

TOTAL PERFORMANCE
VAN'S AIRCRAFT

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REVISION DESCRIPTION:

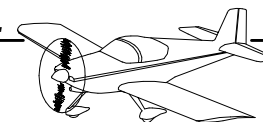
Page: 26-10 MEMO: Added "NOTE: Taildragger builders: if installing the optional F-00018-L & -R Tail Dragger Steps, ignore the remaining steps on this page."

Page: 26-11 REV 3: Added Step 8 (was Step 1 on 26-14). Remaining steps repaginated.

In Figure 1, added "Break These Edges" callout.

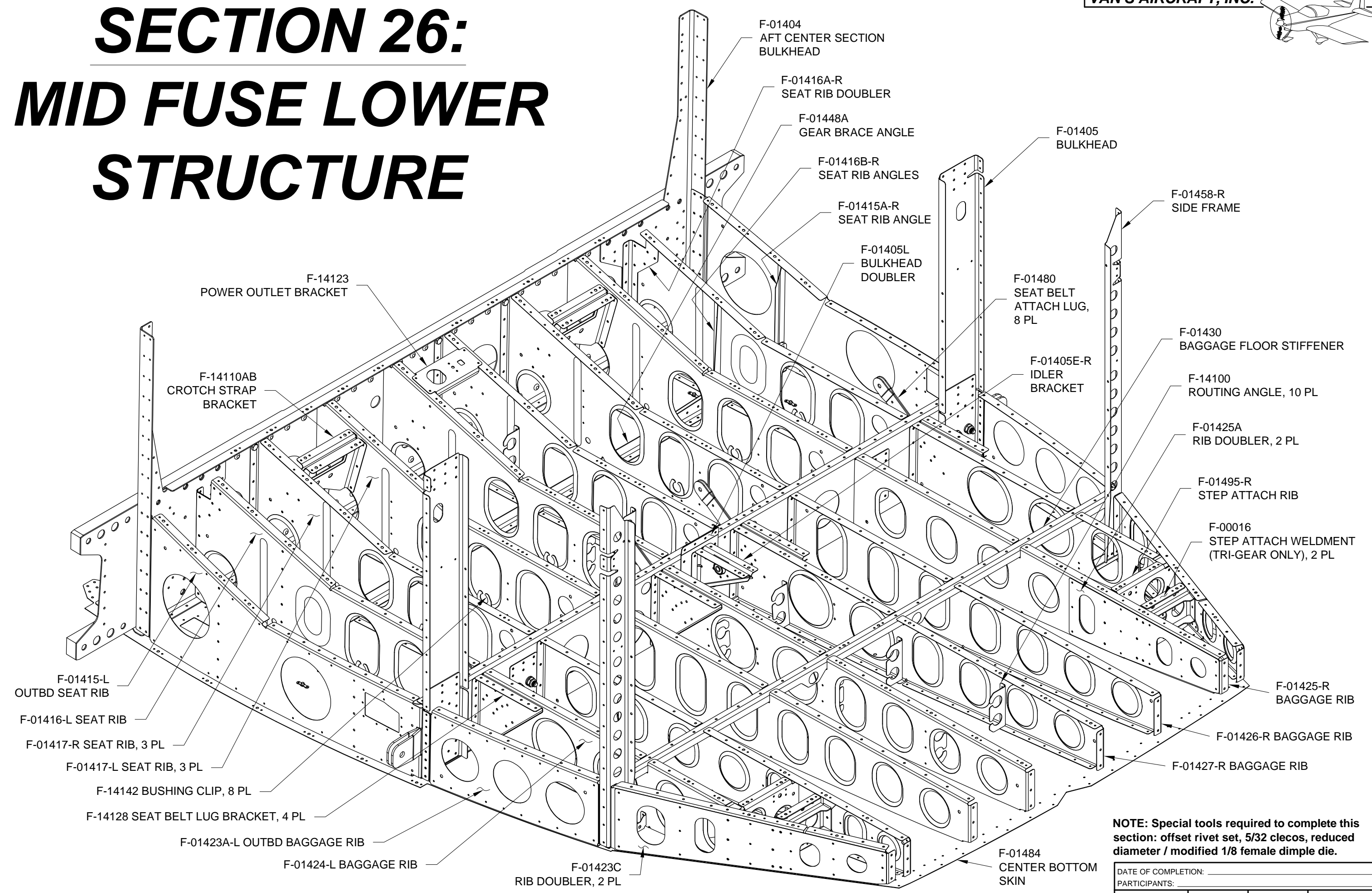
Page: 26-14 REV 1: Removed Step 1. Remaining steps repaginated.

Page: 26-17 MEMO: Added "NOTE: Taildragger builders may choose to perform steps marked "Tri-Gear Only" on this page to allow for installation of the optional F-00018-L & -R Tail Dragger Steps."



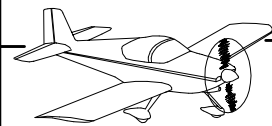
SECTION 26:

MID FUSE LOWER STRUCTURE



NOTE: Special tools required to complete this section: offset rivet set, 5/32 clecos, reduced diameter / modified 1/8 female dimple die.

DATE OF COMPLETION: _____			
PARTICIPANTS: _____			
DATE: 05/01/14	REVISION: 0	RV-14	PAGE 26-01



Step 2: Rivet the F-01425A Rib Doublers to the F-01425-L & -R Baggage Ribs as shown in Figure 2.

Step 1: Rivet one F-01423C Rib Doubler to each of the F-01423B-L & -R Outbd Baggage Ribs as shown in Figure 1.

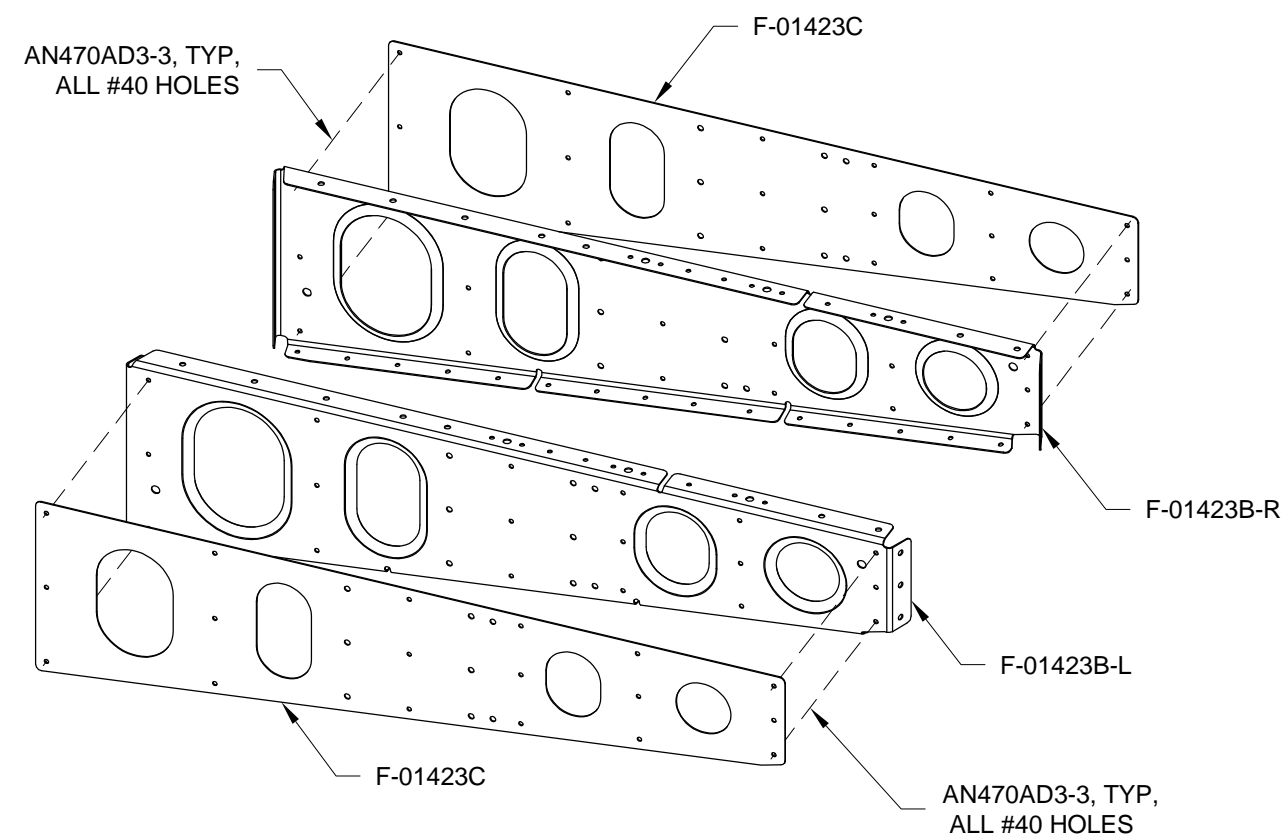


FIGURE 1: OUTBOARD BAGGAGE RIBS

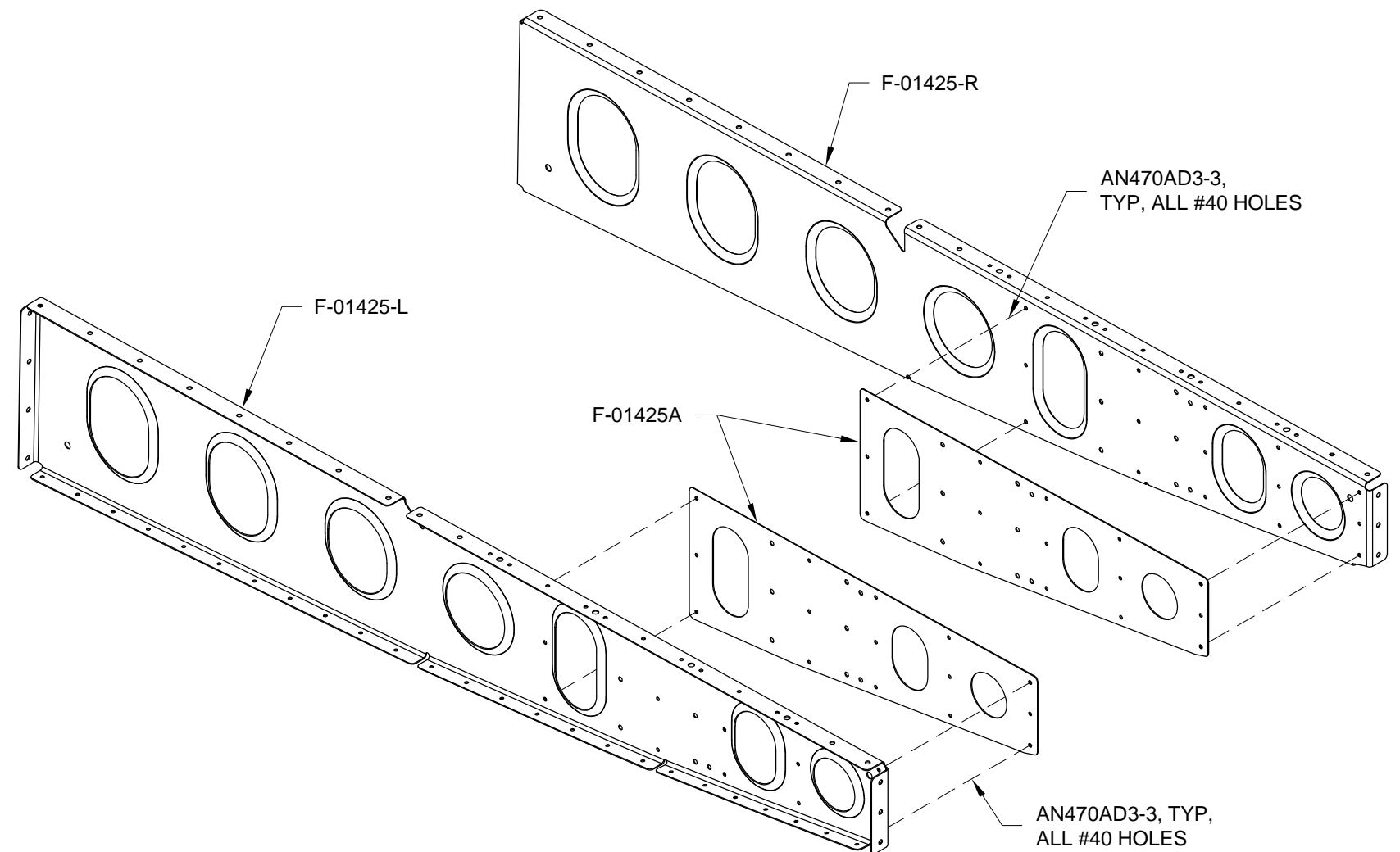
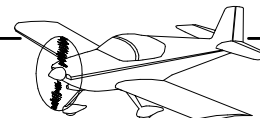


FIGURE 2: BAGGAGE RIBS



Step 1: Dimple the #40 holes in the ramped and lower flanges of the F-01416-L & -R and F-01417-L & -R Seat Ribs except where noted as shown in Figure 1.

Step 2: Dimple the single #30 hole in the F-01416-L & -R and F-01417-L & -R Seat Ribs as shown in Figure 1.

Step 3: Flute the lower flanges of the F-01416-L & -R and F-01417-L & -R Seat Ribs between the holes called out in Figure 1.

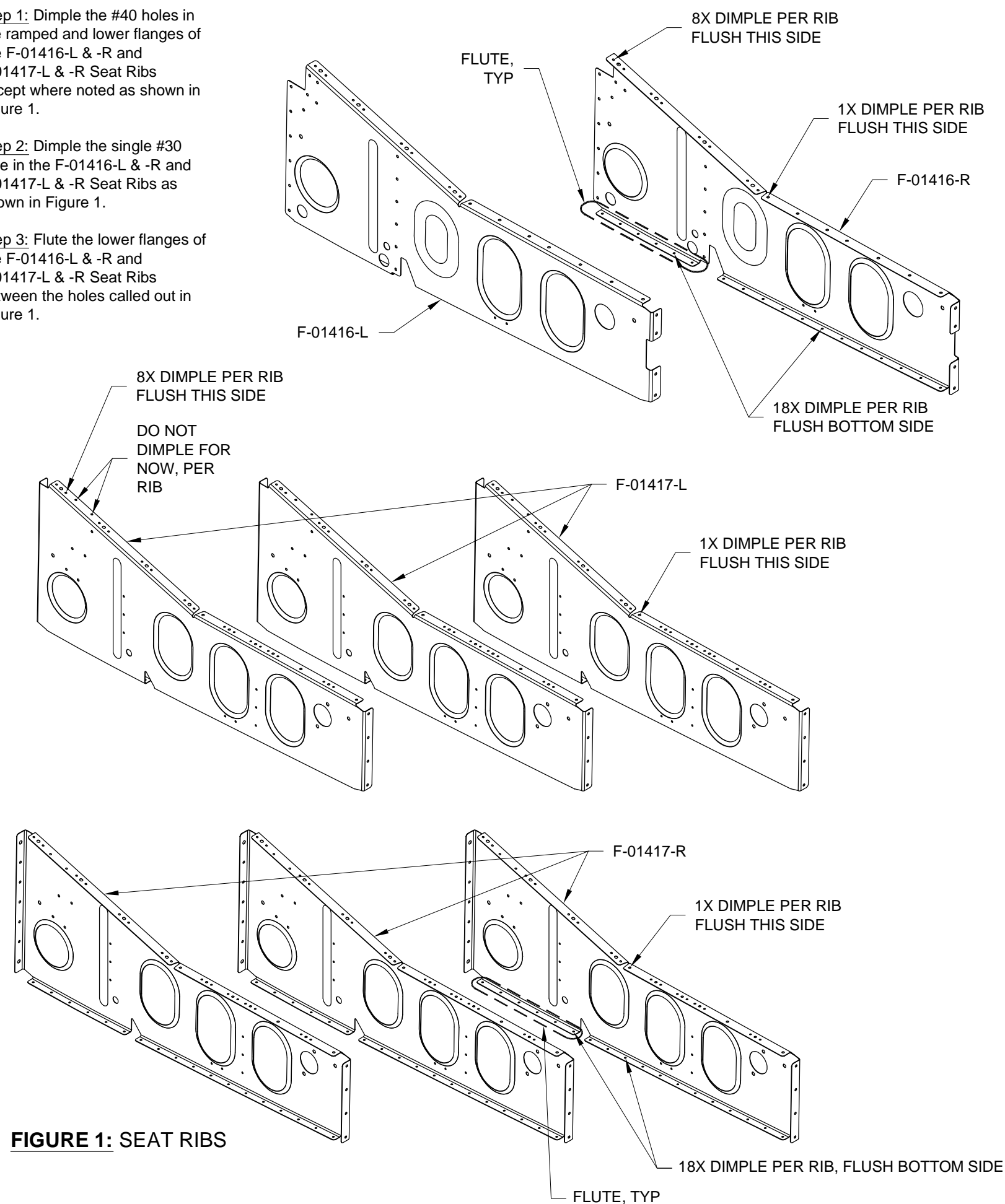


FIGURE 1: SEAT RIBS

Step 4: Select one F-01417-L and one F-01417-R Seat Rib.

Dimple the #40 holes in the upper flanges of the F-01417-L & -R Seat Ribs as shown in Figure 2.

Dimple the two #30 holes in the non-ramped upper flange of the Seat Ribs as shown in Figure 2.

Hereafter refer to these two ribs as the F-01417-L & -R Inboard Seat Ribs.

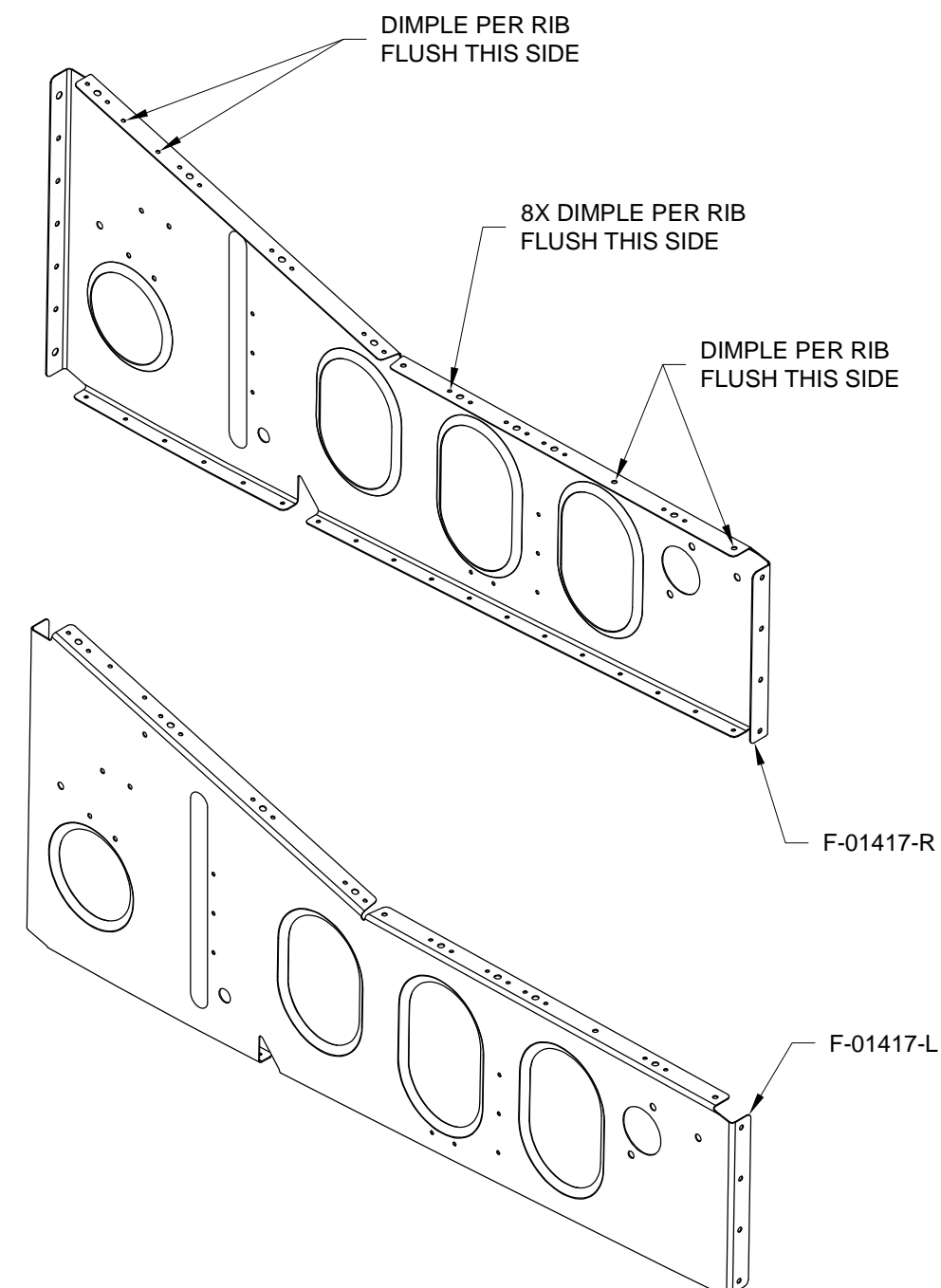
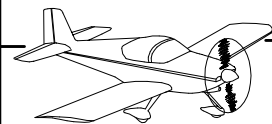


FIGURE 2: INBOARD SEAT RIBS



Step 1: Rivet the nutplates to the ramped flanges of the F-01417-L & -R Seat Ribs as shown in Figure 1.

Step 2: Separate the F-14142 Bushing Clips into individual parts.

Deburr the bushing clips.

Step 3: Rivet the F-14142 Bushing Clips to the F-01417-L & -R Seat Ribs as shown in Figure 1.

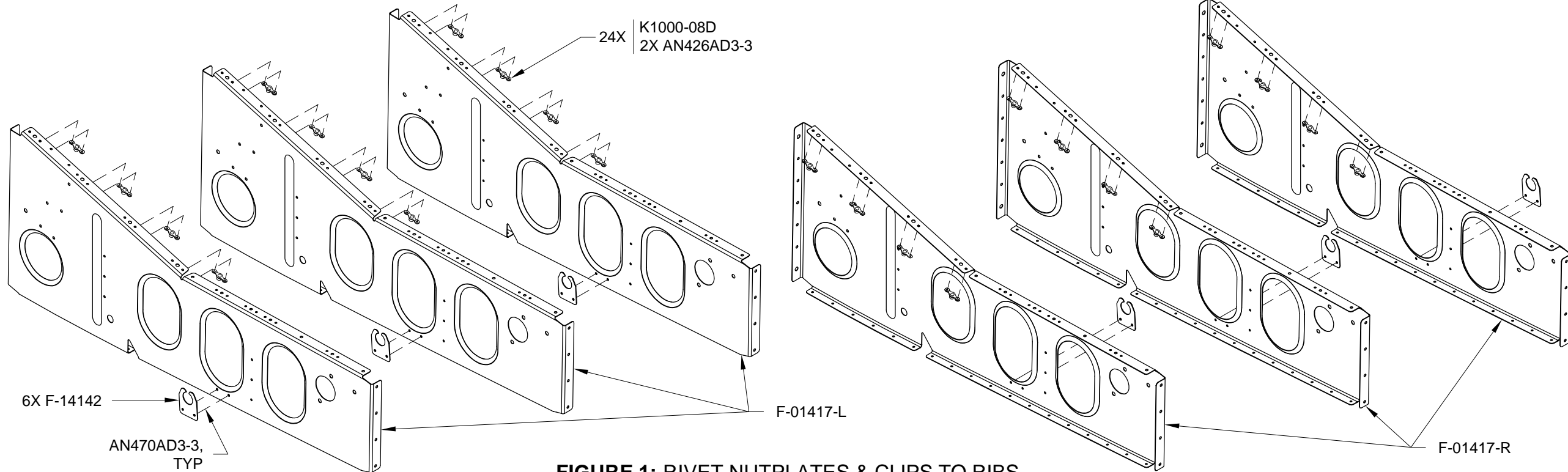


FIGURE 1: RIVET NUTPLATES & CLIPS TO RIBS

Step 4: Rivet the nutplates to the flanges of the F-01416-L & -R Seat Ribs as shown in Figure 2.

Step 5: Separate the F-01416A-L & -R Seat Rib Doublers.

Step 6: Rivet the seat rib doublers to the seat ribs as shown.

Step 7: Rivet the F-14142 Bushing Clips to the F-01416-L & -R Seat Ribs as shown in Figure 2.

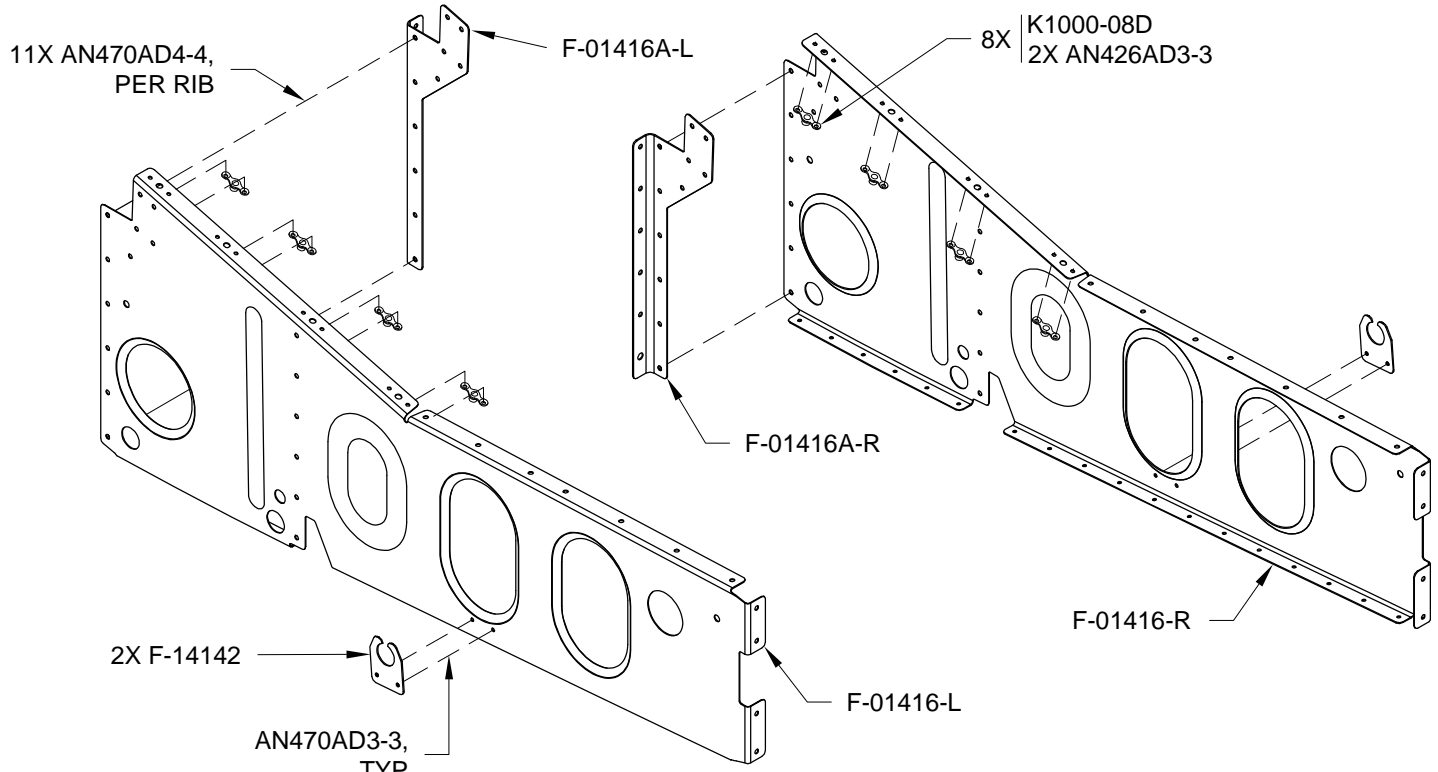


FIGURE 2: RIVET NUTPLATES & DOUBLERS TO RIBS

Step 8: Separate the F-14100 Routing Angles.

Step 9: Locate the two F-01417-L & -R Inboard Seat Ribs.

Rivet the Routing Angles to the Inboard Seat Ribs as shown in Figure 3.

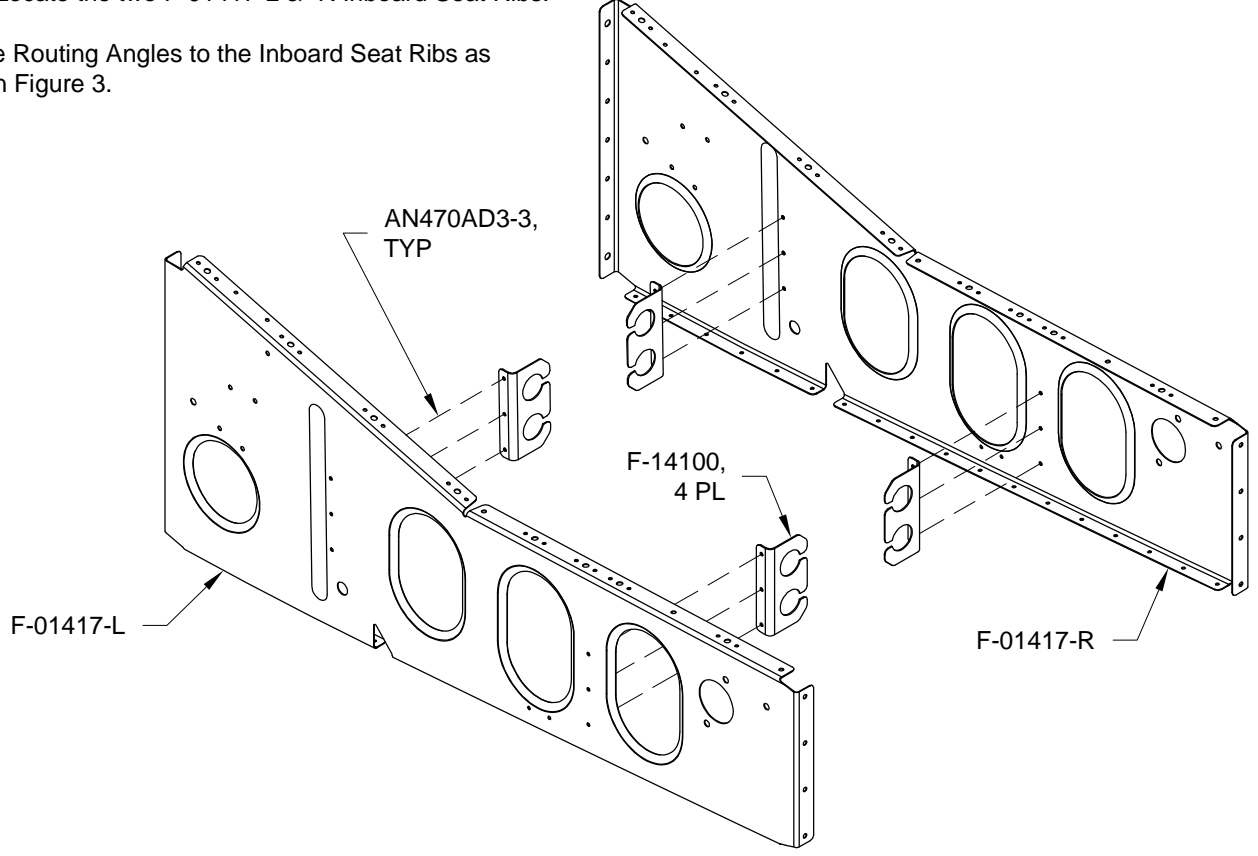
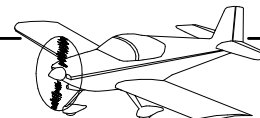


FIGURE 3: RIVET ROUTING ANGLES TO RIBS



NOTE: Except where separate instructions and/or figures exist for both left and right sides of the aircraft, only one side of the aircraft's parts, assemblies, or installations will be shown.

Step 1: Separate the F-14110 Crotch Strap Brackets as shown in Figure 1.

Dimple the #40 holes in the crotch strap brackets as shown in Figure 1.

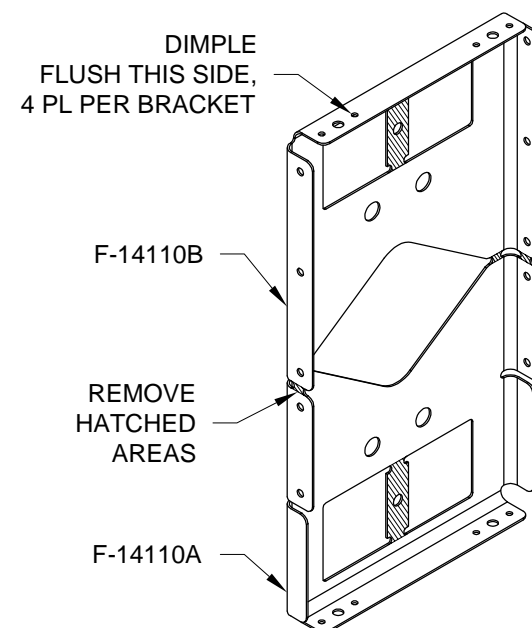


FIGURE 1:
SEPARATE CROTCH STRAP BRACKETS

Step 2: Locate the four F-01417-L and F-01417-R Seat Ribs. Do not select the two Inboard Seat Ribs from Page 26-03, Step 4.

Rivet the F-14110A and F-14110B Crotch Strap Brackets to the F-01417-L & -R Seat Ribs as shown in Figure 2.

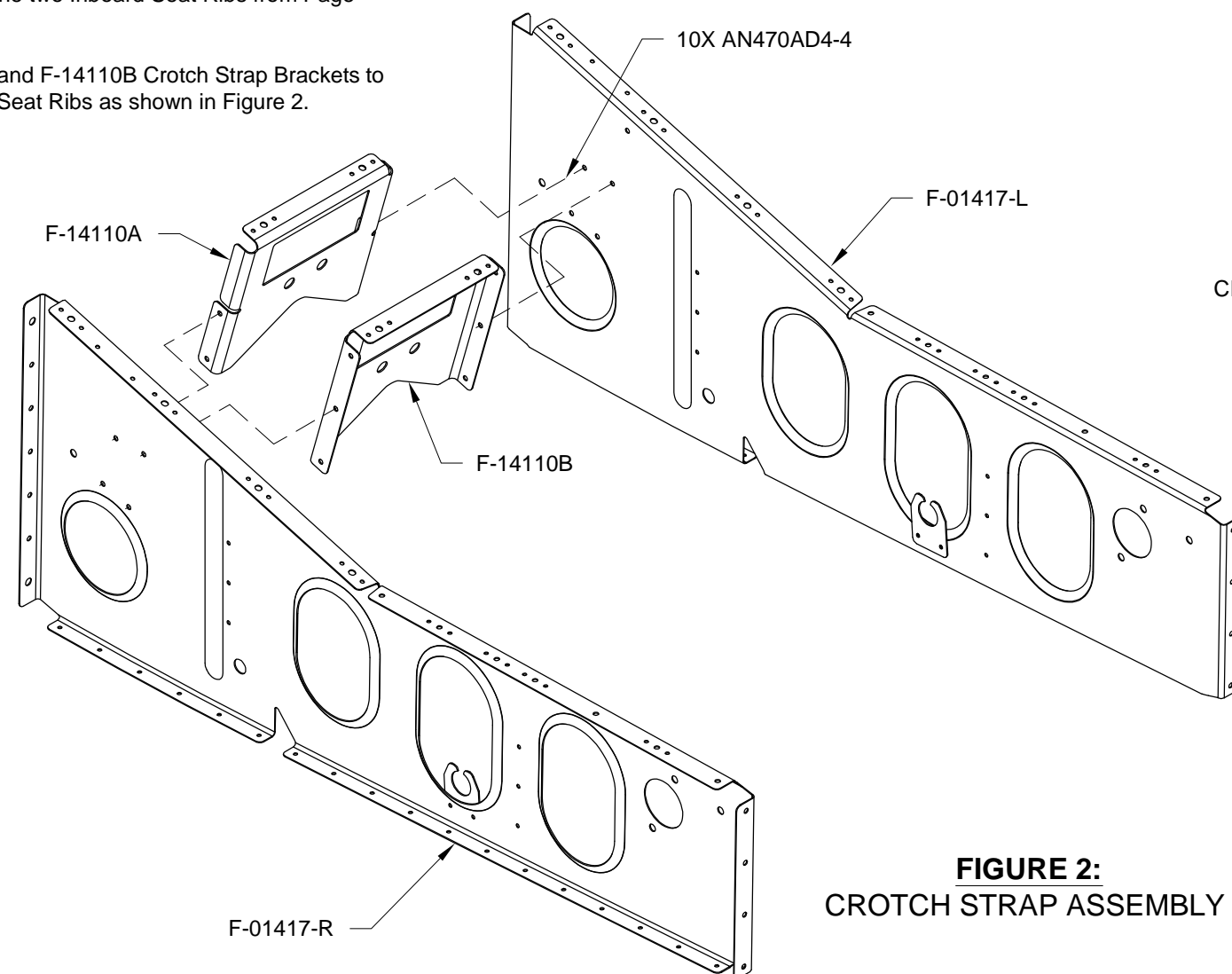


FIGURE 2:
CROTCH STRAP ASSEMBLY

Step 3: Rivet the nutplates to both Crotch Strap Assemblies as shown in Figure 3.

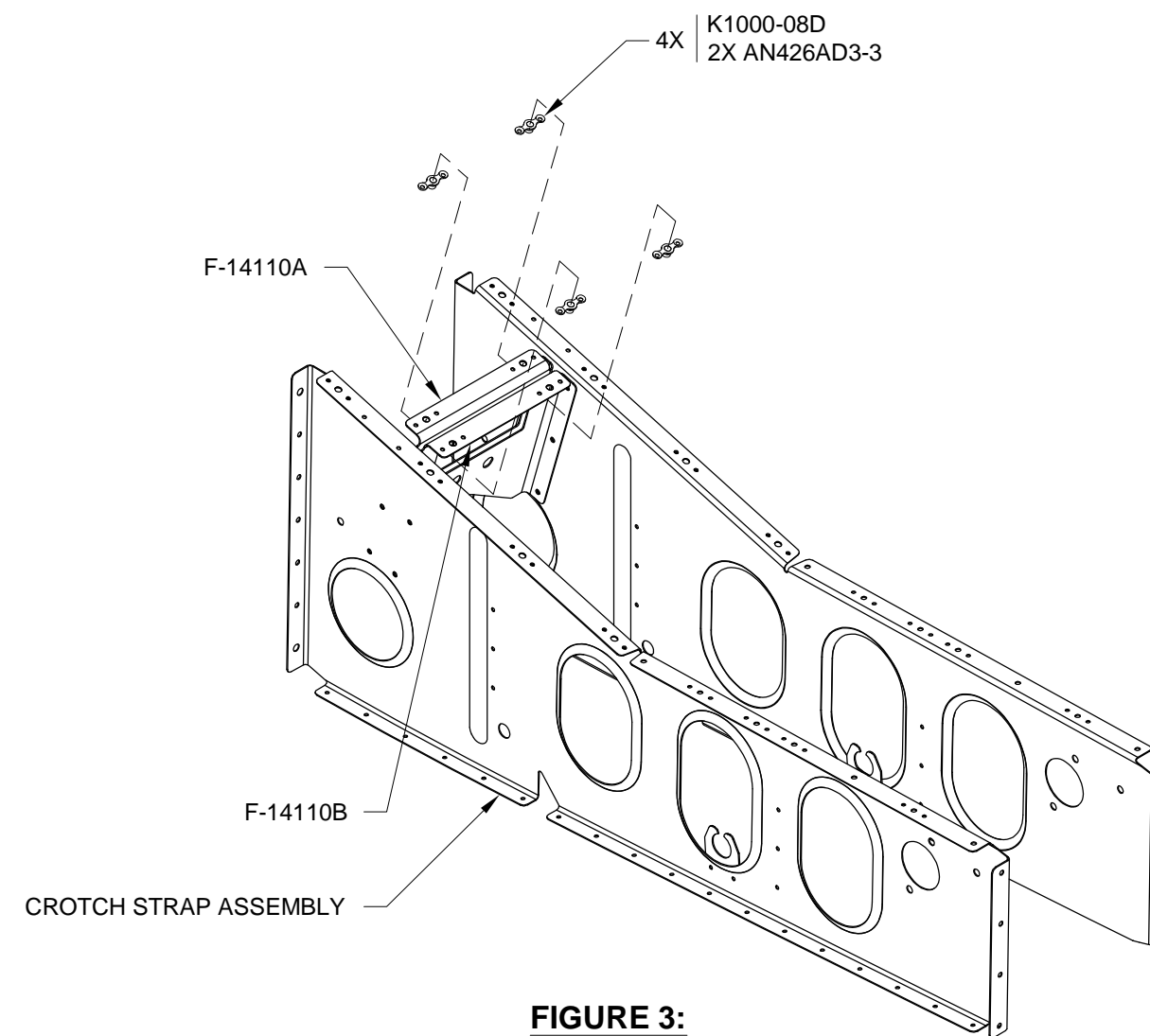
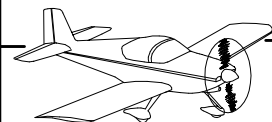


FIGURE 3:
CROTCH STRAP ASSEMBLY NUTPLATES



Step 1: Flute the upper and lower flanges of the F-01415-L & -R Outbd Seat Ribs and the F-01423A-L & -R Outbd Baggage Ribs. Flute a little at a time until the curvature of the rib web matches the outboard edge of the F-01484 Center Bottom Skin. Start at the beginning of the curvature as shown in Figure 1 and flute moving aft. Duplicate the fluting on the top and bottom flanges.

Check the fit by clecoing the ribs to the skin. There should be little or no preload. It may take a few passes with fluting pliers to get the holes to align. A slightly overly curved part is preferable to one that is not curved enough.

Step 2: Dimple the #40 holes in the ramped and lower flanges of the Outbd Seat Ribs.

Dimple the six #40 holes in the web of the Outbd Seat Ribs.

Step 3: Rivet the nutplates to the Outbd Seat Ribs as shown in Figure 1.

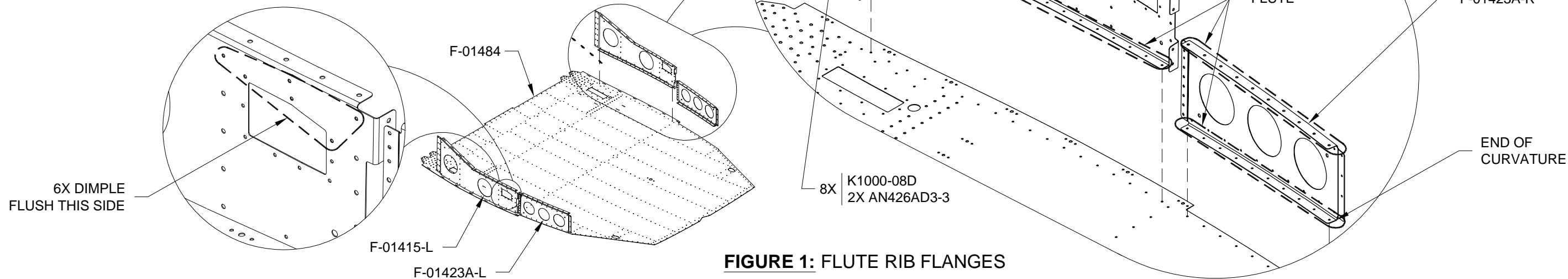
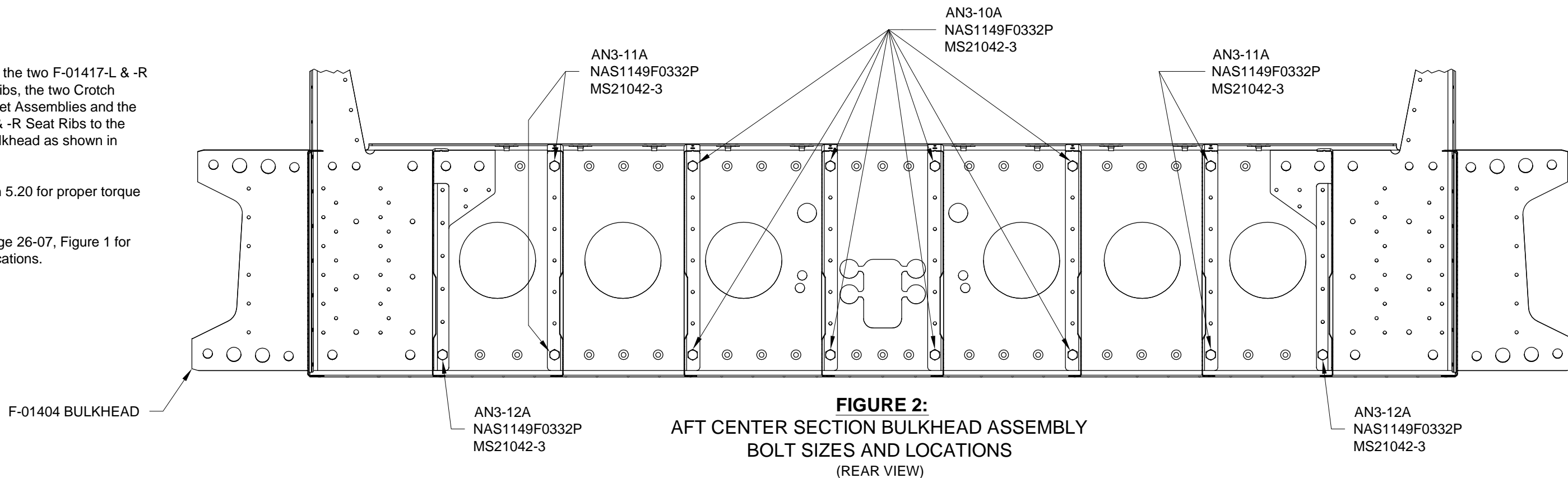


FIGURE 1: FLUTE RIB FLANGES

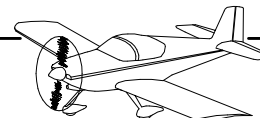
Step 4: Bolt the two F-01417-L & -R Inbd Seat Ribs, the two Crotch Strap Bracket Assemblies and the F-01416-L & -R Seat Ribs to the F-01404 Bulkhead as shown in Figure 2.

See Section 5.20 for proper torque values.

Refer to Page 26-07, Figure 1 for Seat Rib locations.



**FIGURE 2:
AFT CENTER SECTION BULKHEAD ASSEMBLY
BOLT SIZES AND LOCATIONS
(REAR VIEW)**



Step 1: Rivet the Crotch Strap Assemblies, Seat Ribs, and Inboard Seat Ribs to the F-01404 Bulkhead as shown in Figure 1.

Step 2: Cleco the F-01415-L & -R Outbd Seat Ribs to the F-01404 Bulkhead as shown in Figure 1.

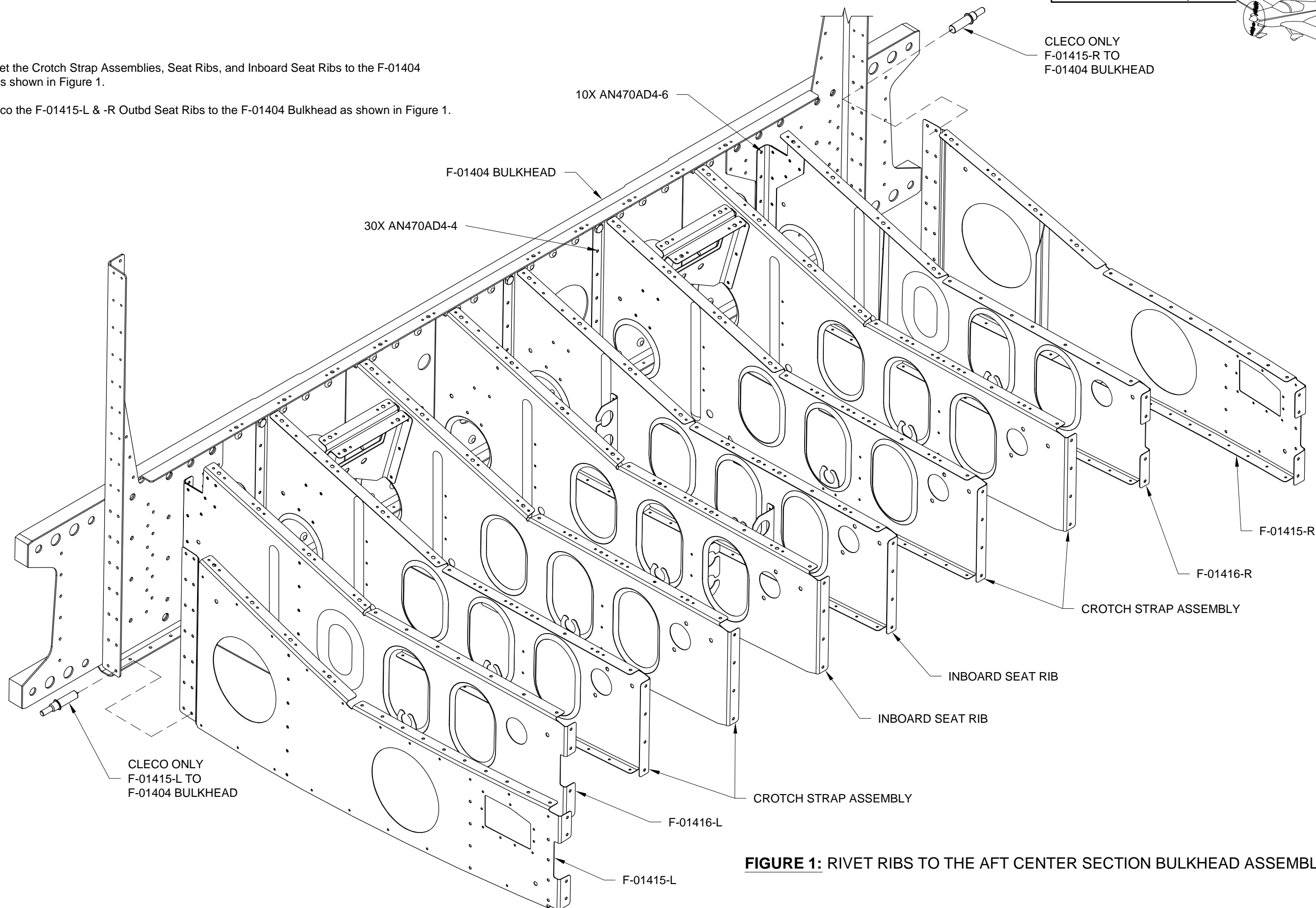
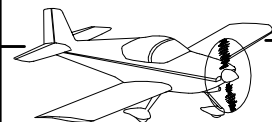


FIGURE 1: RIVET RIBS TO THE AFT CENTER SECTION BULKHEAD ASSEMBLY



Step 1: Separate the F-01480 Seat Belt Attach Lugs as shown in Figure 1.

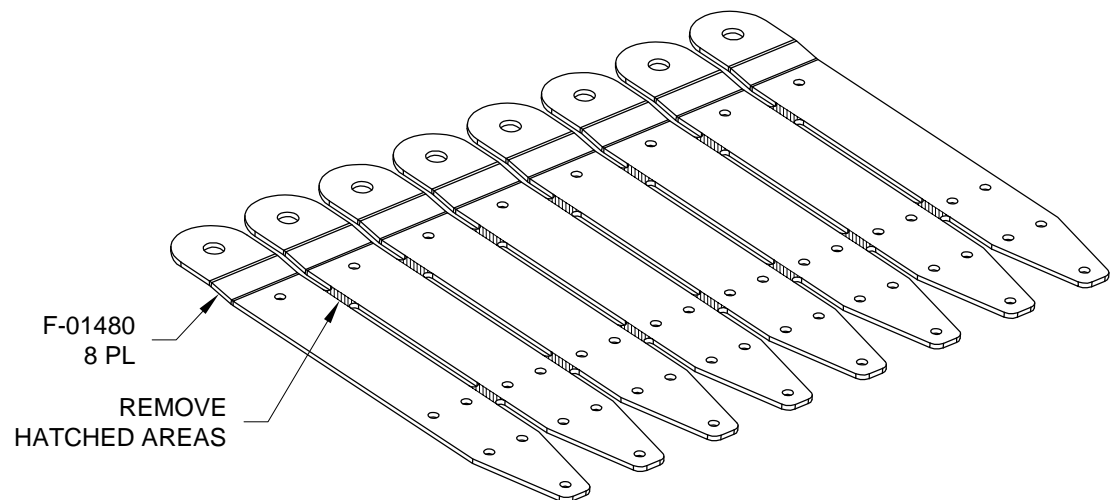


FIGURE 1: SEAT BELT ATTACH LUGS

Step 2: Cleco the F-01480 Seat Belt Attach Lugs and F-14128 Seat Belt Lug Bracket to the F-01424-L & -R and F-01427-L & -R Baggage Ribs. See Figure 2.

Step 3: Rivet the seat belt attach lugs and seat belt lug bracket to the baggage ribs.

Step 4: Final-drill 1/4 the seatbelt attach holes.

Step 5: Separate the F-14100 Routing Angles.

Step 6: Rivet the F-14100 Routing Angles to the Baggage Ribs as shown in Figure 2.

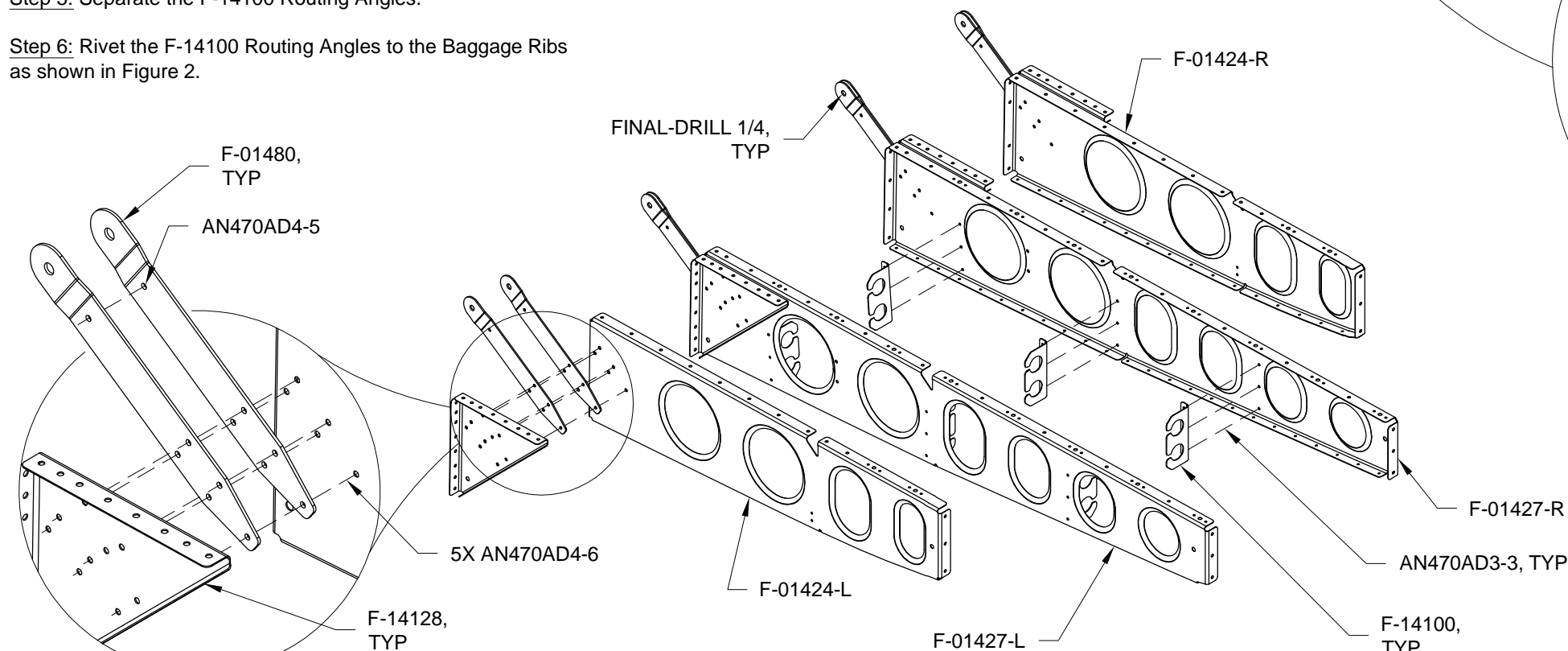


FIGURE 2: BAGGAGE RIBS

Step 7: Cleco the F-01405 Bulkhead to the F-01417-L & -R Inboard Seat Ribs. See Figure 3.

Cleco the F-01405L Bulkhead Angle to the F-01405 Bulkhead.

Step 8: Match-Drill the two #30 holes into the Inboard Seat Ribs as shown in the upper detail of Figure 3.

Step 9: Remove the F-01405L Bulkhead Angle and F-01405 Bulkhead. Clear away chips, deburr and reassemble.

Step 10: Rivet the F-01405L Bulkhead Angle to the F-01405 Bulkhead and Inboard Seat Ribs.

Step 11: Rivet F-01415-L & -R Seat Ribs to the F-01405 Bulkhead as shown in Figure 3.

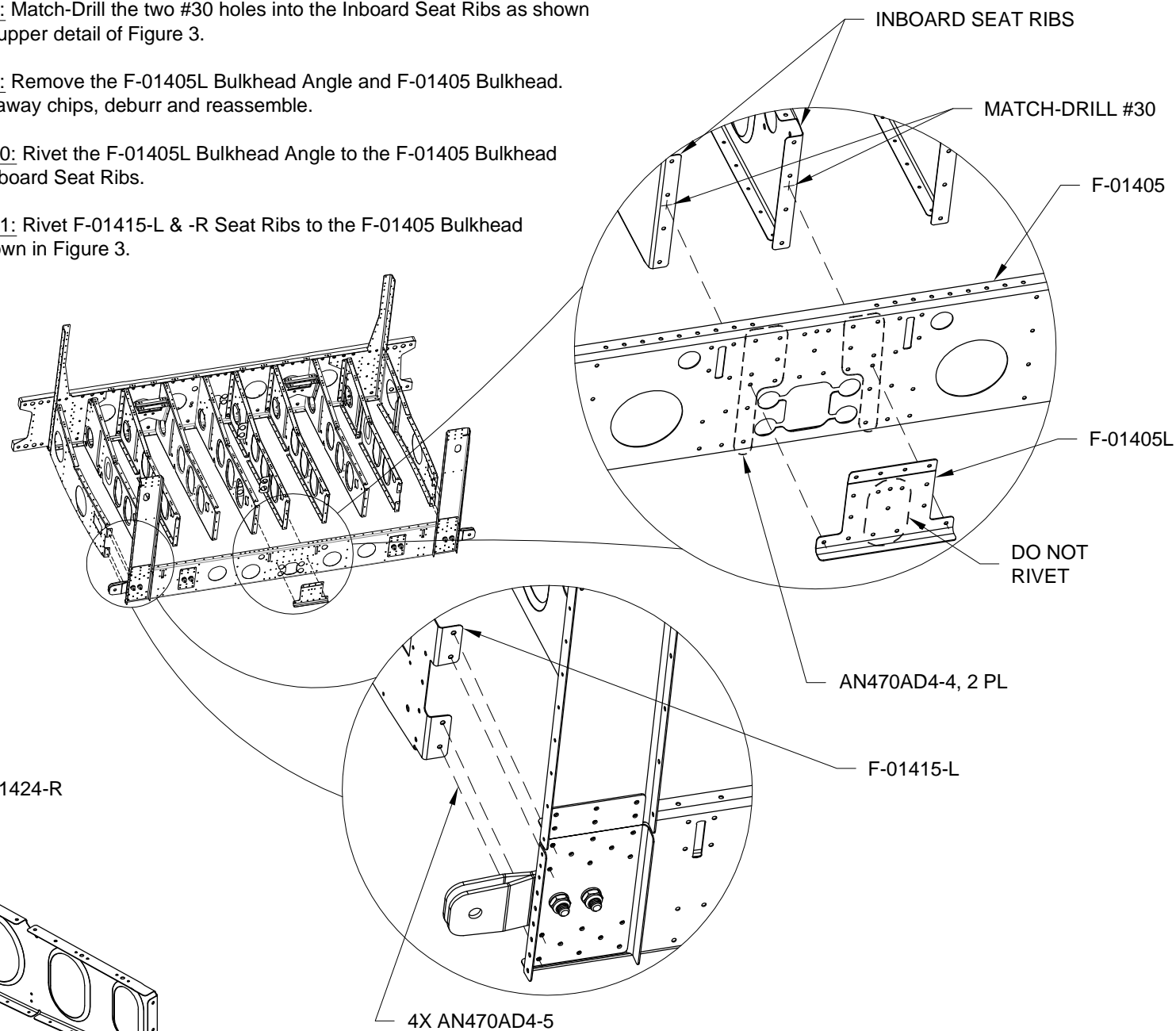
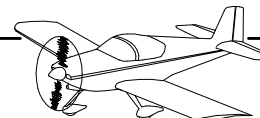


FIGURE 3: MATCH-DRILL & RIVET RIBS



Step 1: Separate and deburr the F-01405E Idler Brackets into individual parts as shown in Figure 1.

Step 2: Dimple the #40 holes in the F-01405E-L & -R Idler Brackets where indicated in Figure 2.

Step 3: Rivet nutplates to the F-01405E-L & -R Idler Brackets as shown in Figure 2.

Step 4: Bend a flange on the F-01405E-L & -R Idler Brackets as shown in Figure 2.

Step 5: Trim and deburr the VA-146 Bearing flange as shown in Figure 3.

Step 6: Cleco together the F-01405E-L & -R Idler Brackets and VA-146 Bearing as shown in Figure 4.

Step 7: Final-Drill #30 the holes indicated in Figure 4.

Disassemble, clear away debris and reassemble.

Step 8: Rivet together the F-01405E-L & -R Idler Brackets and VA-146 Bearing as shown in Figure 4.

Refer to hereafter as the Idler Bracket Assembly.

Step 9: Cleco then rivet the Idler Bracket Assembly to the F-01405 Bulkhead as shown in Figure 4.

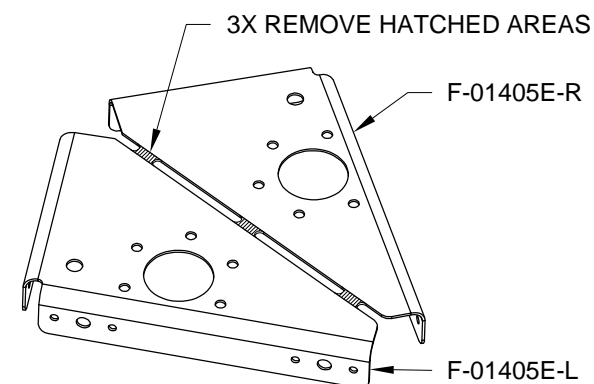


FIGURE 1: SEPARATE BRACKETS

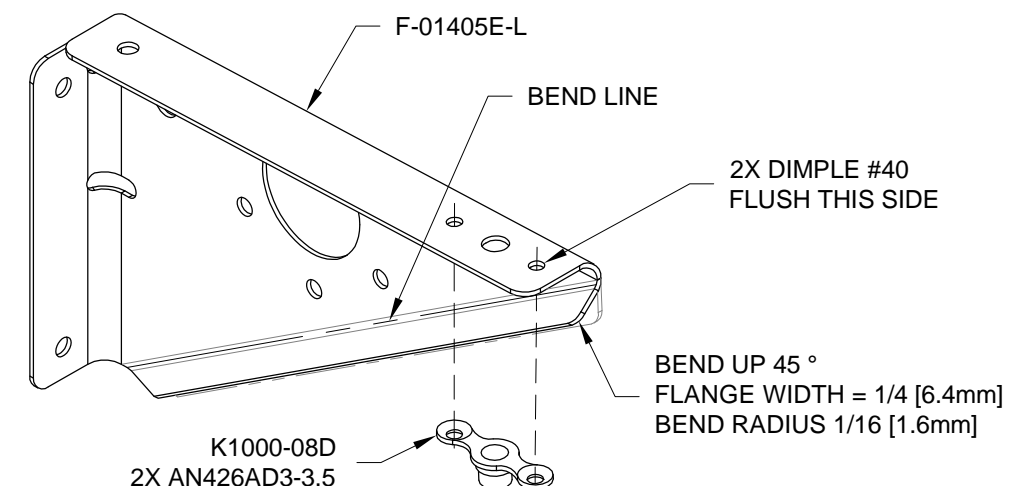


FIGURE 2: BEND FLANGE
(FLANGE SHOWN BENT)

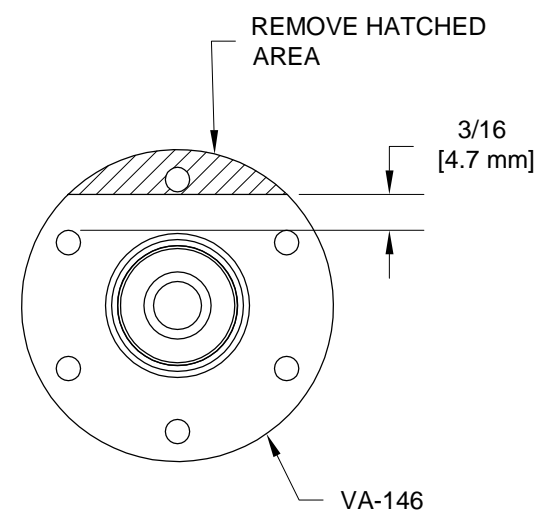


FIGURE 3: TRIM FLANGE

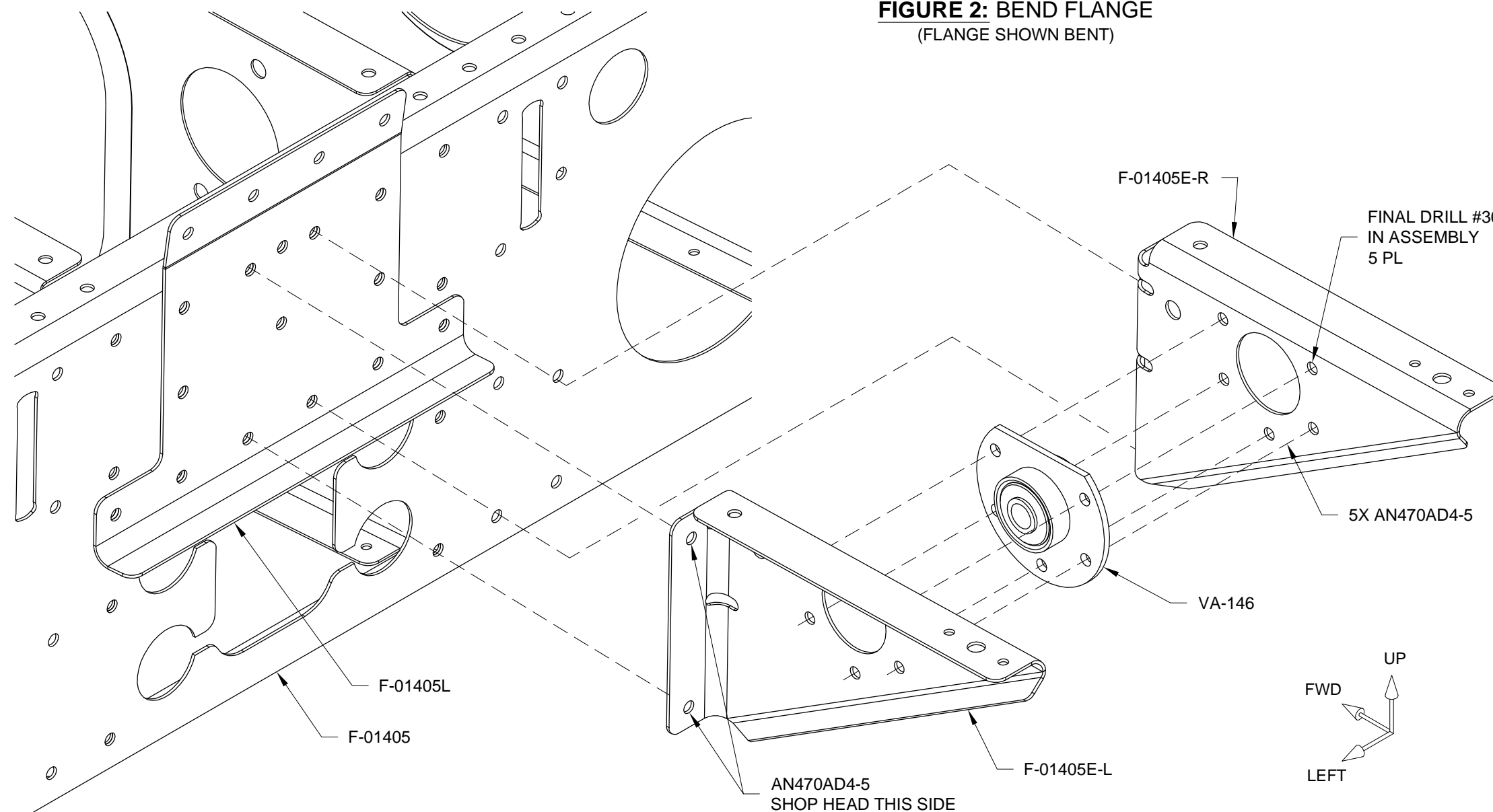
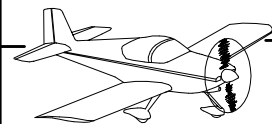


FIGURE 4: BRACKET ASSEMBLY INSTALLATION



NOTE: Refer to Figure 1 for the following steps. Call-outs on this page are mirrored about the aircraft centerline.

Step 1: (Tri-Gear Only) Cleco the F-01483-L & -R Forward Bottom Skins to the F-01484 Center Bottom Skin.

Step 2: (Tri-Gear Only) Match-Drill #30 the F-01483-L & -R Forward Bottom Skins using the inside corners of rectangular hole in the F-01484 Center Bottom Skin as guides.

Step 3: (Tri-Gear Only) Trace the gear leg cutout onto the F-01483-L & -R Forward Bottom Skins.

Step 4: (Tri-Gear Only) Match-Drill #22 the F-01483-L & -R Forward Bottom Skins.

Step 5: (Tri-Gear Only) Use a step drill to enlarge the #22 holes to 11/16 in the F-01484 Center Bottom Skin and F-01483-L & -R Forward Bottom Skins where indicated.

Step 6: (Tri-Gear Only) Remove clecos.

Step 7: (Tri-Gear Only) Cut out the rectangular area in the F-01483-L & -R Forward Bottom Skins using a die grinder.

Step 8: (Tri-Gear Only) Deburr the edges of the cutouts in the F-01483-L & -R Forward Bottom Skins.

Step 9: (Tri-Gear Only) Deburr the edges of the 11/16 hole in the forward bottom skins and in the center bottom skin.

Step 10: (Tail Dragger Only) Dimple the #40 holes in the F-01483-L & -R Forward Bottom Skins for the head of an AN426AD3 rivet where indicated.

Step 11: (Tail Dragger Only) Dimple the #40 holes in the F-01484 Center Bottom Skin for the head of an AN426AD3 rivet where indicated.

Step 12: (Tri-Gear Only) Final-Drill #27 the holes indicated in Figure 1.

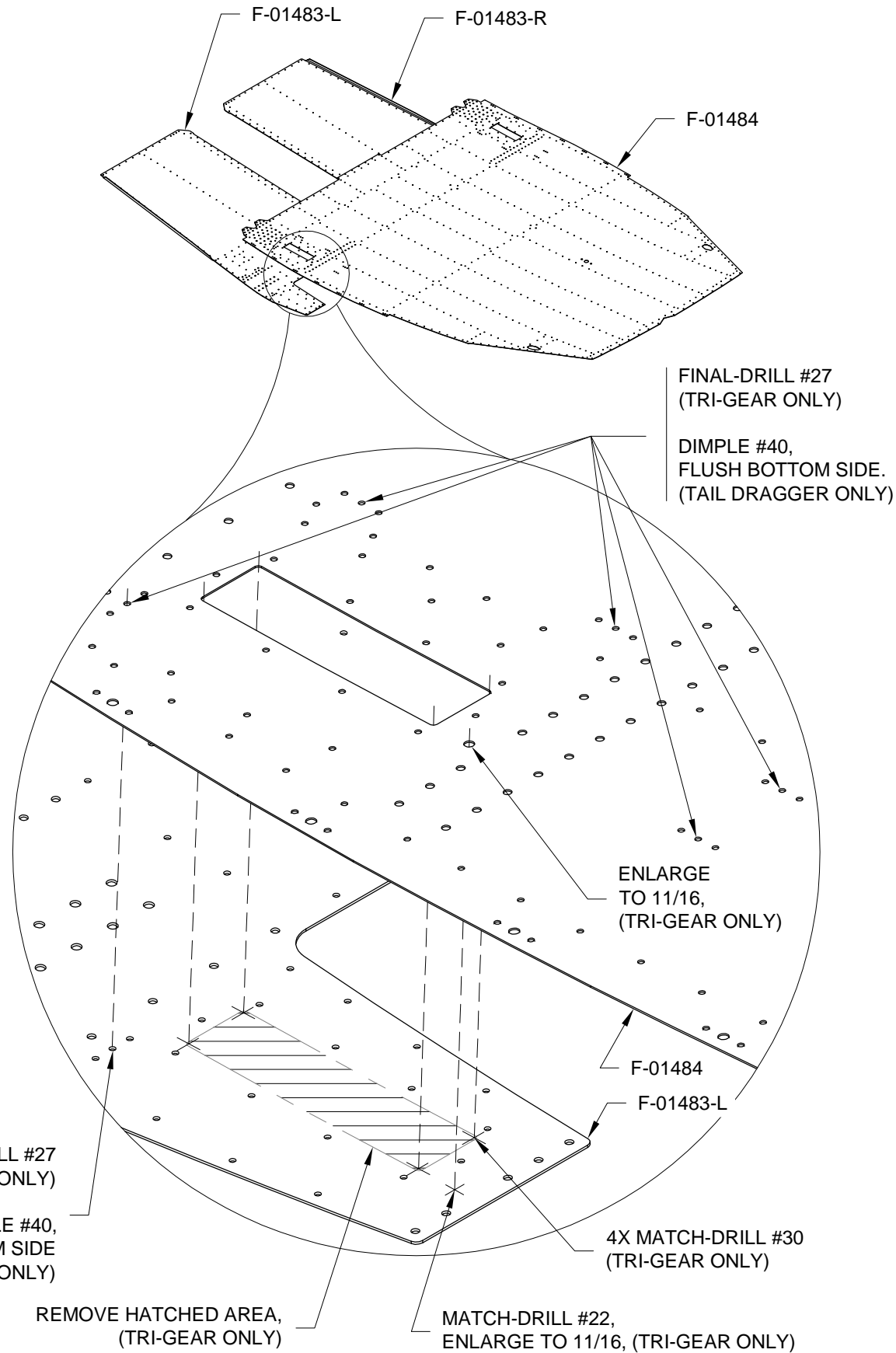


FIGURE 1: FORWARD & CENTER BOTTOM SKINS

NOTE: Taildragger builders: if installing the optional F-00018-L & -R Tail Dragger Steps, ignore the remaining steps on this page.

Step 13: (Tail Dragger Only) Cleco the F-01484A Cover Plates to the F-01484 Center Bottom Skin as shown in Figure 2.

Step 14: (Tail Dragger Only) Match-Drill the #40 hole into the F-01484 Center Bottom Skin using the cover plate as a guide. Remove and deburr.

Step 15: (Tail Dragger Only) Dimple the #40 holes in the cover plates forming left and right hand parts.

Step 16: (Tail Dragger Only) Dimple the #40 holes in the F-01484 Center Bottom Skin where indicated.

Step 17: (Tail Dragger Only) Rivet the F-01484A-L & -R Cover Plates to the F-01484 Center Bottom Skin only where indicated in Figure 2.

Step 18: (Tail Dragger Only) Fill two open holes with called out rivets where indicated in Figure 2.

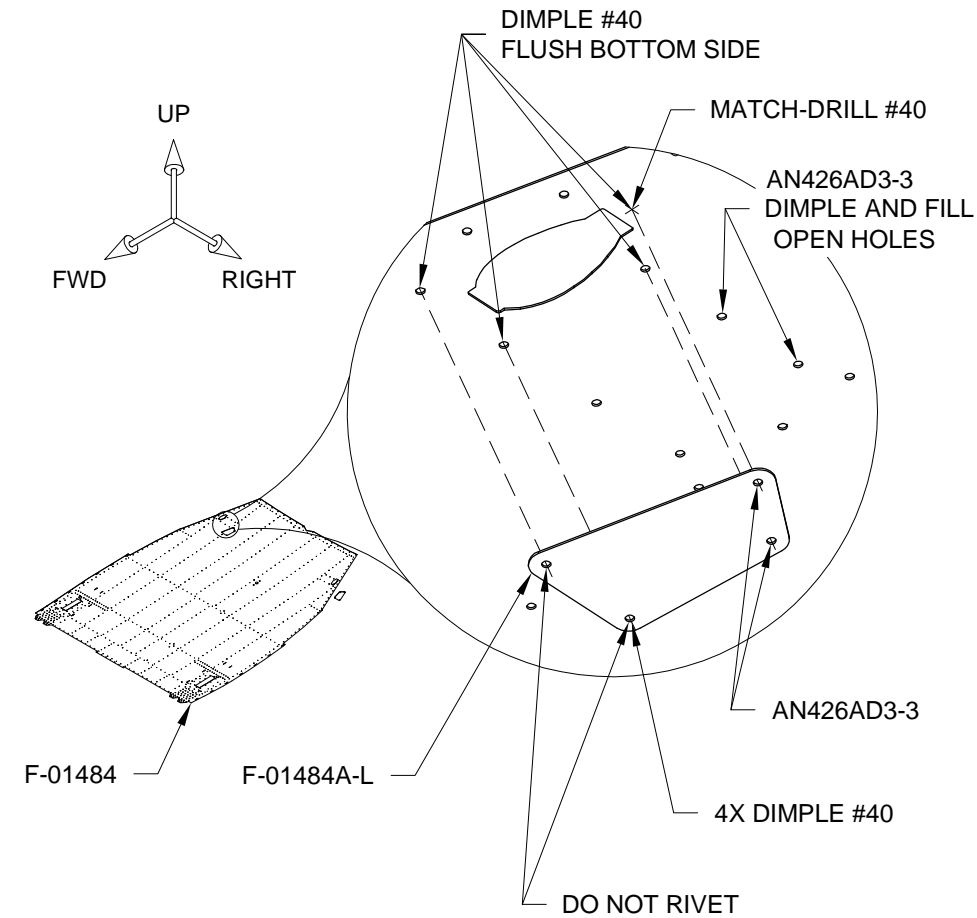
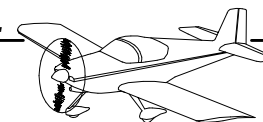


FIGURE 2: COVER PLATE INSTALLATION (TAIL DRAGGER ONLY)



NOTE: The two F-01443 Center Section Lower Doublers are countersunk on opposite sides, forming left-hand and right-hand parts. Call-outs on this page are mirrored about the aircraft centerline.

Refer to Figure 1 for the following steps.

Step 1: Cleco the F-01443 Center Section Lower Doublers back to back (for additional pilot support) then machine countersink for a dimpled .025 skin.

Step 2: Separate the F-14140 Skin Stiffeners as shown.

Step 3: Dimple the #40 holes in the F-14140 Skin Stiffeners.

Step 4: (Tri-Gear Only) Dimple the nutplates.

Step 5: Final-Drill #19 the 14 screw holes in the sides of the F-01484 Center Bottom Skin as shown and carefully deburr both sides.

Step 6: Use a step drill to enlarge the holes #40 hole called-out in the right detail view in Figure 1.

Step 7: Final-Drill #19 the two holes called out in the right detail view in Figure 1.

Step 8: Break the aft edge of the F-01484 Center Bottom Skin upward as shown in Figure 1.

Step 9: Dimple the #30 and #40 holes in the F-01484 Center Bottom Skin flush on the bottom side except where noted otherwise.

Step 10: (Tri-Gear Only) Rivet the nutplates to the F-01484 Center Bottom Skin.

Step 11: (Tail Dragger Only) Fill the nutplate holes in the F-01484 Center Bottom Skin with rivets.

Step 12: Back rivet the F-14140 Skin Stiffeners to the F-01484 Center Bottom Skin.

Step 13: Back rivet the F-01443-L & -R Center Section Lower Doublers to the F-01484 Center Bottom Skin.

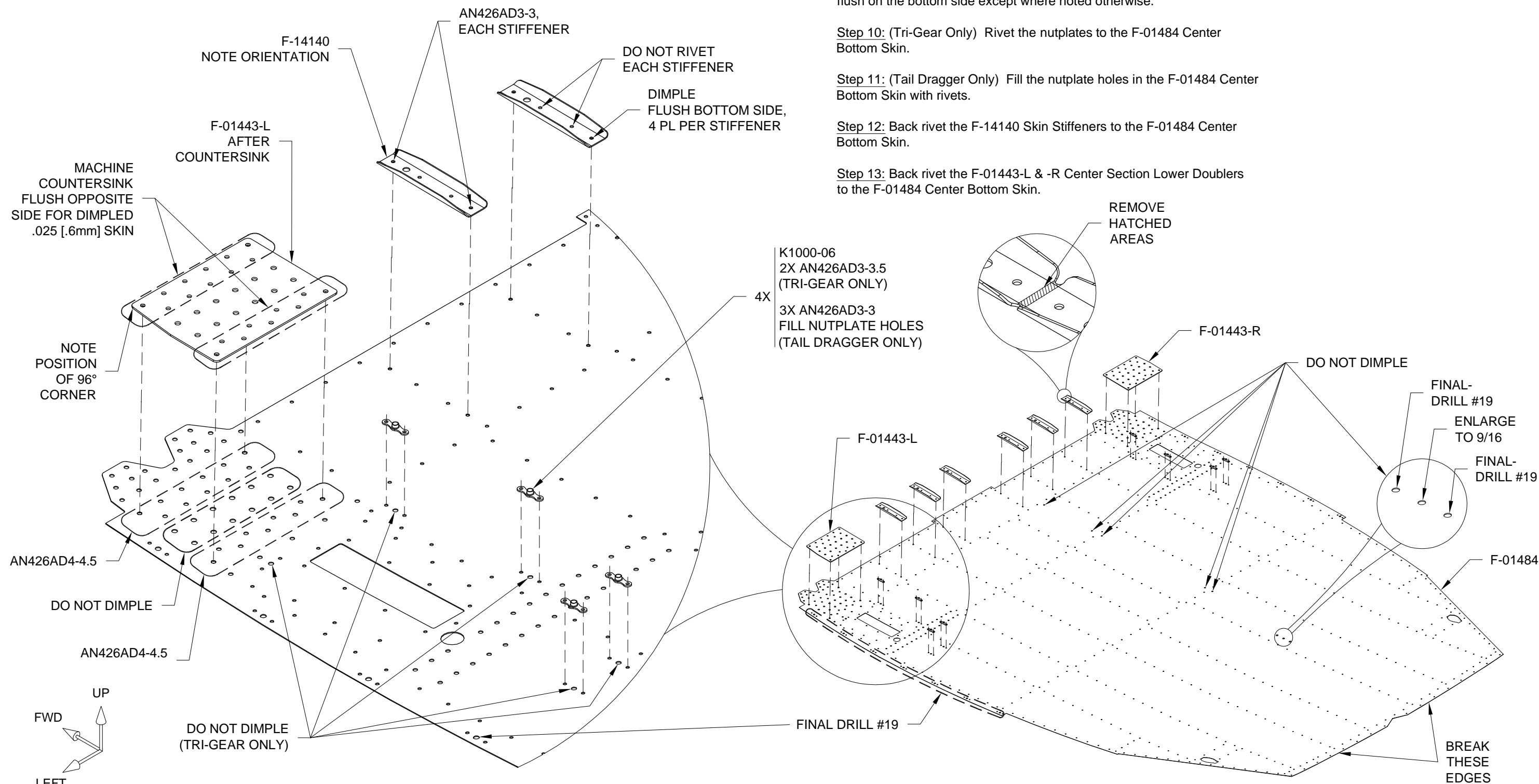
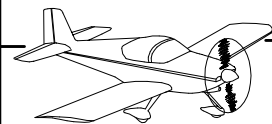


FIGURE 1: RIVET DOUBLERS & STIFFENERS



Step 1: Separate the F-01415A and F-01416B Seat Rib Angles and the F-01448C Gear Brace Bracket as shown in Figure 1.

Step 2: Dimple the #30 holes in the F-01448C Gear Brace Brackets as shown in Figure 1.

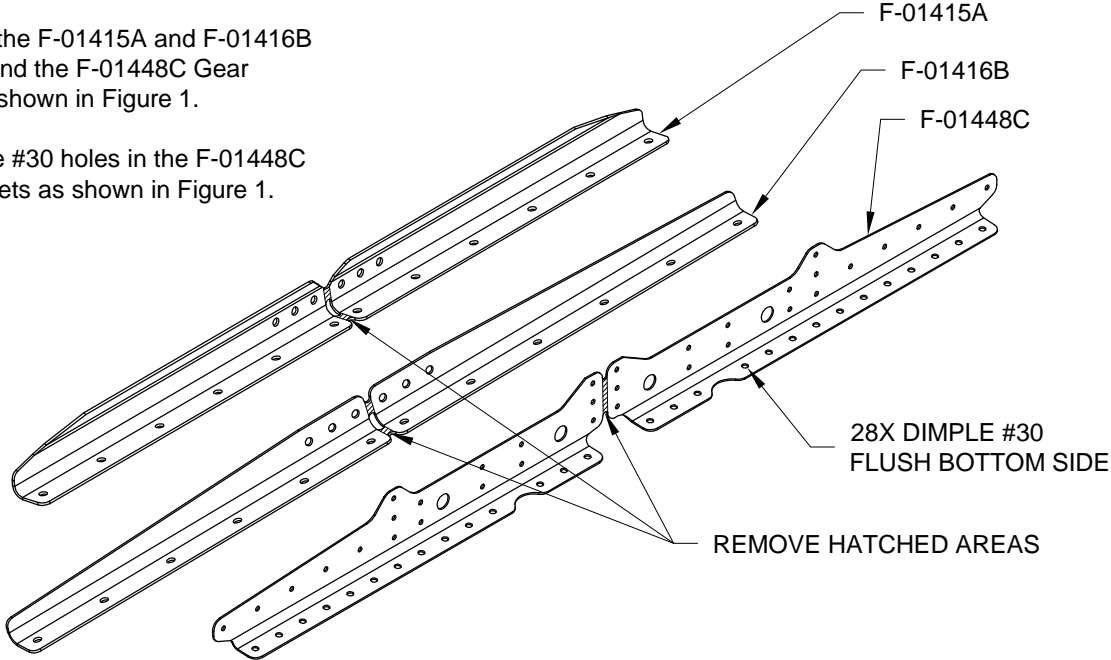


FIGURE 1: SEPARATE & DIMPLE PARTS

Step 3: Dimple only the called out #30 and #40 holes in the F-01448A Aft Gear Brace as shown in Figure 2.

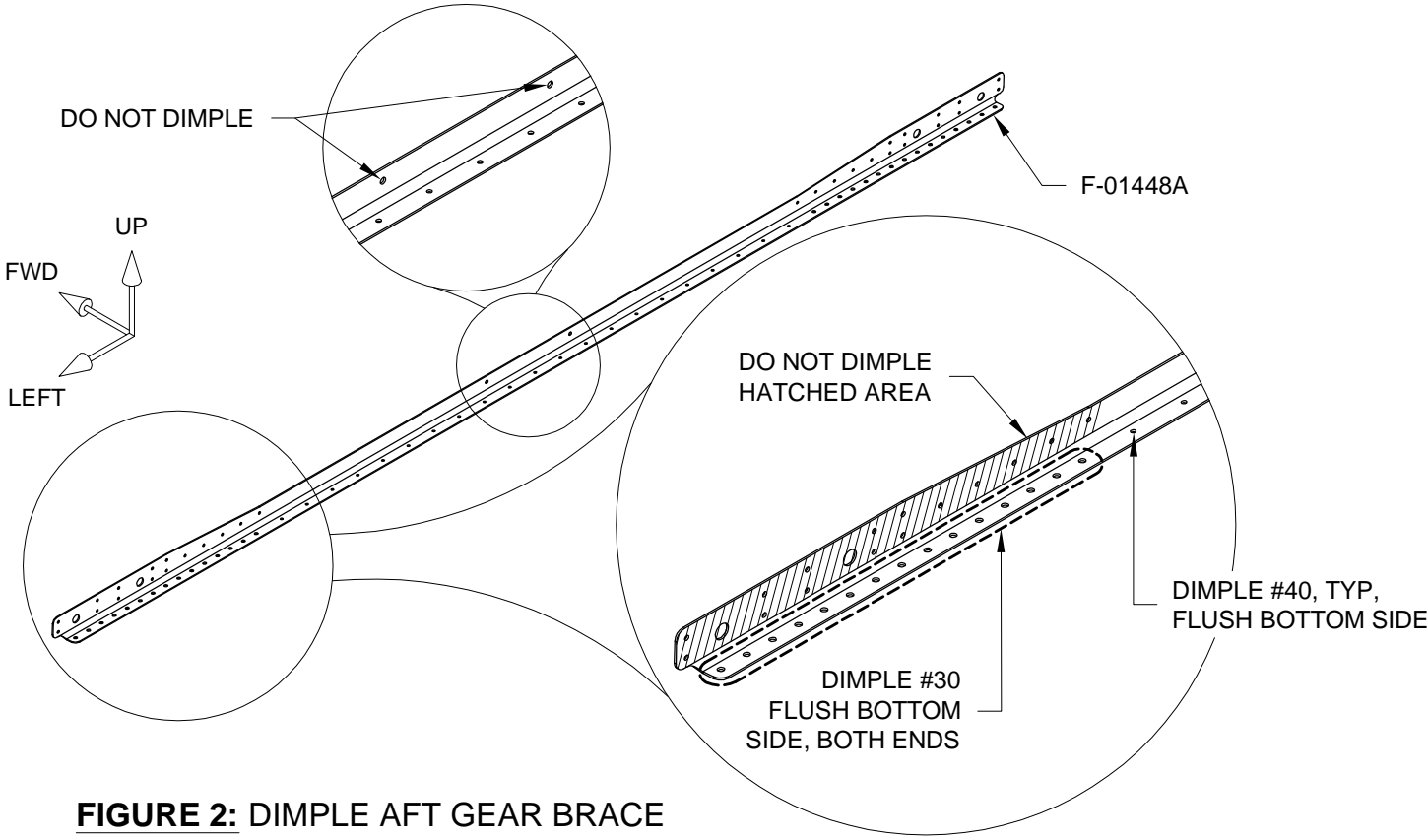


FIGURE 2: DIMPLE AFT GEAR BRACE

Step 4: Straighten the F-01448B Gear Brace Bars using a hammer and bench vise.

Step 5: Cleco together the F-01448C-L & -R Gear Brace Brackets, F-01448B Gear Brace Bars, and F-01448A Gear Brace Angle as shown in Figure 3.

Step 6: Tape over the eight final-drill 1/8 holes.

Step 7: Final-Drill #30 from the fwd side the holes indicated in the F-01448C Gear Brace Brackets, F-01448B Gear Brace Bars, and F-01448A Gear Brace Angle.

Step 8: Remove tape. Final-Drill 1/8 from the fwd side the holes called out in Figure 3. Drill completely through the stack-up of parts as in the previous step.

Step 9: Disassemble, clear away debris and deburr.

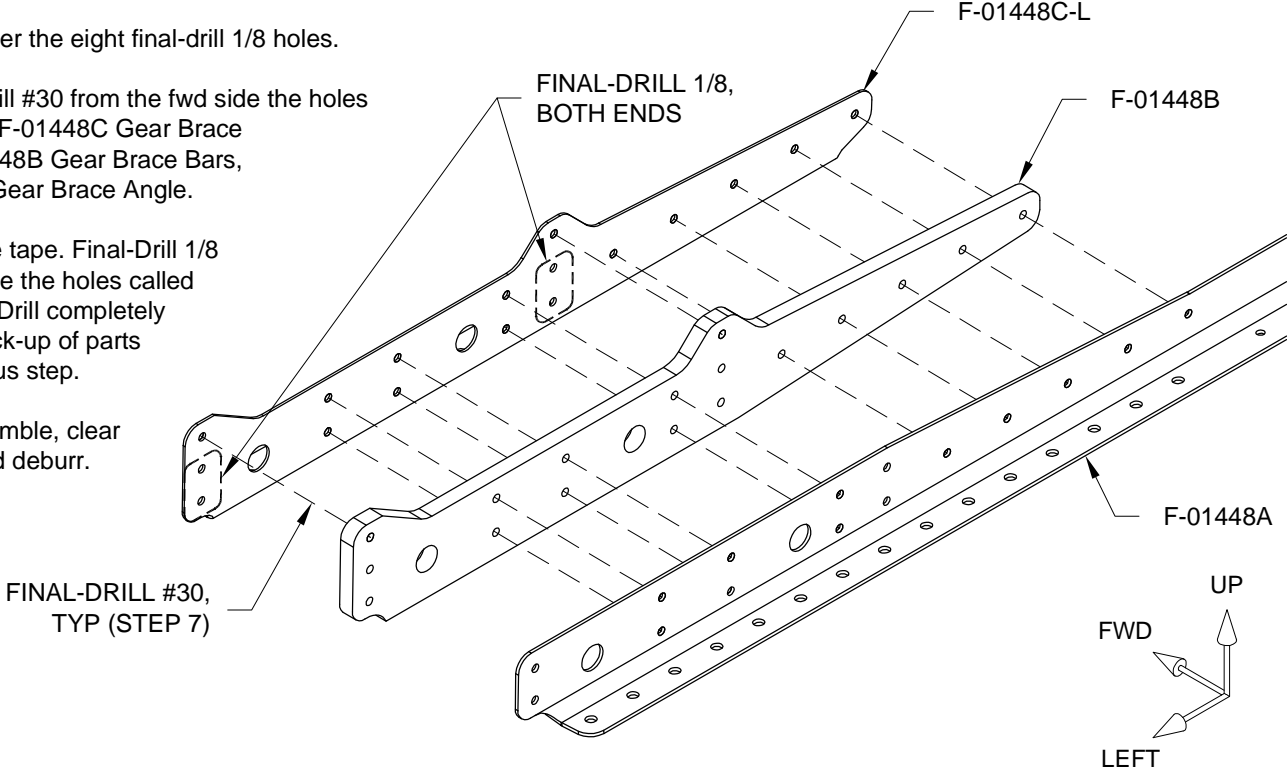


FIGURE 3: FINAL-DRILL

Step 10: Dimple the #30 holes in the F-01448C-L & -R Gear Brace Brackets as shown in Figure 4.

Step 11: Machine countersink the F-01448B Gear Brace Bars for the dimpled .032 [0.8 mm] F-01448C-L & -R Gear Brace Brackets.

Step 12: Prime the F-01448B Gear Brace Bars.

Step 13: Cleco together the F-01448C-L & -R Gear Brace Brackets, F-01448B Gear Brace Bars and the F-01448A Gear Brace Angle as shown in Figure 3 above.

Hereafter refer to as the Aft Gear Brace Assembly.

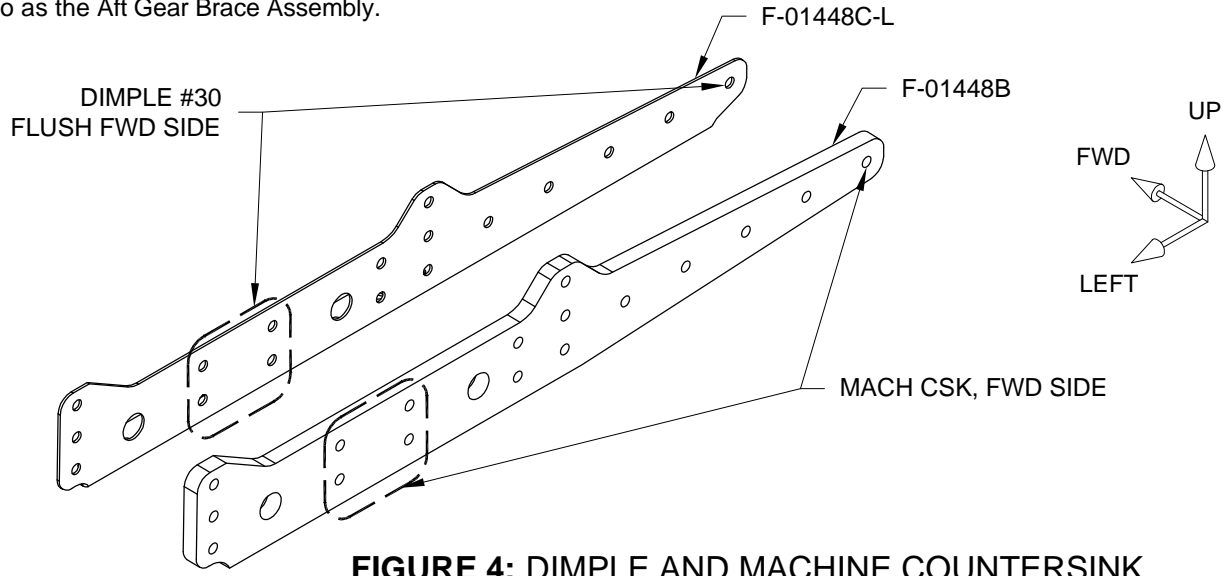
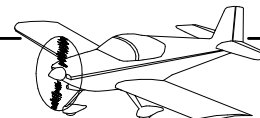


FIGURE 4: DIMPLE AND MACHINE COUNTERSINK



NOTE: Refer to Figure 1 for the following steps. Call-outs on this page are mirrored about the aircraft centerline.

Step 1: Cleco the F-01415A-L & -R Seat Rib Angles to the Aft Gear Brace Assembly.

Step 2: Set the initial angle of the F-01415A-L & -R Seat Rib Angles to Aft Gear Brace Assembly to the angle shown.

Step 3: Partially set the single rivet attaching the F-01415A-L & -R Seat Rib Angles to the Aft Gear Brace Assembly so that the seat rib angles may still be rotated.

Step 4: Rivet together the Aft Gear Brace Assembly. See Figure 1 for exceptions.

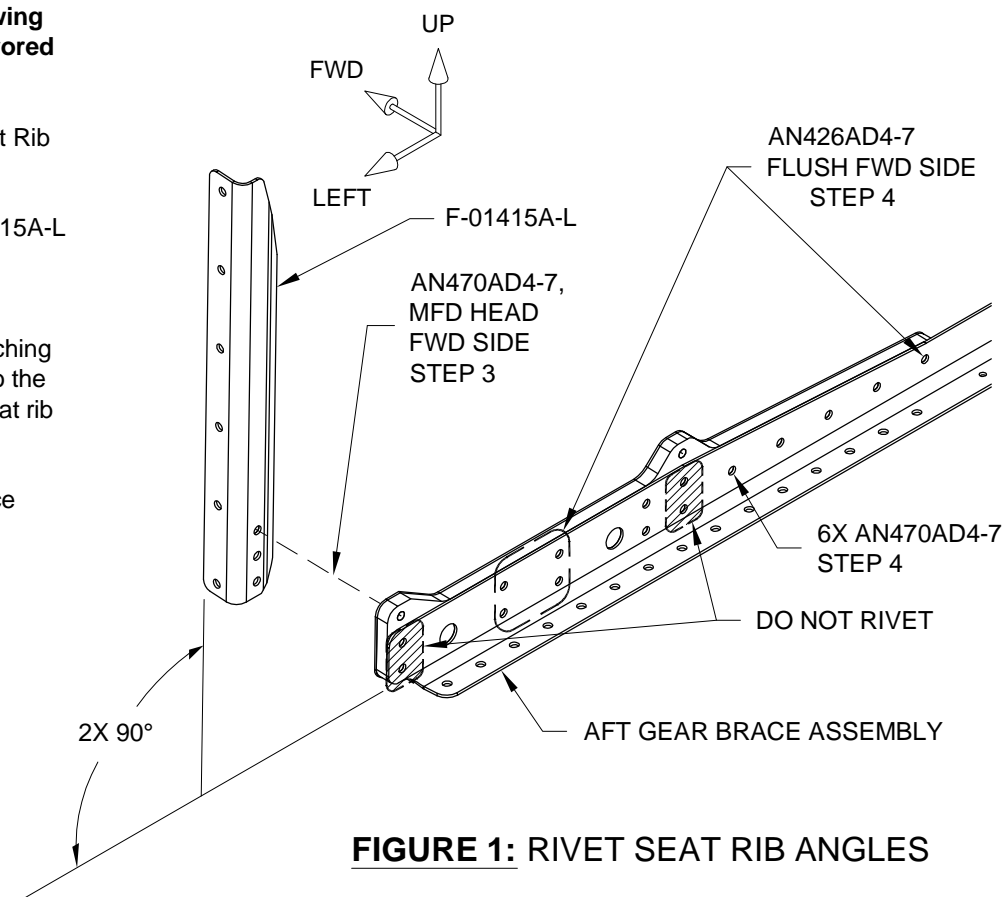


FIGURE 1: RIVET SEAT RIB ANGLES

NOTE: Refer to Figure 2 for the following steps. Call-outs are mirrored about the aircraft centerline.

Step 5: Check the angle of the F-01415A-L & -R Seat Rib Angles to the Aft Gear Brace Assembly as shown and adjust as necessary.

Step 6: Clamp the F-01415A-L & -R Seat Rib Angles securely to the Aft Gear Brace Assembly.

Step 7: Final-Drill #30 from the fwd side the 1/8 holes common to the F-01415A-L & -R Seat Rib Angles.

Step 8: Check the angles one final time. If adjustment is required clamp and run a #30 drill through once again.

Step 9: Rivet the F-01415A-L & -R Seat Rib Angles to the Aft Gear Brace Assembly.

Step 10: Ream the indicated holes in the Aft Gear Brace Assembly from the fwd side.

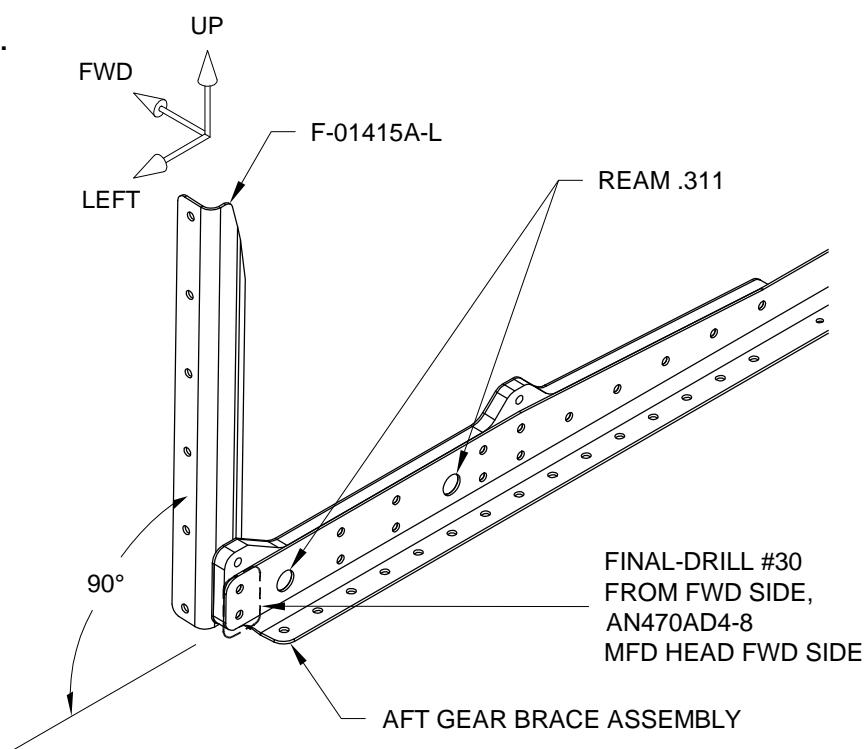


FIGURE 2: FINAL GEAR BRACE ASSEMBLY

NOTE: Refer to Figure 3 for the following steps. Call-outs are mirrored about the aircraft centerline.

Step 11: Cleco the Aft Gear Brace Assembly to the F-01484 Center Bottom Skin as shown in Figure 3.

Step 12: Back rivet the Aft Gear Brace Assembly to the F-01484 Center Bottom Skin. See Figure 3 for rivet call-outs and exceptions.

Step 13: Cleco the F-01416B-L & -R Seat Rib Angles to the Aft Gear Brace Assembly.

Step 14: Partially set the single rivet attaching the F-01416B-L & -R Seat Rib Angles to the Aft Gear Brace Assembly so that the angles may still be rotated.

Step 15: Check that the F-01416B-L & -R Seat Rib Angles are parallel to the F-01415A-L Seat Rib Angles. Adjust as necessary.

Step 16: Clamp the F-01416B-L & -R Seat Rib Angle securely to the Aft Gear Brace Assembly.

Step 17: Final-Drill #30 from the forward side the 1/8 holes common to the F-01416B-L & -R Seat Rib Angles.

Step 18: Check the angles one final time. If adjustment is required clamp and run a #30 drill through once again.

Step 19: Rivet the F-01416B-L & -R Seat Rib Angles to the Aft Gear Brace Assembly.

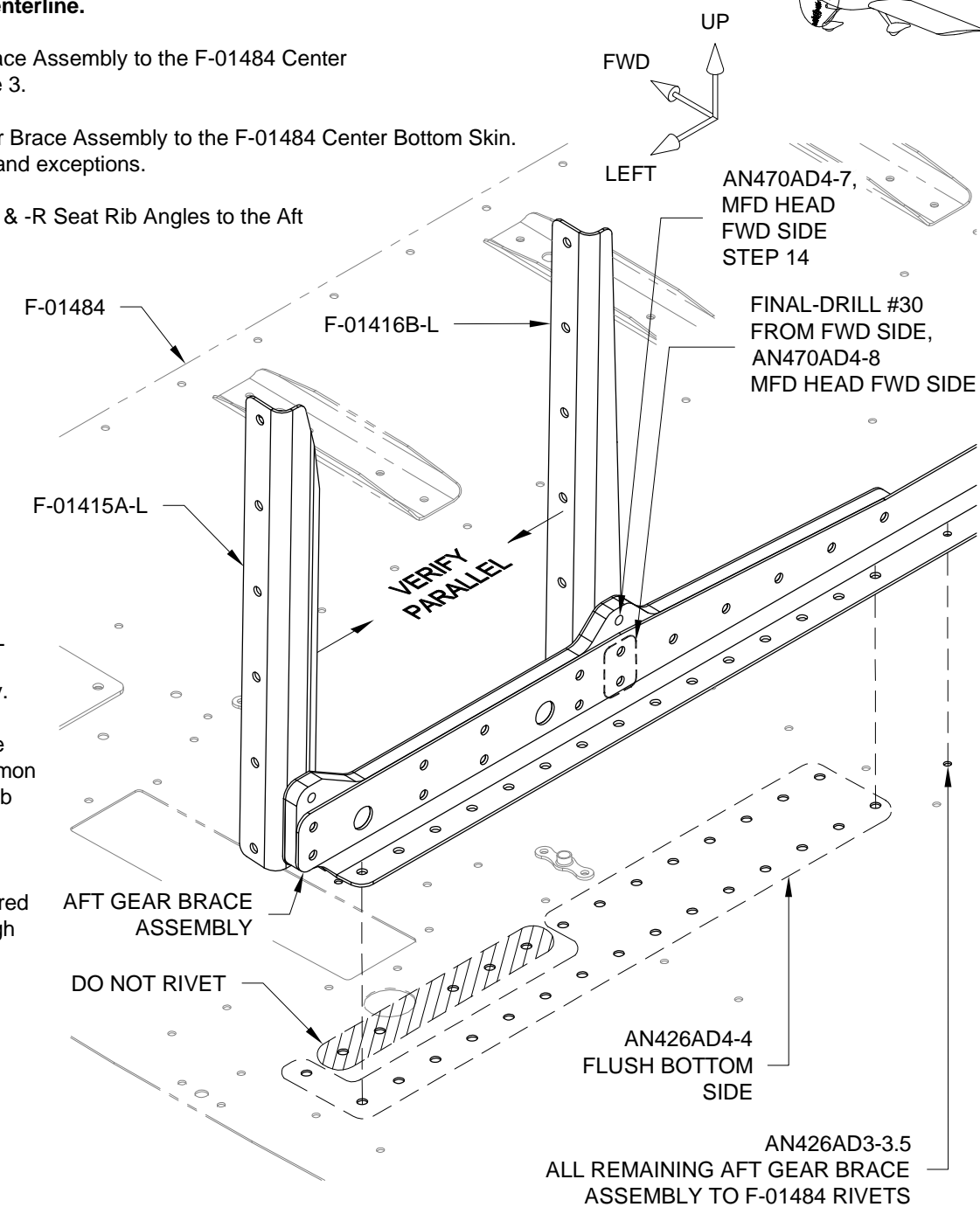
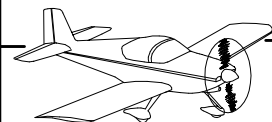


FIGURE 3: RIVET AFT GEAR BRACE ASSEMBLY TO SKIN



NOTE: The 'DO NOT RIVET' areas noted in Figure 1 apply throughout the remainder of this section.

Step 1: Cleco the F-01404 Bulkhead to the F-01484 Center Bottom Skin. See Figure 1.

Step 2: Rivet the five holes common to the F-01484 Center Bottom Skin and F-01404 Bulkhead bottom flange as shown in Figure 1.

Step 3: Cleco and rivet the F-01484 Center Bottom Skin to the Crotch Strap Assemblies, Seat Ribs, Inboard Seat Ribs, lower flange of the F-01405 Bulkhead Assembly and to the F-01448 Aft Gear Brace Assembly. See Figure 1 for rivet call-outs and exceptions.

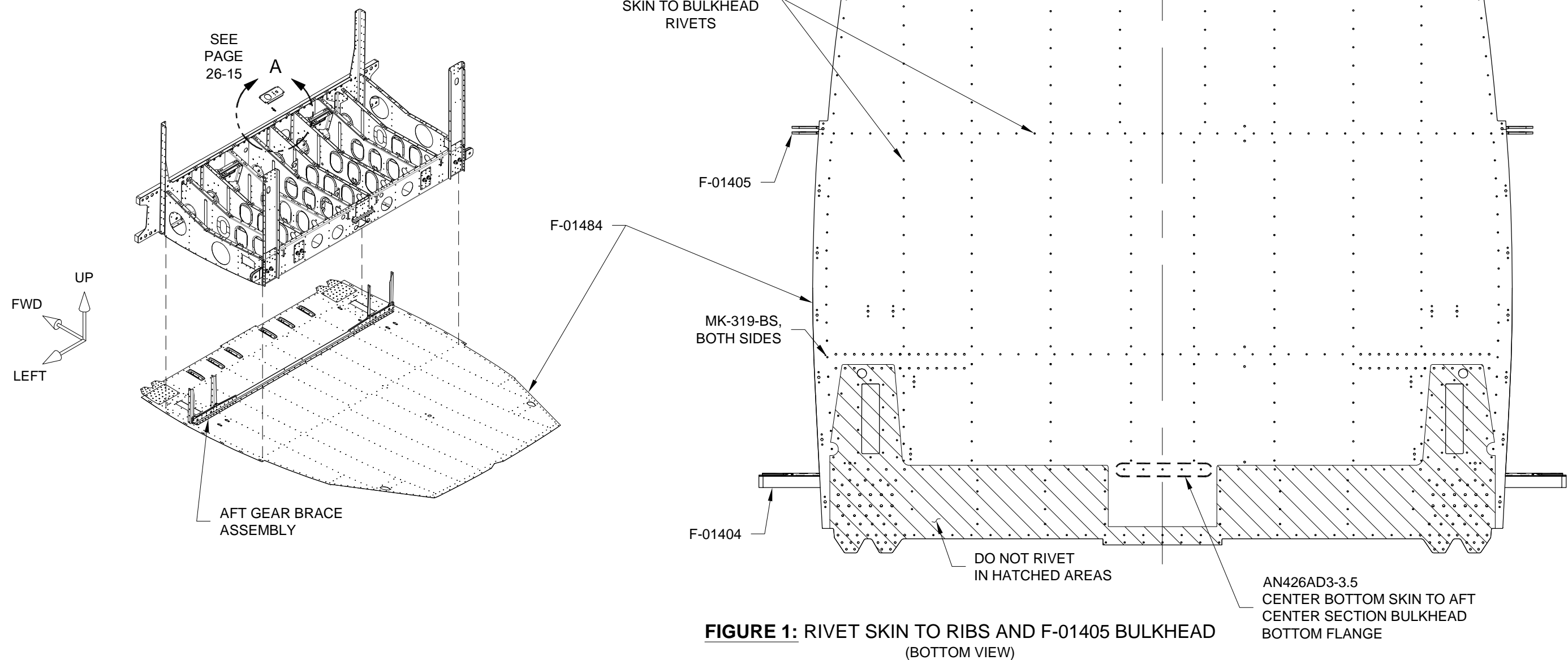
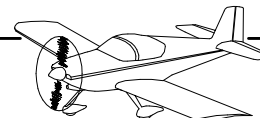


FIGURE 1: RIVET SKIN TO RIBS AND F-01405 BULKHEAD
(BOTTOM VIEW)

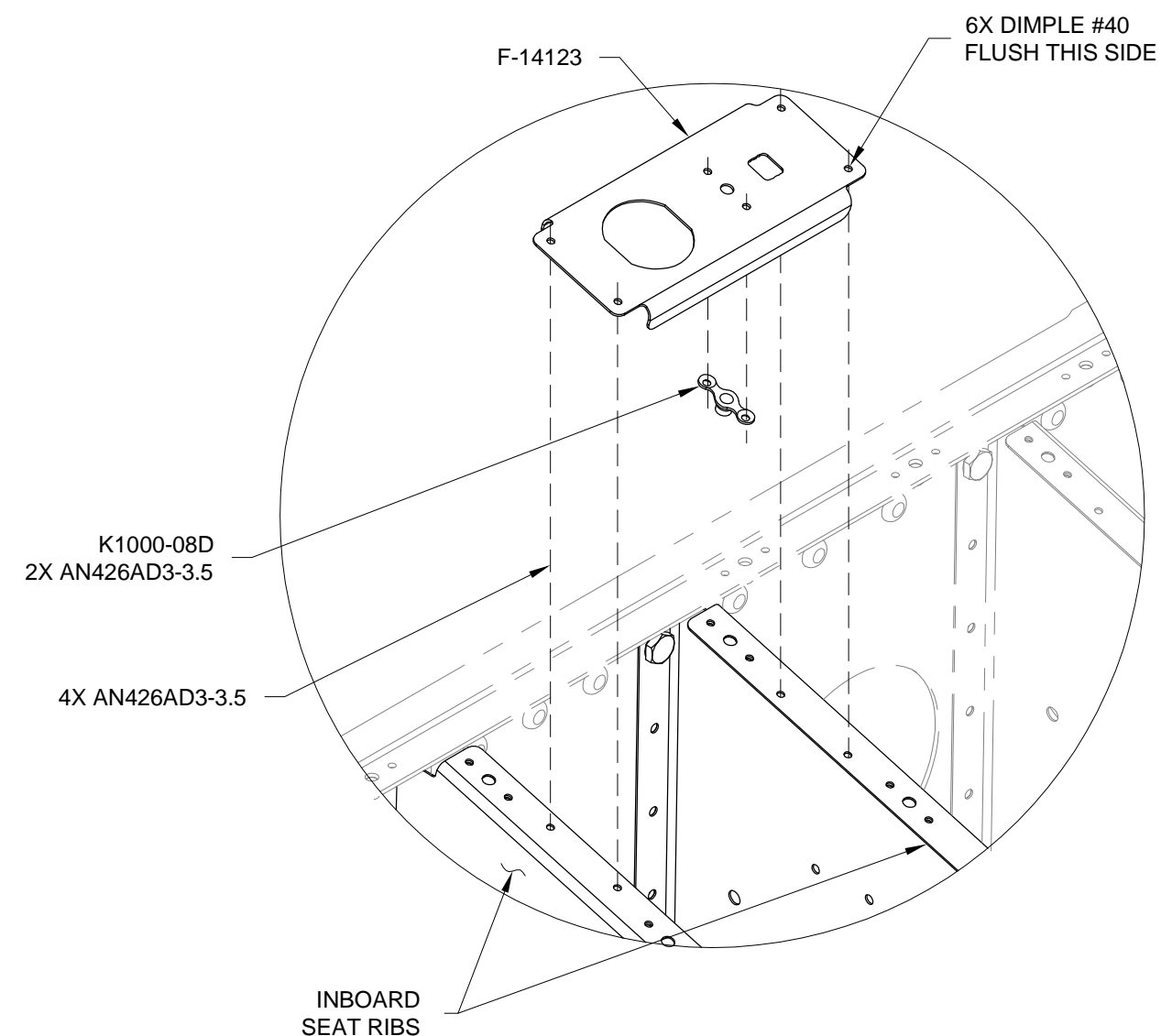


Refer to Detail A for the following steps.

Step 1: Dimple the six #40 holes on the F-14123 Power Outlet Bracket.

Step 2: Rivet the nutplate to the bottom surface of the F-14123 Power Outlet Bracket.

Step 3: Rivet the F-14123 Power Outlet Bracket to the Inboard Seat Ribs.



DETAIL A: POWER OUTLET BRACKET INSTALLATION
(SEE PAGE 26-14, FIGURE 1)

Step 4: Rivet the F-01416B-R Seat Rib Angle to the F-01416-R Seat Rib as shown in Figure 1.

Step 5: Repeat Step 4 for the left side.

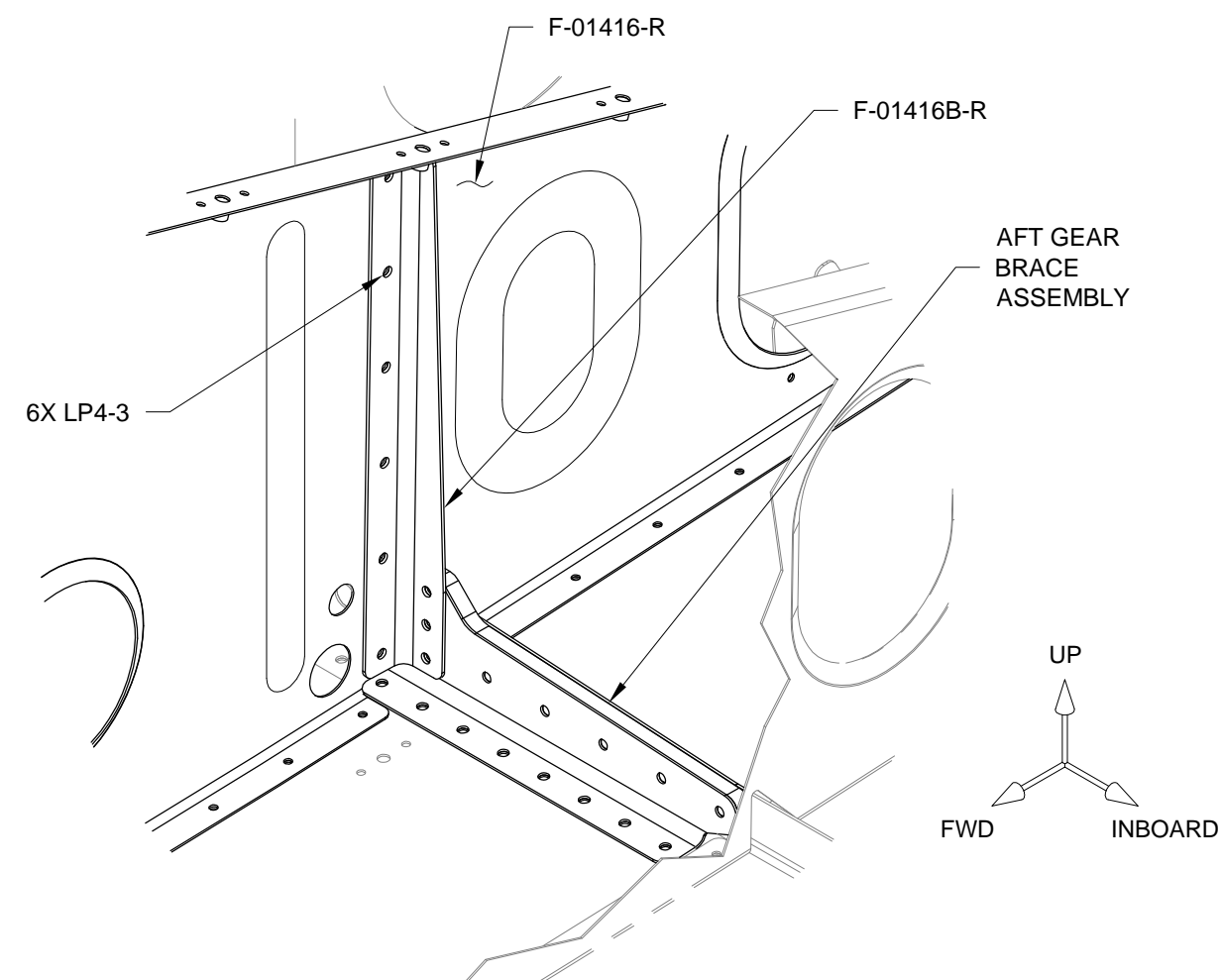
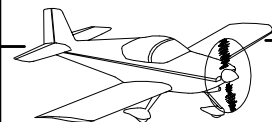


FIGURE 1: RIVET AFT GEAR BRACE ASSEMBLY TO RIBS
(RIGHT SIDE SHOWN)



Refer to Figure 1 for the following steps.

Step 1: Dimple the #40 holes in the lower flanges of the baggage ribs shown.

Step 2: Dimple the #40 holes in the webs of the F-01423A-L & -R Outbd Baggage Rib.

Step 3: Dimple the #40 holes in the joggled forward flange of the F-01423A-L & -R Outbd Seat Ribs.

Step 4: Dimple the #40 holes in the joggled aft flange of the F-01423A-L & -R Outbd Seat Ribs.

Step 5: Dimple the #30 holes in the joggled forward flange of the F-01423A-L & -R Outbd Seat Ribs. Note exceptions.

Step 6: Dimple the #30 holes on the top flange of the F-01427-L & -R Baggage Ribs except as shown.

Step 7: Dimple the #40 holes in the top flange of the F-01427-L & -R Baggage Ribs.

Step 8: Dimple the #40 holes in the top flanges of the F-01423B-L & -R, F-01424-L & -R, and F-01425-L & -R Baggage Ribs where indicated.

Step 9: Flute the lower aft flanges of the Baggage Ribs as required.

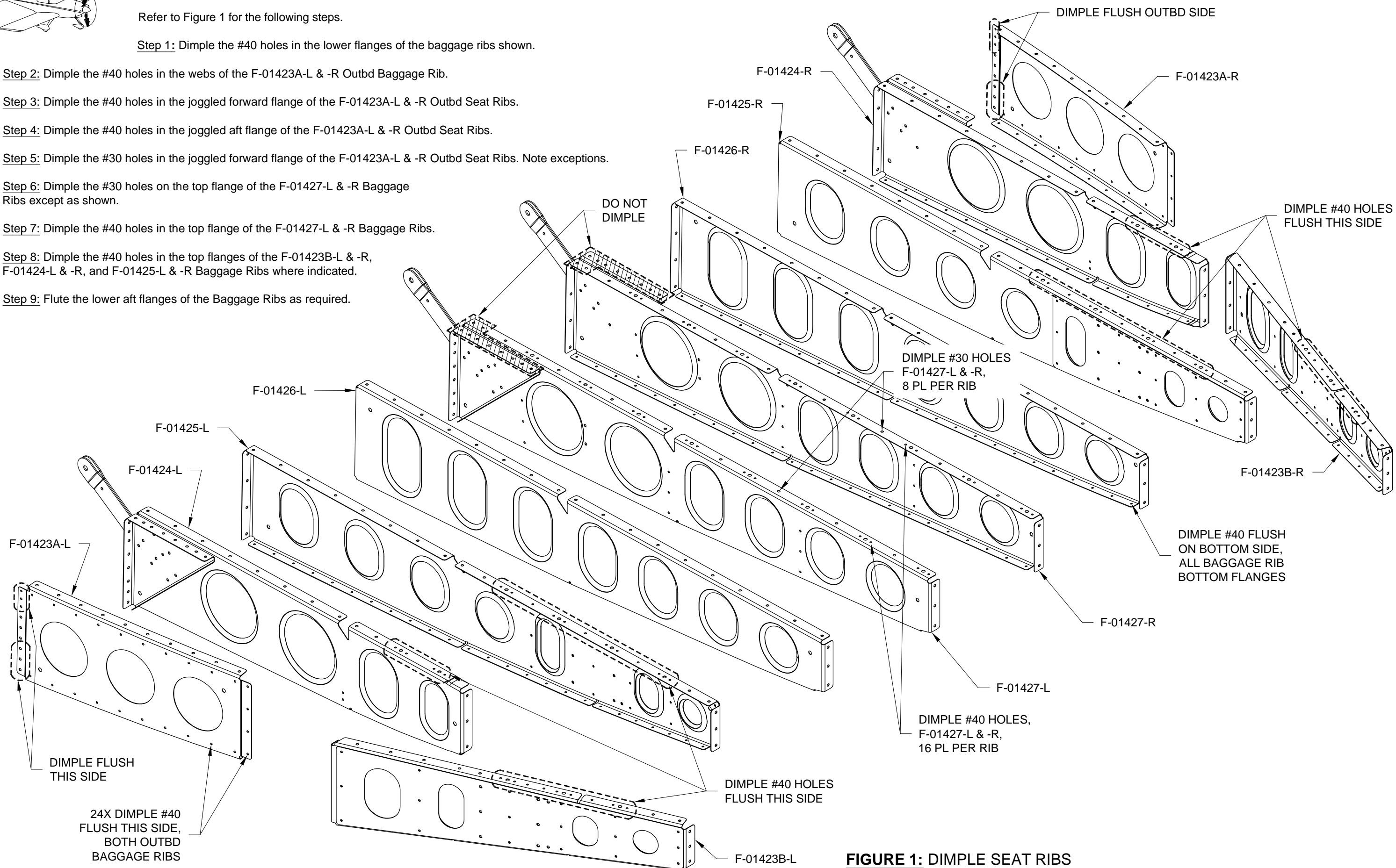
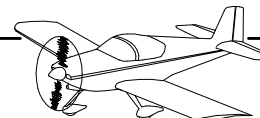


FIGURE 1: DIMPLE SEAT RIBS



NOTE: Taildragger builders may choose to perform steps marked "Tri-Gear Only" on this page to allow for installation of the optional F-00018-L & -R Tail Dragger Steps.

Step 1: (Tri-Gear Only) Separate the F-14145 Step Attach Angles as shown in Figure 1.

Step 2: (Tri-Gear Only) Dimple the #40 holes in the step attach angles as shown in Figure 1.

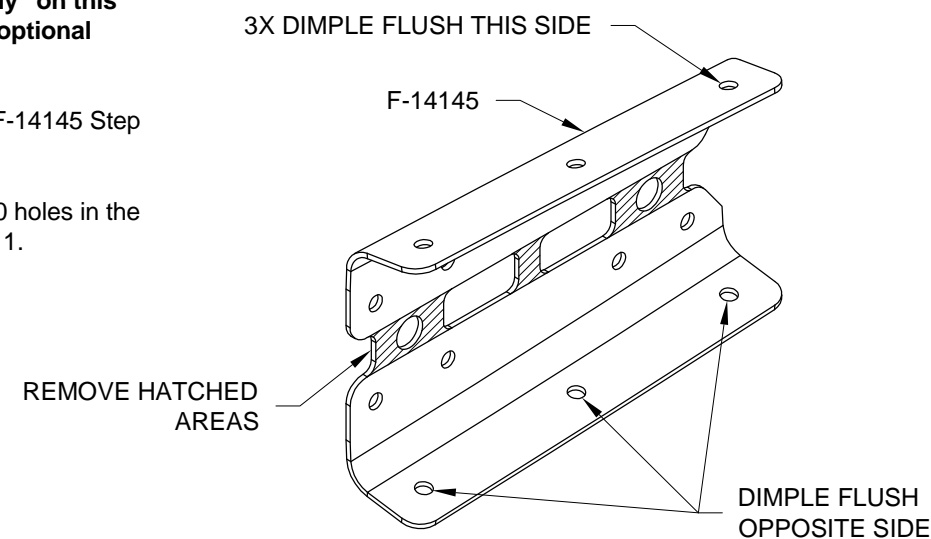


FIGURE 1: STEP ATTACH ANGLES

Step 6: (Tri-Gear Only) Cleco the F-00016-L Step Attach Weldment to the F-01423B-L Outboard Baggage Rib as shown in Figure 3.

Step 7: (Tri-Gear Only) Final-Drill #30 the holes in the F-00016-L as shown in Figure 3.

Step 8: (Tri-Gear Only) Rivet the left and right step attach weldments to the left and right outboard baggage ribs as shown in Figure 3.

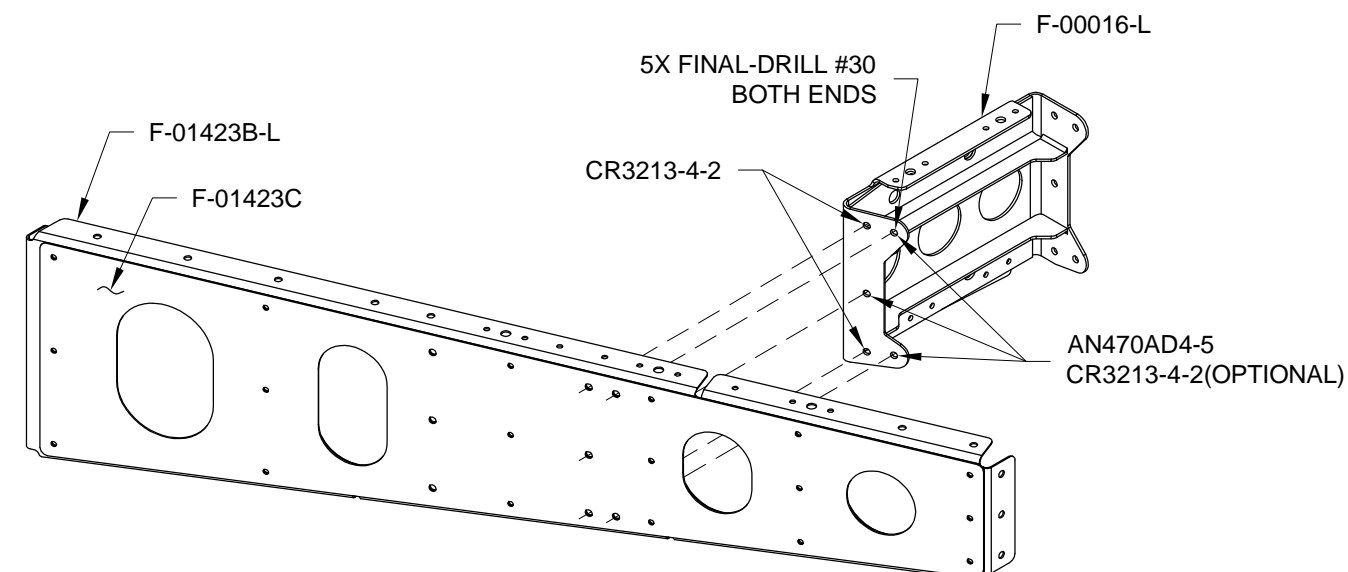


FIGURE 3: LEFT STEP ATTACH ASSEMBLY

Step 3: (Tri-Gear Only) Final-Drill 1/4 the holes in the F-00016-L & -R Step Attach Weldments as shown in Figure 2.

Step 4: (Tri-Gear Only) Machine countersink the holes in the F-00016-L & -R Step Attach Weldments to fit the head of an AN426AD3 rivet. See Figure 2.

Step 5: (Tri-Gear Only) Rivet the F-14145-L & -R Step Attach Angles to the F-00016-L & -R Step Attach Weldments. Since the AN470AD3-5 is a bit long for this application 1/32 [0.8 mm] may be removed before installation.

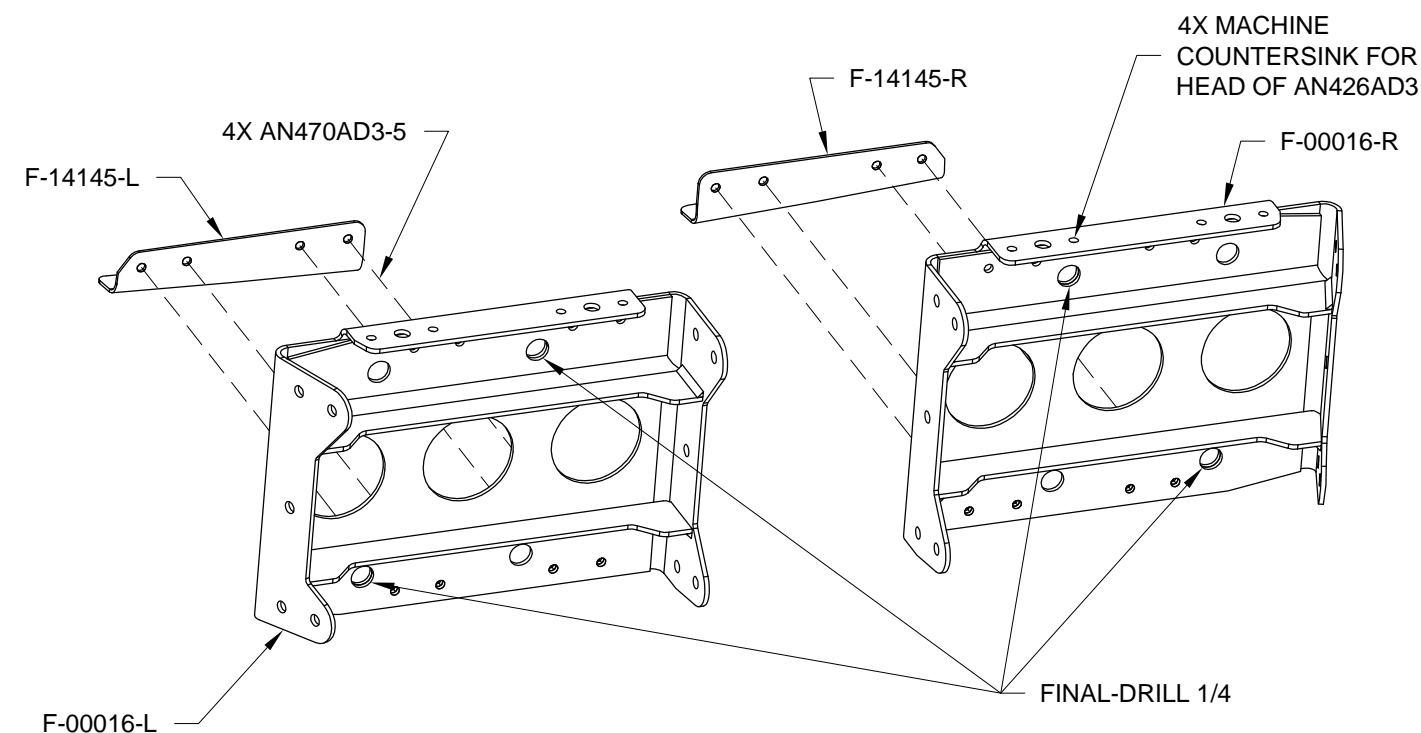
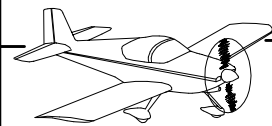


FIGURE 2: STEP ATTACH WELDMENTS



Step 1: Separate the F-01495AB Step Attach Rib Doubler as shown in Figure 1.

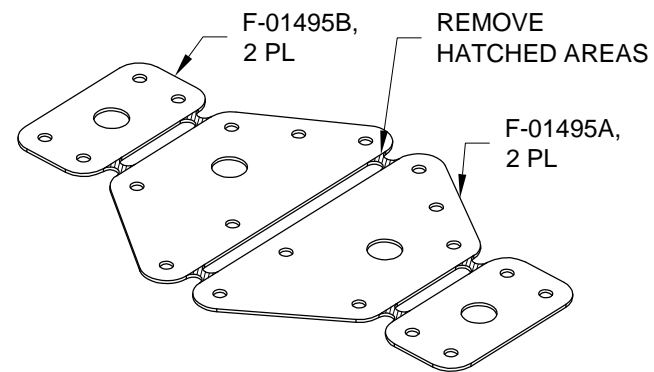


FIGURE 1: STEP ATTACH RIB DOUBLERS

Step 2: Rivet the F-01495A and F-01495B Step Attach Rib Doublers to the F-01495-L & -R Step Attach Ribs as shown in Figure 2.

Step 3: Dimple the #40 holes in the upper and lower flanges of the F-01495-L & -R Step Attach Ribs.

Step 4: Rivet the nutplates to the step attach ribs as shown.

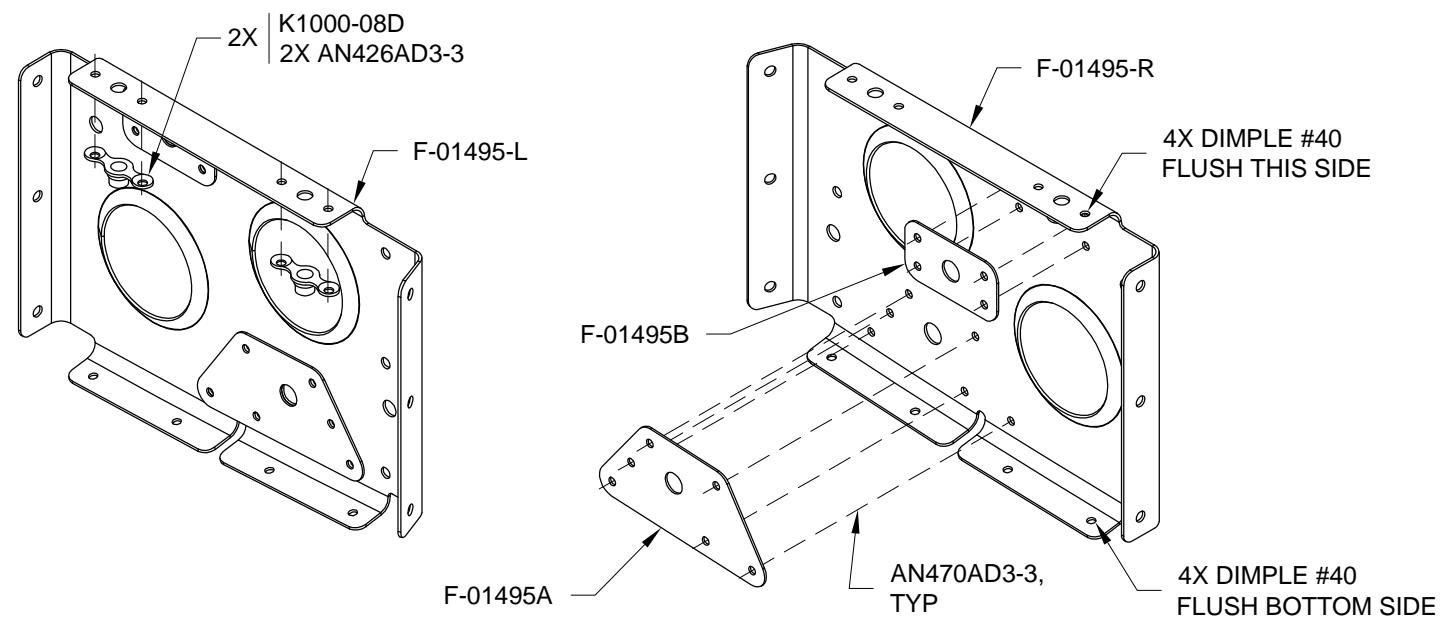


FIGURE 2: RIVET RIB DOUBLERS & NUTPLATES

Step 5: Rivet the F-01495-L & -R Step Attach Ribs to the F-01423B-L & -R Outbd Baggage Rib as shown in Figure 3.

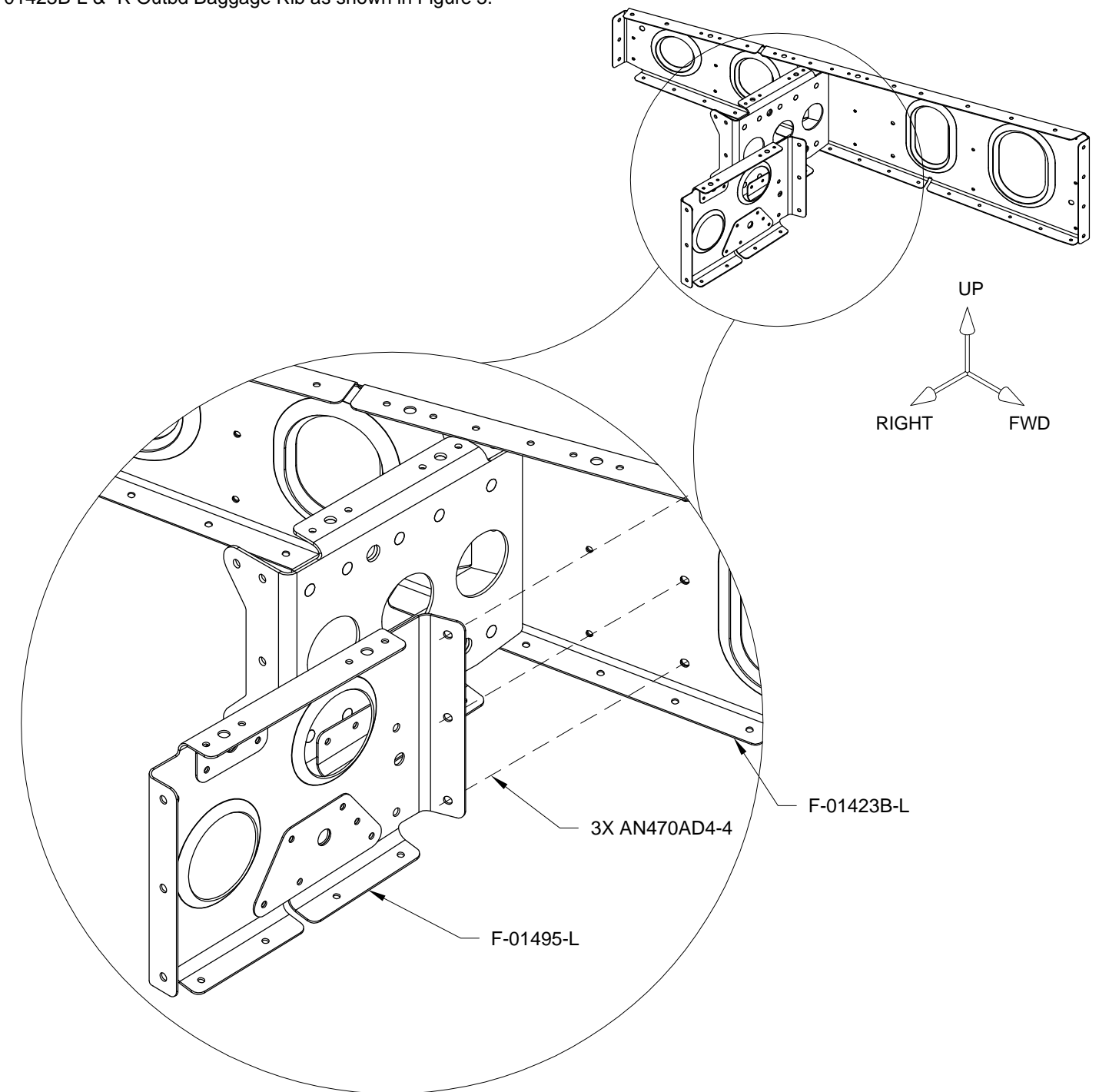
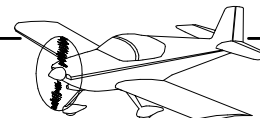


FIGURE 3: STEP ATTACH RIB INSTALLATION



Step 1: Separate the F-01458AB Side Frame Bracket as shown in Figure 1.

Step 2: Dimple the #40 holes in the Side Frame Brackets as shown in Figure 1.

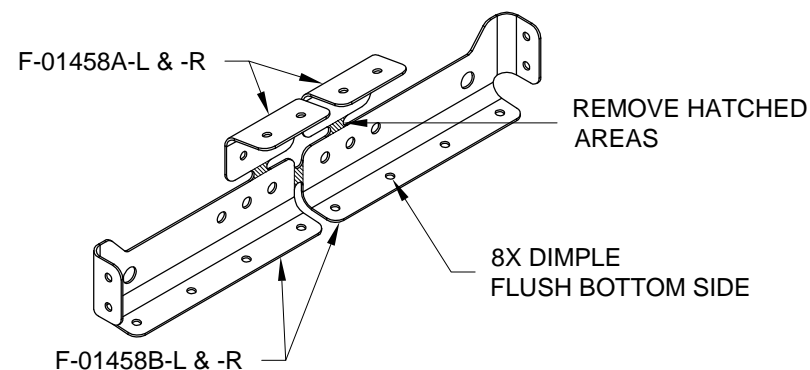


FIGURE 1: SIDE FRAME BRACKETS

Step 3: Separate the F-01458-L & -R Side Frames.

Step 4: Dimple the #40 holes in the outboard flanges of the F-01458-L & -R Side Frames as shown in Figure 2.

Step 5: Rivet the Side Frame Clips to the Side Frames as shown in Figure 2.

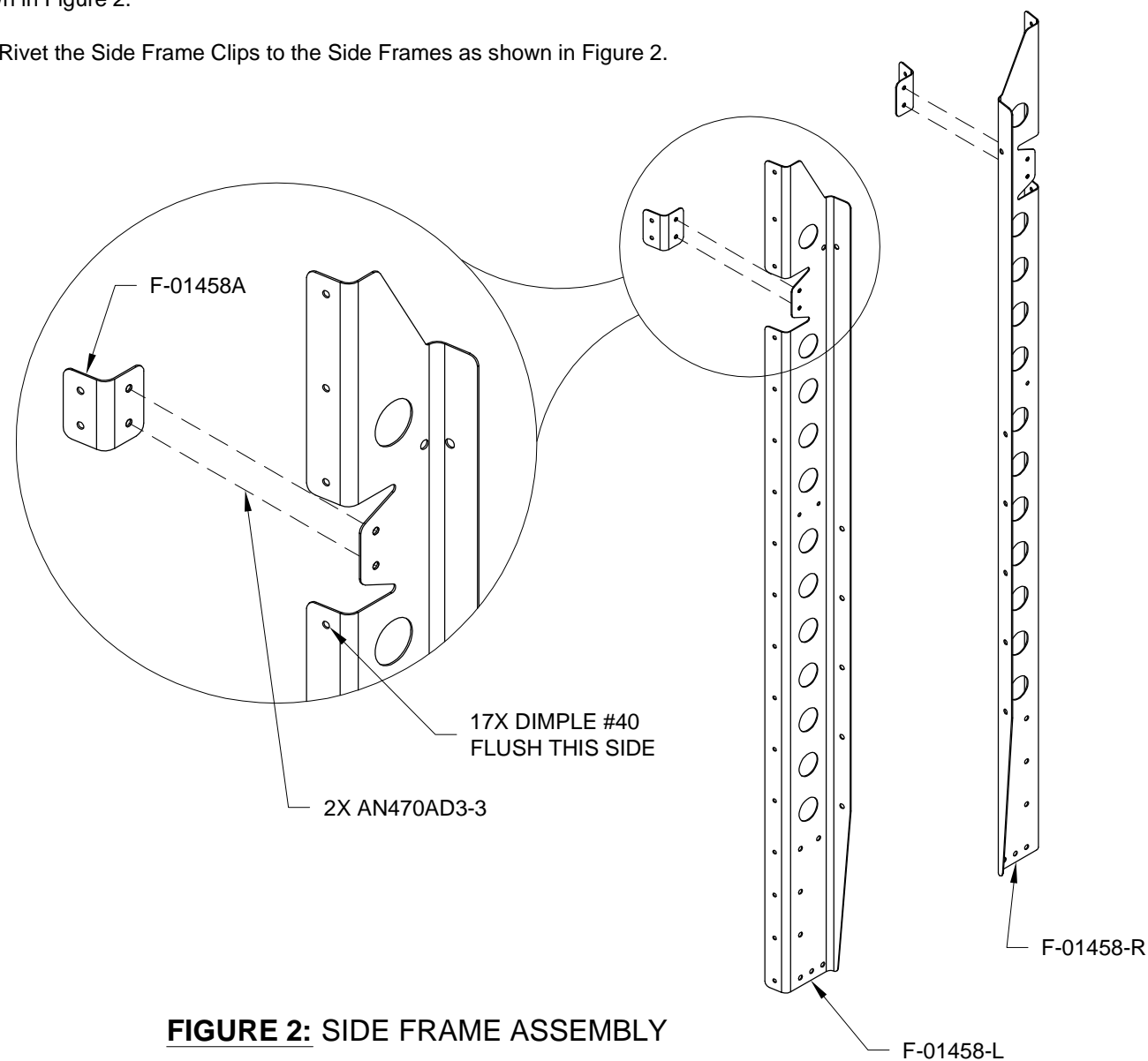


FIGURE 2: SIDE FRAME ASSEMBLY

Step 6: Rivet the Side Frame Assemblies and the F-01458B-L & -R Side Frame Brackets to the F-01423B-L & -R Outbd Baggage Rib as shown in Figure 3.

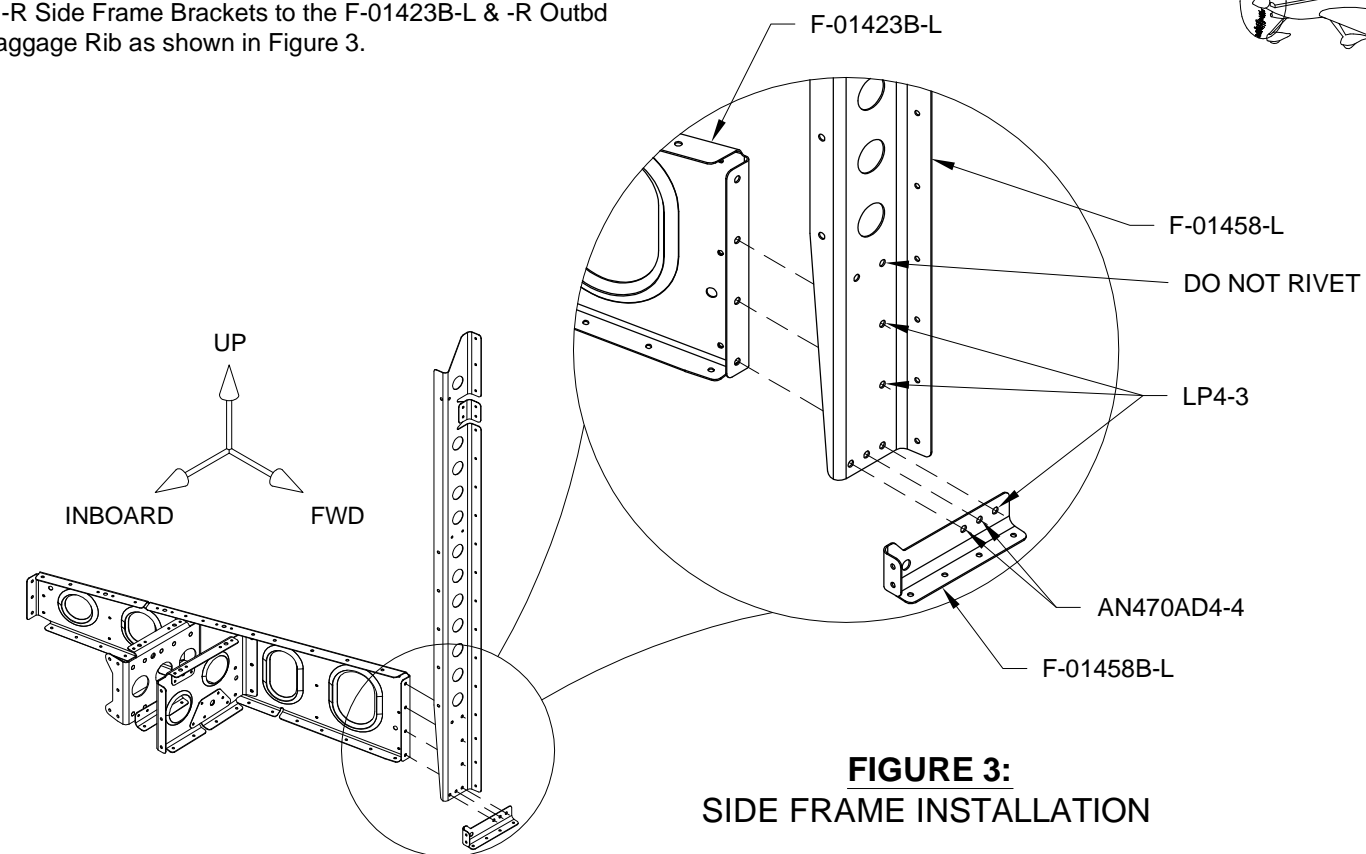


FIGURE 3: SIDE FRAME INSTALLATION

Step 7: Rivet the F-01424-L & -R Baggage Ribs to the F-01458B-L & -R Side Frame Brackets as shown Figure 4.

Step 8: Rivet the Baggage Ribs to the F-01495-L & -R Step Attach Ribs.

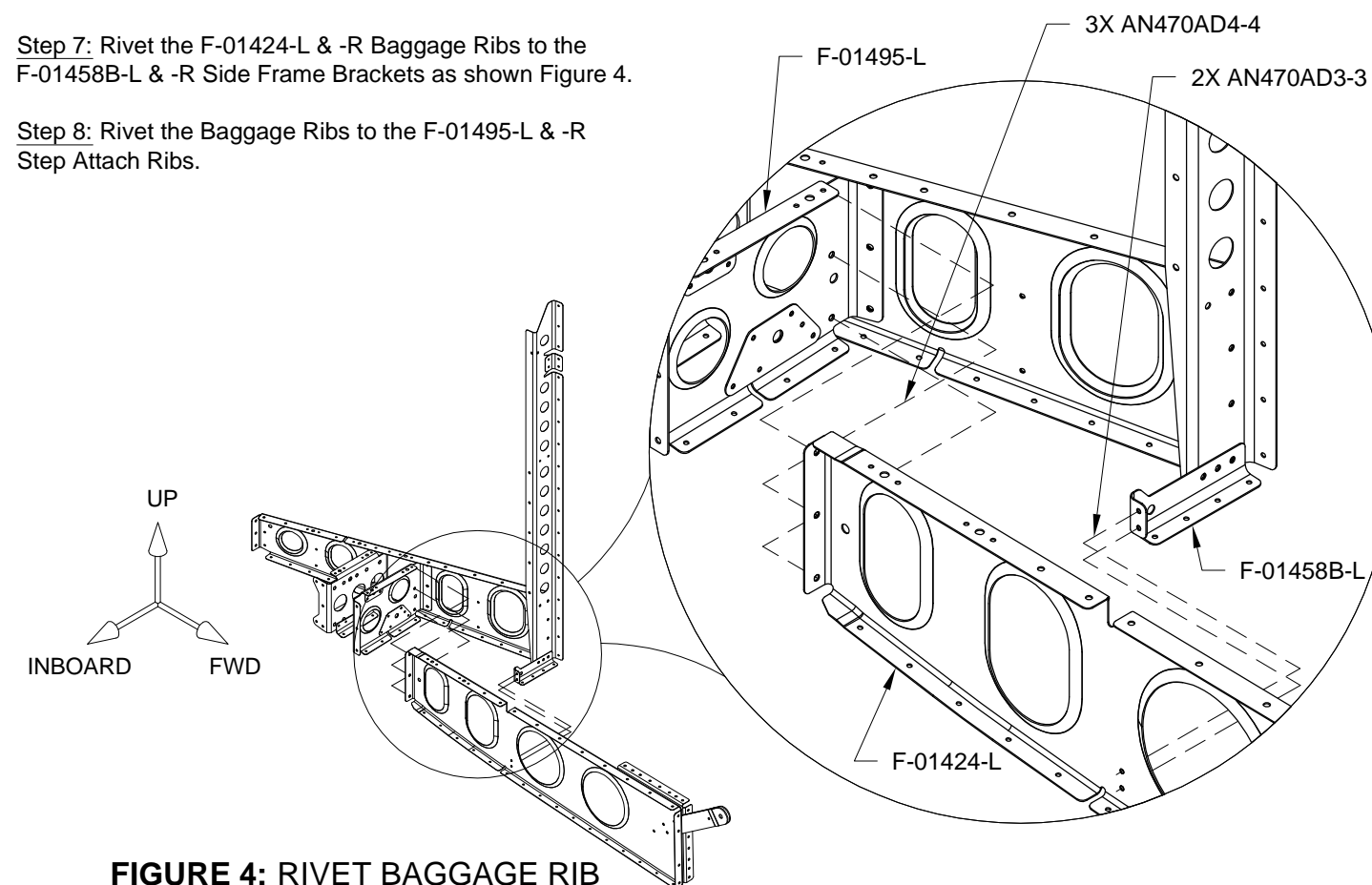


FIGURE 4: RIVET BAGGAGE RIB



Step 1: (Tri-Gear Only) Rivet the F-01425-L & -R Baggage Ribs to the F-00016-L & -R Step Attach Weldments as shown in Figure 1.

Step 2: Rivet the Baggage Ribs to the F-01495-L & -R Step Attach Ribs as shown in Figure 1.

Step 3: (Tri-Gear Only) Rivet K1000-08 nutplates to the F-00016-L & -R Step Attach Weldments as shown in Figure 1.

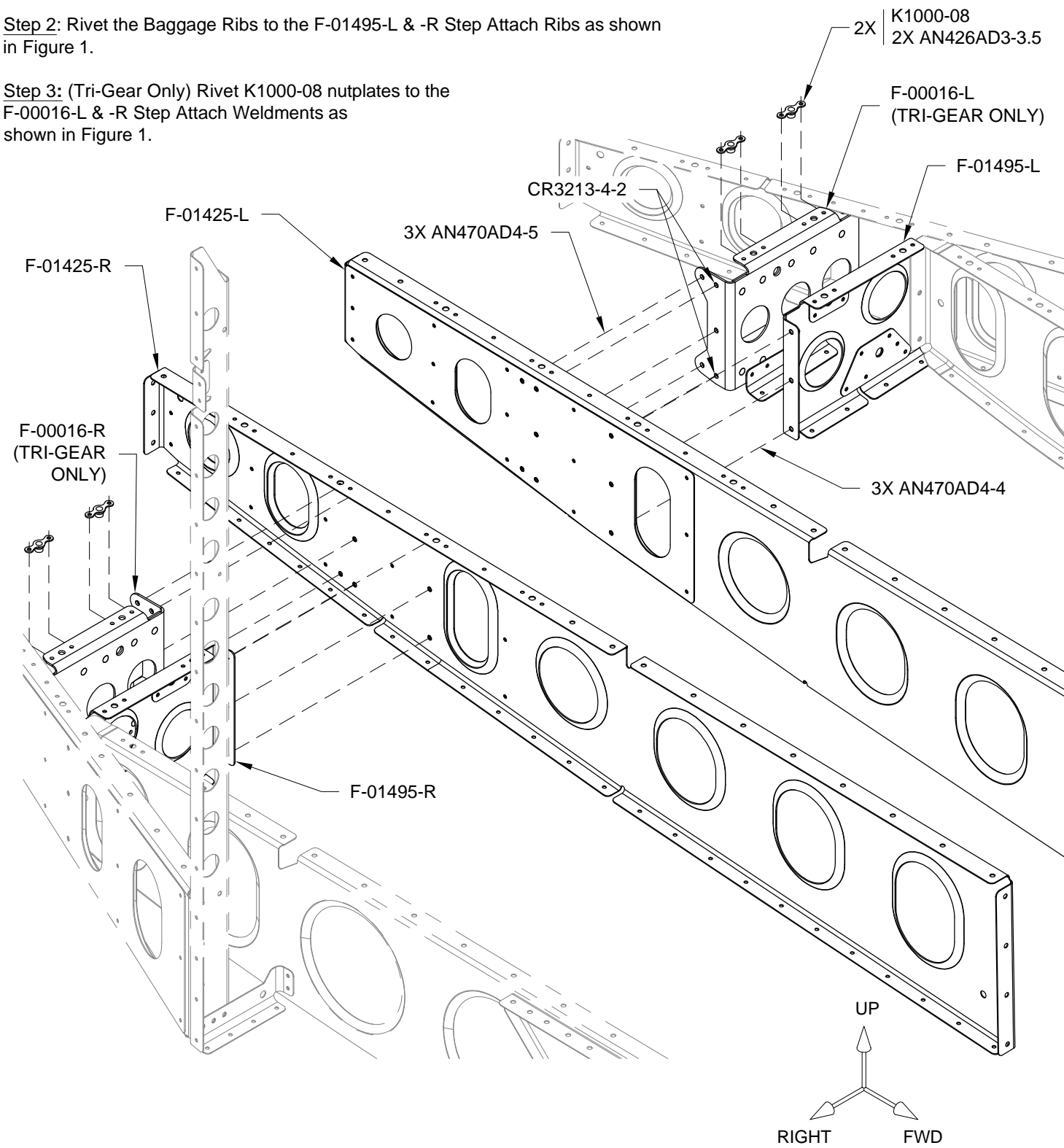


FIGURE 1: STEP ATTACH ASSEMBLIES

Step 4: Rivet the Left and Right Step Attach Assemblies to the F-01405 Bulkhead as shown in Figure 2.

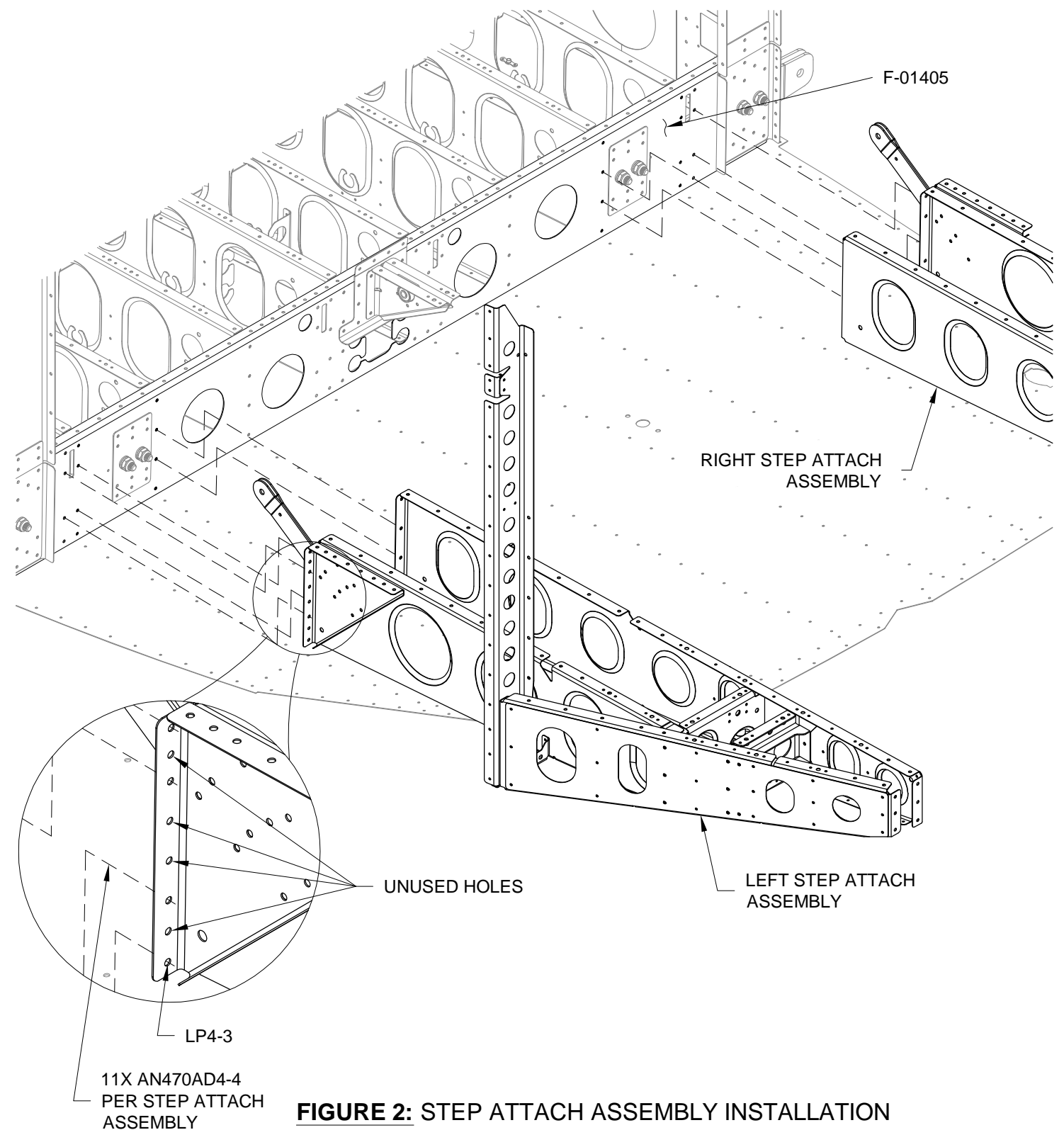
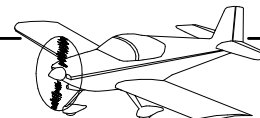


FIGURE 2: STEP ATTACH ASSEMBLY INSTALLATION



Step 1: Rivet the F-01427-L & -R Baggage Ribs and F-14128 Seat Belt Lug Brackets to the F-01405 Bulkhead as shown in Figure 1.

Step 2: Rivet the F-01426-L & -R Baggage Ribs to the F-01405 Bulkhead and to the F-01417-L & -R Seat Ribs as shown in Figure 2.

Step 3: Rivet the seat ribs to the F-01484 Center Bottom Skin.

NOTE: Omit the F-01423B-L & -R Outbd Baggage Rib from the next step.

(Tail Dragger Only) Omit the holes for riveting the F-01484A-L & -R Cover Plates. See Page 26-14, Figure 1.

Step 4: Rivet the baggage ribs to the F-01484 Center Bottom Skin except in the "No Rivet Zone." For the location of the "No Rivet Zone" see Page 26-14, Figure 1. Begin near the F-01405 Bulkhead and proceed aft.

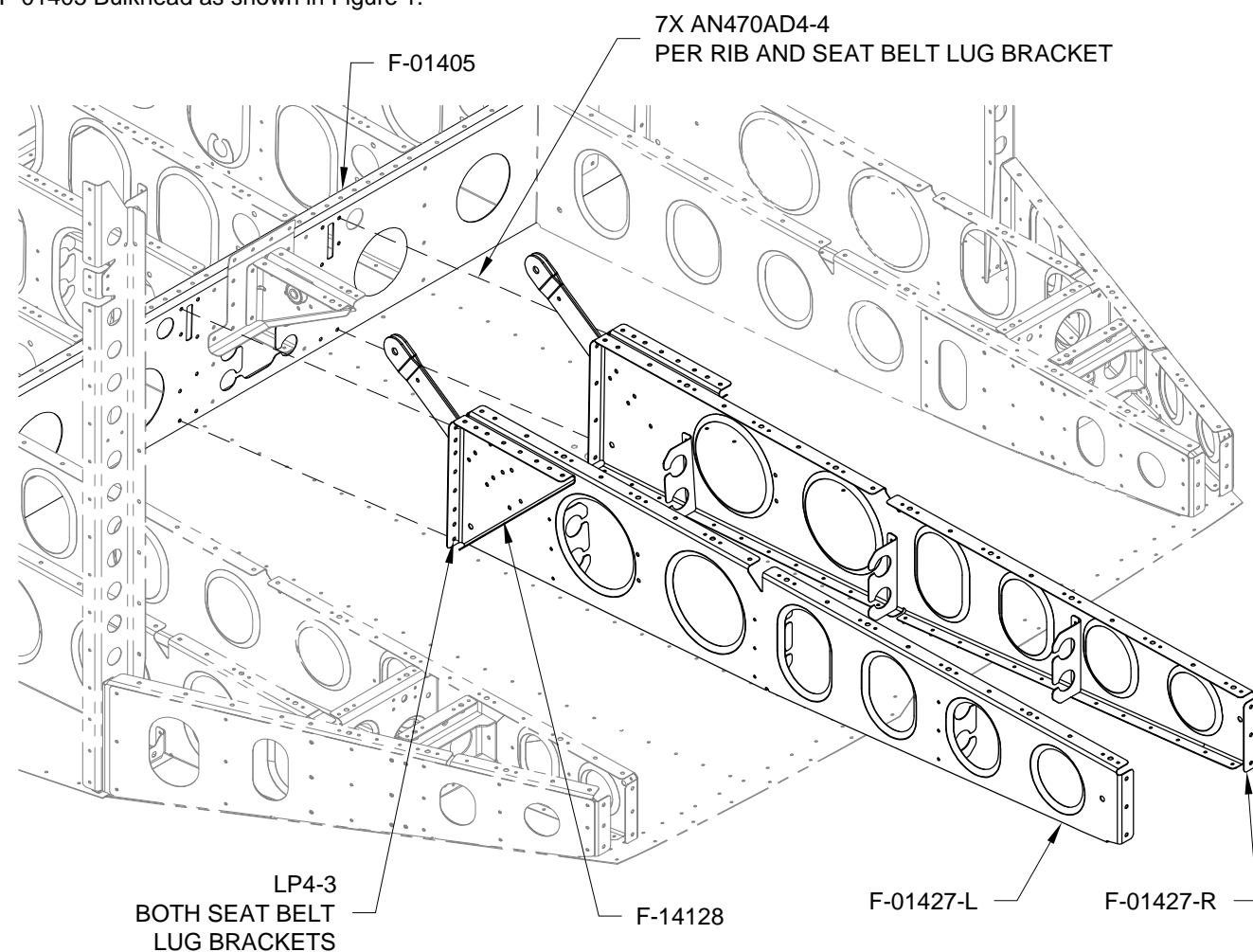


FIGURE 1: BAGGAGE RIB INSTALLATION

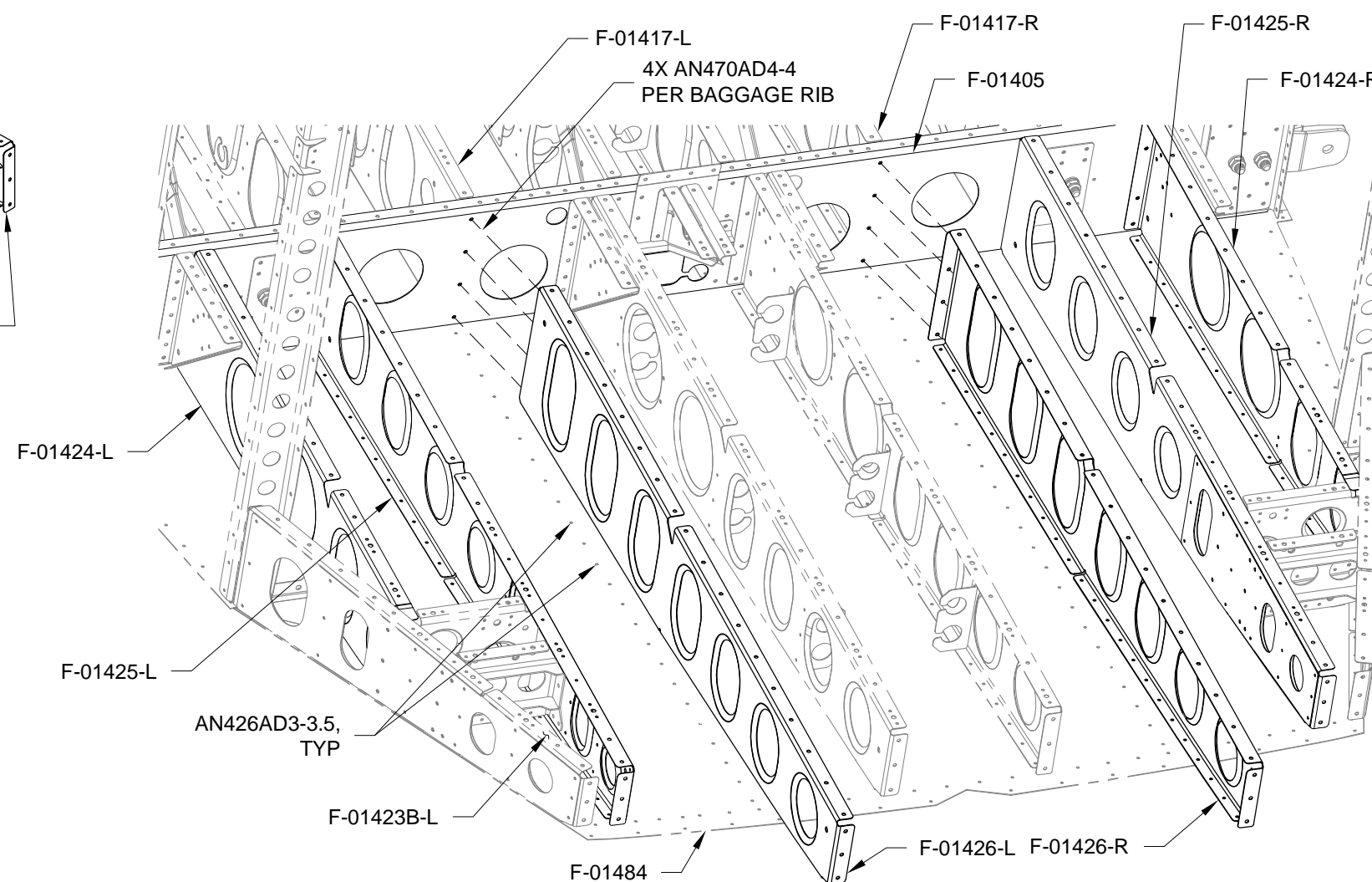
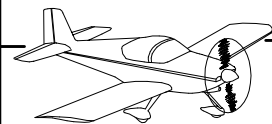


FIGURE 2: BAGGAGE RIB INSTALLATION



NOTE: If a reduced diameter 1/8 female dimple die is not available a standard diameter die may be modified as described below.

Step 1: Grind a shoulder on a standard diameter 1/8 female dimple die as shown in Figure 1.

Radius the corner formed on the die face as shown in Figure 1.

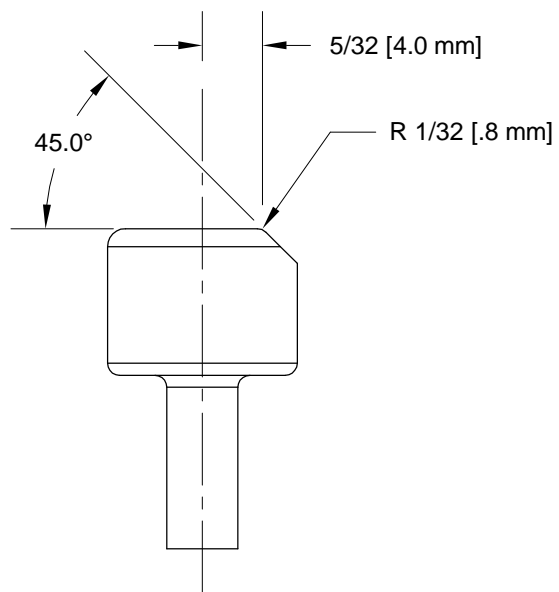


FIGURE 1: DIMPLE DIE MODIFICATION

Step 2: Dimple the two #30 holes where indicated in the F-01430 Baggage Floor Stiffener using a reduced diameter female dimple die or the modified die described in Step 1. See Figure 2.

Step 3: Dimple the #40 nutplate attach holes in the Baggage Floor Stiffener as shown in Figure 2.

Step 4: Rivet the nutplates to the F-01430 Baggage Floor Stiffener as shown in Figure 2.

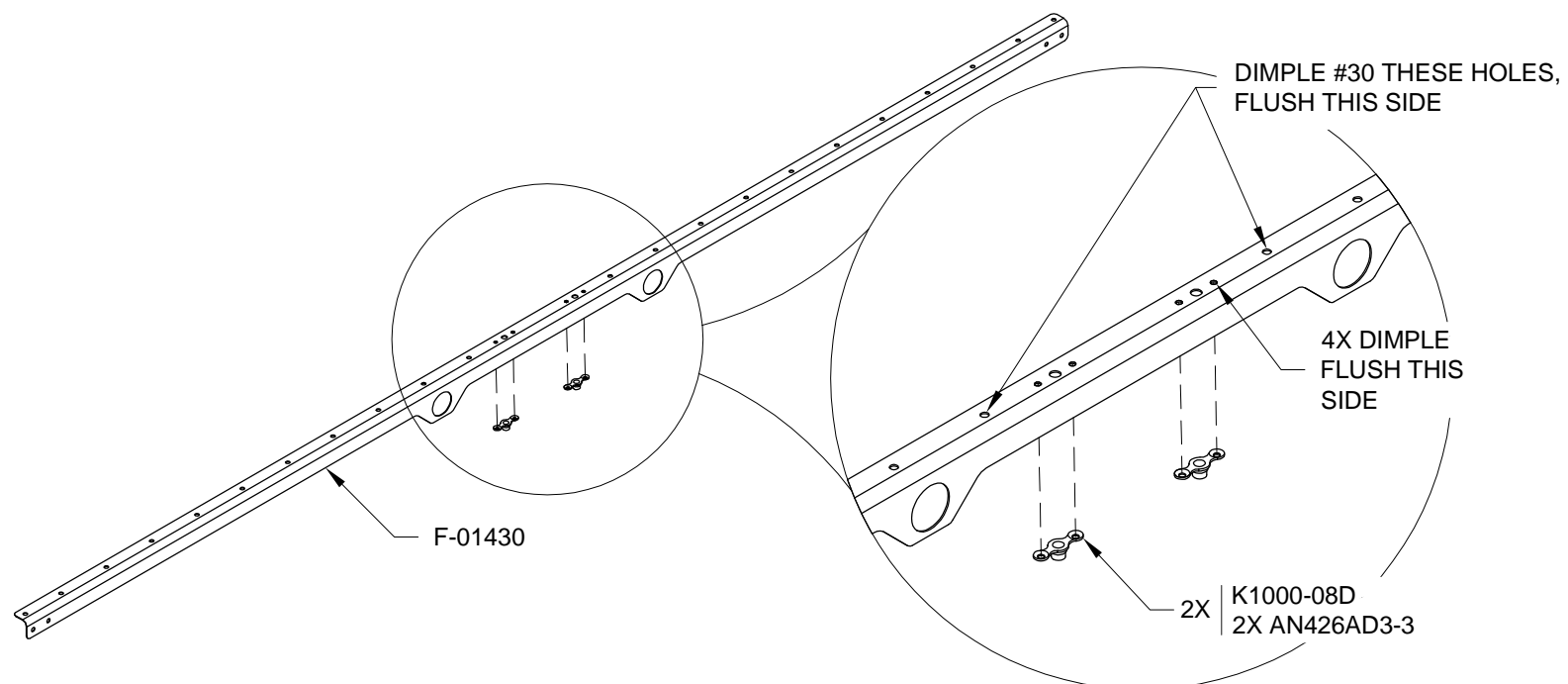


FIGURE 2: RIVET NUTPLATES TO THE FLOOR STIFFENER

Step 5: Rivet the F-01430 Baggage Floor Stiffener to the F-01458-L Side Frame and F-01423B-L Outbd Baggage Rib as shown in Figure 3.

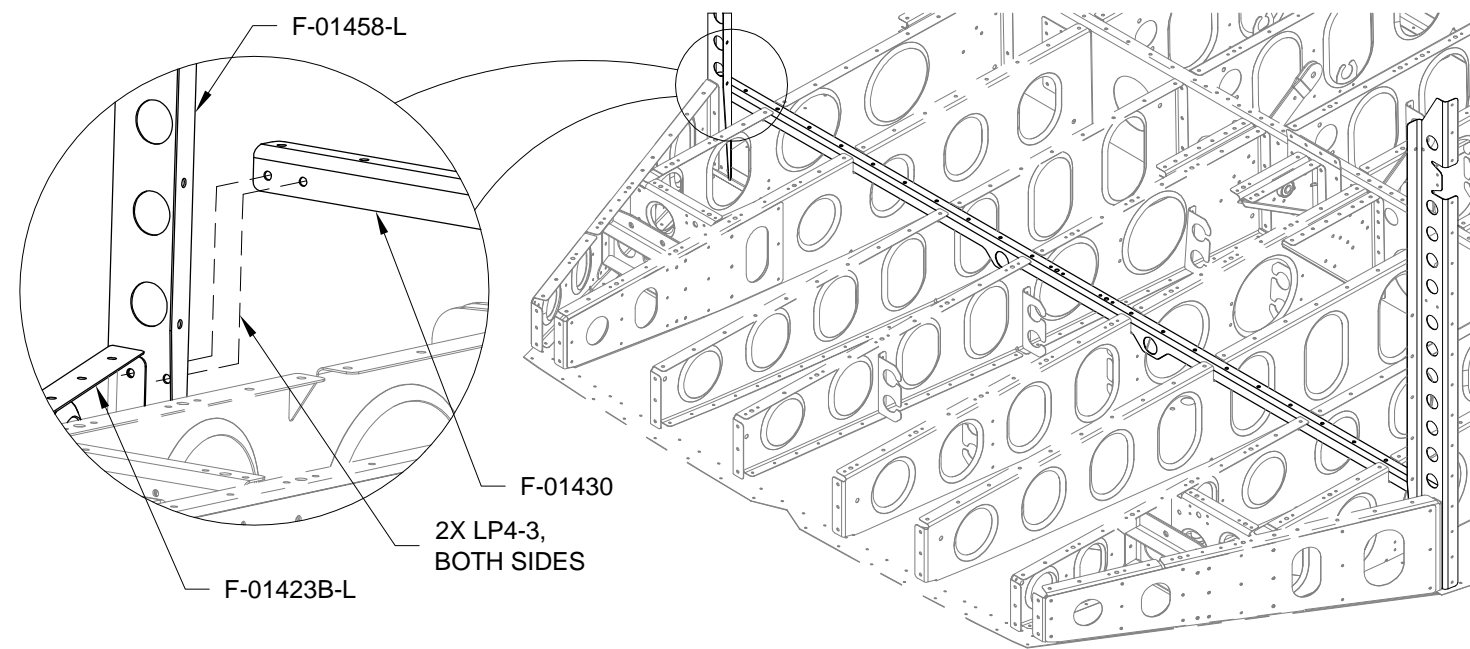


FIGURE 3: INSTALL FLOOR STIFFENER

Step 6: Cleco the F-01423A-L Outbd Baggage Rib to the F-01405D-L Bulkhead Side Channel and to the F-01458-L Side Frame. See Figure 4.

Step 7: Rivet the Outboard Baggage Rib to the F-01484 Center Bottom Skin only.

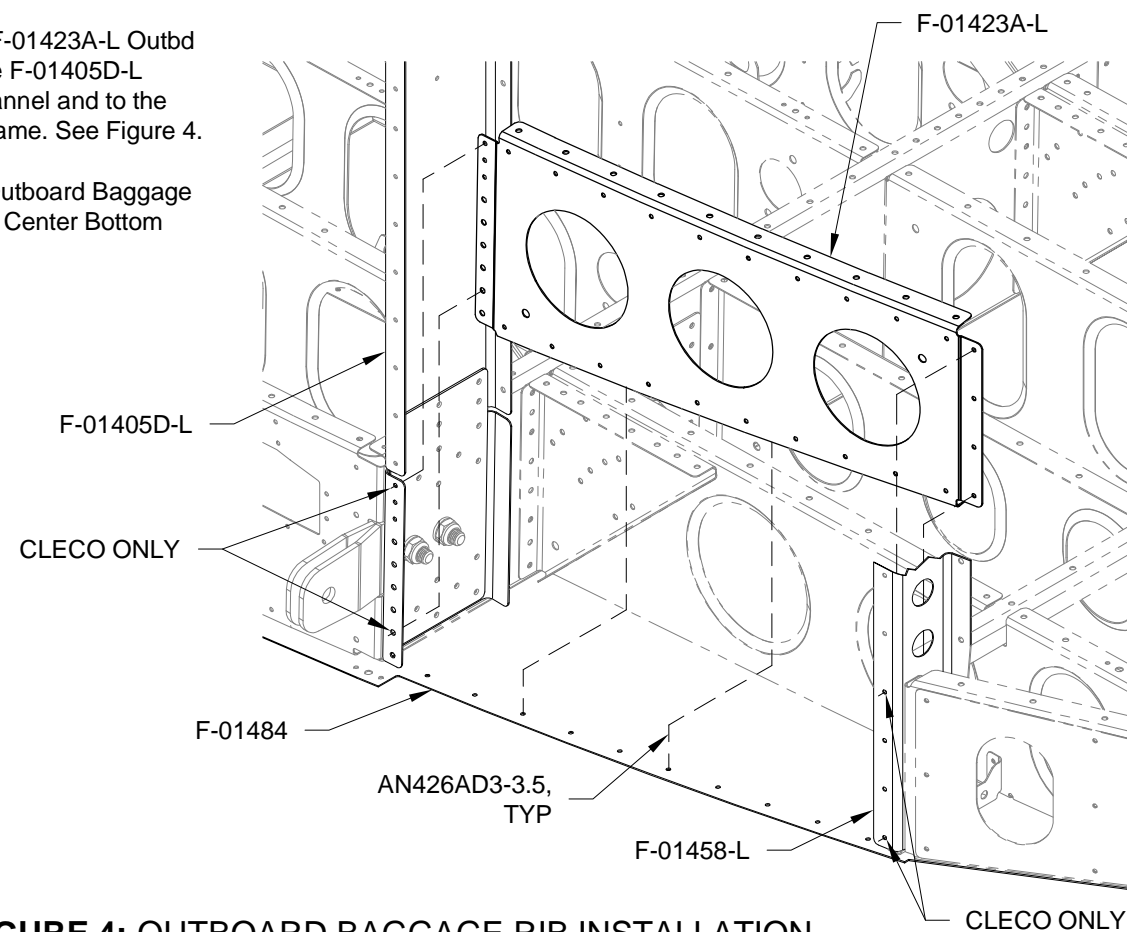


FIGURE 4: OUTBOARD BAGGAGE RIB INSTALLATION