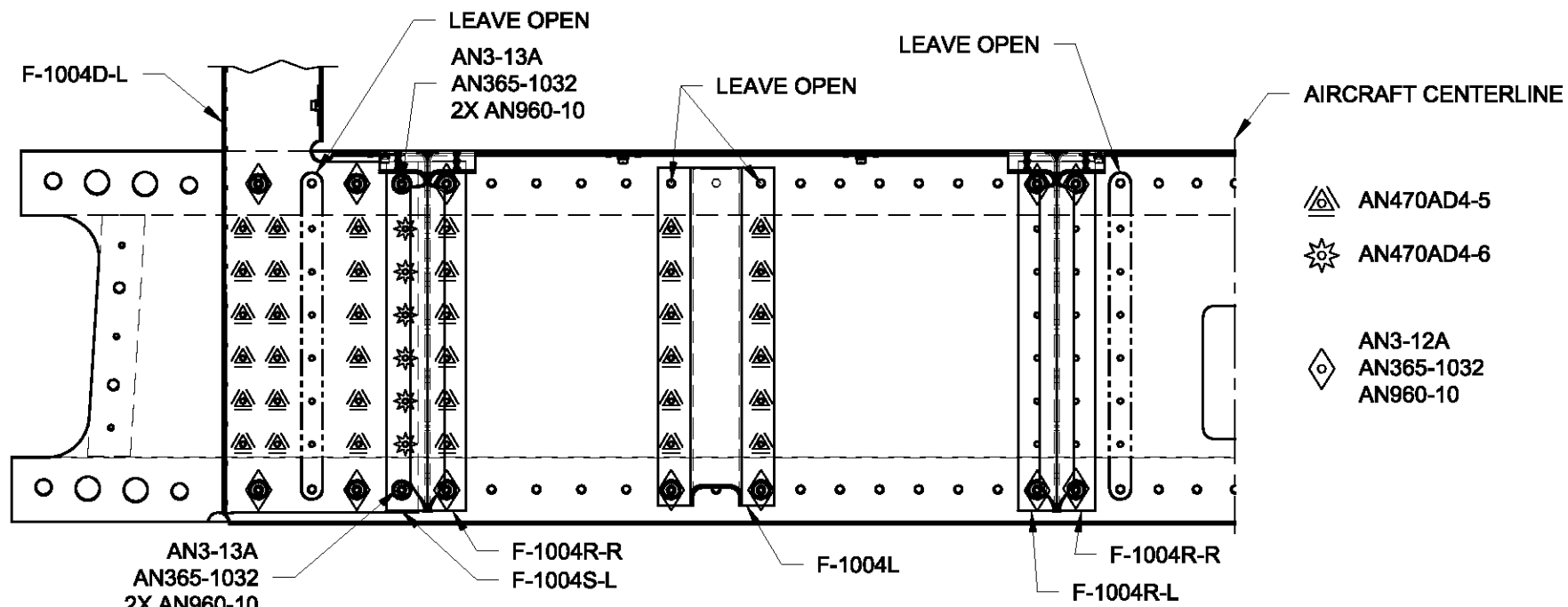


Step 1: Rivet nutplates to the F-1004B, F-1004D-L and -R Center Section Bulkheads as shown in Figure 2.



**FIGURE 1: AFT BULKHEAD HARDWARE**  
(CALLOUTS ARE FOR THE LEFT SIDE OF THE AIRCRAFT  
CALLOUTS ARE SYMMETRICAL ABOUT  
THE AIRCRAFT CENTERLINE)

Step 2: Bolt the Aft Seat Rail Support Subassemblies, F-1004D-L and -R Center Section Bulkheads and F-1004L Center Section Hat Stiffeners to the F-1004B Center Section Bulkhead as shown in Figure 2.

Step 3: Rivet the F-1004D-L and -R Center Section Bulkheads, F-1004L Center Section Hat Stiffeners and Aft Seat Rail Support Subassemblies to the F-1004B Center Section Bulkhead as shown in Page 25-5, Figure 3 and per the callouts in Figure 1.

Step 4: Insert snap bushings into the F-1004D-L and -R Center Section Bulkheads as shown in Figure 2.

Step 5: Fabricate the F-1004M Wear Strip by cutting a piece of 1/8 inch thick by 1/2 inch wide UHMW plastic to 4 3/4 inches long. The wear strip may be up to 1/32 inch short but must not be over length.

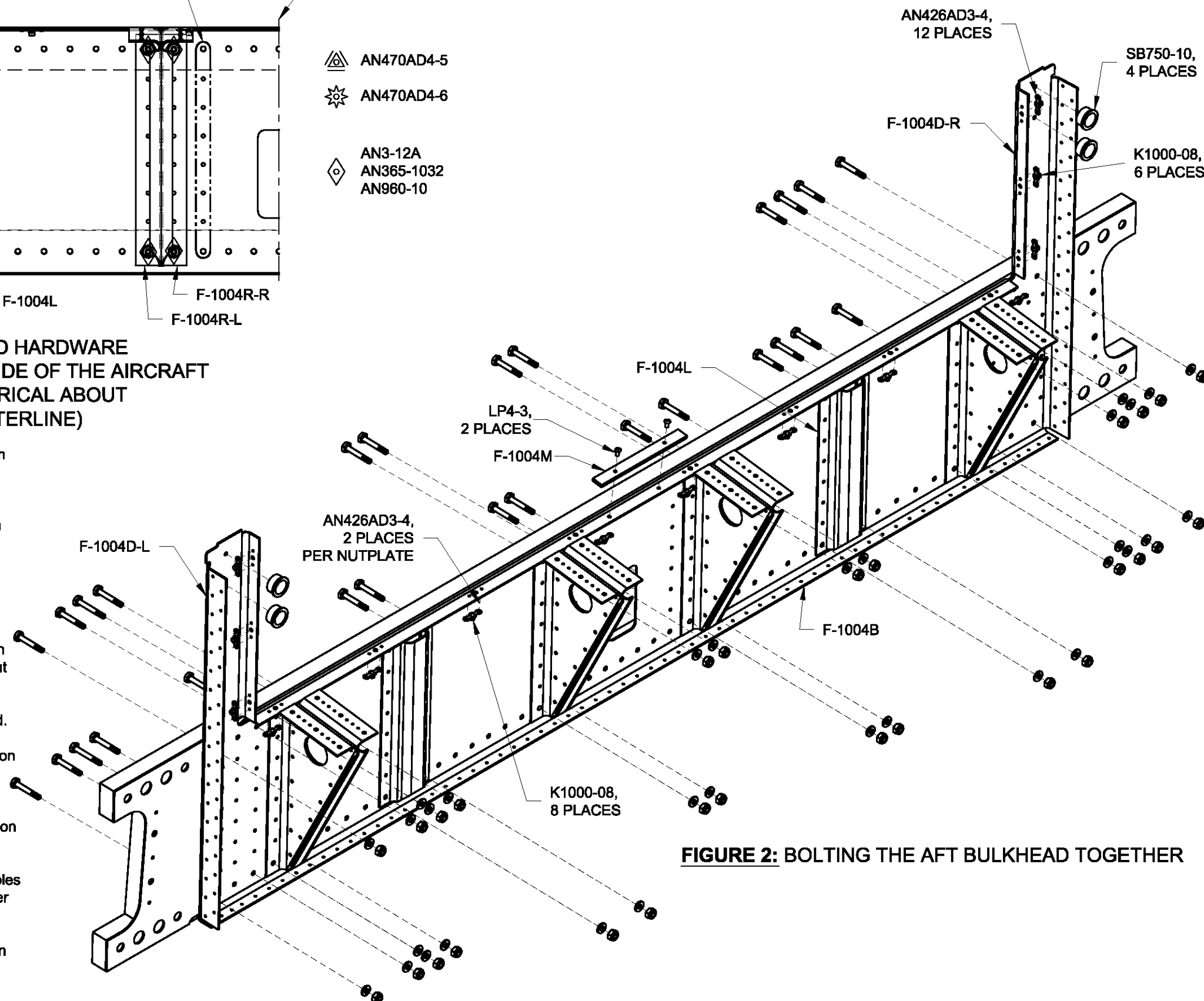
Drill two #30 holes centered on the width of the wear strip, each one 1 inch from the end.

Step 6: Clamp the F-1004M Wear Strip to the upper flange of the F-1004B Center Section Bulkhead.

Position the wear strip such that the aft edge of the wear strip is flush with the center section bulkhead upper flange aft edge and such that the wear strip is exactly centered on the center section bulkhead upper flange.

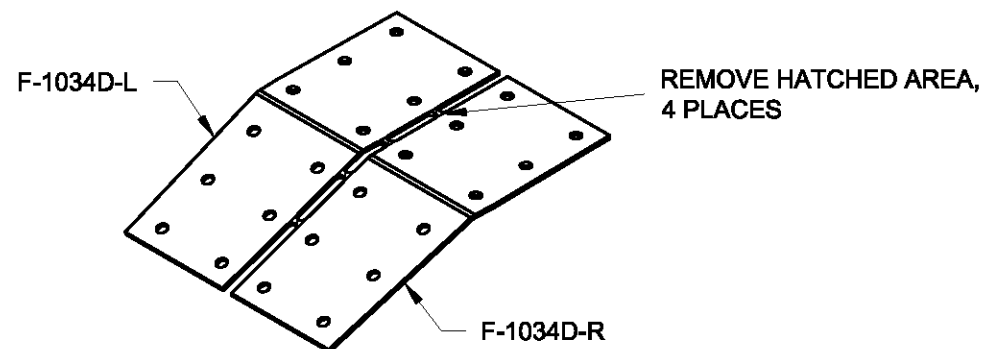
Match-drill two #30 holes through the center section bulkhead upper flange using the holes in the wear strip as drill guides. Remove the wear strip and deburr the holes in the center section bulkhead.

Step 7: Rivet the F-1004M Wear Strip to the upper flange of the F-1004B Center Section Bulkhead as shown in Figure 2.



**FIGURE 2: BOLTING THE AFT BULKHEAD TOGETHER**

**Step 1:** Cut the F-1034D-L and -R Gussets apart from one another as shown in Figure 1.



**FIGURE 1: BREAKING APART THE GUSSETS**

**Step 2:** Cleco the F-1034A Fuselage Bulkhead, F-1034C-L and -R Fuselage Bulkheads, and F-1034D-L and -R Gussets together as shown in Figure 2.

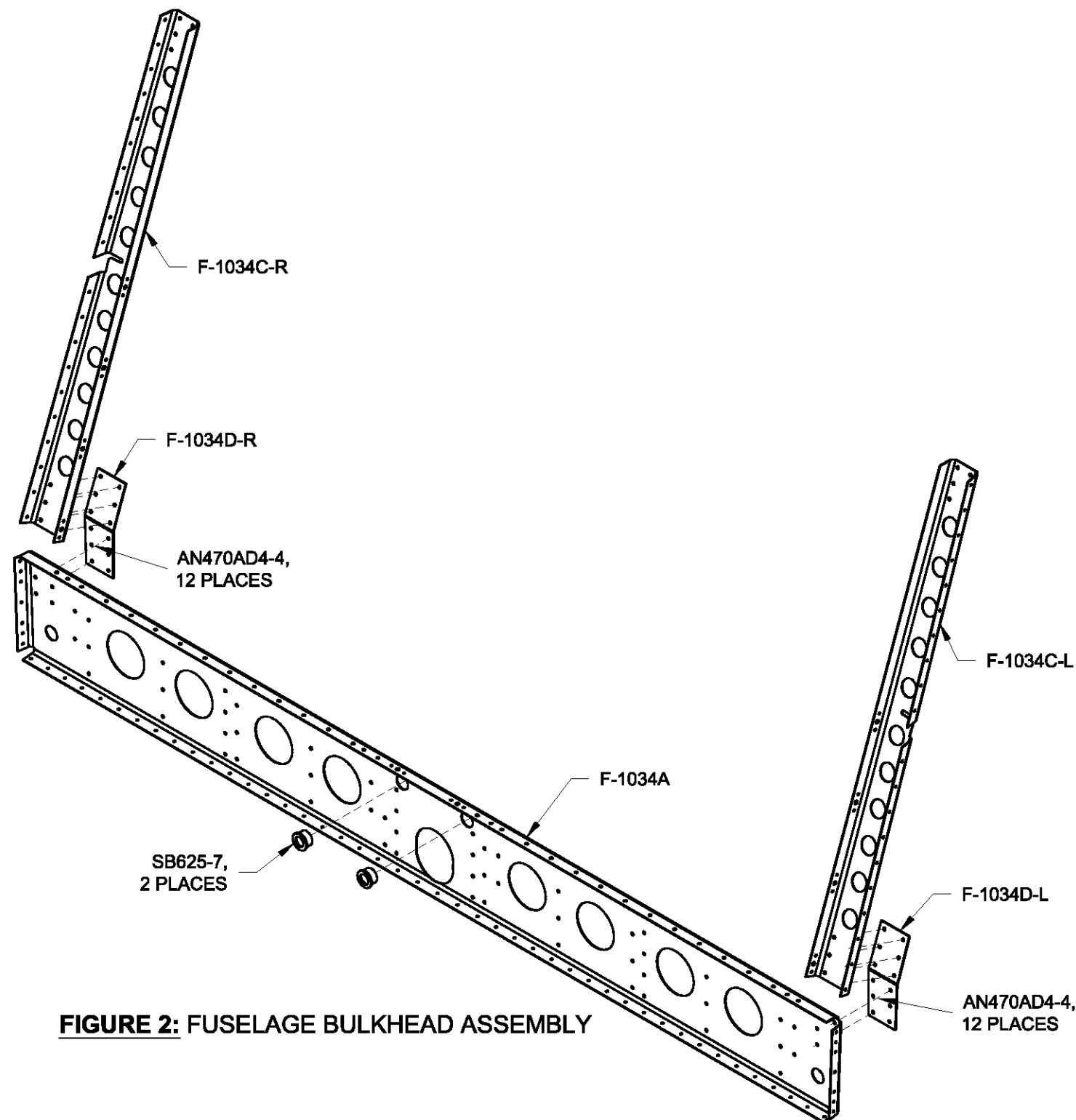
**Step 3:** Final-Drill #30 all holes common between the parts clecoed together in Step 2.

**Step 4:** Final-Drill the nutplate attach holes for both nutplates near the center of the F-1034A Fuselage Bulkheads upper flange. Final-Drill #19 the screw holes for these nutplates.

**Step 5:** Disassemble all parts and deburr all edges. Prime parts if/as desired.

**Step 6:** Rivet the F-1034D-L and -R Gussets to the F-1034A Fuselage Bulkhead per the callouts in Figure 2. To this subassembly rivet the F-1034C-L and -R Fuselage Bulkheads per the callouts in Figure 2.

**Step 7:** Install snap bushings into the F-1034A Fuselage Bulkhead as shown in Figure 2.



**FIGURE 2: FUSELAGE BULKHEAD ASSEMBLY**