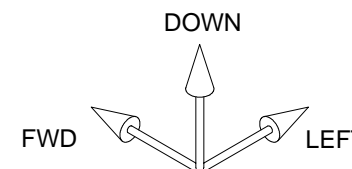




Step 1: Dimple the four sets of nutplate attach rivet holes around each access hole in the F-1276 Bottom Skin depicted in Figure 1.

CLECO BUT DO NOT RIVET HOLES IN THIS AREA

F-1276



LP4-3 TYP.

OPTIONAL ADD K1000-08 NUTPLATES, 4 PLACES

F-1268A
F-1268B
F-1268C

F-1204Z-L

K1000-08
2X AN426AD3-3.5
4 PLACES PER ACCESS HOLE

F-1268A
F-1268B

F-1268D

F-1268E

Step 2: Dimple the twenty nutplates called out in Figure 1, then rivet them around each access hole in the F-1276 Bottom Skin.

Step 3: Break the edges along both sides of the F-1276 Bottom Skin.

Step 4: Cleco the F-1276 Bottom Skin to the fuselage.

Step 5: Reach through the openings in the sides of the fuselage or through the access holes in the F-1276 Bottom Skin, then cleco the F-1204Z-L & -R Bottom Stiffeners to the bottom skin as shown in Figure 1. The hole in the vertical flange of the bottom stiffeners locates the front of the part.

Step 6: Cleco the F-1268A,B,C,D, & E Doublers to the F-1276 Bottom Skin, to the F-1204Z-L & -R Bottom Stiffeners, and to the F-1204A & D Center Section Bulkhead flanges.

Step 7: Except for the holes indicated in Figure 1, rivet in place the F-1268A,B,C,D, & E Doublers, the F-1204Z-L & -R Bottom Stiffeners, and the F-1276 Bottom Skin using the rivets called out in the figure.

F-1204A

F-1204Z-R

CLECO BUT DO NOT RIVET HOLES IN THESE AREAS

FIGURE 1: RIVETING THE BOTTOM SKIN