



Step 1: Smear a thin layer of fuel tank sealant on the upper surface of the bottom flange of the F-1201A Firewall Upper.

Rivet the F-1201A Assembly to the fuselage assembly as shown in Figure 1.

Step 2: Match-Drill #30 the F-12116-L and F-12116-R Mid Cowl Hinges to the F-1201P Firewall Spacers and F-1270 Side Skins as shown in the Figure 1 detail. Deburr.

Step 3: Cleco then rivet the F-12116-L and F-12116-R Mid Cowl Hinges to the F-1201P Firewall Spacers and F-1270 Side Skins (with the manufactured head on the exterior) as shown in Figure 1.

Step 4: Dimple the nutplate rivet holes in the nutplates, then rivet to the F-1201A Assembly and fuselage assembly as shown in Figure 1.

Step 5: Cleco then rivet the F-1202N-L and F-1202N-R Forward Skin Stiffeners to the F-1201A Assembly and the F-1270-L and F-1270-R Fuselage Side Skins as shown in Figure 2.

Step 6: Fill the #11 tooling holes in the F-1201A Firewall Upper with Firewall Sealant as shown in Figure 2. Add a bead of Firewall Sealant around the perimeter of the firewall parts. Use a popsicle stick to form a smooth fillet. Make sure all gaps from the bend relief notches along the flange and in the corners are fully sealed. Use a light on the forward side of the firewall to help verify that the full perimeter of the firewall is fully sealed.

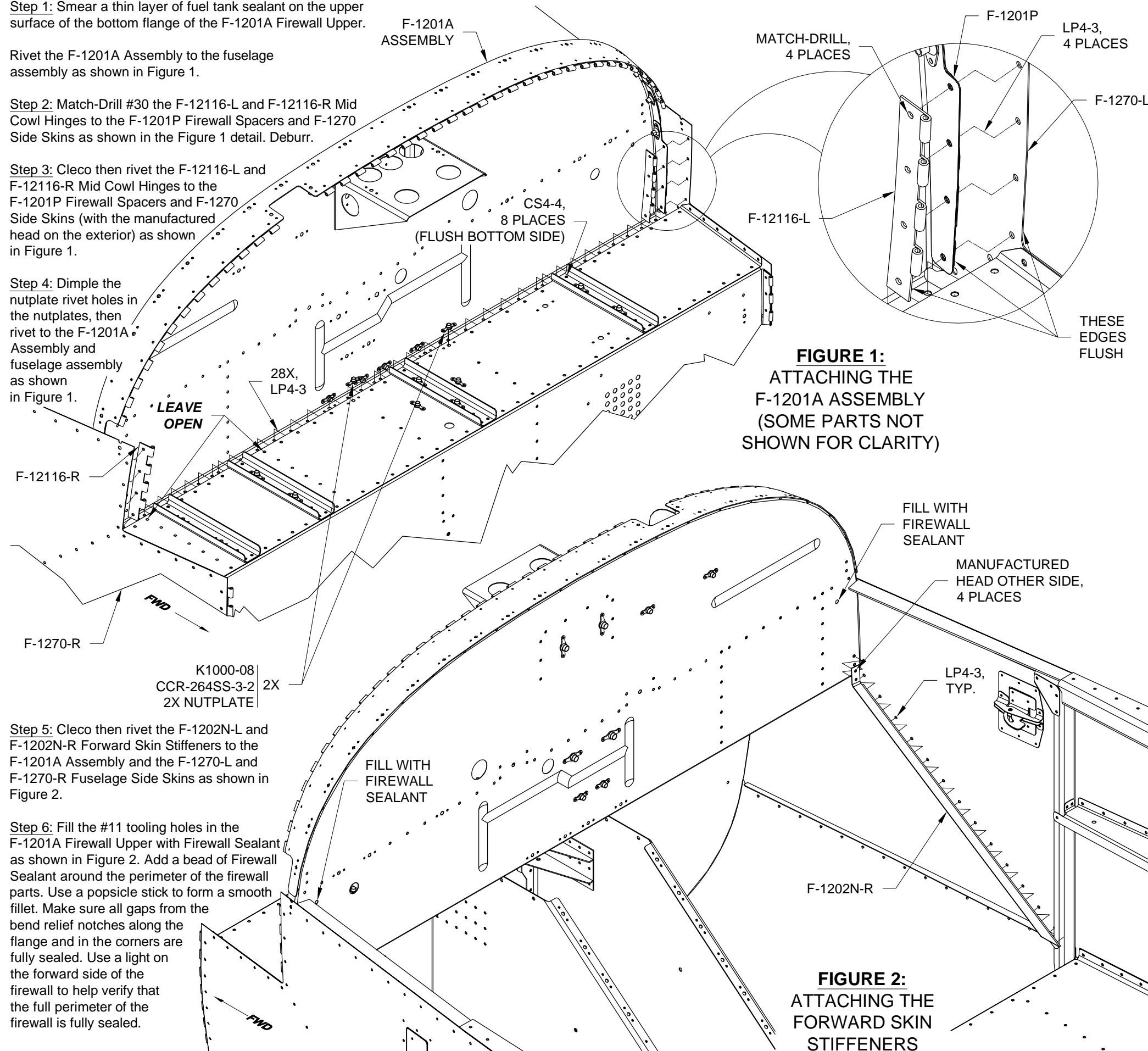


FIGURE 1:
ATTACHING THE
F-1201A ASSEMBLY
(SOME PARTS NOT
SHOWN FOR CLARITY)

Step 7: Separate the F-1202J Inst Stack Angles into left and right parts as shown in Figure 3.

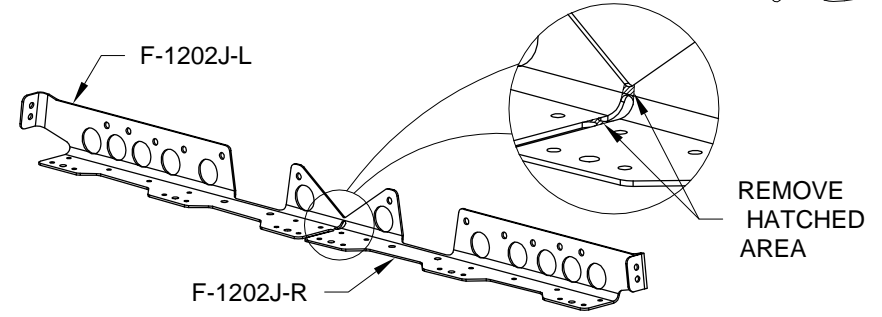


FIGURE 3: SEPARATING THE INST STACK ANGLE

Step 8: Separate the F-1202K Inst Stack Support into left and right parts as shown in Figure 4.

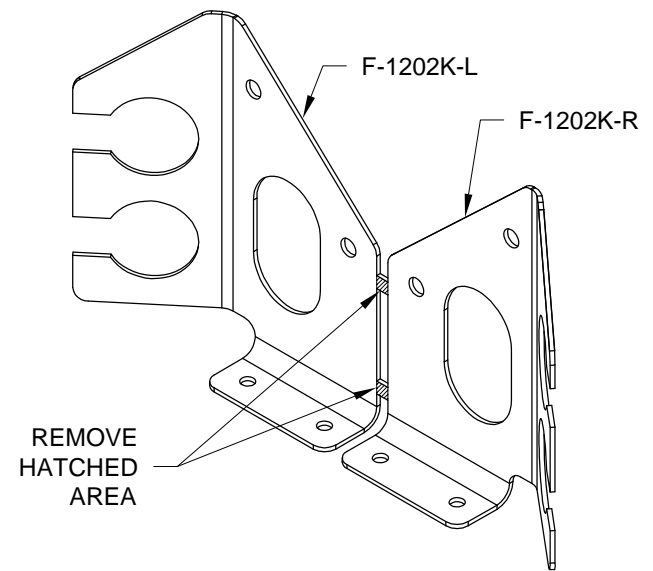


FIGURE 4: SEPARATING THE INST STACK SUPPORT

Step 9: Separate the F-1202M Canopy Attach Doubler into left and right parts as shown in Figure 5.

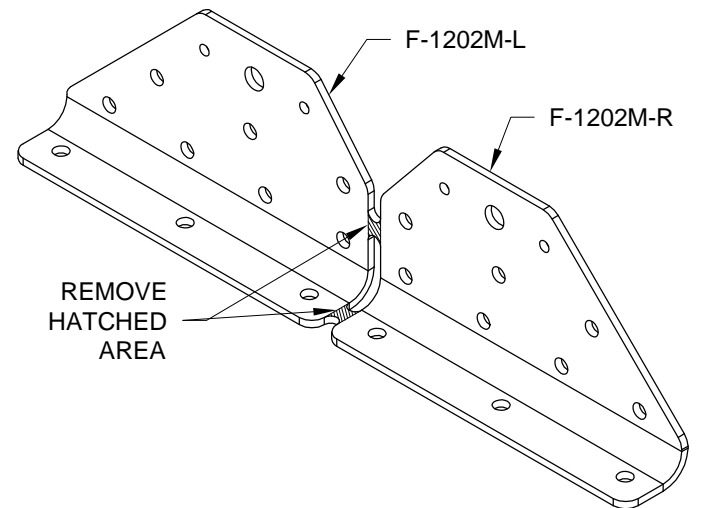


FIGURE 5: SEPARATING THE CANOPY ATTACH DOUBLER

FILL WITH FIREWALL SEALANT
MANUFACTURED HEAD OTHER SIDE, 4 PLACES

FIGURE 2:
ATTACHING THE
FORWARD SKIN
STIFFENERS