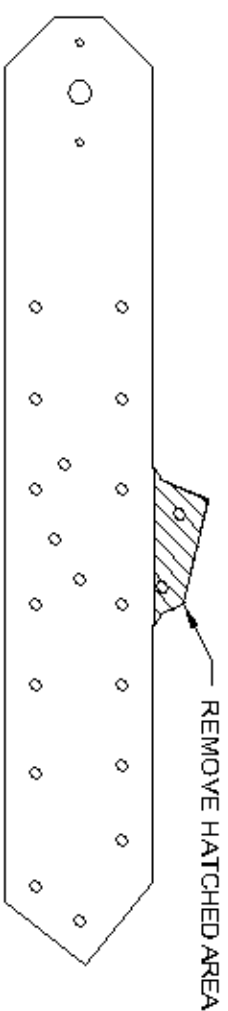


Step 1: Remove the tabs on the **two** remaining instances of the F-1016D Seat Belt Attach Bar as shown in Figure 1. This will create two F-1016D TRIMMED Seat Belt Attach Bars. Radius the lower edge as shown in Figure 2.



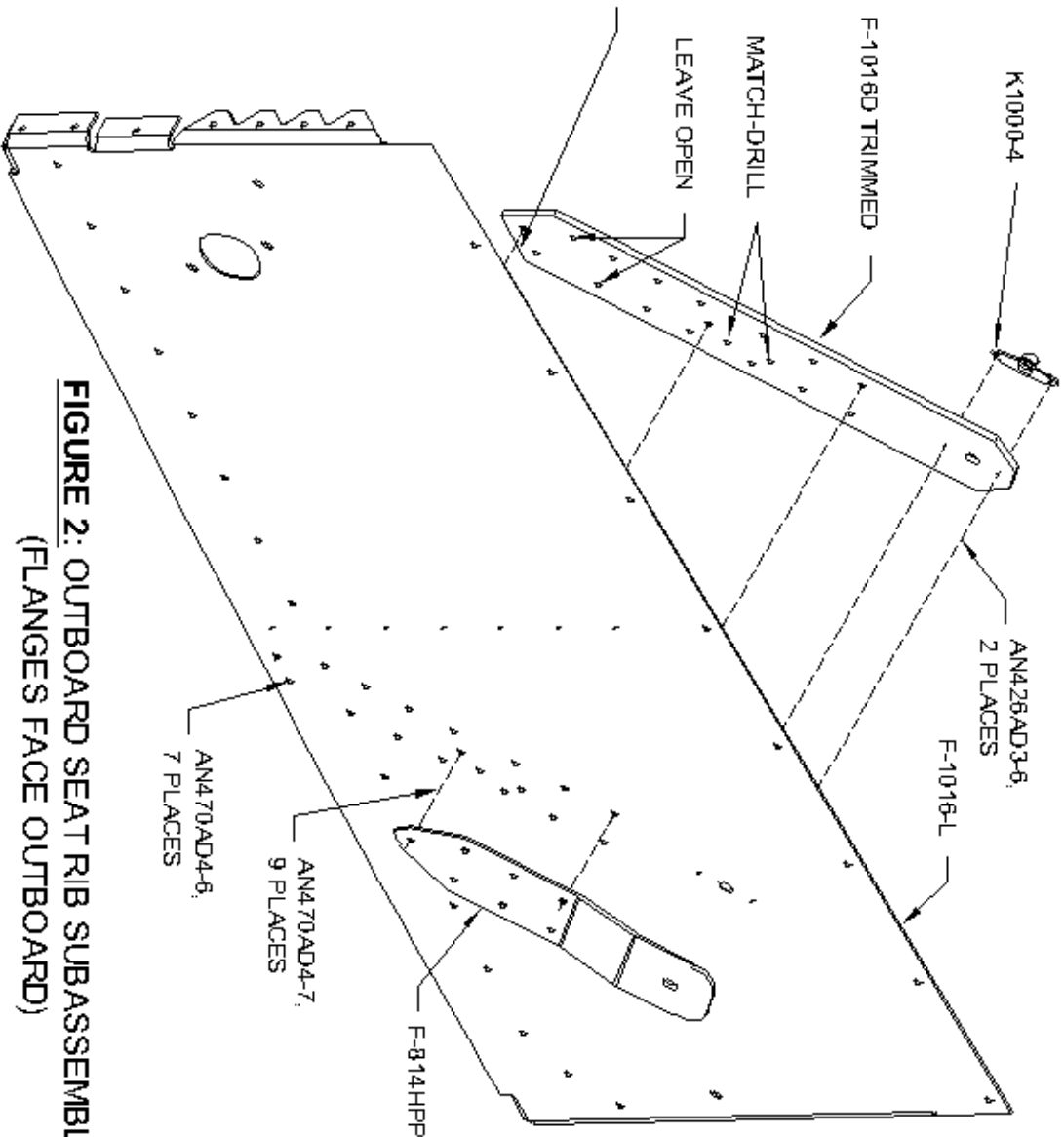
**FIGURE 1: MODIFYING THE SEAT BELT ATTACH BAR**

Step 2: Cleco the F-1010D TRIMMED Seat Belt Attach Bar, and F-814HPP Fwd Seat Belt Anchor to the F-1016-L Outboard Seat Rib as shown in Figure 2.

Step 3: Final-Drill #40 the nutplate attach holes in the F-1016D TRIMMED Seat Belt Attach Bar and F-1016-L Outboard Seat Rib. Final-Drill 1/4 dia. the bolt hole in the F-814HPP Fwd Seat Belt Anchor, seat belt attach bar and F-1016-L Outboard Seat Rib. Final-Drill #30 the remaining holes common between the seat belt attach bar, outboard seat rib and fwd seat belt anchor. Match-Drill #30 the holes called out in Figure 2 into the fwd seat belt anchor using the holes in the outboard seat rib and seat belt attach bar as drill guides.

Step 4: 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).

RADIUS INSIDE  
EDGE AS REQ'D  
TO REMOVE  
INTERFERENCE  
WITH RADIUS ON  
THE BOTTOM  
FLANGE OF  
THE OUTBOARD  
SEAT RIB



**FIGURE 2: OUTBOARD SEAT RIB SUBASSEMBLY  
(FLANGES FACE OUTBOARD)**

Step 5: Cleco the F-1015B-L Seat Rib Intercoastal and F-1016E Spacer to the F-1016-L Outboard Seat Rib as shown in Figure 3. 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 intercoastal. Final-Drill #19 the open screw holes along the upper edge of the outboard seat rib to create the Left Outboard Seat Rib Subassembly.

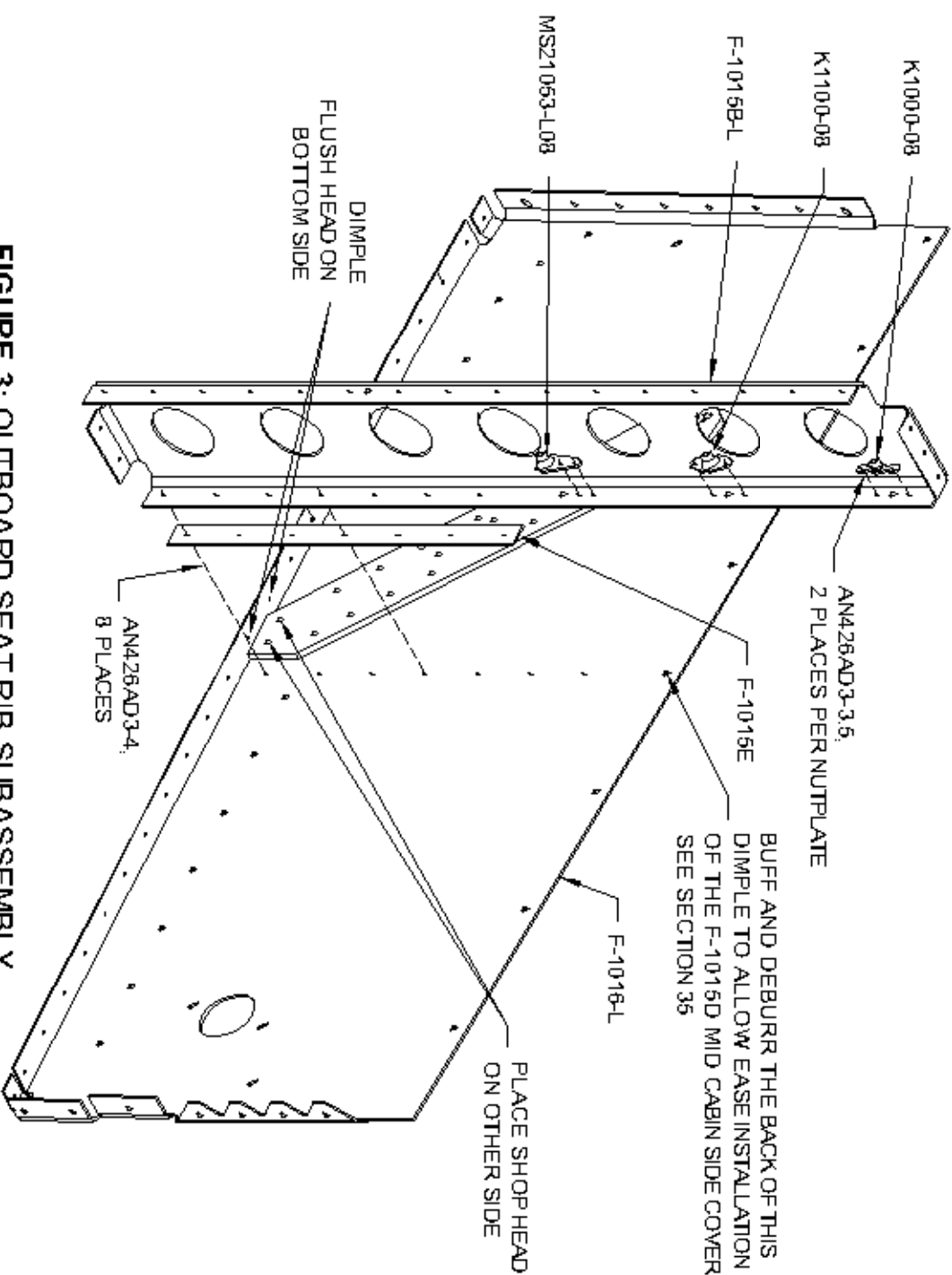
Step 6: Repeat Steps 2, 3 and 5 to create the Right Outboard Seat Rib Subassembly. The right is a mirror of the left.

Step 7: 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 and -R Outboard Seat Ribs. Machine countersink the F-1016D TRIMMED Seat Belt Attach Bars for the dimples in the outboard seat ribs. Dimple the screw holes in the inboard flange of the seat rib intercoastals 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 and -R Seat Rib Intercoastals. Dimple the nutplate attach holes in the inboard flange of the seat rib intercoastals. 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 3). File the bottom flange of both the outboard seat rib subassemblies. Prime all parts if/as desired.

Step 8: Dimple the K1000-08, K1100-08 and MS21053-L08 nutplates. Rivet the nutplates to the inboard flange of the F-1015B-L and -R Seat Rib Intercoastals per the callouts in Figure 3.

Step 9: Cleco the K1000-4 nutplates and F-1016D Seat Belt Attach Bars onto the F-1016-L and -R Outboard Seat Ribs. Rivet the K1000-4 nutplates in place per the callouts in Figure 2. Cleco the rest of the parts together per Step 2 and Step 4 to form the Left and Right Outboard Seat Rib Subassemblies.

Step 10: Rivet the F-1016D TRIMMED Seat Belt Attach Bar, and F-814HPP Fwd Seat Belt Anchor to the F-1016-L Outboard Seat Rib per the callouts in Figure 2 (leave the holes open as called out). Rivet the F-1015B-L Seat Rib Intercoastal and F-1015E Spacer to the F-1016-L Outboard Seat Rib per the callouts in Figure 3 to finish the Left Outboard Seat Rib Subassembly. Repeat this step to finish the Right Outboard Seat Rib Subassembly.



**FIGURE 3: OUTBOARD SEAT RIB SUBASSEMBLY**

