

## REAR FUSELAGE FLOOR SUB-ASSY

REVISION DATE: 15/02		REVISION: 0		MAN. TO MWO: REAR FUSELAGE FLOOR SUB-ASSY			
PART NO	REV.	DRAWING	ASSEMBLY	DESCRIPTION	QTY	CODE	BUILDER
				FOR DRILLING THE Z ANGLES AND LONGERONS, THERE ARE TWO RECOMMENDED METHODS. 1, MARK THE POSITION OF THE HOLES ON THE BOTTOM SKINS AND DRILL ALL THE HOLES IN THE SKINS. TURN THE SKIN UP-SIDE-DOWN, DRAW CENTER LINES ON THE Z ANGLES AND LONGERONS AND POSITION THEM UNDER THE SKINS AND DRILL INTO THEM.			
				2, DRILL THE HOLE LOCATIONS INTO THE BOTTOM SKINS, PLACE THE LONGERONS AND Z ANGLES ON TOP AND LOCATE THE HOLES WITH A HOLE FINDER.			
20-F-1-1		20-F-1	20-F-1	BOTTOM SKIN. MAKE SURE THAT THE SKIN IS CUT OUT AS PER DRAWING 640-F-1-1. CUT OUT ACCESS HOLE ETC. MARK OUT THE Z ANGLE STIFFENER LOCATIONS STARTING AT THE REAR. 10mm+340mm+340mm ETC.	1		
20-F-2-2		20-F-2	20-F-2	REAR BOTTOM SKIN. IINSTALL TO THE BOTTOM SKIN. OVERLAP BY 20mm AS SHOWN IN 640-F-2 DETAIL B. MAKE SURE THAT THE CENTER LINE OF BOTH SKINS LINES UP. DRILL AND CLECO TO THE TABLE. A4 PIRCH 35. LEAVE A SPACE ON BOTH ENDS FOR THE LONGERONS.	1		
640-F-24-3R		640-F-24	20-F-3	LOWER REAR LONGERONS. INSTALL FLUSH TO THE EDGE OF THE BOTTOM SKINS. AS PER DRAWING 640-F-5, THE LOGERONS ARE POSITIONED AT THE REAR AT THE RUDDER HINGES. SEE DETAILS.	2		
20-F-5-2		20-F-5	20-F-5	LOWER TOP RUDDER HINGE. MARK AND DRILL THE 10 HOLES FOR THE AD-5 RIVETS. POSITION TO BOTTOM SKIN	1		
20-F-5-3		20-F-5	20-F-5	LOWER BOTTOM RUDDER HINGE. POSITION AS PER DETAIL ON 640-F-5 DETAIL	1		
20-F-5-4		20-F-5	20-F-5	SHIM. POSITION.	1		
				MAKE SURE THAT THE END OF THE LONGERONS ARE LINED UP THE END OF 640-F-5-2. DRILL THROUGH THE LOWER TOP RUDDER HINGE INTO THE OTHER PARTS AND CLECO TO TABLE. THE 5/16" HOLES ARE DRILLED AT A LATER TIME. DRILL THE LONGERONS TO THE BOTTOM SKINS FOR A4 RIVETS, PITCH 35.			
Z				CUT AND POSITION THE Z ANGLES AS PER 640-F-1. ONCE CUT, JOGGLE THE ENDS FOR PROPER OVERLAP OVER THE EXTRUSIONS. SEE 640-F-3 "TYPICAL DETAIL" AND 640-F-1 DETAIL B. ALL Z ANGLES ARE P40 TO 48, A4. POSITION Z ANGLES FOR THE ACCESS DOOR AS PER 640-F-1. DRILL ALL ANGLES AND CLECO TO TABLE.			
20-F-1-2		20-F-1	20-F-1	ACCESS DOOR. POSITION AND DRILL AS PER 640-F-1	1		
9657-1014				RIVET NUT 3/16	16		
1619E00AL				ACCESS DOOR HINGE L=406mm	1		
				TAKE ASSEMBLY APART CLEAN AND RIVET TOGETHER. DO NOT RIVET REAR TO FRONT BOTTOM SKIN AREA WHERE HT FRAME WILL GO. FOR THE AD-5 SOLID RIVETS IN THE REAR HINGE, YOU CAN USE AN3 BOLTS IF YOU WANT.			
INSPECTION:				DATE:		SIG	