

Step 1: Using the edge of a table or other straight edge, bend the lower portion of the F-1068A Sub Panel Center as shown in Figure 1.

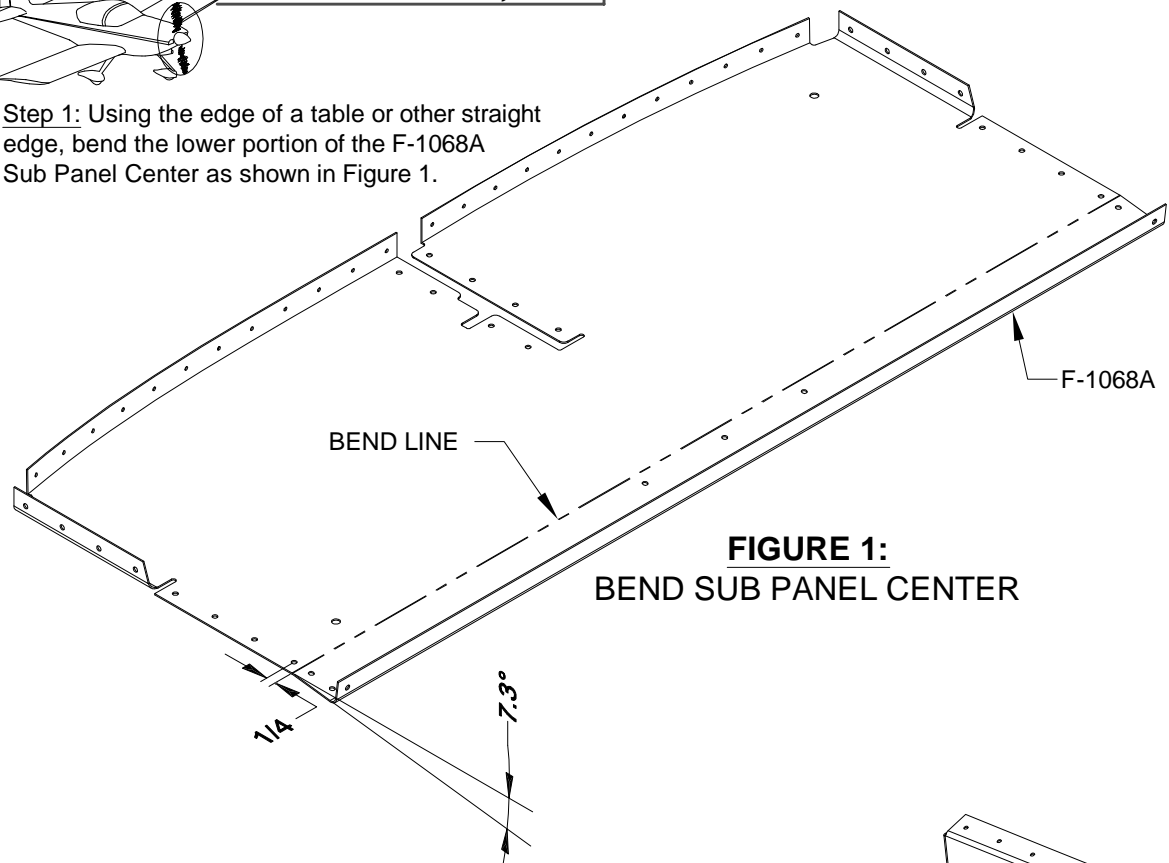


FIGURE 1:
BEND SUB PANEL CENTER

Step 2: Using the edge of a table or other straight edge, bend the lower portions of the F-1068B-L and F-1068B-R Sub Panel Sides as shown in Figure 2.

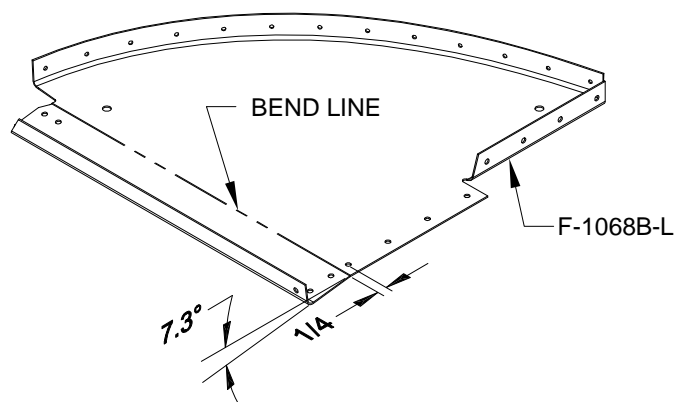


FIGURE 2: BEND SUB PANEL SIDE

Step 3: Flute and straighten the curved flanges of the F-1068B-L and F-1068B-R Sub Panel Sides per Section 5N.

Step 4: Cleco the F-1044A Fwd Fuselage Rib, F-1044D, E, & F Angles, F-1045-L & R Fwd Fuselage Ribs, F-1068A Sub Panel Center, F-1068B-L & R Sub Panel Sides, and F-1083Q Quadrant Mount Bracket as shown in Figure 3.

Final-Drill #30 all holes common to the parts clecoed together.

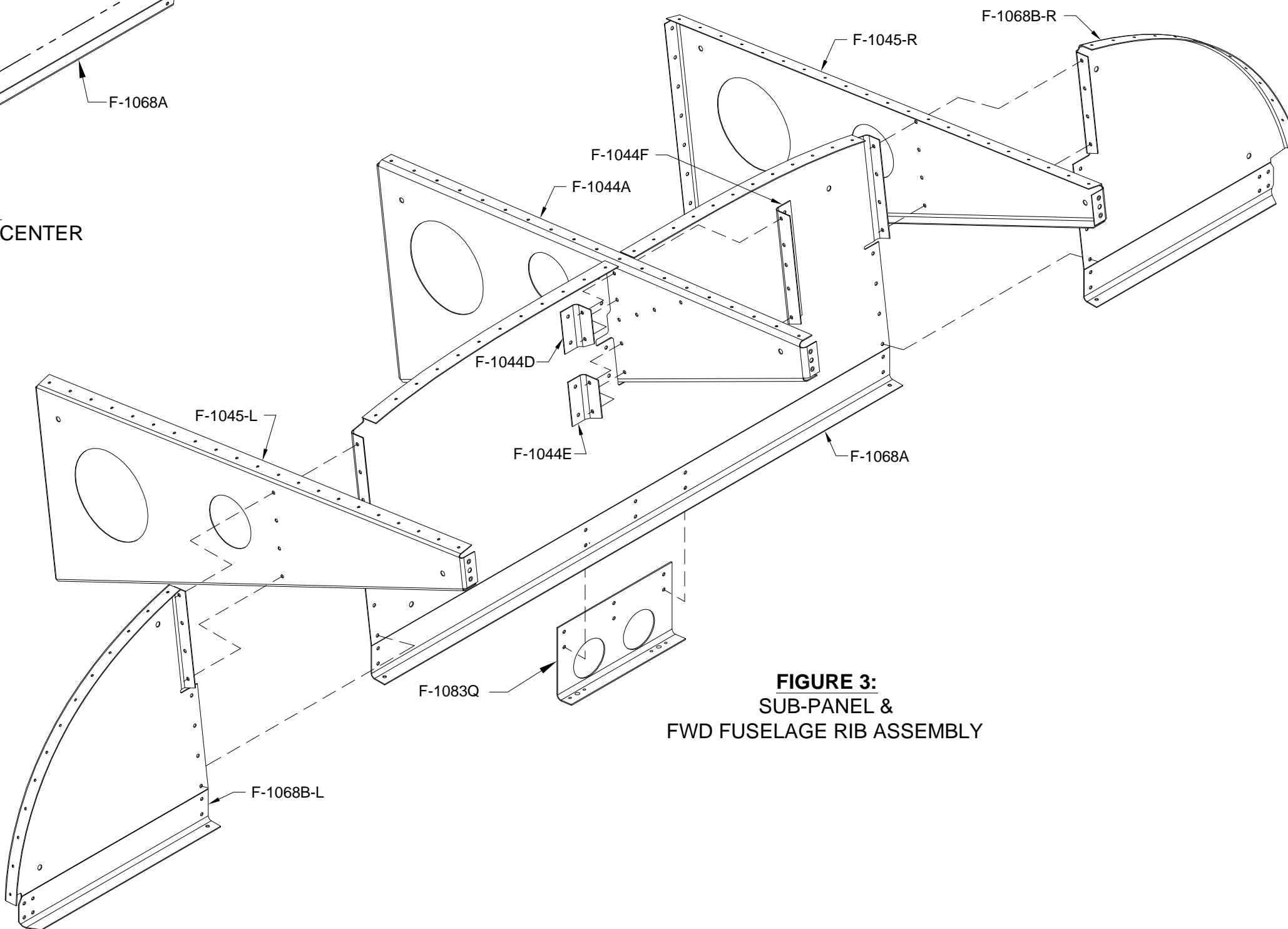
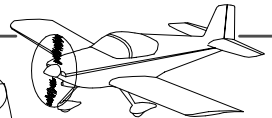


FIGURE 3:
SUB-PANEL &
FWD FUSELAGE RIB ASSEMBLY



Step 1: Rivet the F-1044 Fwd Fuselage Rib Subassembly and F-1083Q Quadrant Mount Bracket to the F-1068A Sub Panel Center as shown in Figure 1.

Step 2: Rivet the F-1068B-L Sub Panel Side and F-1045-L Fwd Fuselage Rib to the F-1068A Sub Panel Center as shown in Figure 1.

Rivet the F-1068B-R Sub Panel Side and F-1045-R Fwd Fuselage Rib to the sub panel center as shown in Figure 1.

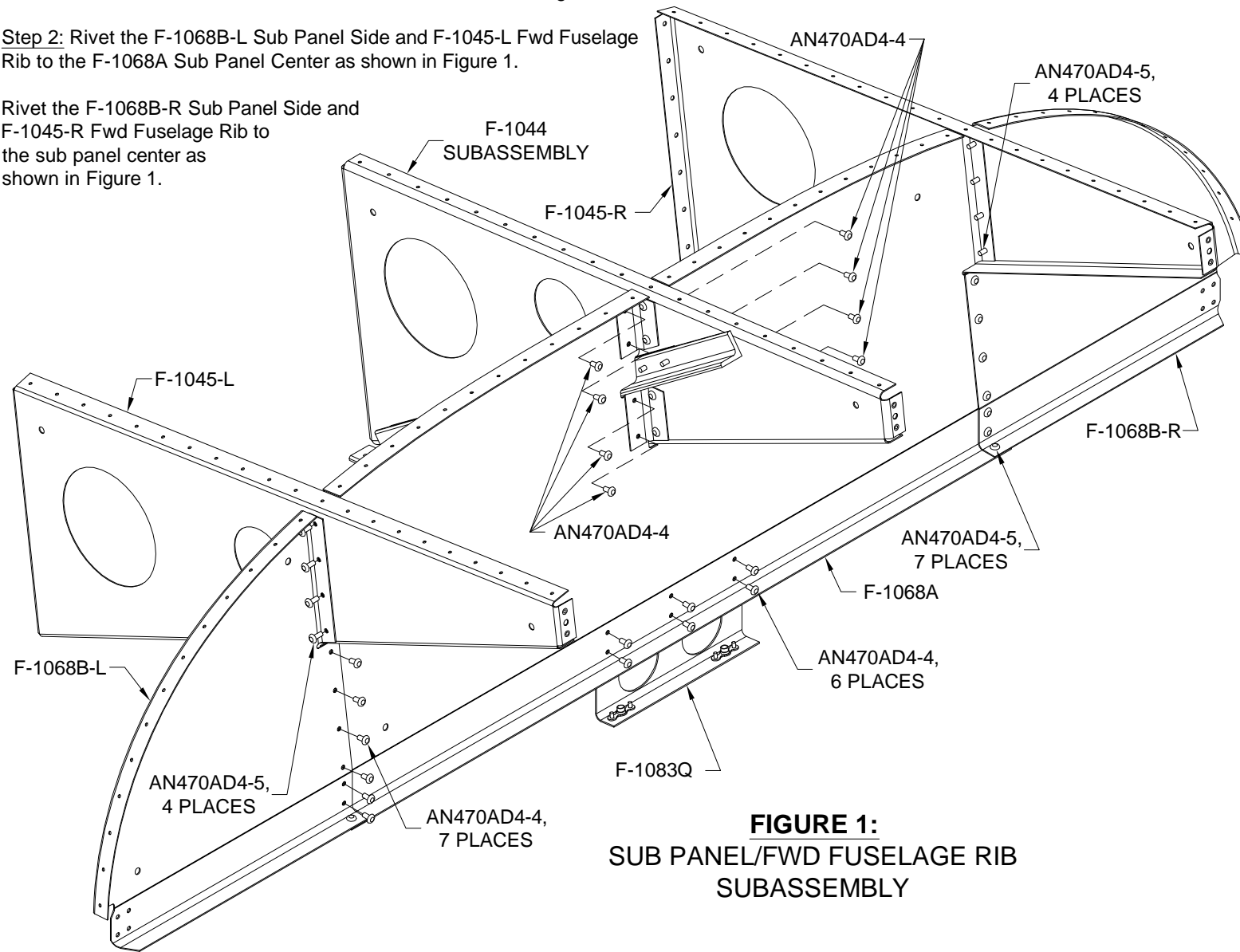


FIGURE 1:
SUB PANEL/FWD FUSELAGE RIB
SUBASSEMBLY

Step 3: Rivet the F-1071 Fwd Fuse Top Skin to the Sub Panel/Fwd Fuselage Rib Subassembly using the rivets and riveting sequence shown in Figure 2.

Install the rivets sequentially beginning with the rivet row labeled "RIVET 1st" through the rivet row labeled "RIVET 5th" only. See Figure 2.

Install the rivets in the rivet rows labeled "RIVET 6th" and "RIVET 7th" beginning each row with the most inboard rivet and progressing outboard. See Figure 2.

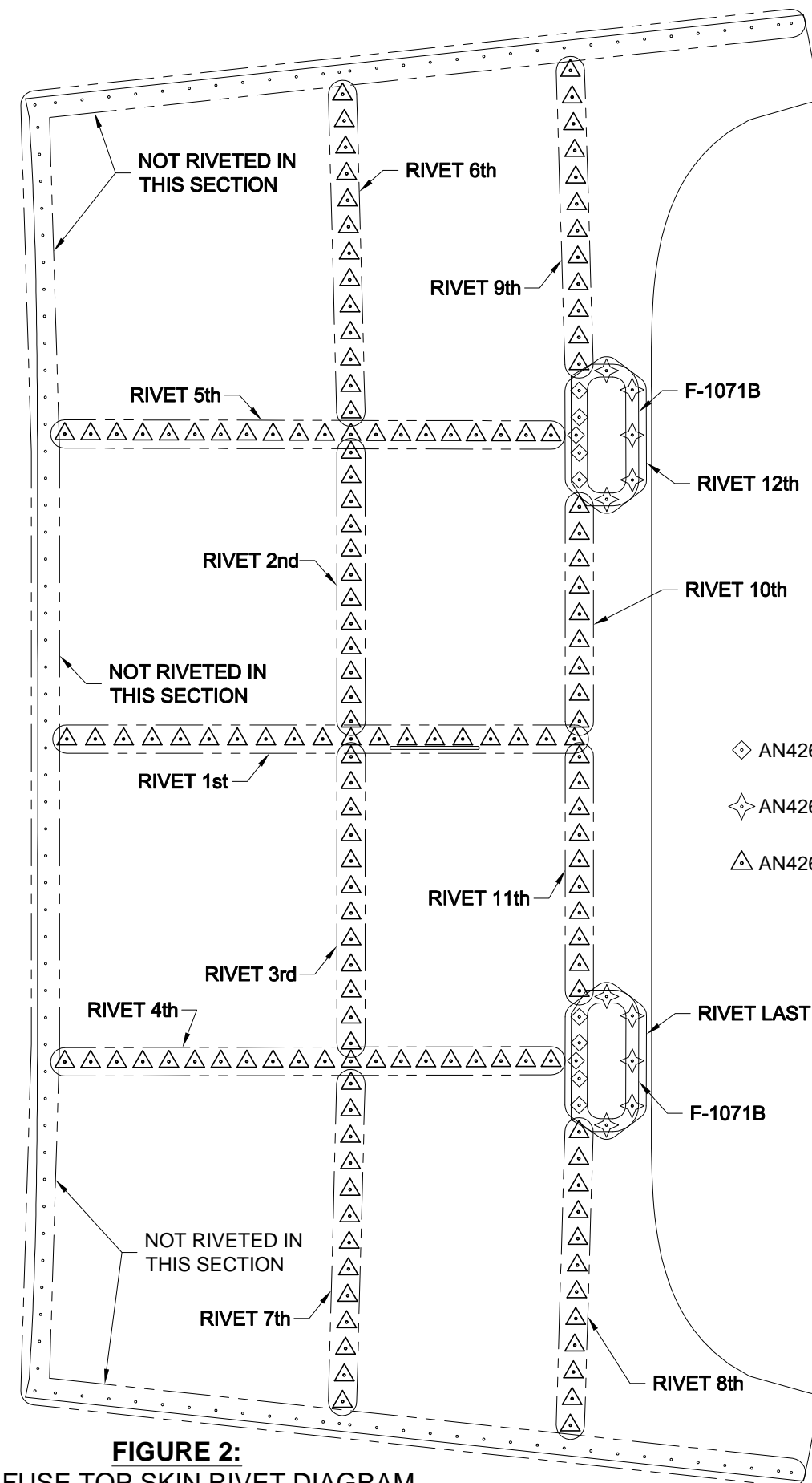


FIGURE 2:
FWD FUSE TOP SKIN RIVET DIAGRAM

Step 1: Rivet the F-1003C-L & R Inst Panel Attach Flanges to the F-1071 Fwd Fuse Top Skin as shown in Figure 1. Use the rivets and riveting sequence shown in Page 31-9Q, Figure 2.

Step 2: Rivet the F-1003D and F-1003E Inst Panel Attach Flanges to the F-1071 Fwd Fuse Top Skin as shown in Figure 1. Use the rivets and riveting sequence shown in Page 31-9Q, Figure 2.

Step 3: Rivet the two F-1071B Hand Hold Doublers to the F-1071 Fwd Fuse Top Skin as shown in Figure 1. Use the rivets shown in Page 31-9Q, Figure 2.

Step 4: Temporarily attach the F-1003A Instrument Panel and F-1003B Inst Panel Lower Flange to the Upper Forward Fuselage Subassembly and set aside for now.

The attachment of the upper forward fuselage subassembly is covered in a later section of the assembly manual. Now is a good time to plan the lay-out and installation of the items that will be mounted in and/or behind the instrument panel. Pay particular attention to placement of equipment so as to avoid interference with the upper forward fuselage structure.

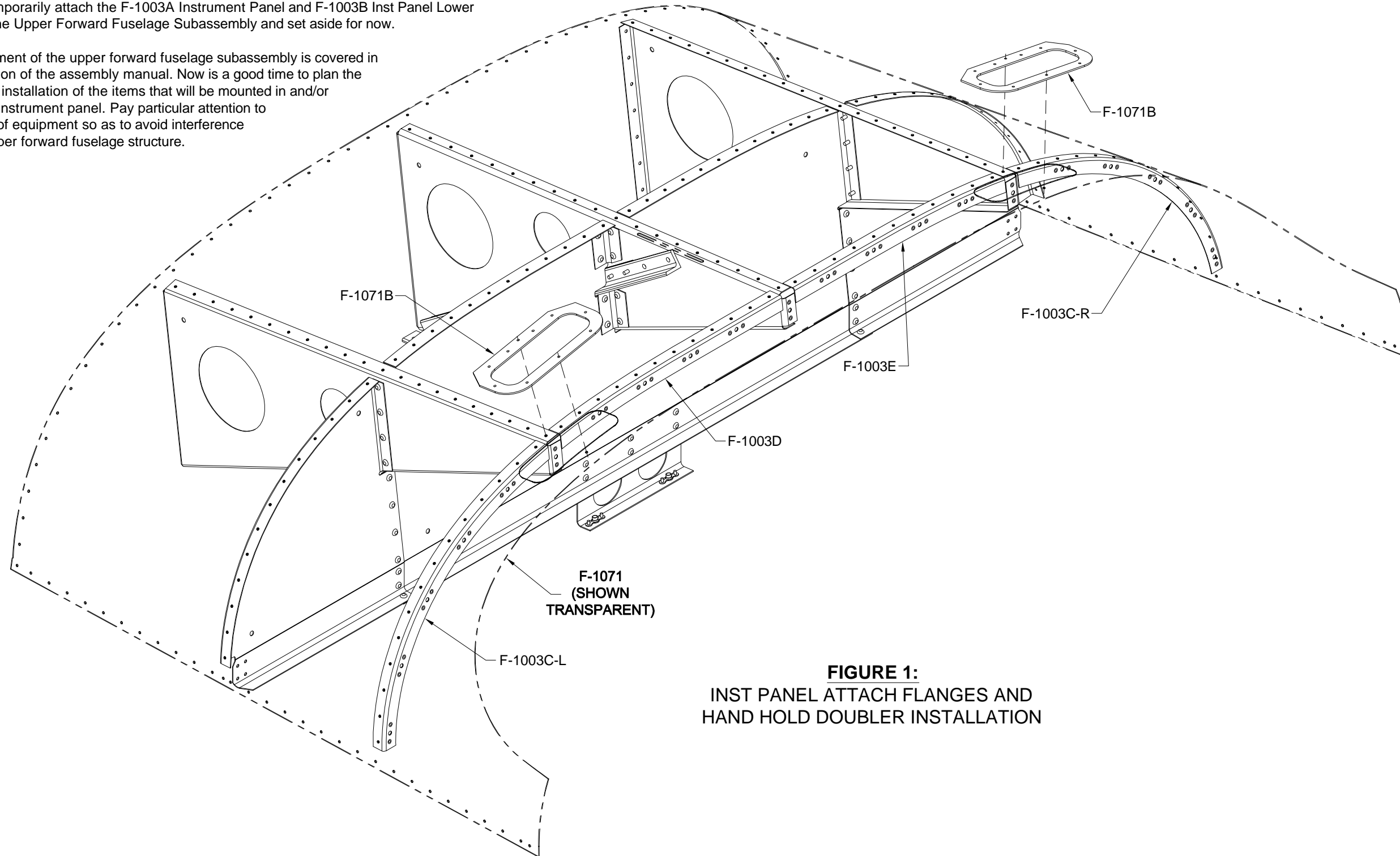


FIGURE 1:
INST PANEL ATTACH FLANGES AND
HAND HOLD DOUBLER INSTALLATION