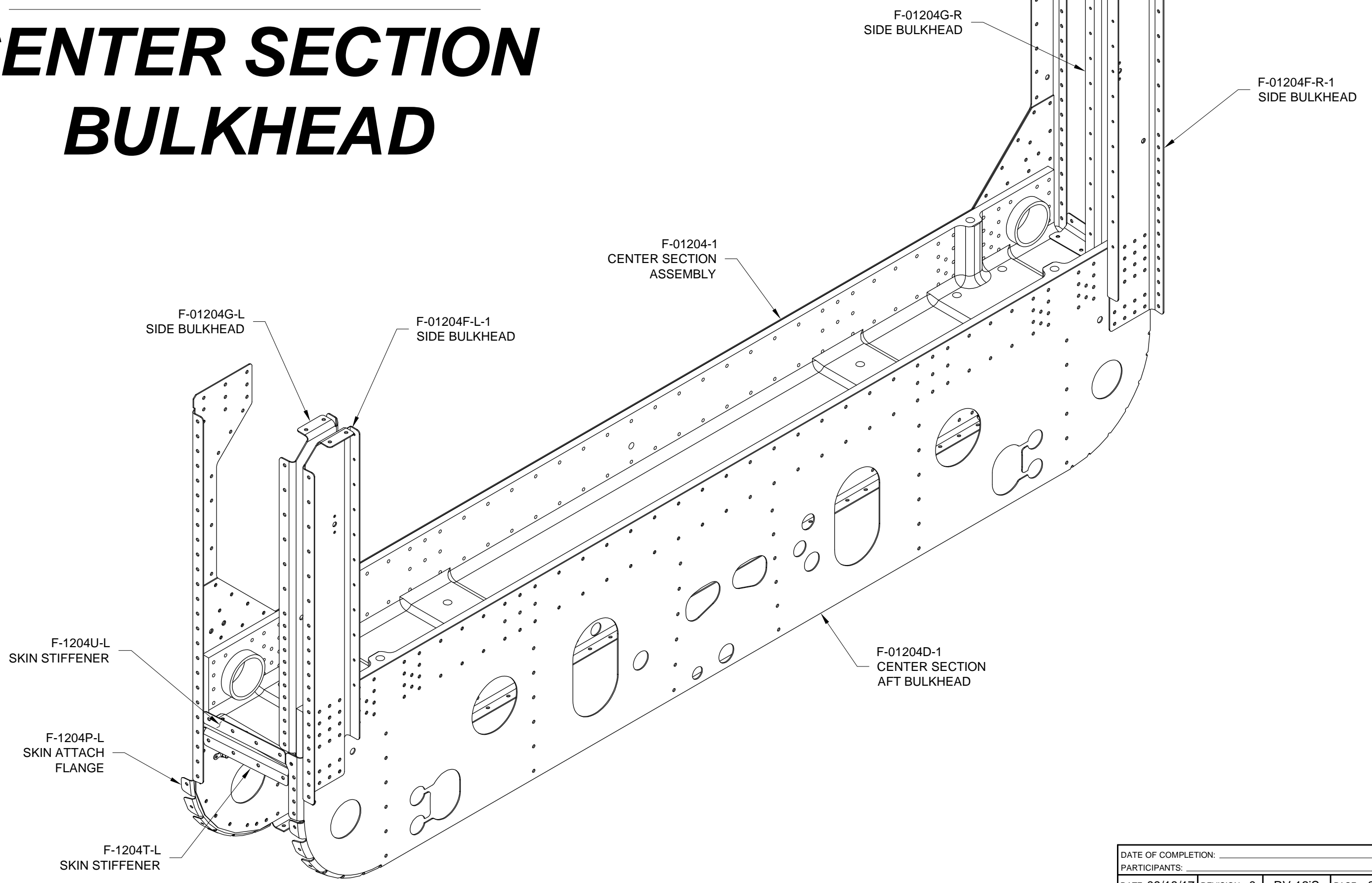


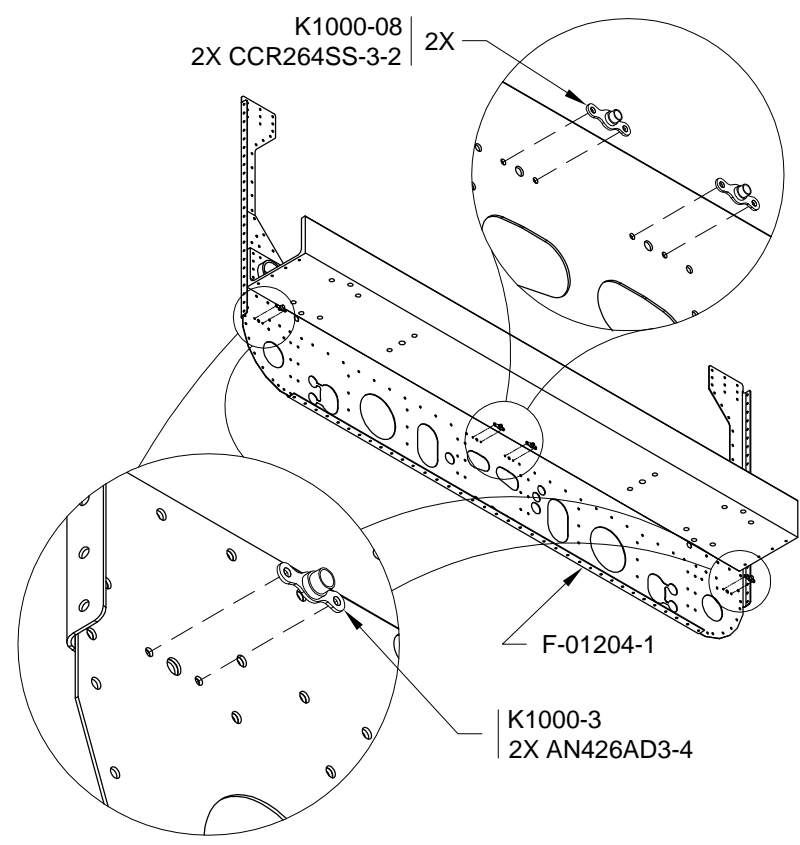
# SECTION 20iS: CENTER SECTION BULKHEAD



**NOTE:** In this section the F-01204-1 Center Section Assembly may be referred to simply as F-01204-1 or for the sake of clarity as either F-01204-1 bulkhead or F-01204-1 channel.

**Step 1:** Machine countersink #40 the nutplate rivet holes in the F-01204-1 bulkhead per Figure 1 call-outs.

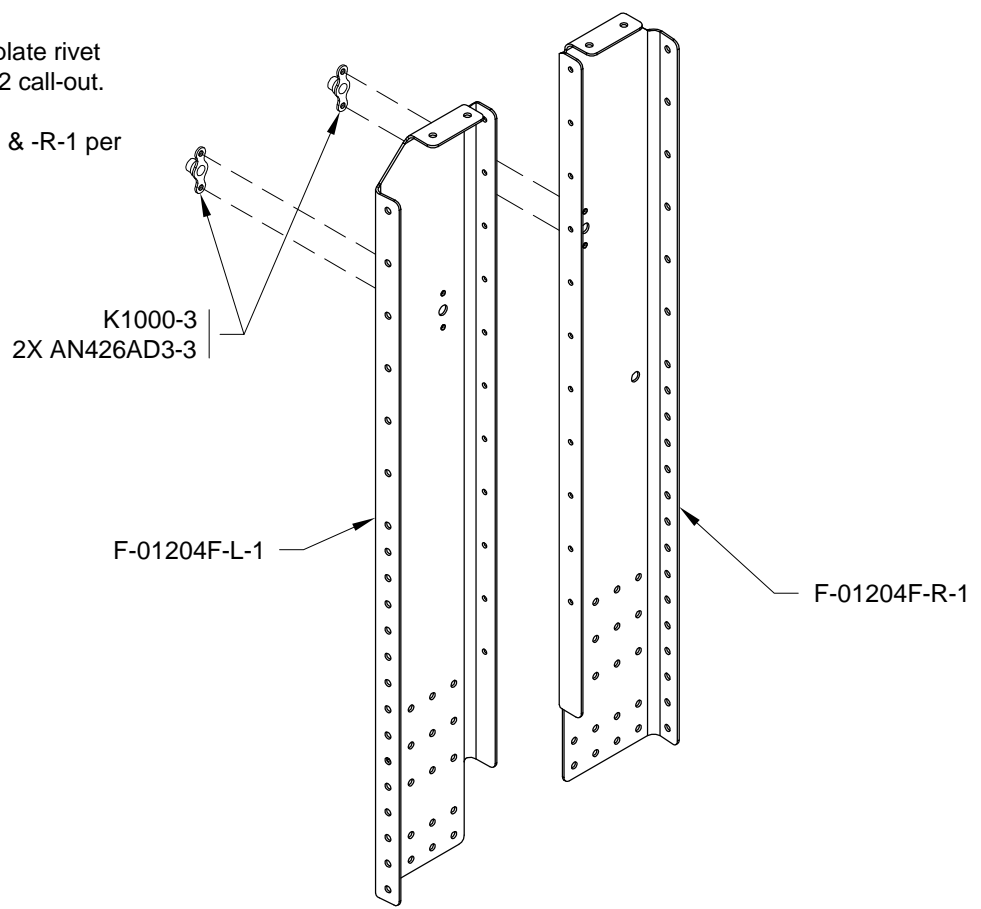
**Step 2:** Install nutplates on the F-01204-1 bulkhead per Figure 1 call-outs.



**FIGURE 1: INSTALL NUTPLATES**

**Step 3:** Machine countersink #40 the nutplate rivet holes in F-01204F-L-1 & -R-1 per Figure 2 call-out.

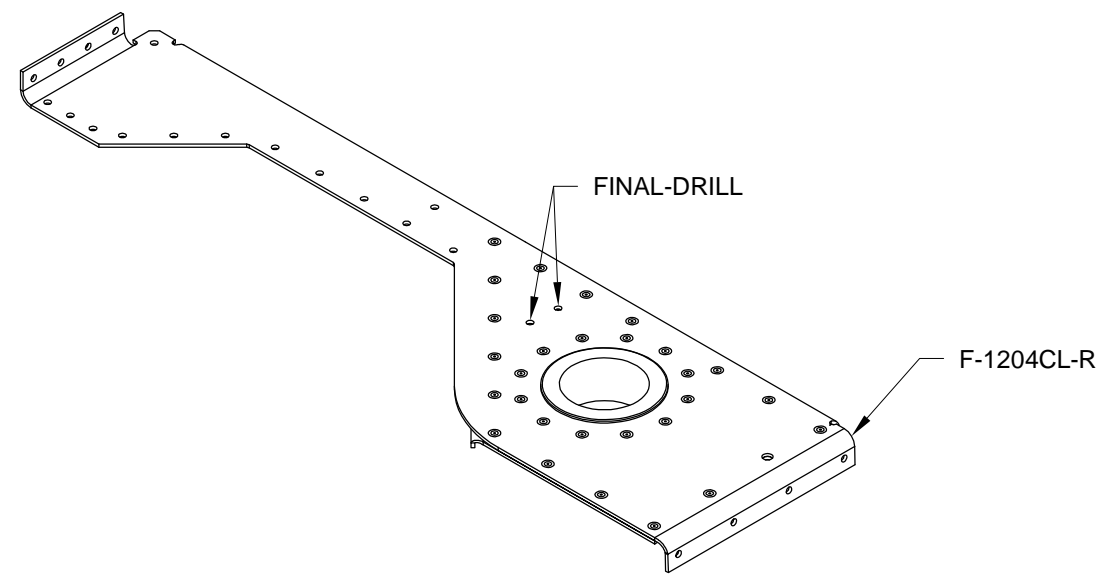
**Step 4:** Install nutplates on F-01204F-L-1 & -R-1 per the call-out.



**FIGURE 2: INSTALL NUTPLATES**

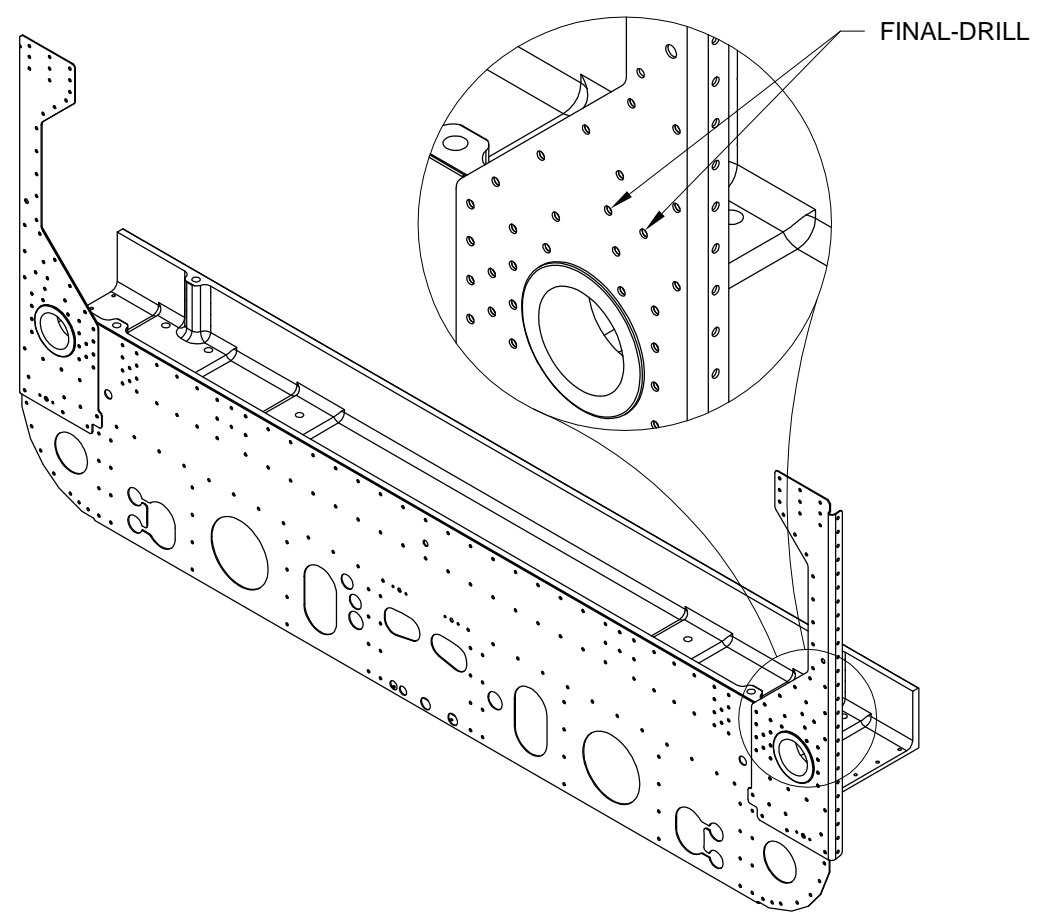
**Step 5:** Final-Drill #12 the two #30 holes in F-1204CL-R per the call-out in Figure 3.

Set this assembly aside for use in the next section.



**FIGURE 3: FINAL-DRILL F-1204CL-R**

**Step 6:** Final-Drill #12 the two #30 holes in the F-01204-1 Assembly per the call-out in Figure 4.



**FIGURE 4: FINAL-DRILL F-01204-1**



Step 1: Dimple #30 the holes indicated in the tabs at the corners of F-01204D-1 as shown in Figure 1 detail view.

Insert any two AN4 bolts into the 1/4 inch holes in F-01204D-1 as shown in Figure 1 detail view.

Rest the bottom surface of the F-01204-1 channel on the shanks of the two AN4 bolts per the call-out.

Clamp F-01204D-1 to F-01204-1 channel with spring clamps as shown.

Step 2: Place F-01276-1 on the tabletop. Place F-01204-1 over F-01276-1 and cleco the bottom flanges of both bulkheads to the skin. See Figure 3 for remaining steps on this page unless otherwise noted.

Step 3: Temporarily loosen the spring clamps holding F-01204D-1 to F-01204-1 and allow the parts to realign now that the F-01276-1 is clecoed in place. Re-tighten with C-clamps to securely hold the parts in alignment. Remove clecos from F-01276-1 and set aside.

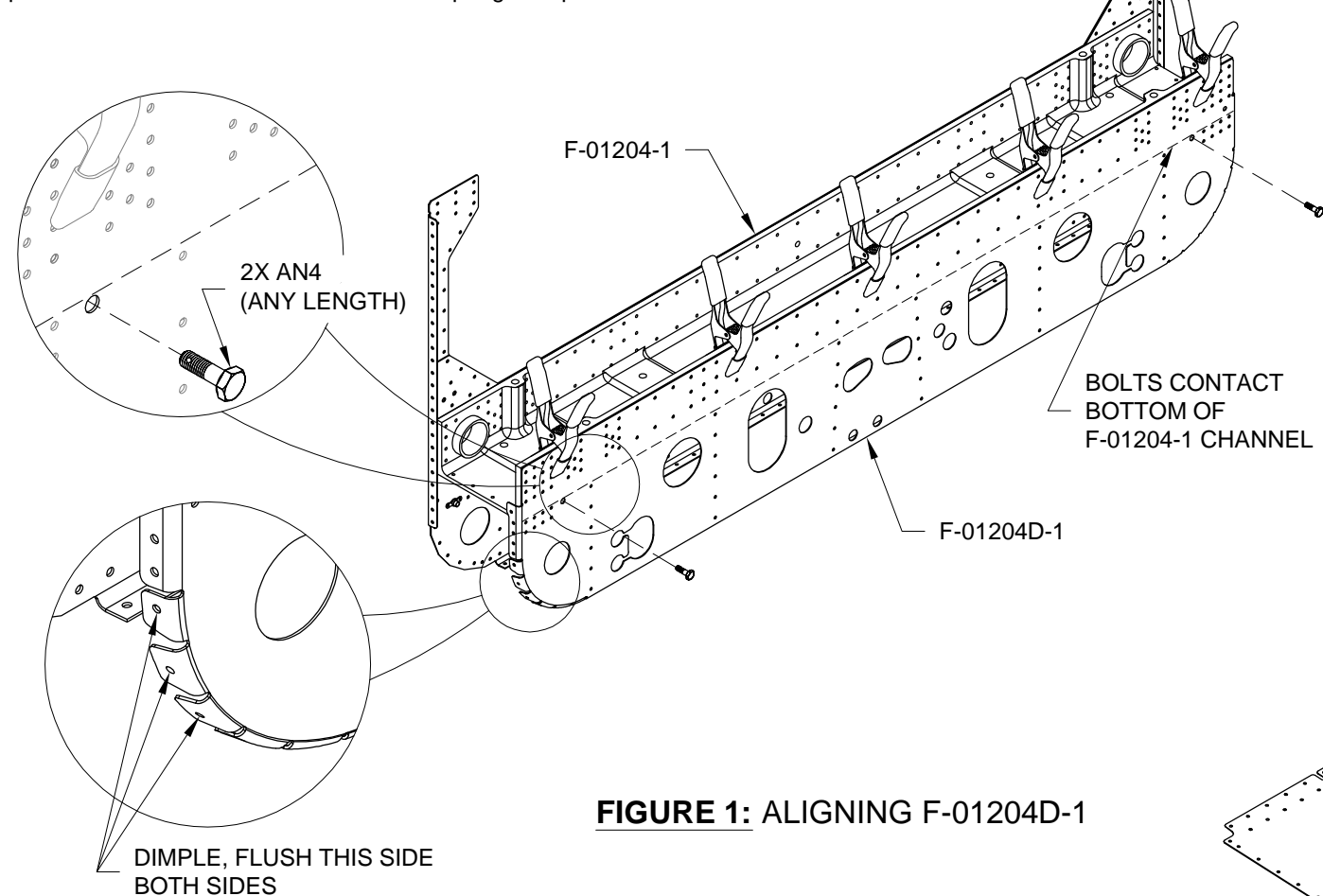
Step 4: Match-Drill #30 F-01204-1 using F-01204D-1 as a guide. Begin at the center of F-01204D-1 and progressively drill and cleco outboard. For help drilling straight holes see Section 5.24.

Step 5: Remove clecos and AN4 bolts from F-01204D-1 and F-01204-1. Deburr all match-drilled holes.

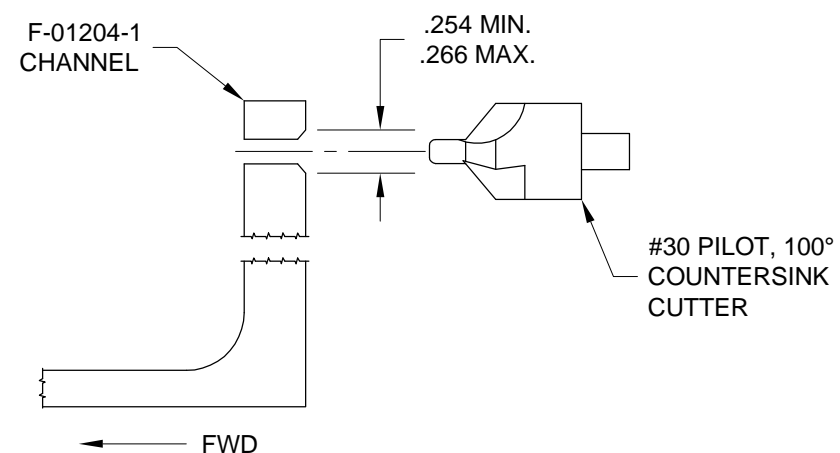
Step 6: Dimple #30 the holes in F-01204D-1 corresponding to the flush rivet call-outs shown on Page 20iS-06, Figure 1.

Step 7: Machine countersink #30 the holes in F-01204-1 to fit the dimples in F-01204D-1. See Page 20iS-06, Figure 1 for flush rivet locations. See Figure 2 for countersink detail. A piece of thin scrap with a 1/4 inch hole drilled in it may be used to check the diameter. See description on Page 14-02, Figure 2.

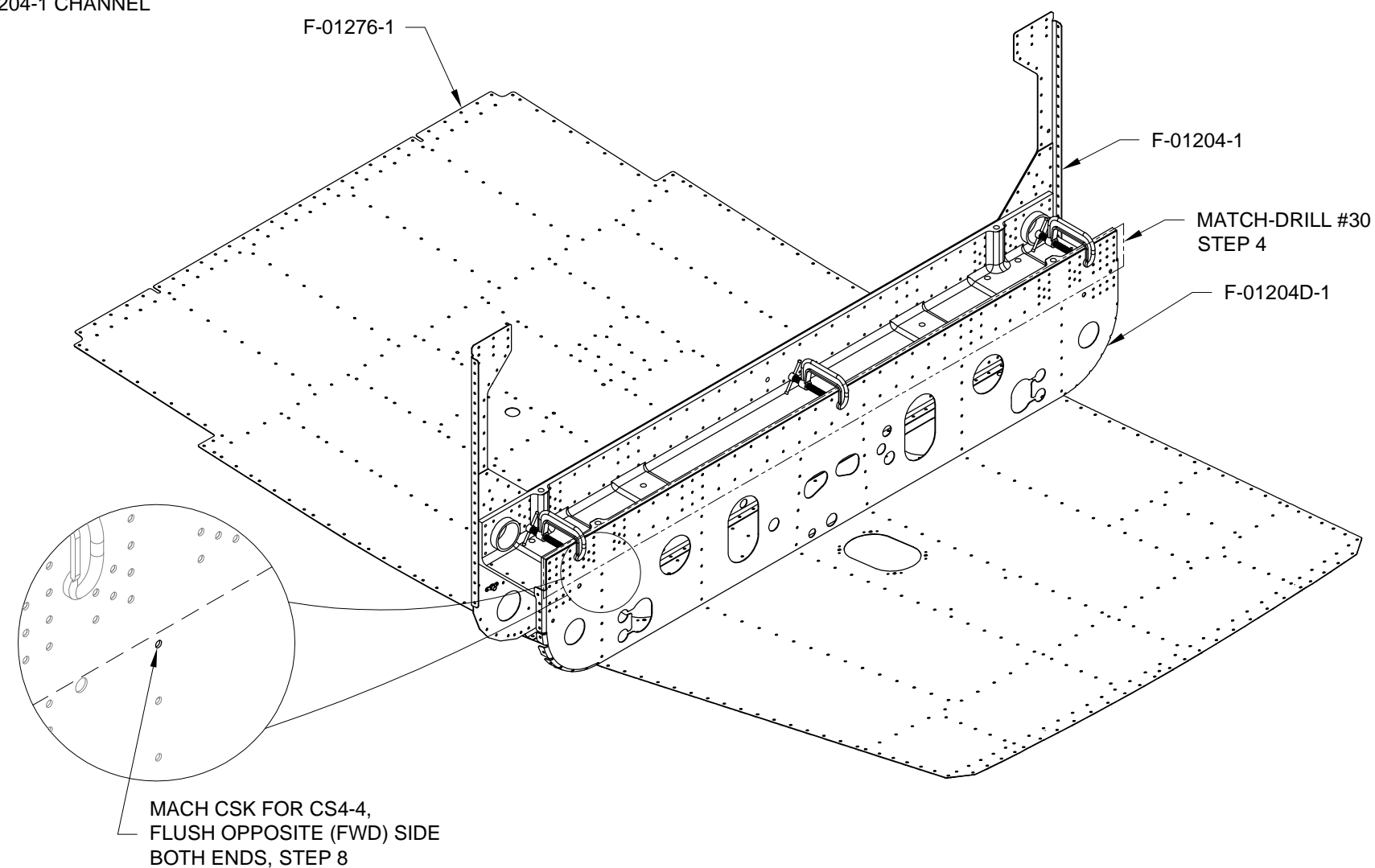
Step 8: Machine countersink #30 the two outboard holes, **noting their orientation**, in F-01204D-1 depicted in the Figure 3 detail.



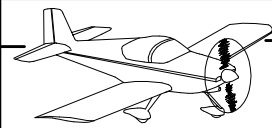
**FIGURE 1: ALIGNING F-01204D-1**



**FIGURE 2: COUNTERSINK ORIENTATION DETAIL**



**FIGURE 3: ALIGNING CENTER SECTION BULKHEAD TO BOTTOM SKIN**



Step 1: Separate F-1204P as shown in Figure 1.

Dimple #30 the holes in F-1204P-L & -R where indicated. See Figure 1 call-out.

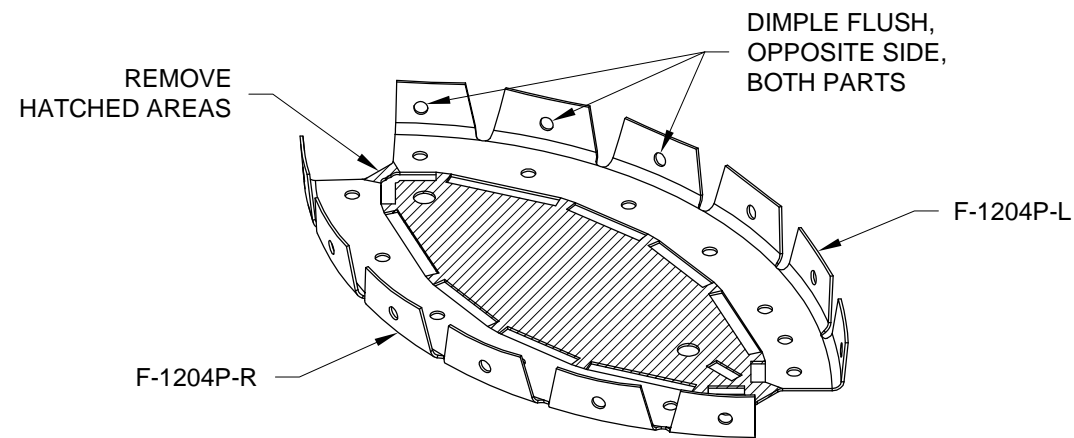


FIGURE 1: SEPARATING & DIMPLING F-1204P

Step 2: Separate F-1204T by removing the hatched areas shown in Figure 2.

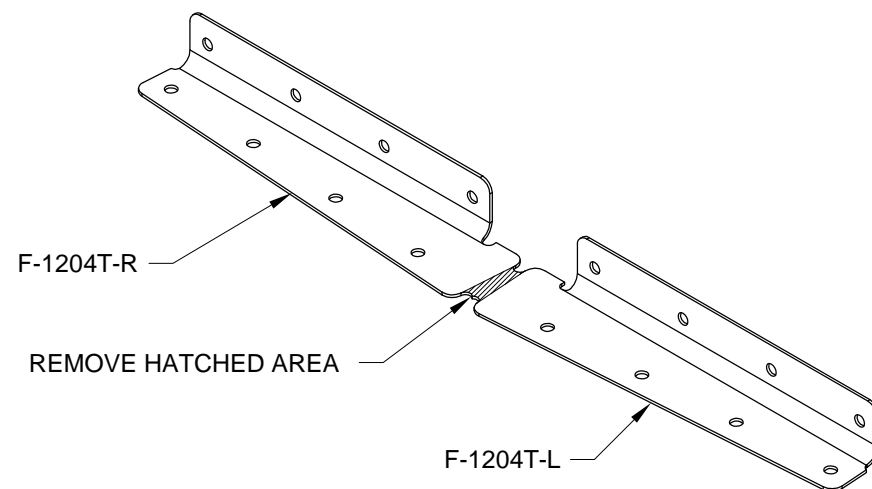


FIGURE 2: SEPARATING F-1204T

Step 3: Separate F-1204U by removing the hatched areas shown in Figure 3.

Step 4: Bend the ends of the bottom flanges of F-1204U-L & -R up to fit the inside radius of the F-01204-1 channel as shown in Figure 4. See Figure 5 for radius and part location.

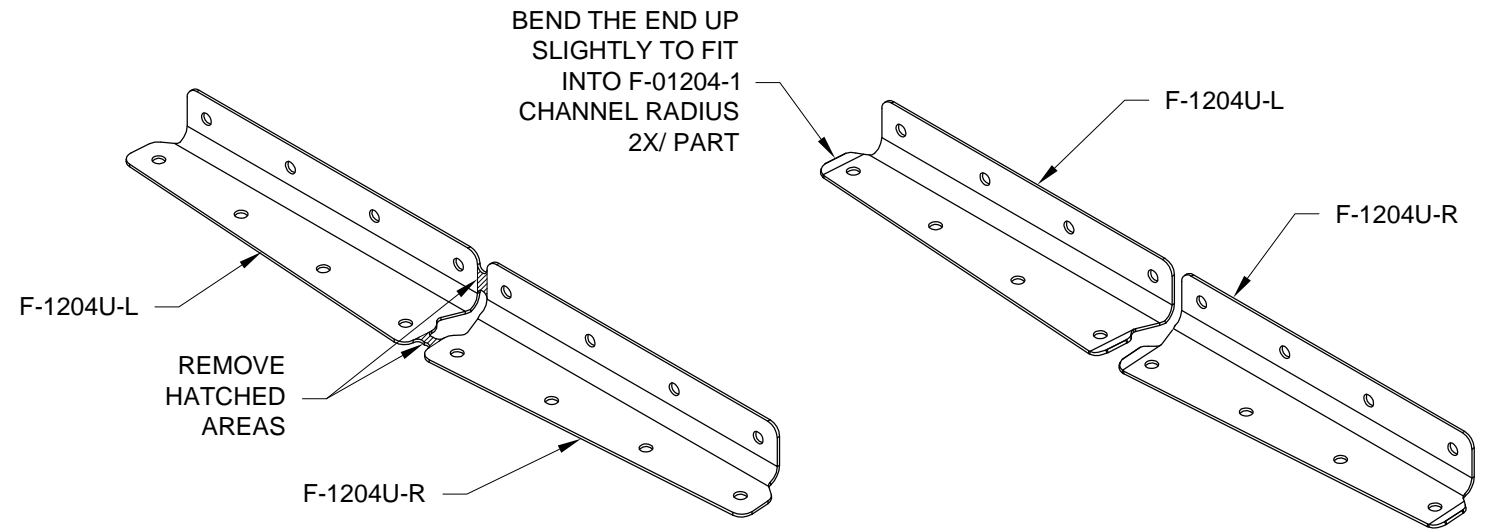


FIGURE 3: SEPARATING F-1204U

FIGURE 4: BENDING F-1204U-L/R

NOTE: See Section 5.4 before installing CherryMAX rivets.

Step 5: Rivet F-1204T-L and F-1204U-L to F-01204-1 as shown in Figure 5.

Repeat for the right side.

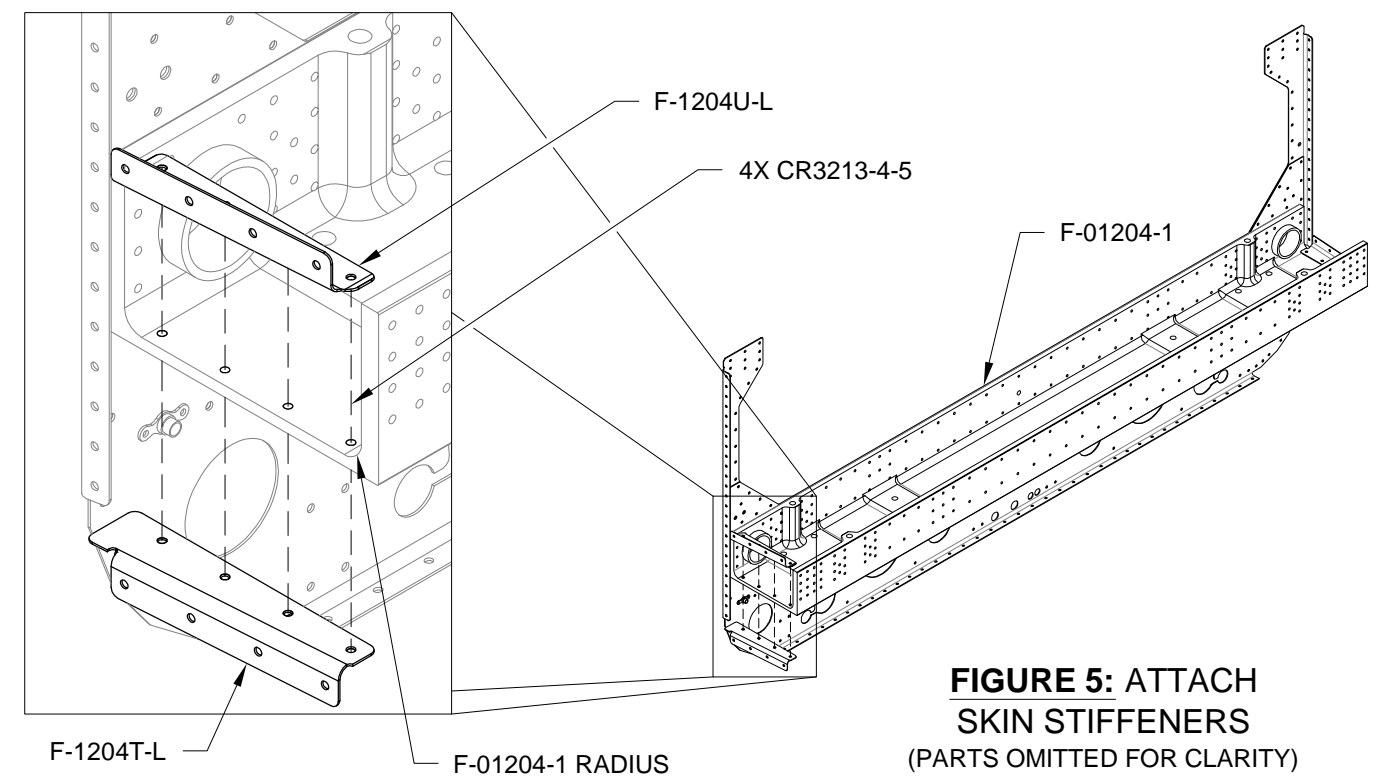
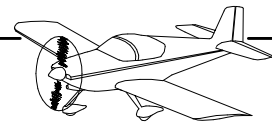


FIGURE 5: ATTACH SKIN STIFFENERS (PARTS OMITTED FOR CLARITY)



Step 1: Rivet F-1204P-L & -R to F-01204-1 as shown in Figure 1.

Step 2: Rivet F-01204F-L-1 & -R-1 to F-01204D-1. For now, rivet only the bottom eight holes in F-01204F-L-1 & -R-1 per the call-out. See Page 20iS-06 for rivet call-outs.

Step 3: Cleco F-01204D-1 to F-01204-1, (except at F-01204F-L-1 & -R-1), and cleco both F-01204J, F-01204G-L & -R, F-01205A-1, and two F-01205B-1 to the F-01204-1 assembly as shown in Figure 1 (for rigidity). See Figure 2 for the position of F-01205A-1 on F-01204-1.

Step 4: Clamp F-01204G-L & -R to F-01204-1 using a C-clamp and a small block of wood held in the footprint of the rivet pattern on the fwd side of the F-01204G-L & -R.

Step 5: Final-Drill #30 F-01204G-L & -R in three to four places using F-01204-1 (and F-01204F-L-1 & -R-1) as a guide.

Step 6: Remove the C-clamp and wood block.

Step 7: Install clecos in the new #30 (final-drilled) holes.

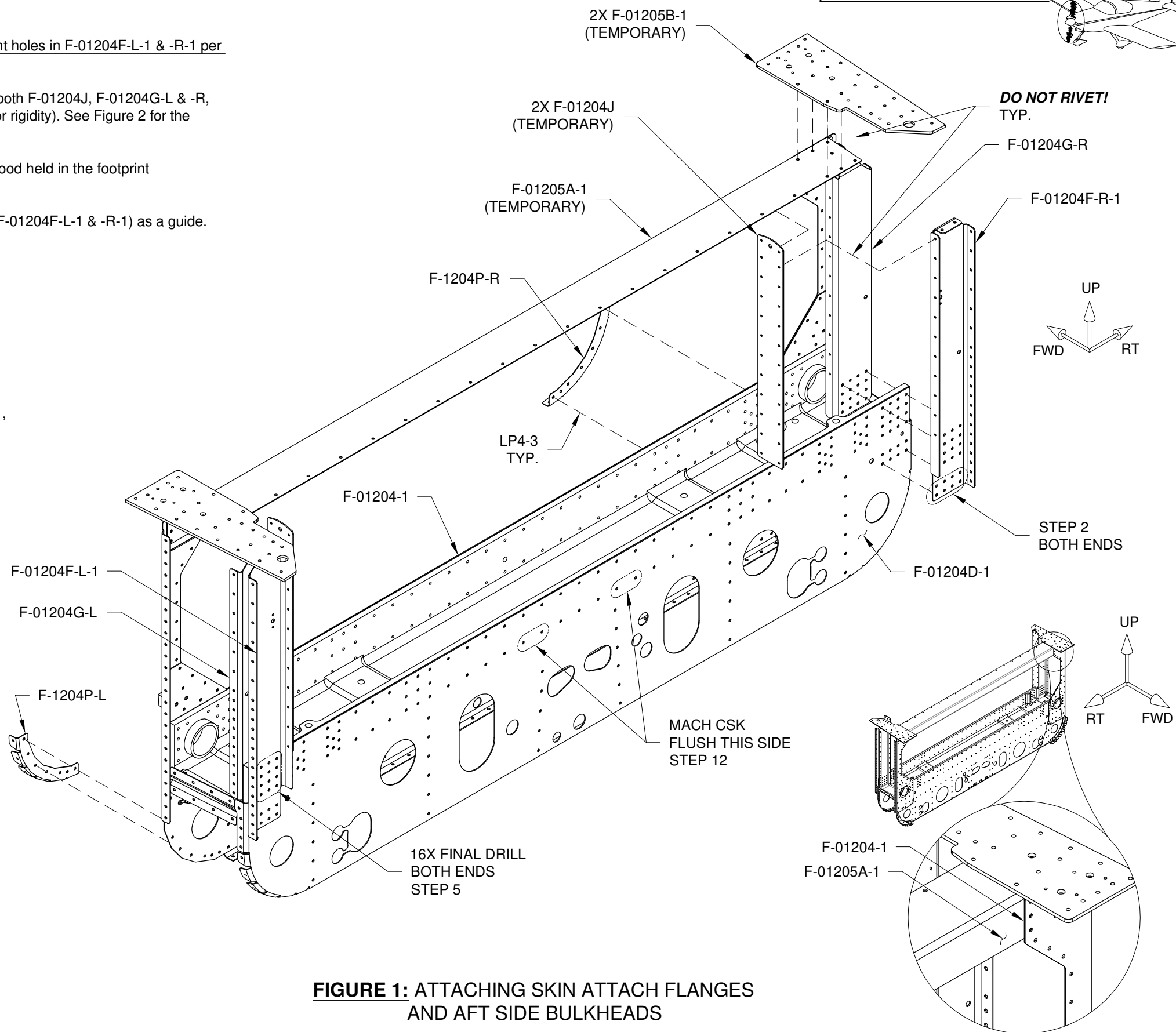
Step 8: Final-Drill #30 the remaining holes, installing clecos along the way.

Step 9: Remove F-01204D-1 and F-01204F-L-1 & -R-1, F-01204G-L & -R along with the temporary parts added in Step 3.

Step 10: Clear away chips, deburr and re-install F-01204D-1 and F-01204F-L-1 & -R-1, and F-01204G-L & -R with clecos.

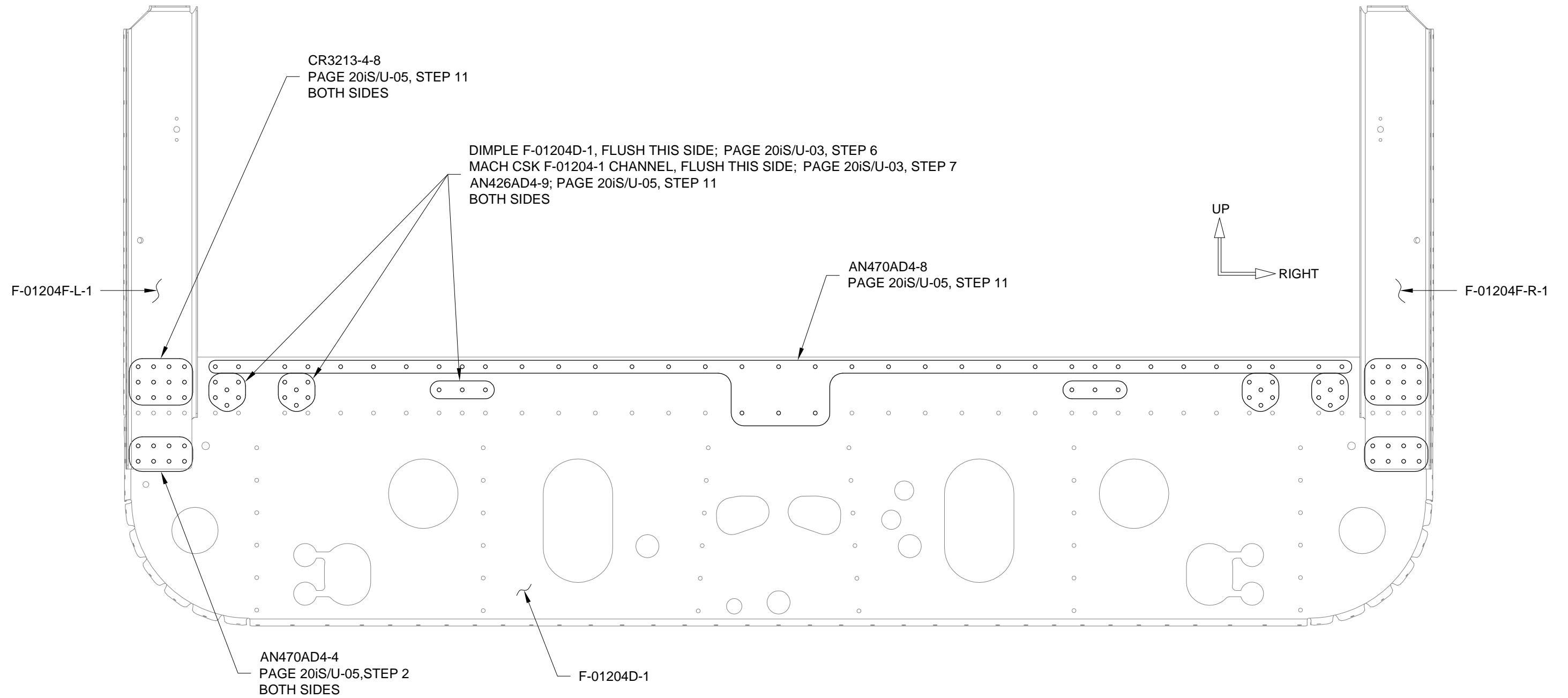
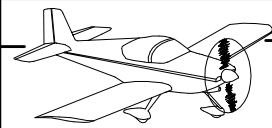
Step 11: Rivet F-01204D-1 and F-01204F-L-1 & -R-1, and F-01204G-L & -R to F-01204-1. See Page 20iS-06 for rivet call-outs.

Step 12: Machine countersink #30 the four holes near the centerline of F-01204D-1 to 100° per the Figure 1 call-out. These holes will be riveted in the next section.



**FIGURE 1: ATTACHING SKIN ATTACH FLANGES AND AFT SIDE BULKHEADS**

**FIGURE 2: ASSEMBLY REFERENCE**



**FIGURE 1: RIVET CALL-OUTS**  
(REAR VIEW, PARTS OMITTED FOR CLARITY)