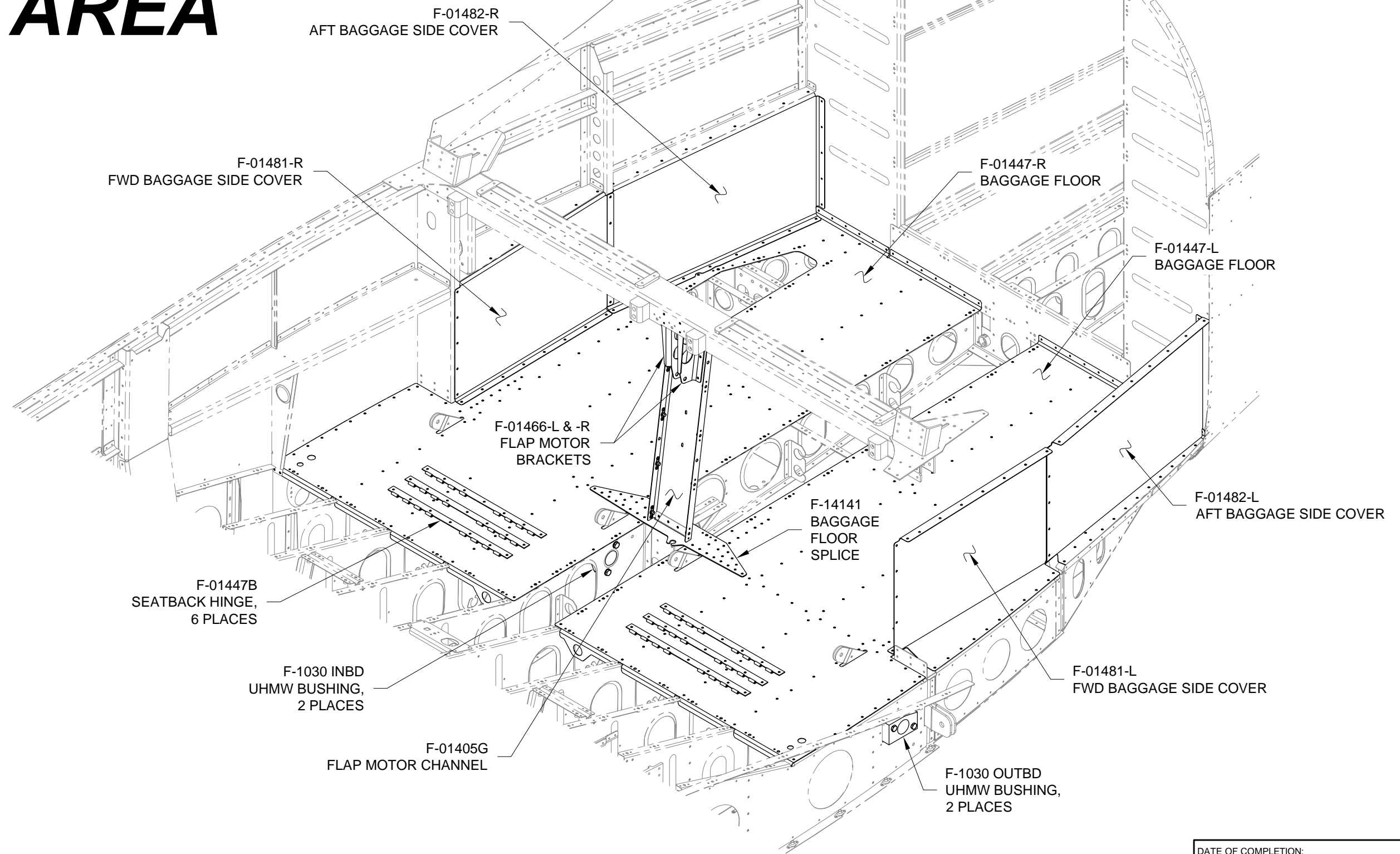


SECTION 32: BAGGAGE AREA





Step 1: Trim two F-1030 UHMW Bushings to fabricate the two F-1030 Outboard Bushings. See Figure 1.

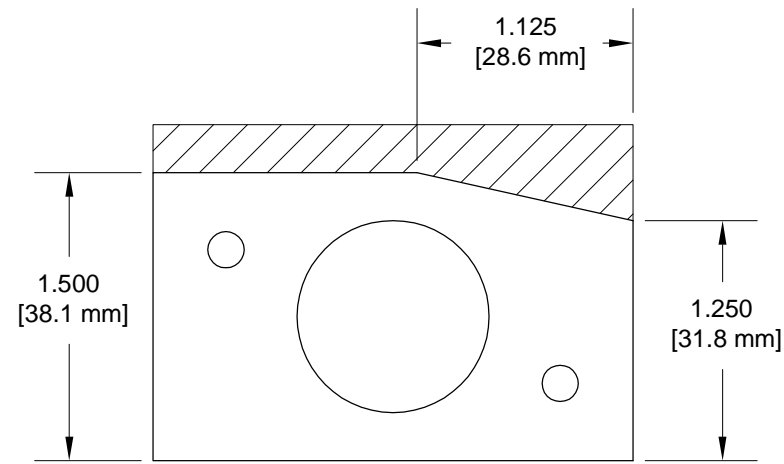
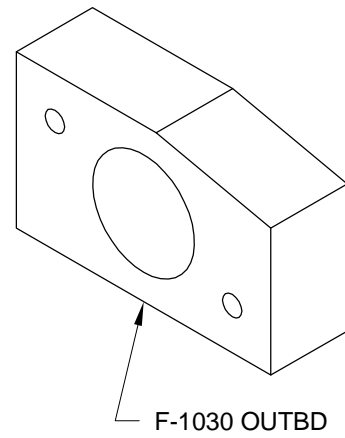


FIGURE 1: TRIM OUTBOARD UHMW BUSHINGS



Step 2: Trim two F-1030 UHMW Bushings to fabricate the two F-1030 Inboard Bushings. See Figure 2.

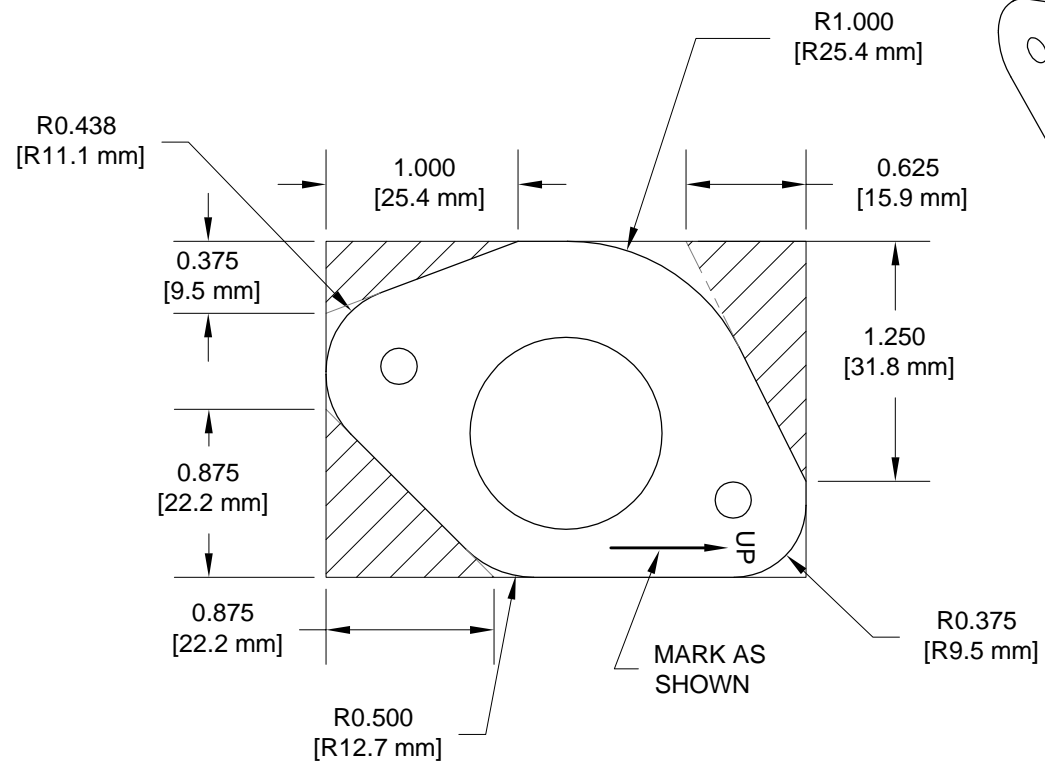
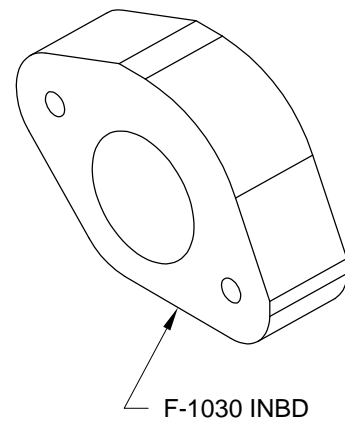


FIGURE 2: TRIM INBOARD UHMW BUSHINGS



Step 3: Bolt the two F-1030 Outboard Bushings to the F-01433-L & -R Flap Block Brackets as shown in Figure 3.

Tighten the nuts and bolts just enough to increase the turning friction of the bolts in the blocks. **DO NOT** use standard torque values.

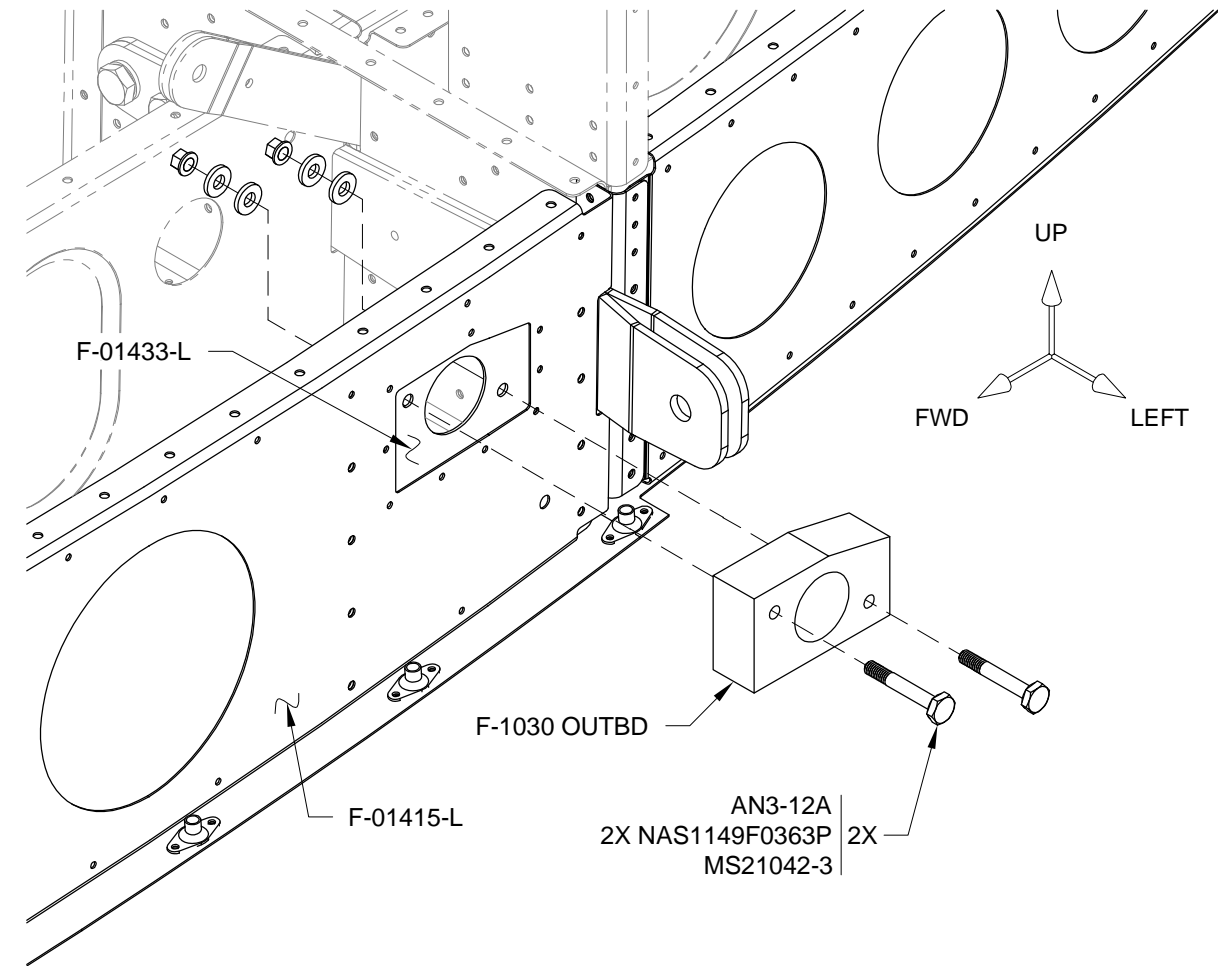


FIGURE 3: INSTALL OUTBOARD BUSHING (LEFT SIDE SHOWN)



Step 1: Bolt one F-1030 Inboard Bushing to the outboard side of the F-01417-L Seat Rib as shown in Figure 1. Orient the bushing such that the previously marked arrow is pointing up.

Step 2: Bolt the remaining F-1030 Inboard Bushing to the outboard side of the F-01417-R Seat Rib as shown in Figure 1.

CAUTION: When cutting lengths of AN257-P3 hinge, be sure enough hinge remains to fabricate the seat hinges in Section 39: Seat Backs.

Step 3: Remove the hinge pin from the AN257-P3 hinge and cut six F-01447B Seatback Hinges as shown in Figure 2.

Step 4: Trim the middle two eyelets from each F-01447B Seatback Hinge as shown in Figure 2.

Step 5: Draw a line on the flush side of each F-01447B Seatback Hinge as shown in Figure 2.

Step 6: Drill one #30 locating hole in each F-01447B Seatback Hinge as shown in Figure 2. Deburr.

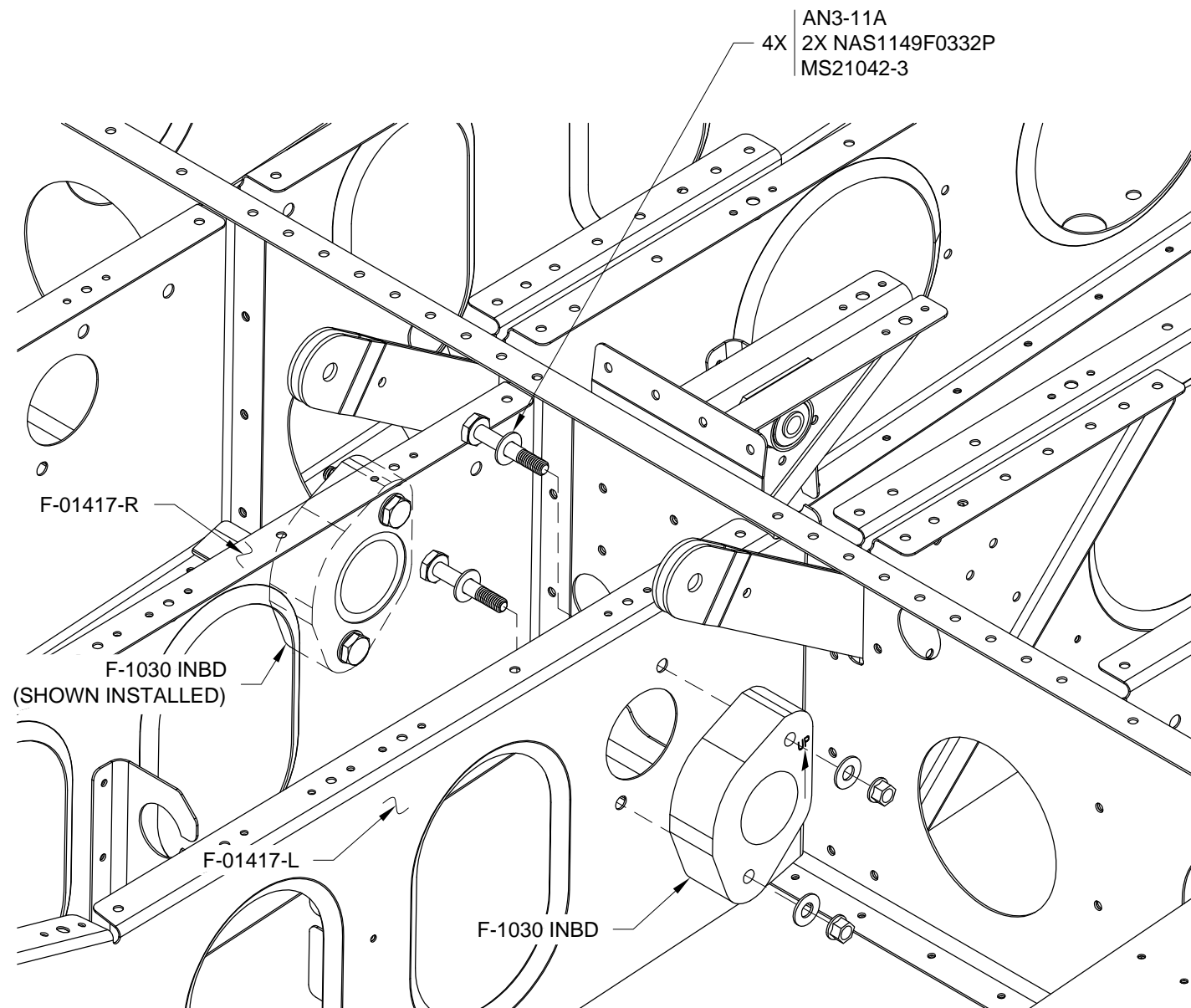


FIGURE 1: INSTALL INBOARD BUSHINGS

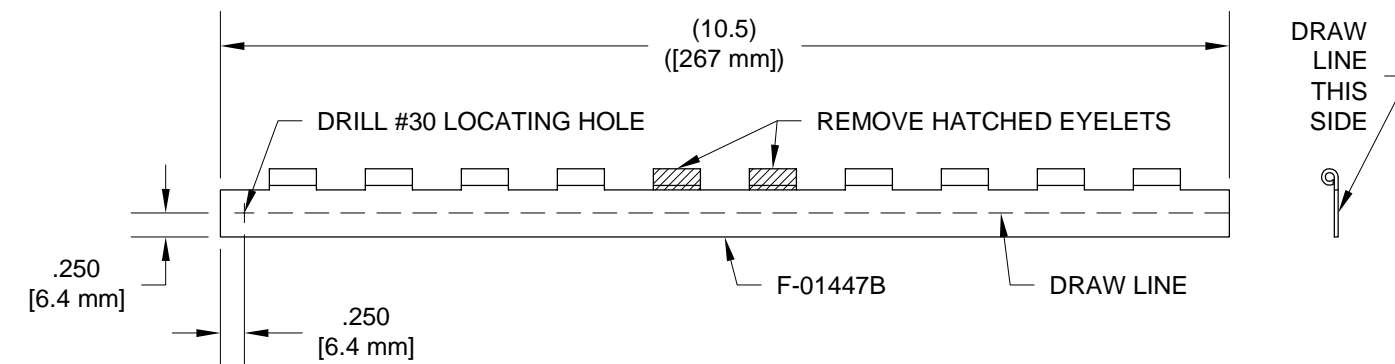
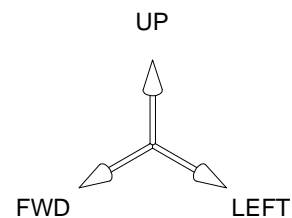


FIGURE 2: SEATBACK HINGES

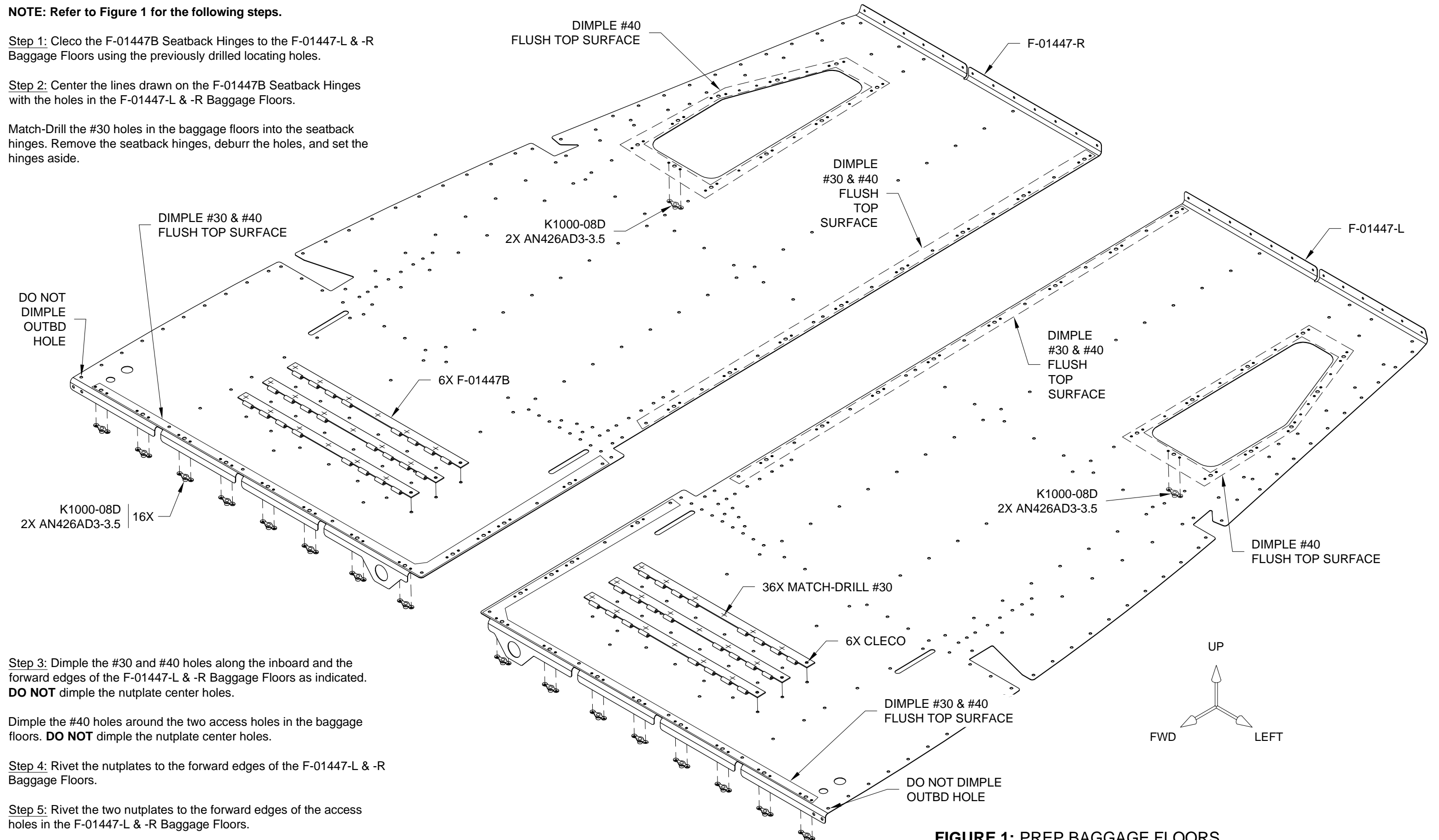


NOTE: Refer to Figure 1 for the following steps.

Step 1: Cleco the F-01447B Seatback Hinges to the F-01447-L & -R Baggage Floors using the previously drilled locating holes.

Step 2: Center the lines drawn on the F-01447B Seatback Hinges with the holes in the F-01447-L & -R Baggage Floors.

Match-Drill the #30 holes in the baggage floors into the seatback hinges. Remove the seatback hinges, deburr the holes, and set the hinges aside.



Step 3: Dimple the #30 and #40 holes along the inboard and the forward edges of the F-01447-L & -R Baggage Floors as indicated. **DO NOT** dimple the nutplate center holes.

Dimple the #40 holes around the two access holes in the baggage floors. **DO NOT** dimple the nutplate center holes.

Step 4: Rivet the nutplates to the forward edges of the F-01447-L & -R Baggage Floors.

Step 5: Rivet the two nutplates to the forward edges of the access holes in the F-01447-L & -R Baggage Floors.

FIGURE 1: PREP BAGGAGE FLOORS



NOTE: Refer to Figure 1 and Figure 2 for the following steps.

Step 1: Dimple the #30 holes in the F-01447-L & -R Baggage Floors and F-01417-L & -R Seat Ribbs for the CS4-4 rivets as shown.

Step 2: Ensure that the area underneath the F-01447-L & -R Baggage Floors is completely clean and free of debris.

Step 3: Place the F-01447-L & -R Baggage Floors into position over the substructure.

Step 4: Final-Drill #19 the nutplate center holes in the forward inboard edges of the F-01447-L & -R Baggage Floors.

Step 5: Cleco the F-01447-L & -R Baggage Floors to the substructure, F-01406A-L & -R Bulkheads, F-01406B Bulkhead, and F-01428-L & -R Side Frames.

Step 6: Rivet the F-01447-L & -R Baggage Floors to the substructure using the nutplates and rivets as shown.

Rivet the baggage floors to the F-01406A-L & -R Bulkheads and F-01406B Bulkhead using the rivets as shown.

Rivet the baggage floors to the F-01428-L & -R Side Frames using the rivets as shown.

Step 7: Cleco then rivet the six F-01447B Seatback Hinges to the F-01447-L & -R Baggage Floors.

- ☆ CS4-4
- ⊗ LP4-3
- ◁ AN426AD4-4
- ▽ AN426AD3-3
- ⊗ CCR-264SS-3-2

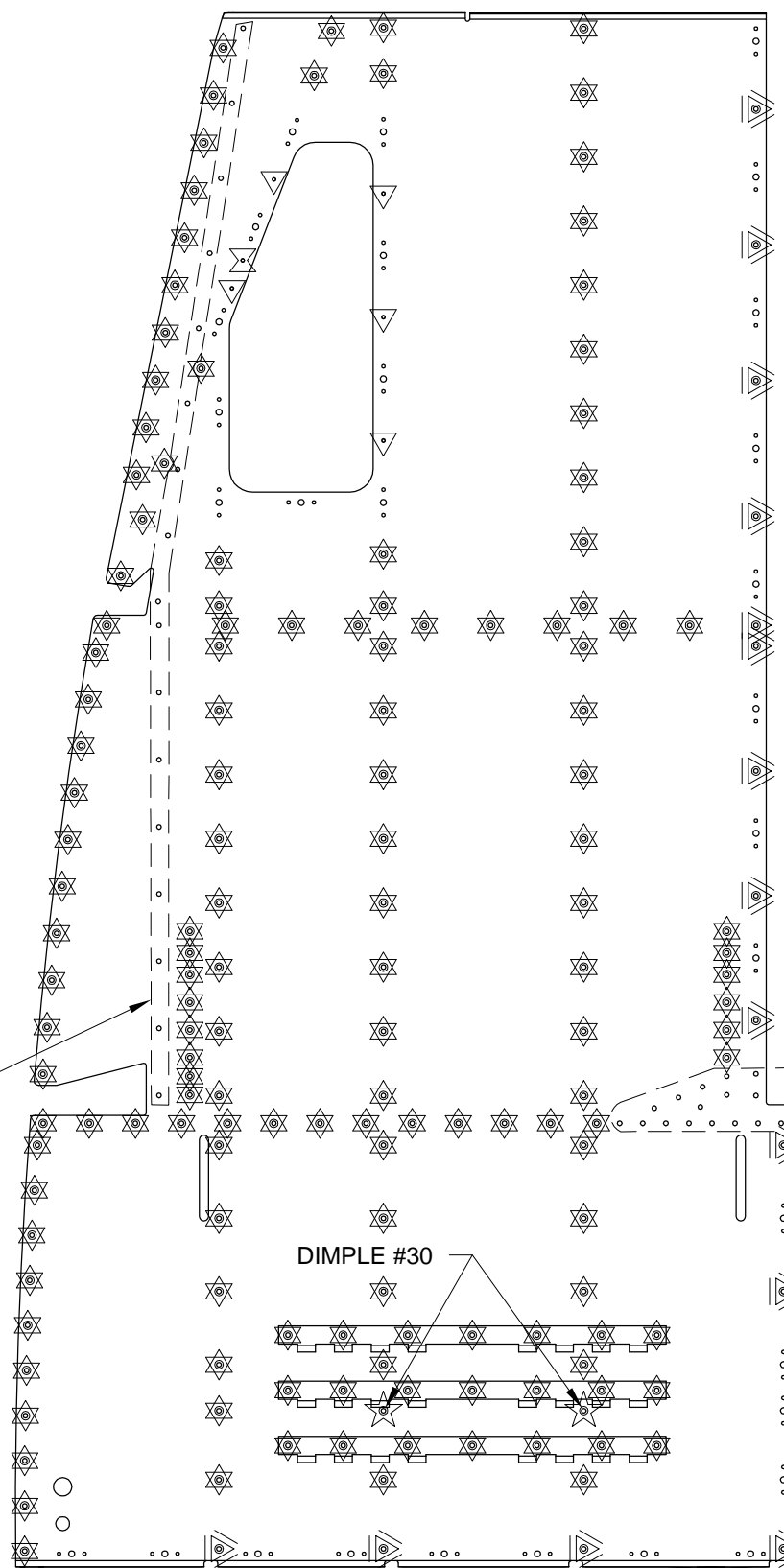


FIGURE 1: BAGGAGE FLOOR RIVETS
(RIGHT SIDE SHOWN, TOP VIEW LOOKING DOWN)

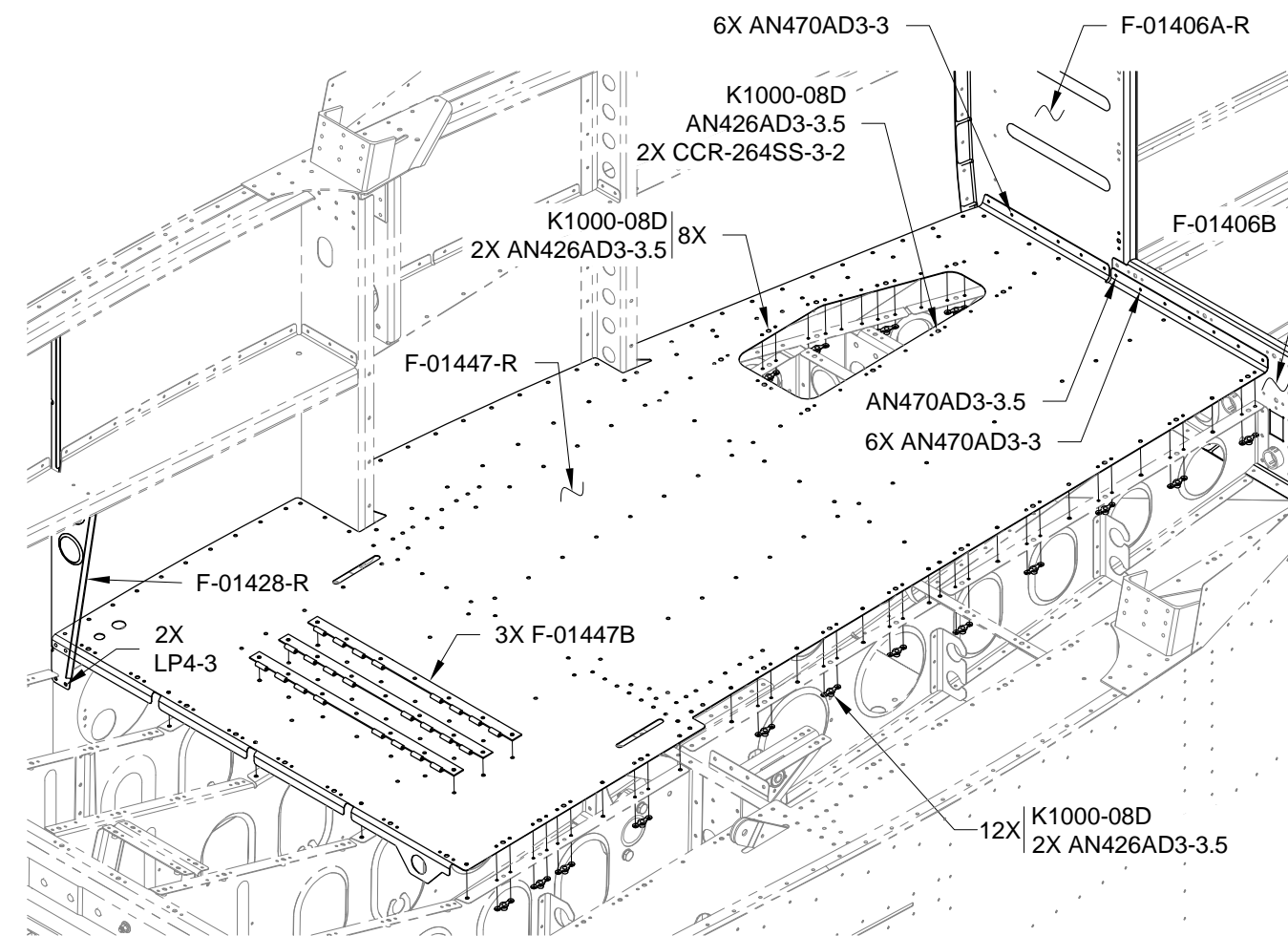
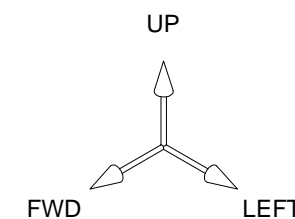
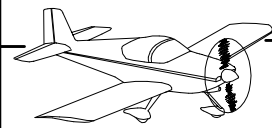


FIGURE 2: INSTALL BAGGAGE FLOORS
(RIGHT SIDE SHOWN)





Step 1: Machine countersink the F-14141 Baggage Floor Splice as shown in Figure 1. **DO NOT** machine countersink the nutplate center holes.

Step 2: Rivet the nutplates to the F-14141 Baggage Floor Splice as shown in Figure 2.

Step 3: Rivet the F-14141 Baggage Floor Splice to the F-01447-L & -R Baggage Floors as shown in Figure 1 and Figure 2.

Step 4: Dimple the #40 holes in the F-01405G Flap Motor Channel as shown in Figure 3.

Step 5: Rivet the nutplates to the F-01405G Flap Motor Channel as shown in Figure 3.

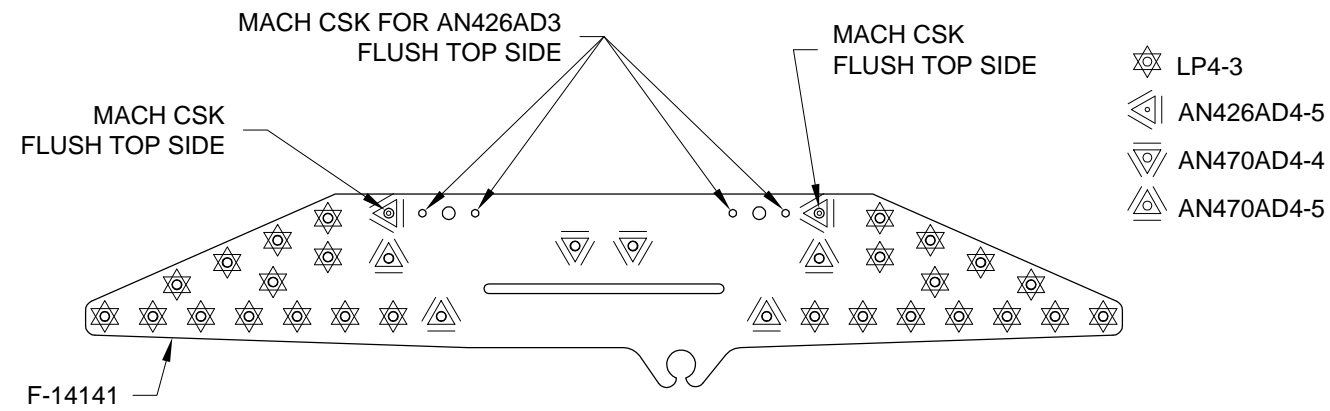


FIGURE 1: BAGGAGE FLOOR SPLICE
(TOP VIEW LOOKING DOWN)

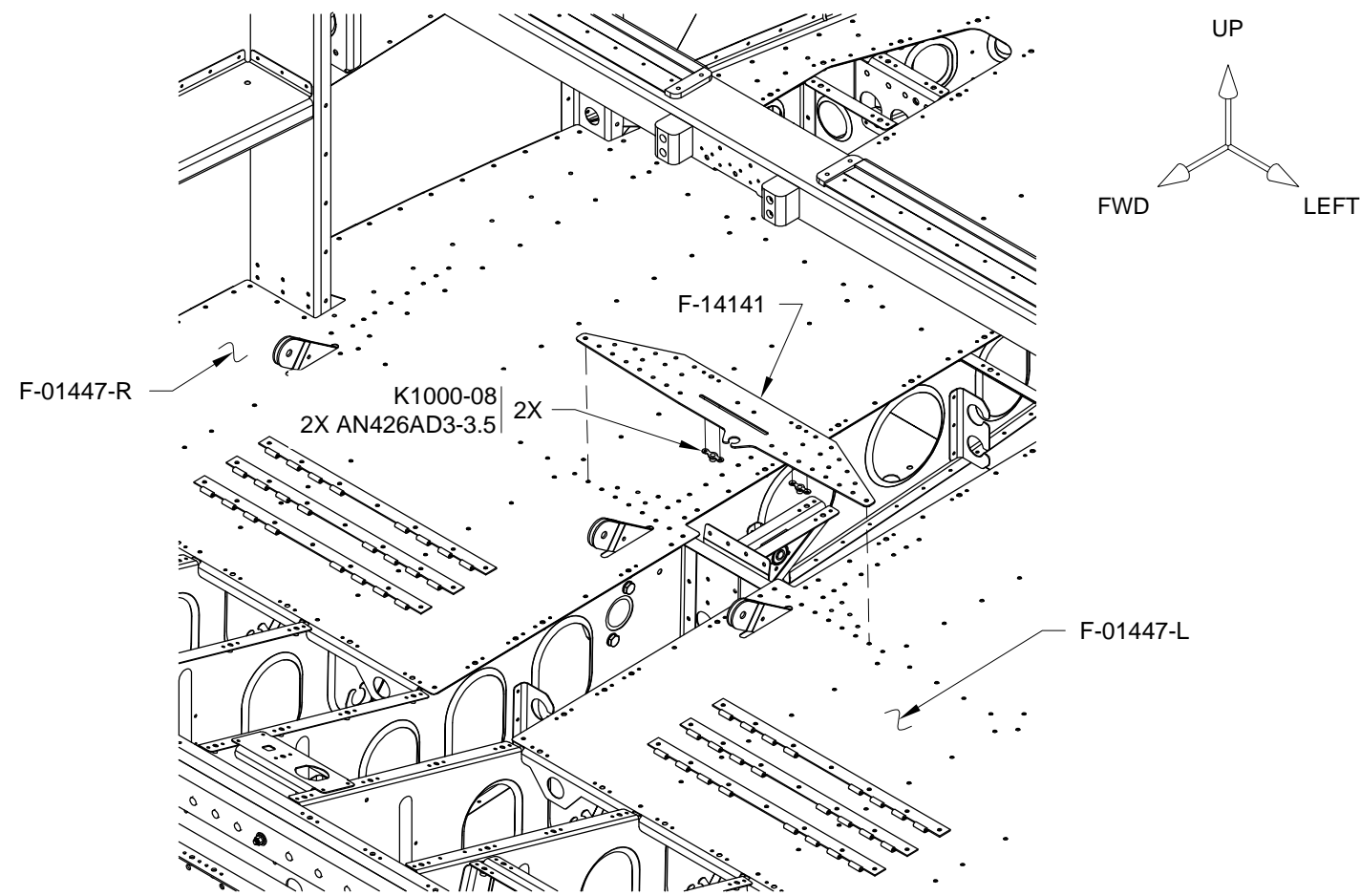


FIGURE 2: INSTALL BAGGAGE FLOOR SPLICE

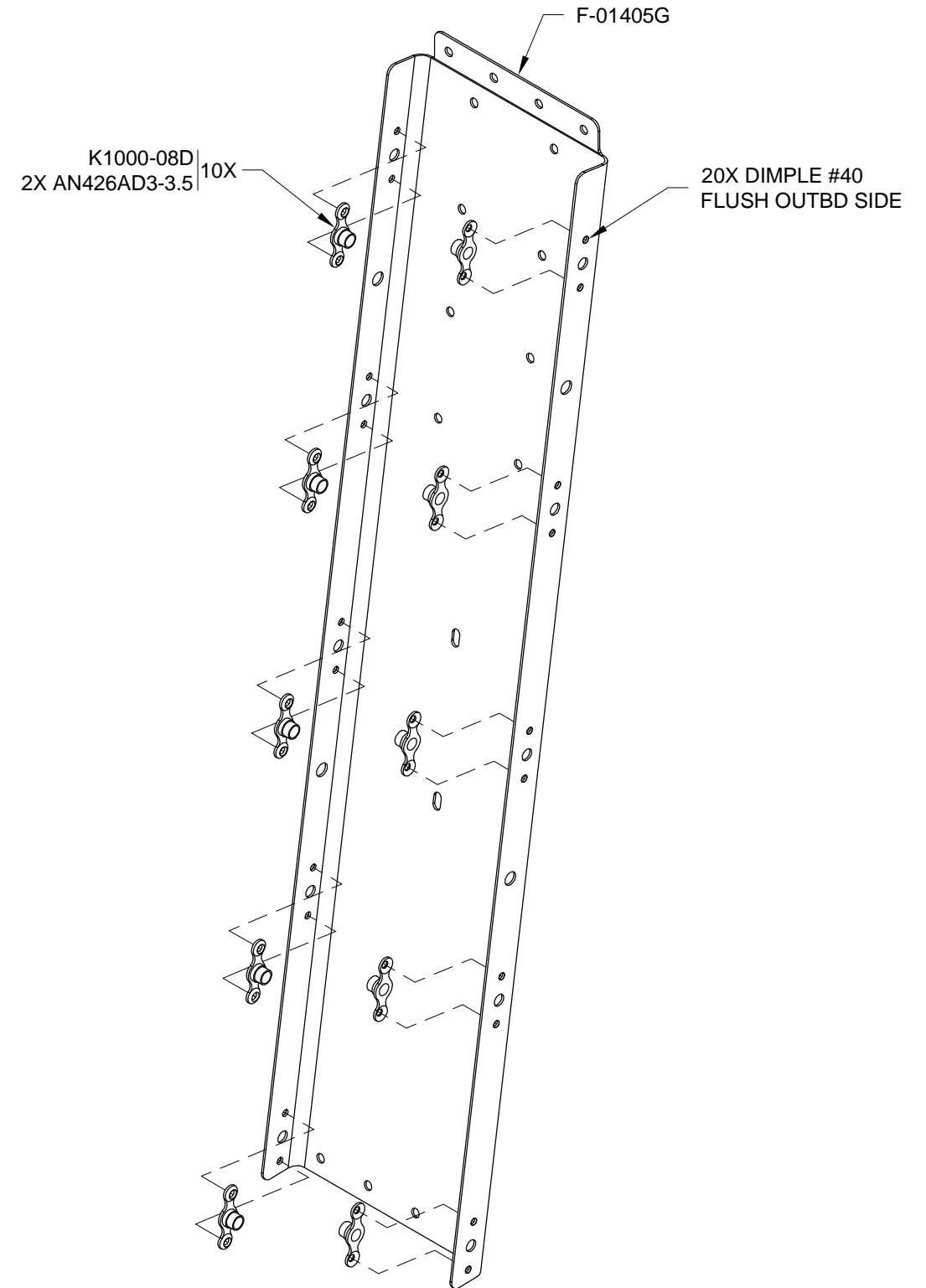
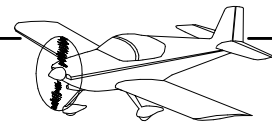


FIGURE 3: FLAP MOTOR CHANNEL



NOTE: The forward side of the F-01405G Flap Motor Channel mates with the aft side of the F-01405L Bulkhead Doubler.

Step 1: Rivet the upper flange of the F-01405G Flap Motor Channel to the F-01405F Mid Fuse Brace as shown in Figure 1.

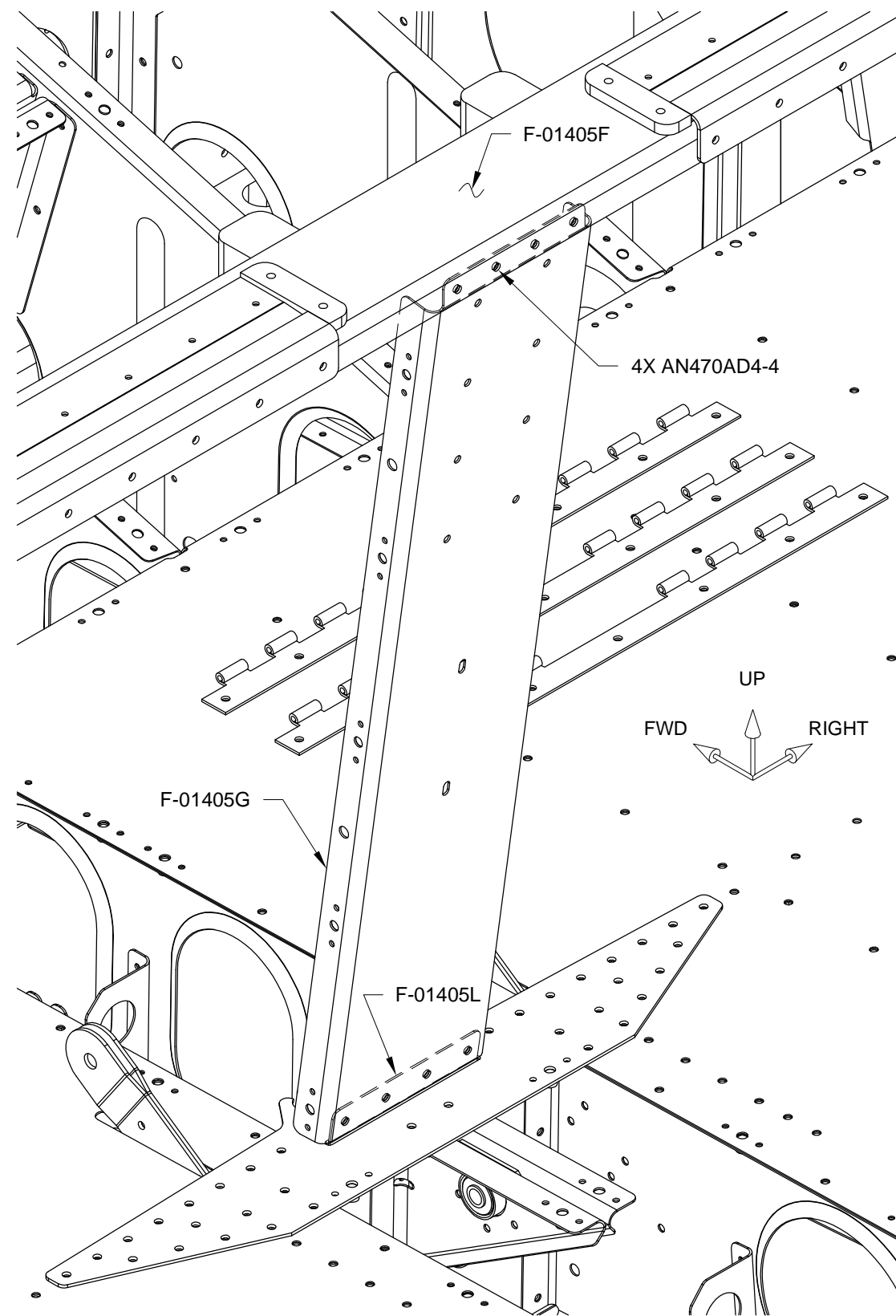


FIGURE 1: INSTALL FLAP MOTOR CHANNEL

Step 2: Trim the F-01466-L & -R Flap Motor Brackets as shown in the detail view in Figure 2.

Step 3: Rivet the F-01466-L & -R Flap Motor Brackets to the F-01405G Flap Motor Channel as shown in Figure 2. The rivet call-outs shown for F-01466-L also apply to F-01466-R.

Pull the flap motor channel aft as required when installing the flap motor brackets.

Step 4: Rivet the lower end of the F-01405G Flap Motor Channel to the F-01405L Bulkhead Doubler as shown in Figure 2.

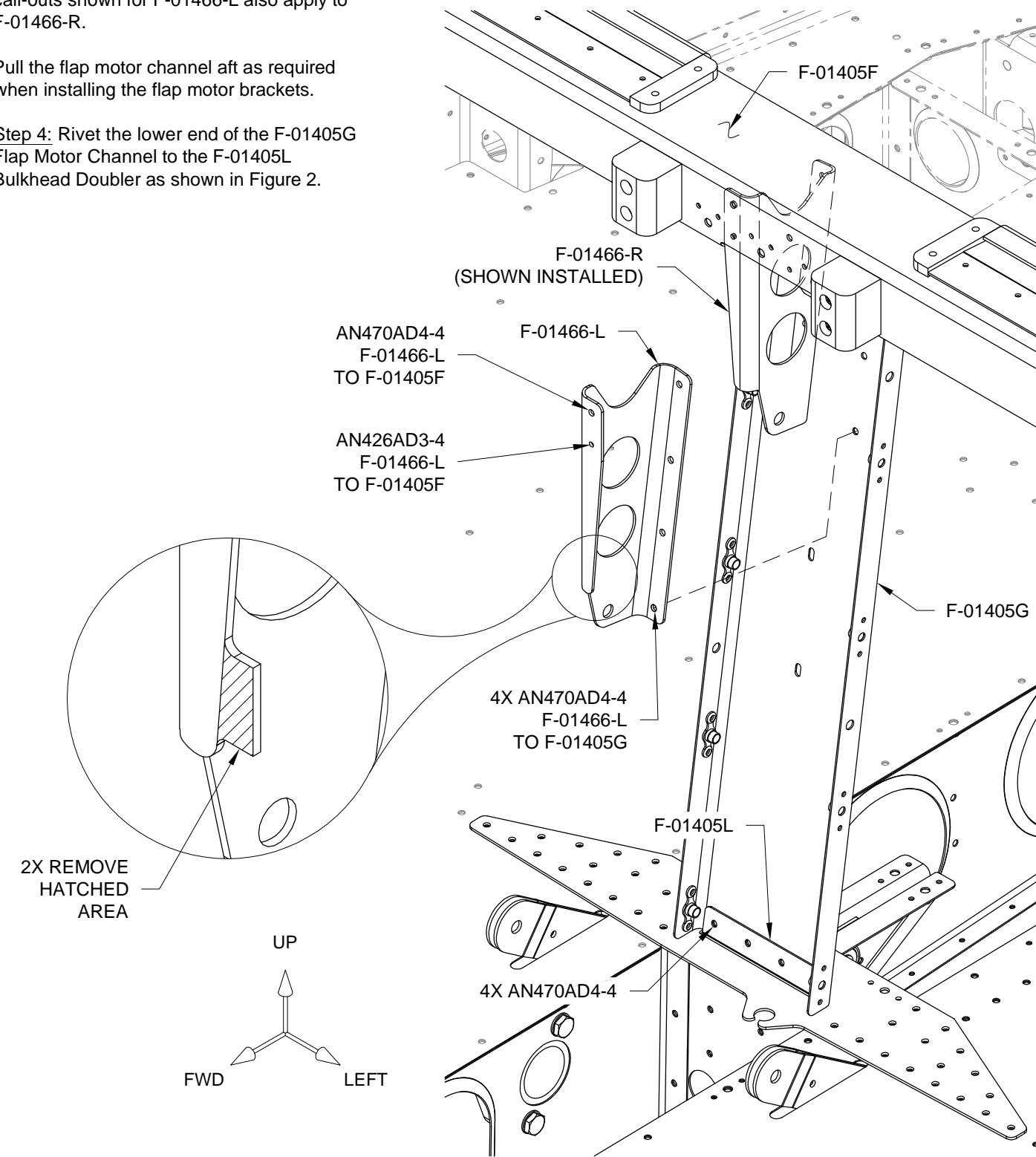


FIGURE 2: INSTALL FLAP MOTOR BRACKETS



NOTE: Refer to Figure 1 for the following steps.

Step 1: Break the forward and aft edges of the F-01481-L & -R Fwd Baggage Side Covers.

Step 2: Break the edge on the aft flange of the F-01482-L & -R Aft Baggage Side Covers.

Step 3: Cleco the F-01482-L & -R Aft Baggage Side Covers to the fuselage.

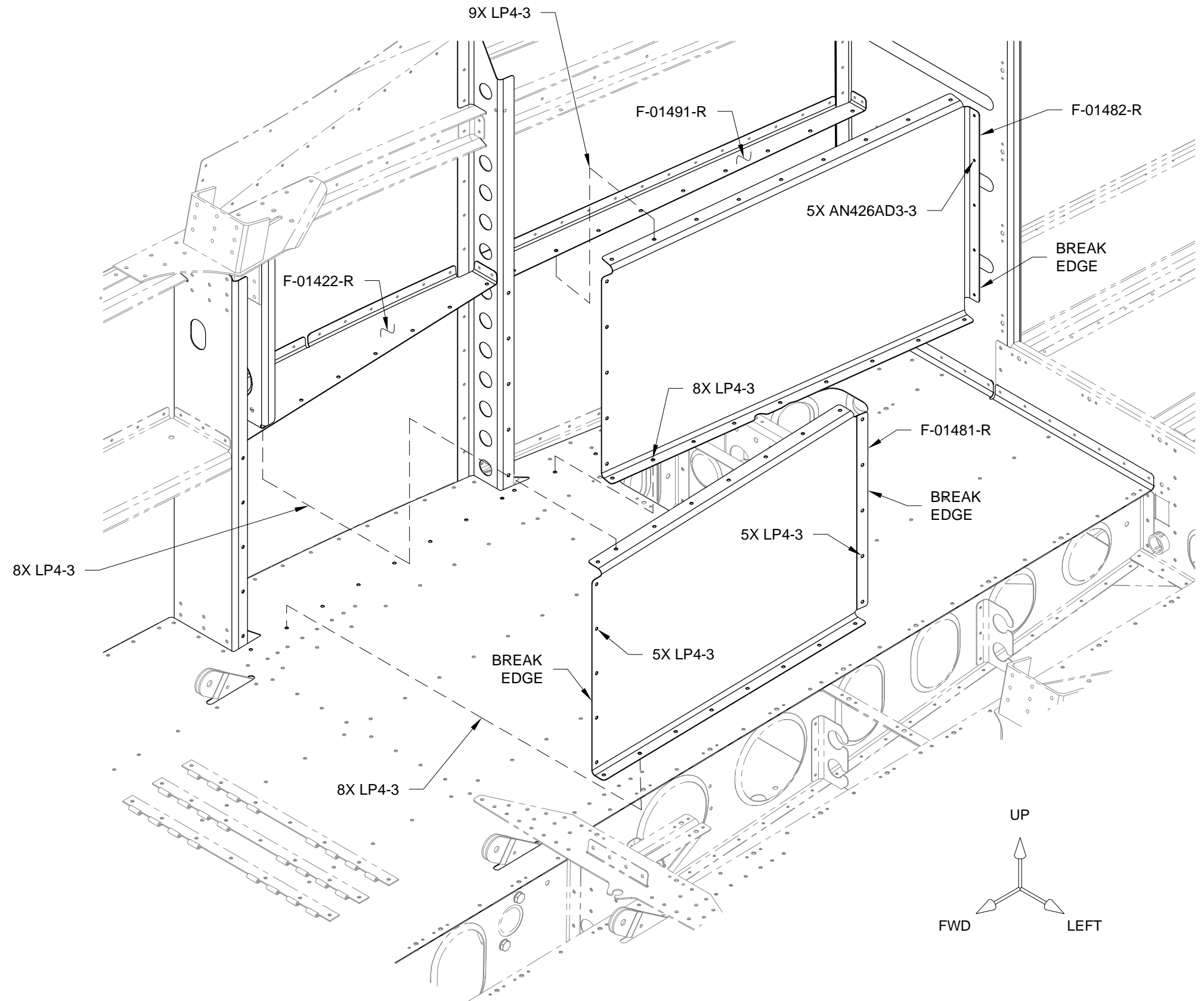
The aft baggage side covers install underneath the F-01491-L & -R Fuselage Side Ribs.

Step 4: Cleco the F-01481-L & -R Fwd Baggage Side Covers to the fuselage.

The fwd baggage side covers install underneath the F-01422- L & -R Fuselage Side Ribs.

Step 5: Rivet the F-1481-L & -R Fwd Baggage Side Covers and F-01482-L & -R Aft Baggage Side Covers to the fuselage.

NOTE: If you choose to do so, now is a good time to paint the interior of the cockpit.



**FIGURE 1: INSTALL BAGGAGE SIDE COVERS
(RIGHT SIDE SHOWN)**