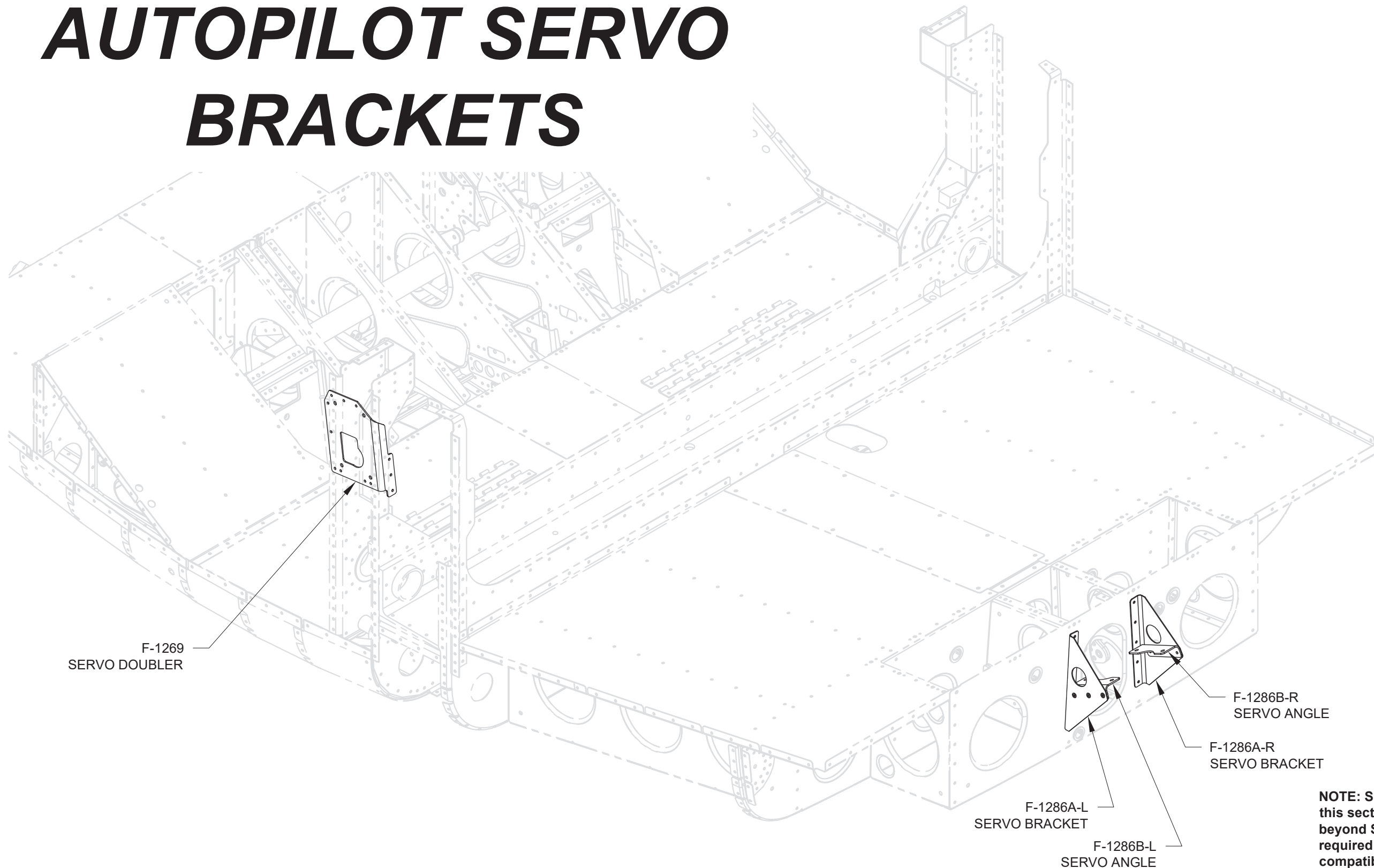


SECTION 39: AUTOPILOT SERVO BRACKETS



NOTE: Special tools are required to complete this section for aircraft that are assembled beyond Section 21. The special tools required are a 90° angle drill attachment, a compatible short #12 and short #30 drill bit.



NOTE: The following instructions cover installing the autopilot servo brackets on aircraft pre-construction and post-construction. Instructions unique to an aircraft under construction are preceded with the step number and "(PRECONST)". Instructions unique to assembled aircraft are preceded with the step number and "(POSTCONST)". Installation on an assembled aircraft will require removing some access covers to access the parts shown in these instructions.

PRECONST NOTE: This section is a two part interlude to Section 21. The F-1269 Servo Doubler will be installed here while installing the seat ribs. The F-1286A & B Servo Bracket and Angle will be installed here while installing the F-1207B Baggage Bulkhead.

Step 1: Trim the called out F-1215-R Seat Rib by removing the material shown hatched in Figure 1.

Mark then remove extra material from the seat rib using the doubler as a guide. See Figure 2, Detail A-A.

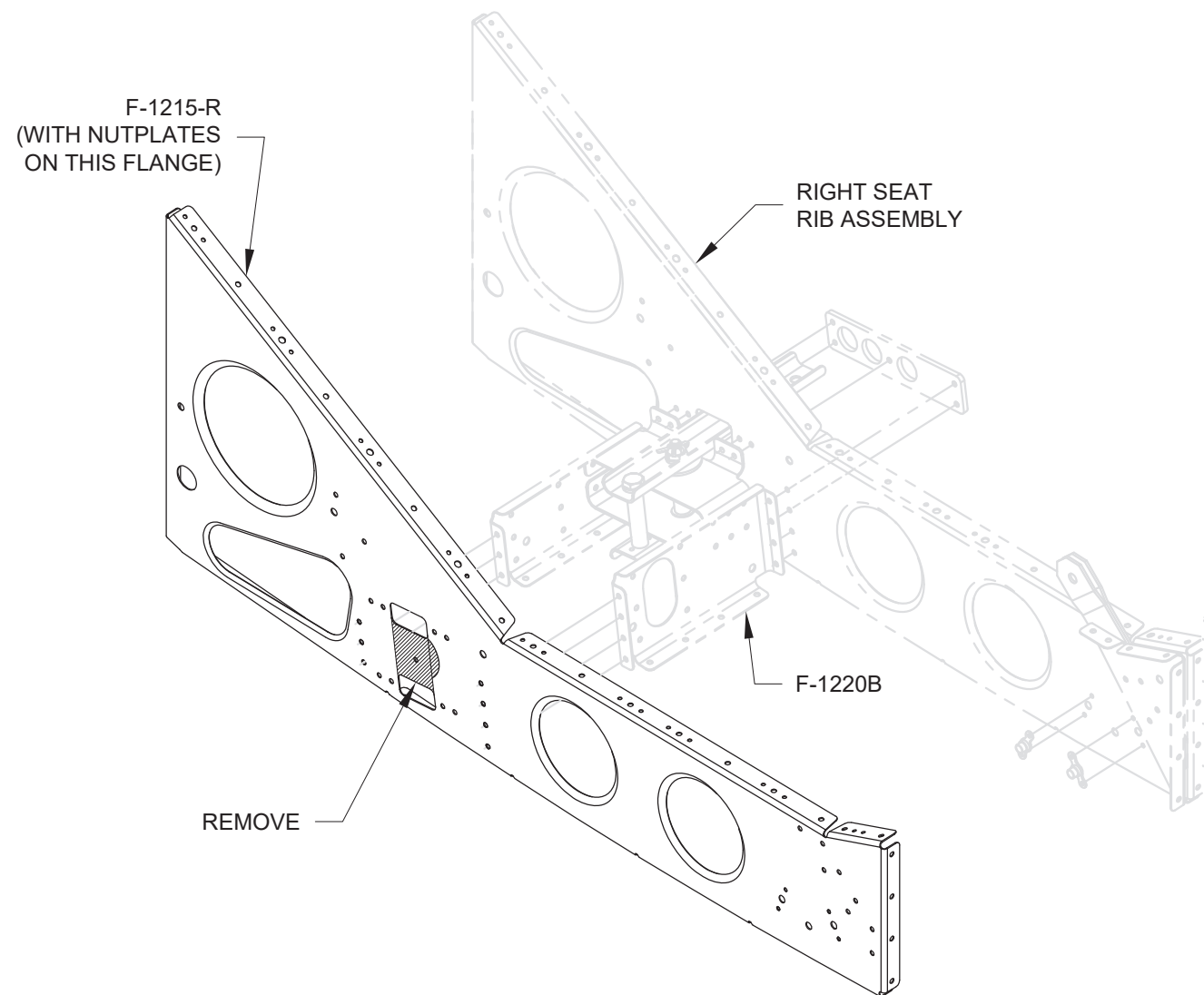


FIGURE 1: TRIMMING THE SEAT RIB

Step 2 (PRECONST): Proceed to Step 3.

Step 2 (POSTCONST): Remove the rivets that connect the F-1215-R Seat Rib to the F-1267B Crotch Strap Bracket as called out in Figure 2, Detail A-A. Remove the nutplate attach rivet called out in Figure 2. Rotate the nutplate out of the way.

Step 3: Cleco the F-1269 Servo Doubler to the F-1215-R Seat Rib as shown in Figure 2. Match-Drill the holes from the servo doubler into the seat rib per the call-outs in Figure 2, Detail A-A.

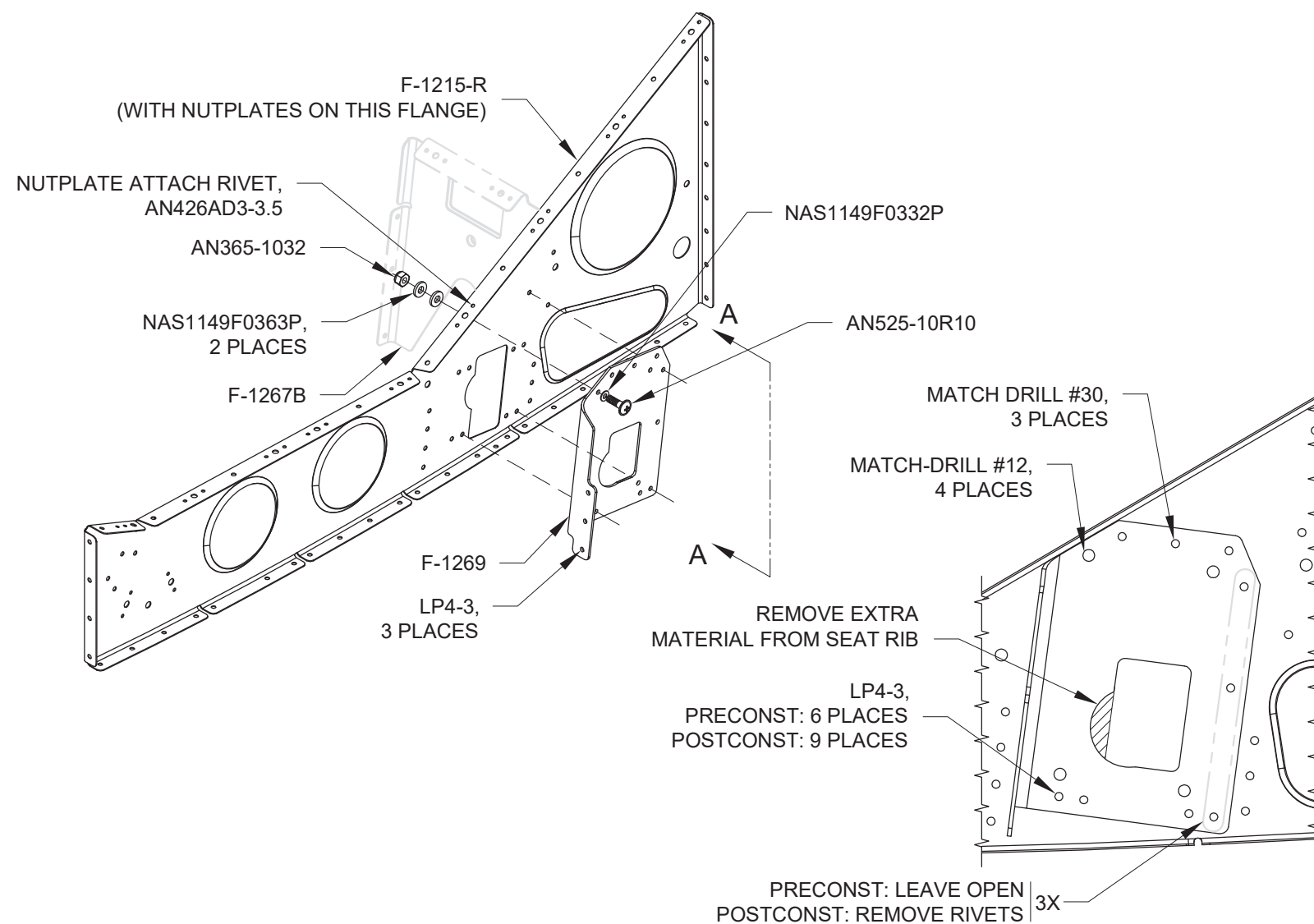
Step 4: Rivet the F-1269 Servo Doubler to the F-1215 Seat Rib per the call-outs in Figure 2, Detail A-A.

Step 5: Rivet the F-1269 Servo Doubler to the F-1220B Aft Intercostal. See Figure 1 for assembly orientation and Figure 2 for rivet call-out.

Step 6: Install the screw, washers and nut called out in Figure 2. Rotate, then rivet the nutplate back into place using the rivet called out in Figure 2.

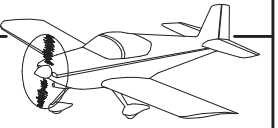
Step 7 (PRECONST): Proceed with the assembly instructions in Section 21. Continue from here when referred back to this section for autopilot bracket installation.

Step 7 (POSTCONST): Proceed to next page.



DETAIL A-A

FIGURE 2: SEAT RIB PREPARATION



Step 1: Label, then separate the F-1286A-L & -R Servo Bracket by removing the material shown hatched in Figure 1.

Step 2: Label, then separate the F-1286B-L & -R Servo Angle by removing the material shown hatched in Figure 2.

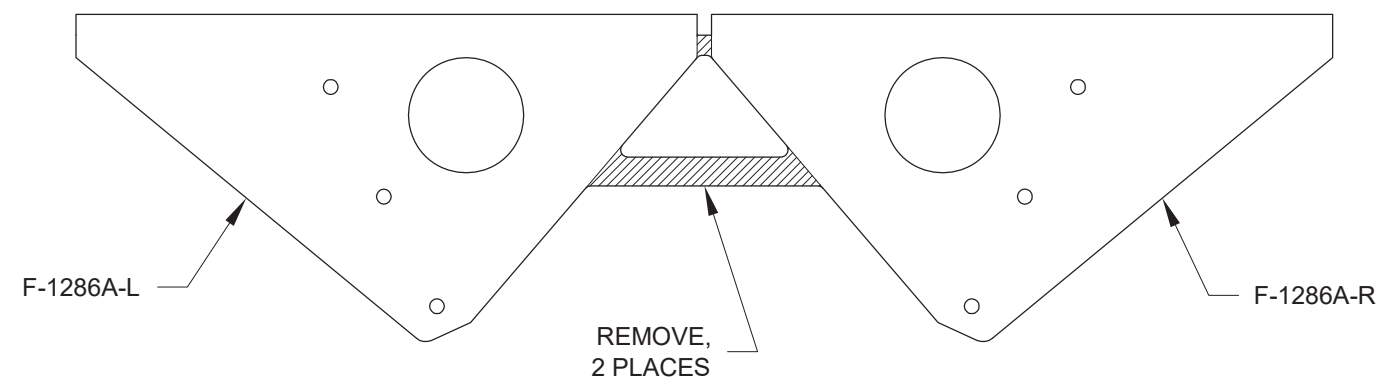


FIGURE 1:
SERVO BRACKET SEPARATION

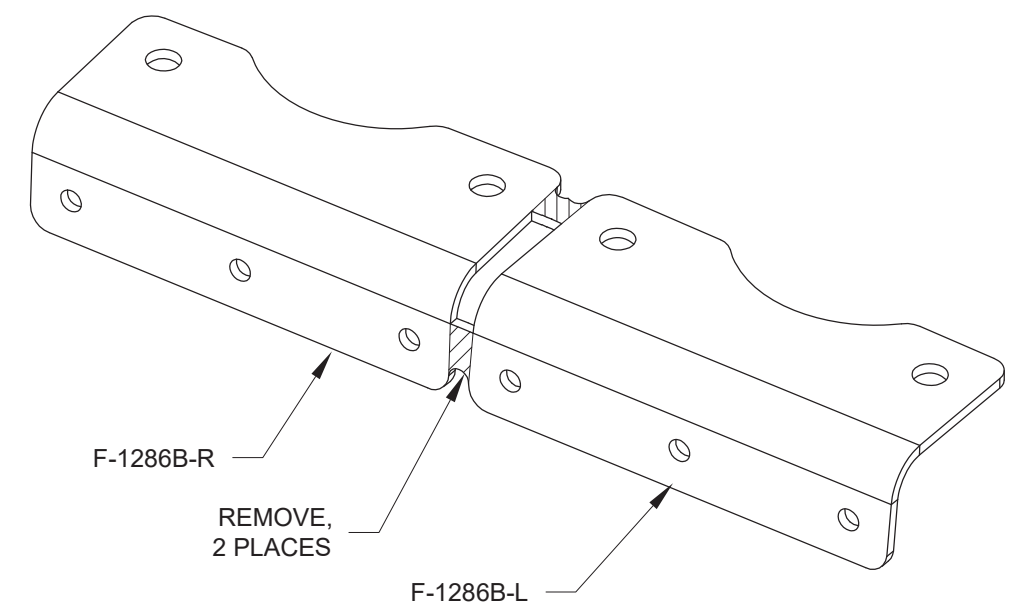


FIGURE 2:
SERVO ANGLE SEPARATION

Step 1 (PRECONST): Proceed to Step 2.

Step 1 (POSTCONST): Remove the rivets that connect the F-1207B Baggage Bulkhead to the F-1206G-L & -R Baggage Ribs as called out in Figure 1.

Step 2: Cleco then rivet the F-1207B Baggage Bulkhead and the F-1286A Servo Brackets to the F-1206G-L & -R Baggage Ribs using the rivets called out in Figure 1.

Step 3: Cleco then rivet the F-1286B-L & -R Servo Angles to the F-1286A-L & -R Servo Brackets as shown in Figure 2.

Step 4 (PRECONST): Proceed with the assembly instructions in Section 21.

Step 4 (POSTCONST): Section complete.

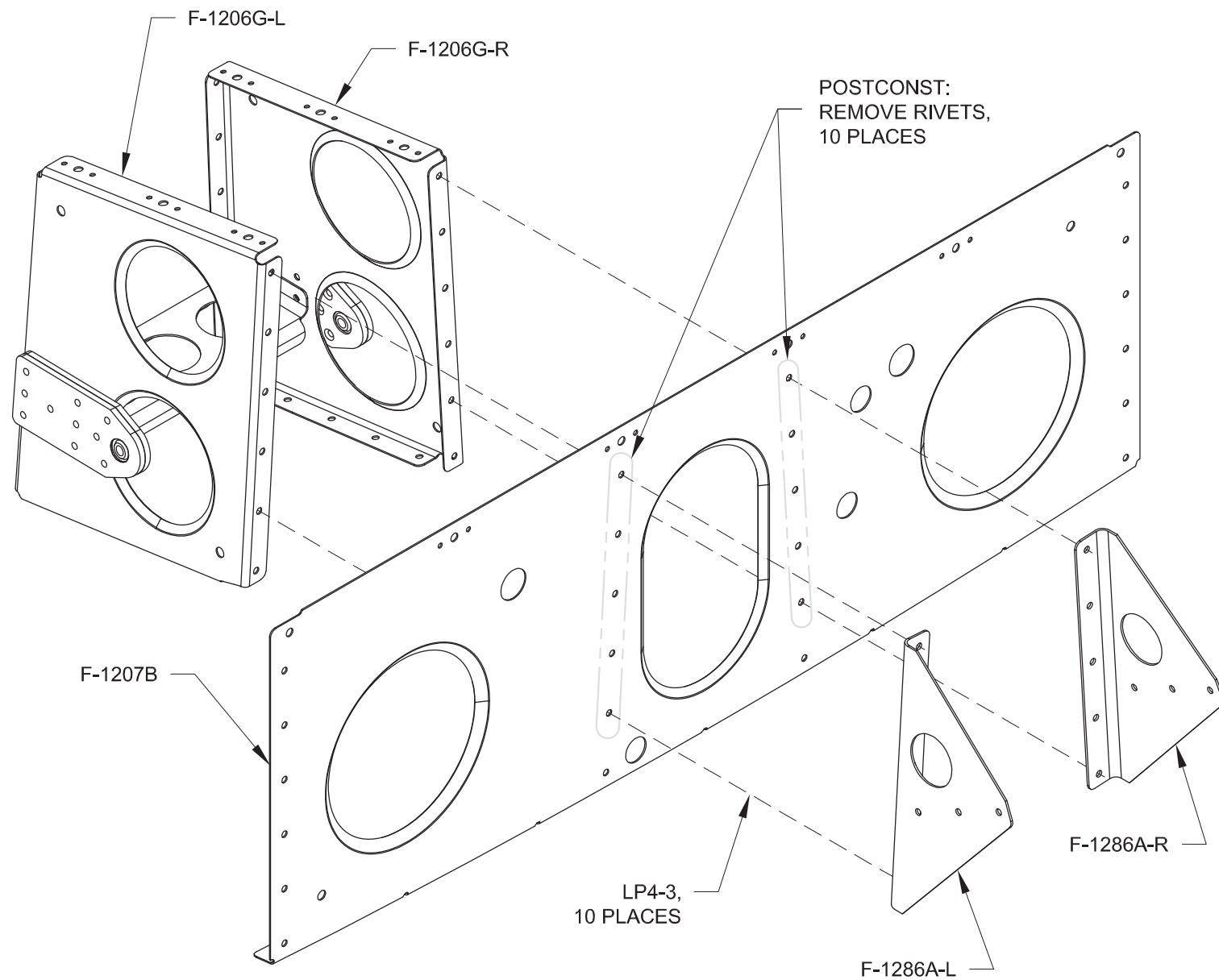


FIGURE 1:
SERVO BRACKET INSTALLATION

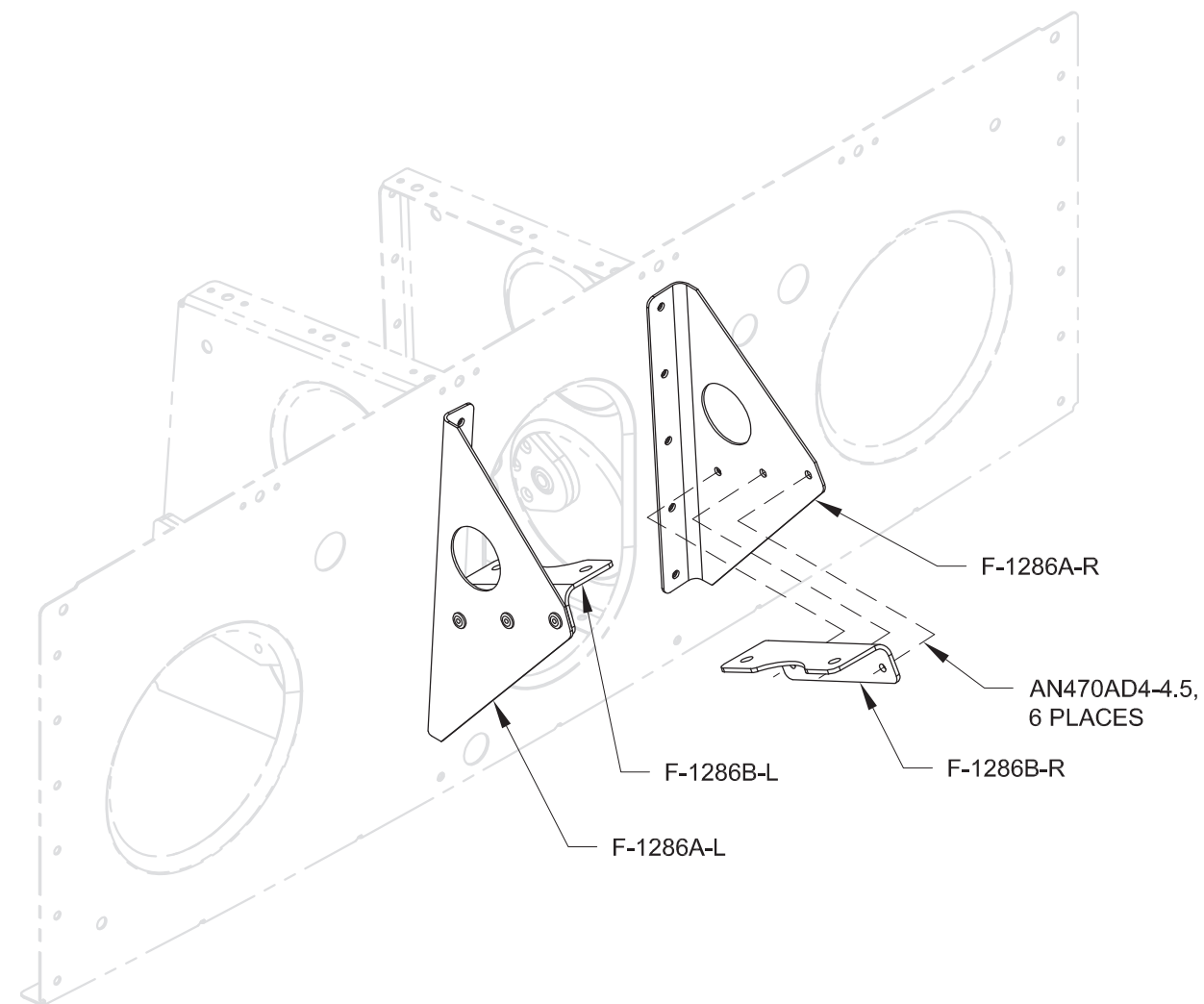


FIGURE 2:
SERVO ANGLE INSTALLATION