R
TUNNEL RIB

F-1271-R
FWD FUSE CORNER SKIN

F-1288
COOLER STIFFENER

VA-188
FLO-SCAN MOUNT BRACKET

F-1217A-L
TUNNEL RIB

F-1271-L
FWD FUSE CORNER SKIN

F-1272
FWD FUSE
FLOOR SKIN

Step 1: Dimple the #40 holes in the nutplate attach pattern labled "Return Line Clamp" on the F-1201C Firewall Bottom, flush aft side. See Figure 4.

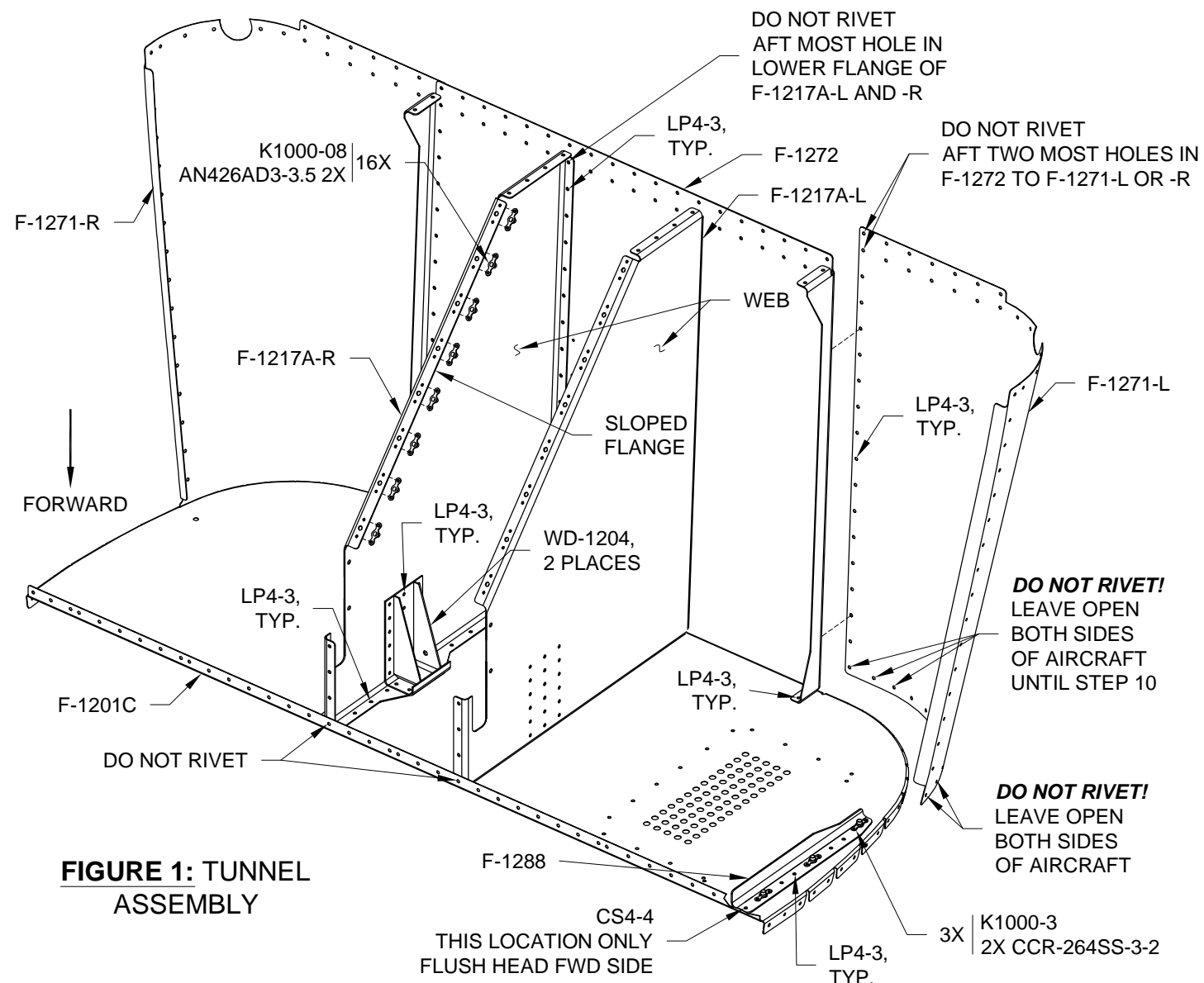
Step 2: Machine countersink the nutplate attach holes in the sloped upper flange of the F-1217A-L & -R Tunnel Ribs as shown in Figure 1. Machine countersink all the nutplate attach holes in the F-1272 Fwd Fuse Skin flush on the bottom side. See Figure 4. Machine countersink the upper most hole in the F-1288 Cooler Stiffener. See Figure 1.

Step 3: Dimple nutplates then rivet them to the F-1217A-L & -R Tunnel Ribs and F-1201C Firewall Bottom per the callouts in Figure 1.

Step 4: Cleco, final-drill #30, the WD-1204 Engine Mount Brackets to the F-1217A-L & -R Tunnel Ribs as shown in Figure 1. Rivet the engine mount brackets to the web of the tunnel ribs (not the fwd flange, installed from bottom side).

Step 5: Machine countersink #30 the holes in the forward flange of the F-1217A-L and -R Tunnel Ribs that correspond to the flush rivets called out in Figure 4.

Step 6: Cleco then rivet, the F-1217A-L & -R Tunnel Ribs to the F-1272 Fwd Fuse Skin (Do not rivet the aft most hole!). To this assembly cleco then rivet the F-1201C Firewall Bottom & F-1271-L and -R Fwd Fuse Corner Skin to create the Fwd Lower Fuse Assembly (Do not rivet the locations labled "DO NOT RIVET" in Figure 1).



Step 7: Trim the flange of the F-1288 Cooler Stiffener as shown in Figure 2.

Step 8: Rivet the F-1288 Cooler Stiffener and corresponding nutplates to the firewall bottom. See Figure 1 and Figure 4.

Step 9: Rivet nutplates to the F-1217A-L & -R Tunnel Ribs and F-1272 Fwd Fuse Skin per the call outs in Figure 4. Rivet nutplates to the F-1201C Firewall Bottom and fwd fuse skin per the call outs in Figure 4.

Step 10: Make two F-1201U Firewall Spacers from AS3-020 as shown in Figure 3.

NOTE: Curve parts slightly by hand in the following steps for a better fit.

Step 11: Center the F-1201U Firewall Spacers about the holes used to attach them to the Fwd Lower Fuse Assembly. Place the F-12118 Cowl Attach Plates over the top of the firewall spacer then cleco the hole on the inboard edge of the cowl attach plates. Clamp the outboard edge of the cowl attach plate and the firewall spacer to the Fwd Lower Fuse Assembly. See the exploded detail view in Figure 4.

Step 12: Match-Drill #30 the holes in the Fwd Lower Fuse Assembly into the F-1201U Firewall Spacers and F-12118 Cowl Attach Plates. Remove and deburr the firewall spacers. Machine countersink the nutplate attach holes in the cowl attach plates (flush bottom side). Rivet nutplates to the cowl attach plates. Rivet the firewall spacers and cowl attach plates to the fwd lower fuse assembly. See the detail view in Figure 4.

Step 13: Rivet a nutplate to the forward side of the F-1201C Firewall Bottom to the location labled "Return Line Clamp". See Figure 4.

Step 14: Use a unibit to enlarge the hole between the gascolator attach holes per the dimension given in Figure 4. To keep the hole centered draw a cross hair out from the hole for reference.

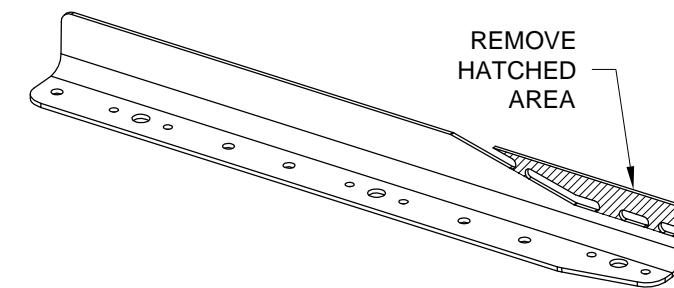


FIGURE 2: TRIMMING THE COOLER STIFFENER

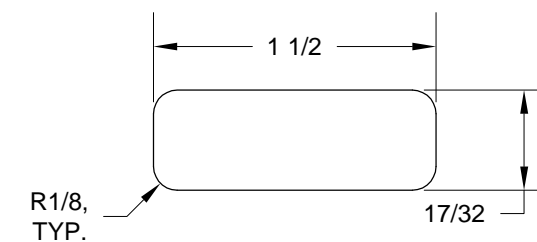
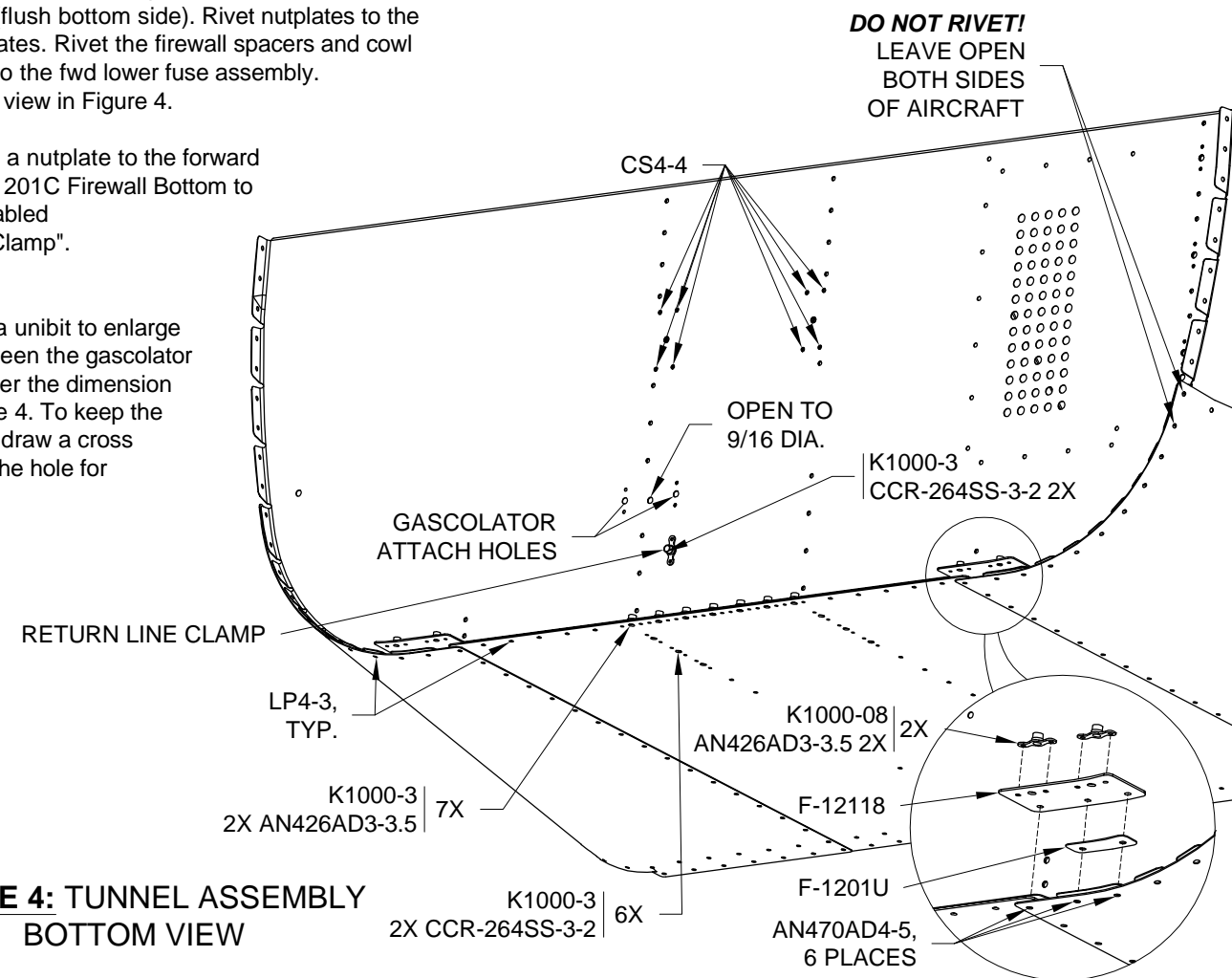


FIGURE 3: MAKING THE FIREWALL SPACERS





Step 1: Cut apart and deburr the F-1257 Rudder Pedal Support Channels as shown in Figure 1.

Step 2: Dimple the aft two holes and nutplate attach holes in the F-1257 Rudder Support Channels. Dimple the corresponding holes in the F-1201B Firewall Shelf. See Figure 2.

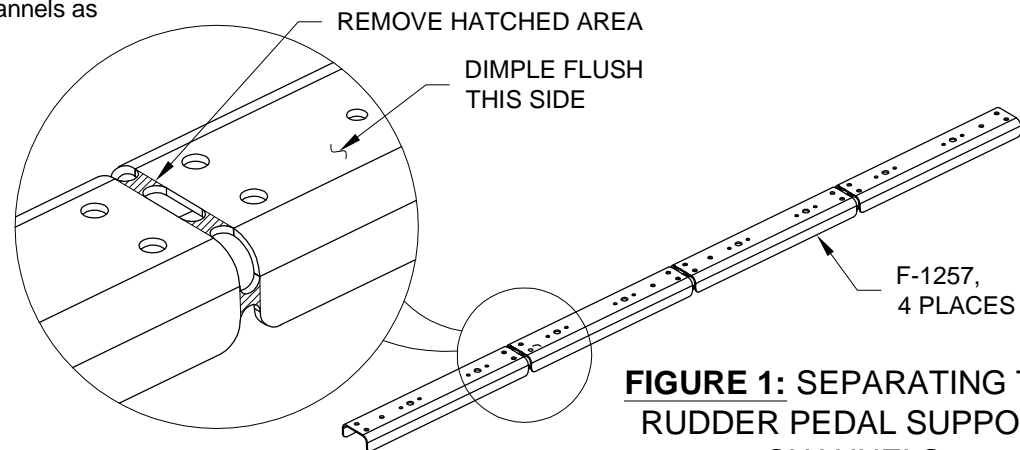


FIGURE 1: SEPARATING THE RUDDER PEDAL SUPPORT CHANNELS

Step 3: Dimple then rivet nutplates to the F-1201B Firewall Shelf and F-1257 Rudder Pedal Support Channels as shown in Figure 2.

Step 4: Smear a thin layer of MC-240-B1/2 Tank Sealant on the top flanges of the F-1201C Firewall Bottom and F-1217A-L and -R Tunnel Ribs. Cleco then rivet the F-1201B Firewall Shelf and F-1257 Rudder Pedal Support Channels to the Fwd Lwr Fuse Assembly per the call outs in Figure 2.

Step 5: Fill the tooling holes on the F-1201C Firewall Bottom with a blind rivets. See Figure 2.

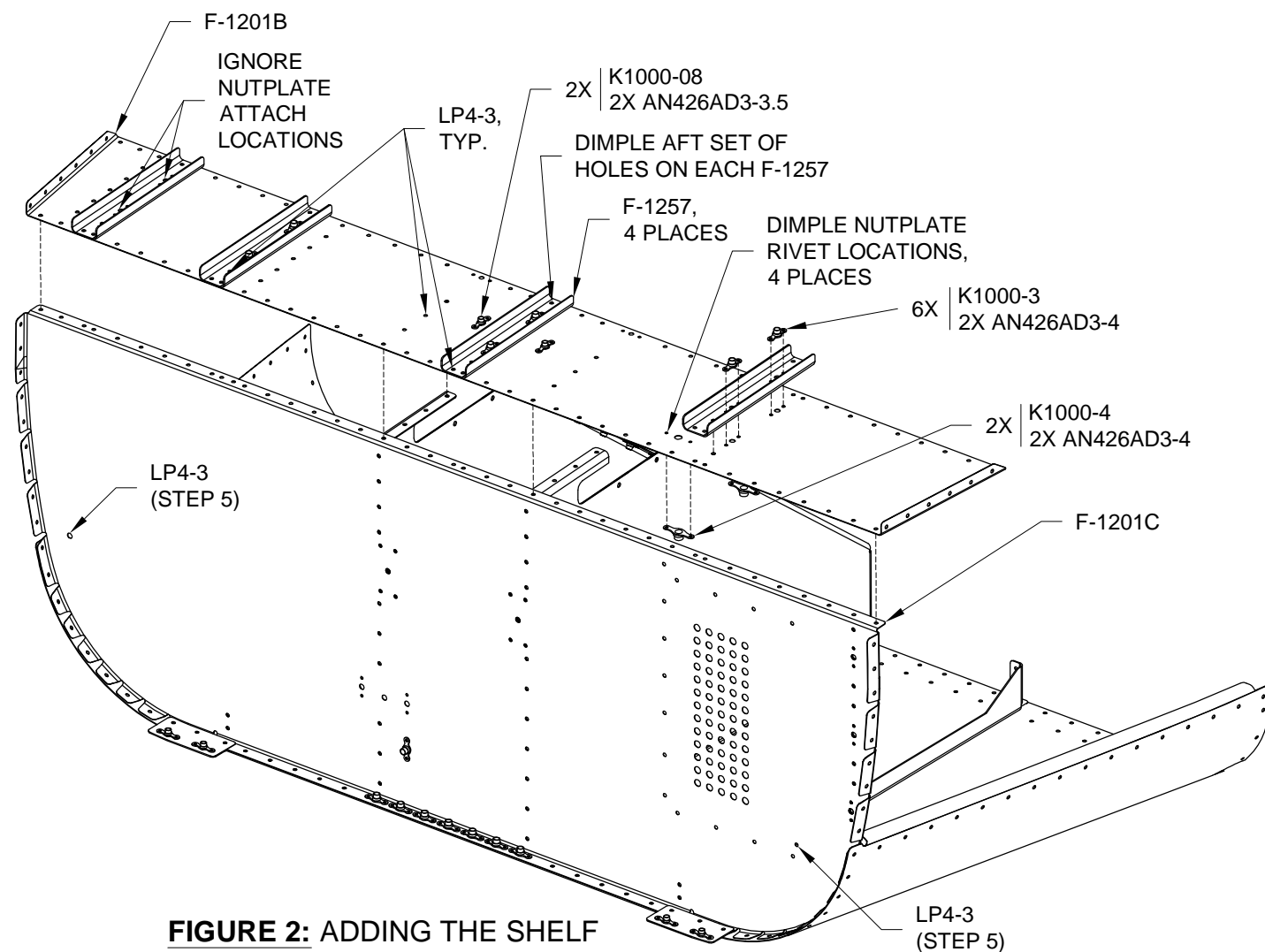


FIGURE 2: ADDING THE SHELF

Step 6: Make the F-1201L Bracket from AA6-063X3/4X3/4 per the dimensions given in Figure 3.

Step 7: Draw a centerline on the forward face of the F-1201L Bracket. See Figure 3.

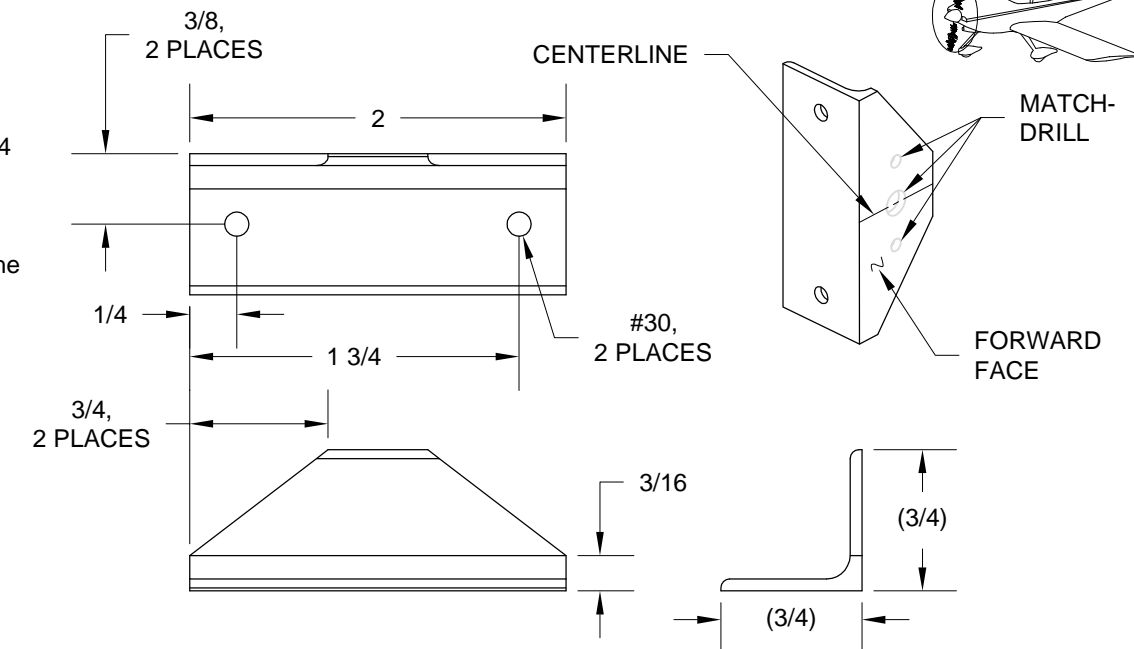


FIGURE 3: MAKING F-1201L

Step 8: Place the F-1201L Bracket flush against the F-1217A-R Tunnel Rib and F-1201C Firewall Bottom dimples as shown in Figure 4. Align the centerline on the forward face of the bracket with the gascolator attach hole (Page 22-2, Figure 3) then match-drill #40 the nutplate attach holes in the firewall bottom into the bracket (use a small wood block to protect your fingers). Remove the bracket and machine countersink the nutplate attach holes in the forward face of the bracket for the dimples in the firewall bottom.

Step 9: Cleco the F-1201L Bracket to the F-1201C Firewall Bottom. Match-Drill #30 and cleco the two holes in the inboard flange of the bracket into the F-1217A-R Tunnel Rib (a #30 12 inch extension bit is useful for these holes). Match-Drill #12 the gascolator attach hole in the firewall bottom into the bracket. See Figure 4.

Step 10: Deburr the F-1217A-R Tunnel Rib and F-1201L Bracket. Prime the bracket.

Step 11: Rivet the F-1201L Bracket to the F-1217A-R Tunnel Rib and with a nutplate to the F-1201C Firewall Bottom as shown in Figure 4. Dimple then rivet a second nutplate to the remaining gascolator attach hole on the firewall bottom inside the tunnel.

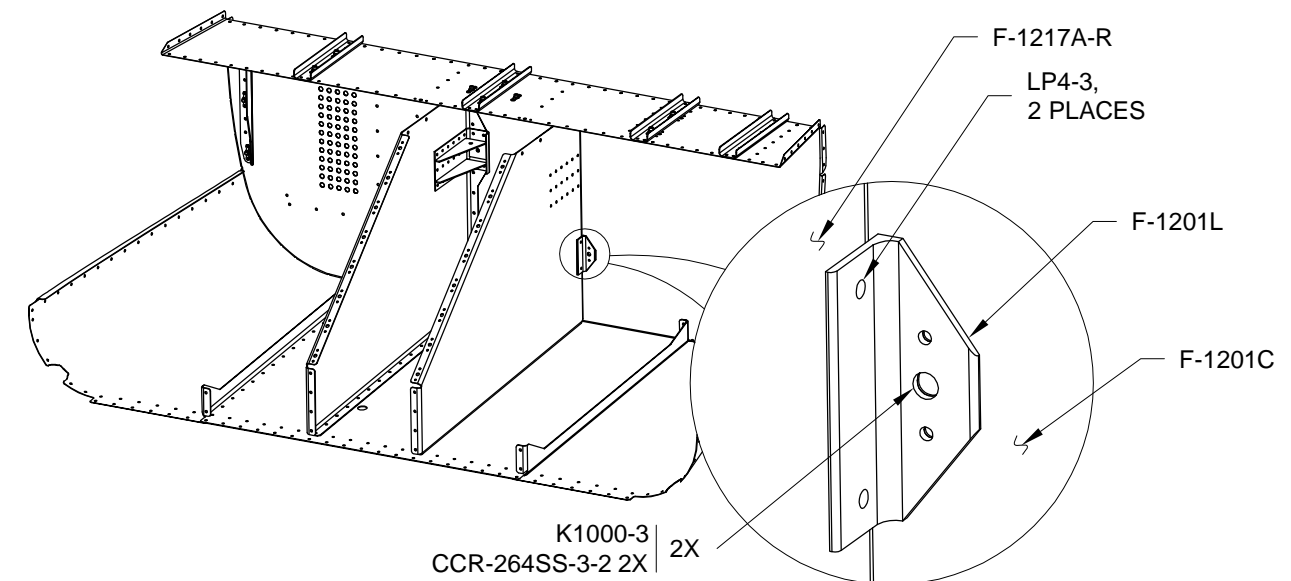


FIGURE 4: INSTALLING F-1201L

Step 1: Install nutplates to the VA-188 FLO-SCAN Mount Bracket per the call-outs in Figure 1.

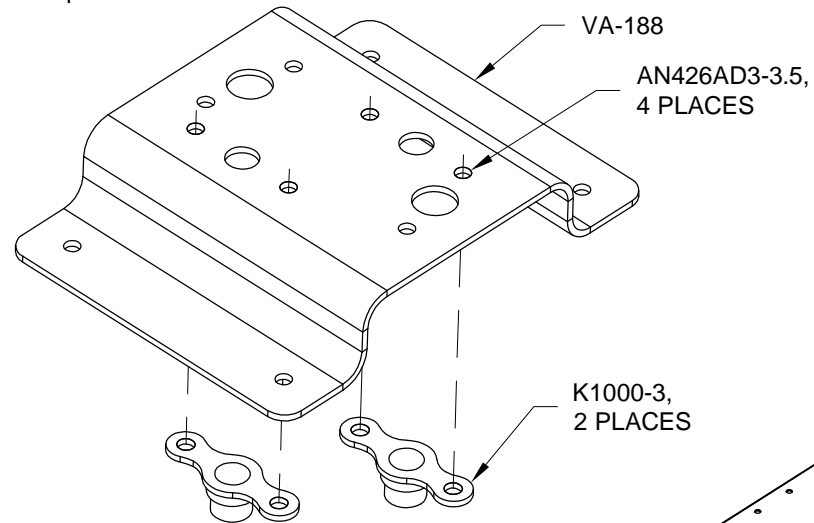


FIGURE 1: INSTALLING NUTPLATES

Step 2: Cleco the VA-188 FLO-SCAN Mount Bracket to the F-1272 Fwd Fuse Floor Skin. Final-Drill #30 the four attach holes. Remove the bracket and deburr both parts.

Step 3: Rivet the VA-188 FLO-SCAN Mount Bracket to the F-1272 Fwd Fuse Floor Skin per the call-outs in Figure 2.

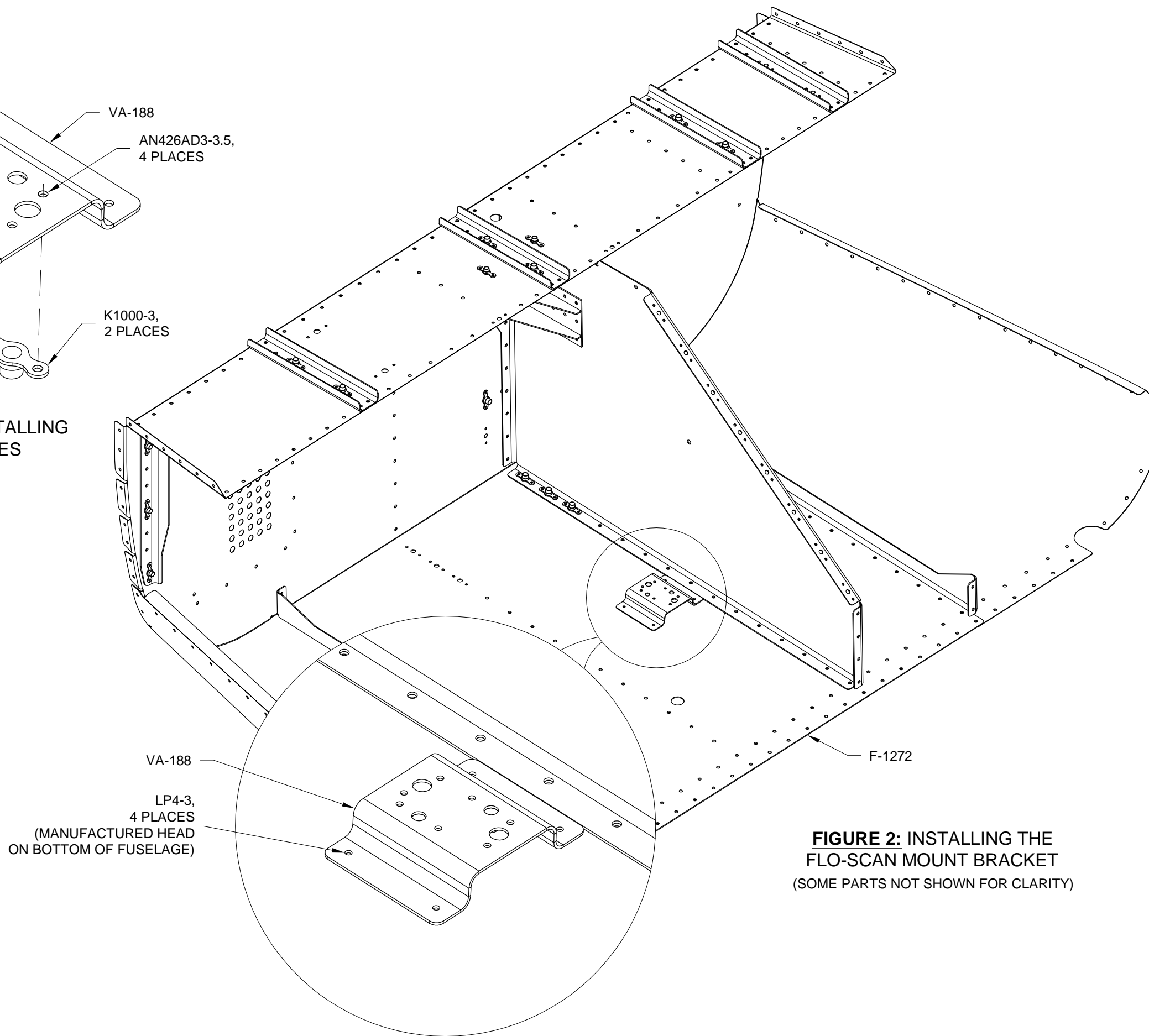
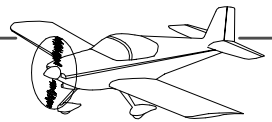


FIGURE 2: INSTALLING THE FLO-SCAN MOUNT BRACKET
(SOME PARTS NOT SHOWN FOR CLARITY)



CAUTION: Do not rivet the upper row of holes in the F-1271-L & -R Fwd Fuse Corner Skins that will later attach to the F-1270-L & -R Fuselage Side Skins.

Step 1: Cleco then rivet the Forward Lower Fuse Assembly to the Mid Fuse and Bottom Skin Assembly as shown in Figure 1 and Figure 2. The skins from the Fwd Lower Fuse Assembly lie over outside of the skins on the Mid Fuse and Bottom Skin Assembly.

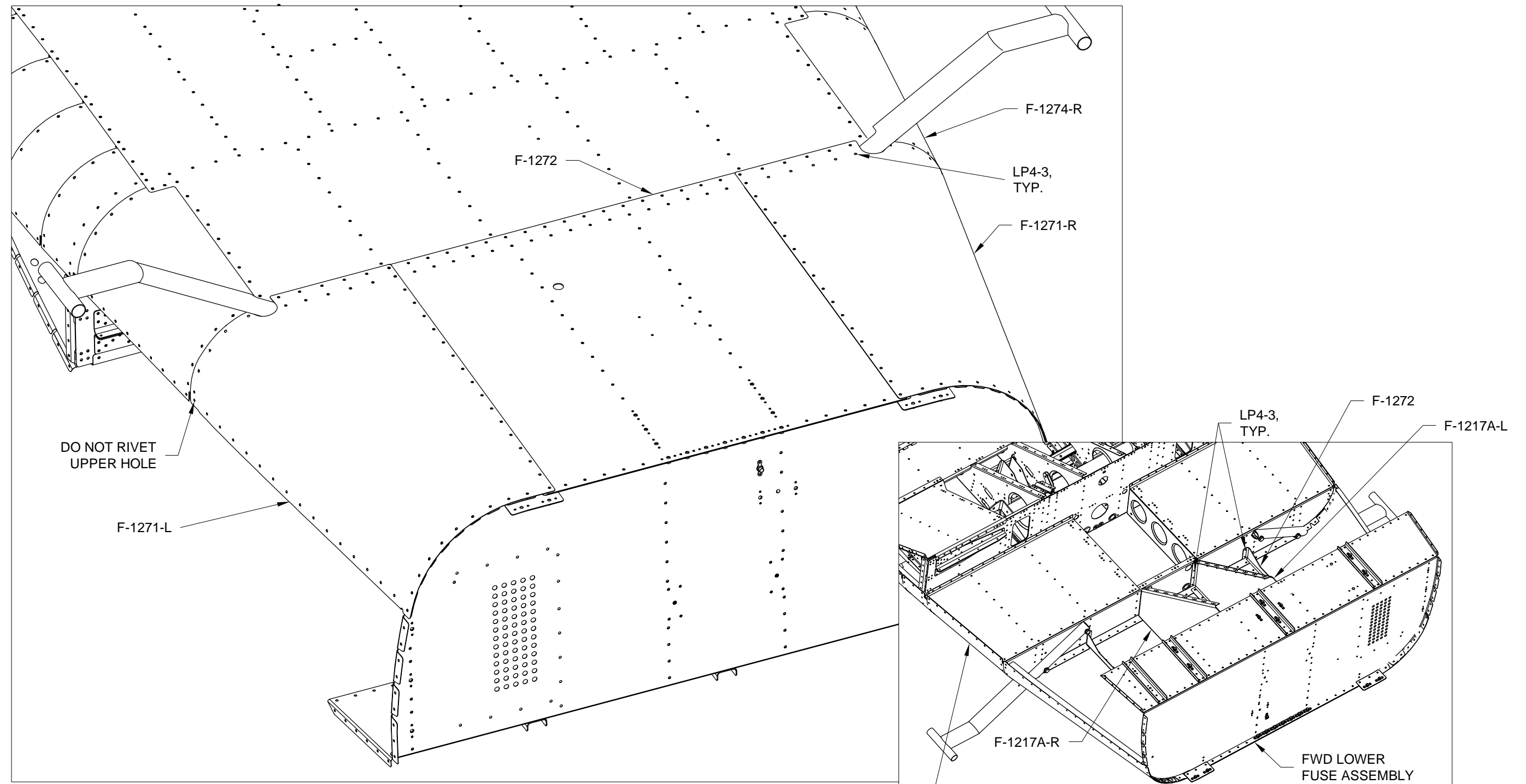
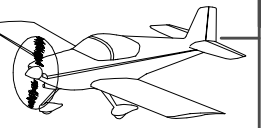


FIGURE 1: ATTACHING THE FORWARD LOWER FUSE SKINS

MID FUSE AND
BOTTOM SKIN
ASSEMBLY

FIGURE 2: ATTACHING THE AFT FLANGES OF THE TUNNEL AND FWD BOTTOM SKIN



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