

9) Cleco one of the bulkhead assemblies into place at the top of Station 9. This will complete the Station 9 bulkhead. Key to holes in the existing bulkheads. **NOTE:** The new bulkhead assembly will slide inside the Station 9 bulkhead.

10) Join the top and bottom halves of the Station 9 bulkhead using the typical nine rivet joint. **NOTE:** Debur, chromate and rivet at this time. Figure 9.8.5.

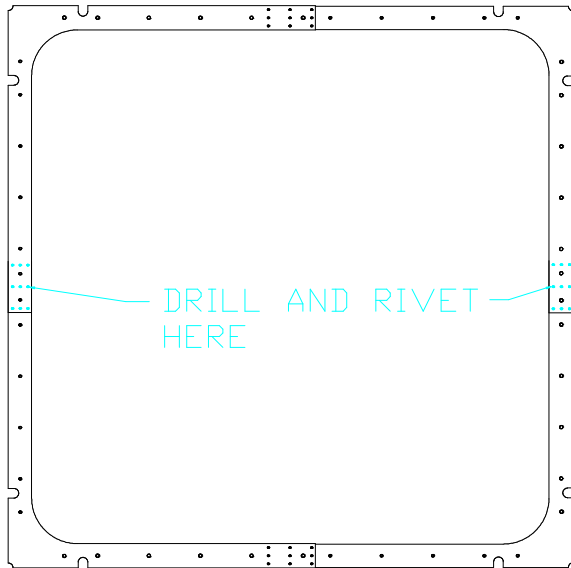


Figure 9.8.5

11) Use the FUS-401 skin as a guide. Drill into the Station 9 bulkhead. Make sure the center line you put on the outside flange of the bulkhead is visible at all times. Drill #40, use lots of clecos.

### 9.9 Root Rib Install

1) Trim the cabin root ribs (FUS-27 left and right) as in Figure 9.9.1.

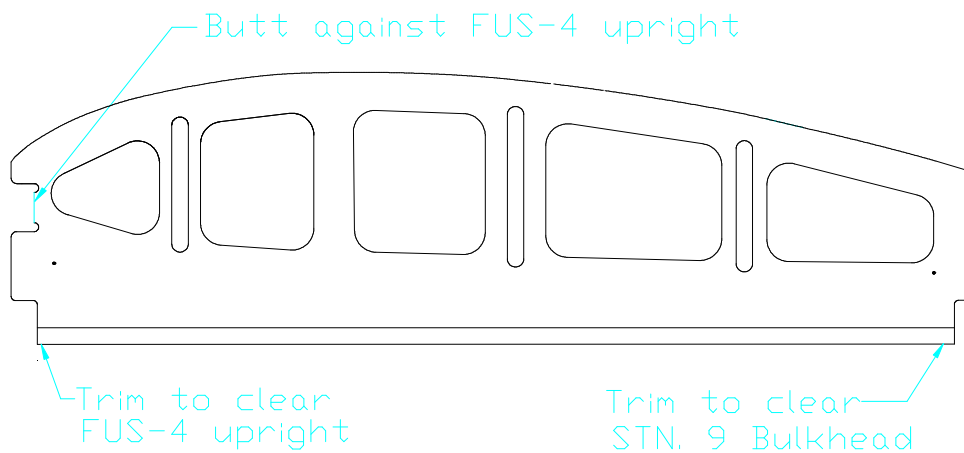


Figure 9.9.1

- 2) Straighten the top flange of both root ribs (FUS-27) so the top flanges of the ribs are 90° to the web surface. This can be done with crimping pliers, shrinker or hammer and dolly. The rib should lie flat on the table when you're done.
- 3) Position the left root rib (FUS-27) as in Figure 9.9.2.

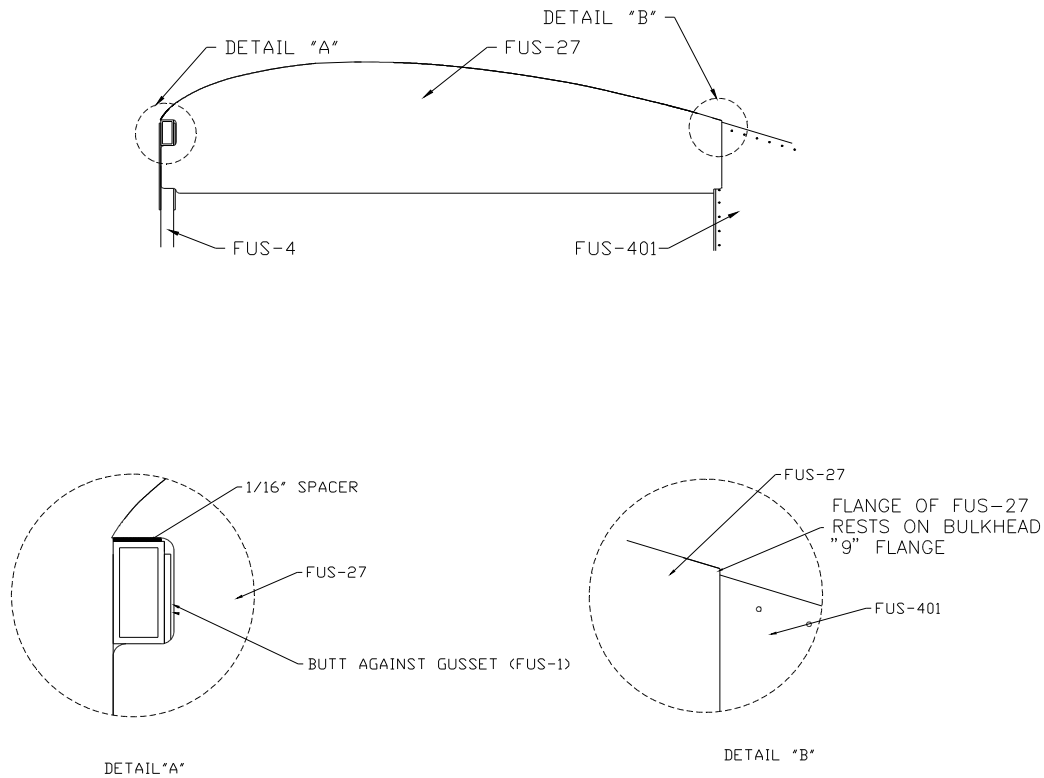


Figure 9.9.2

**NOTE:** Check that the forward cage is still square and the cage uprights (FUS-04) and the Station 9 Bulkheads are parallel.

- 4) Drill back through the Station 9 bulkhead into the FUS-27 root rib. Drill #40, cleco. Figure 9.9.3.

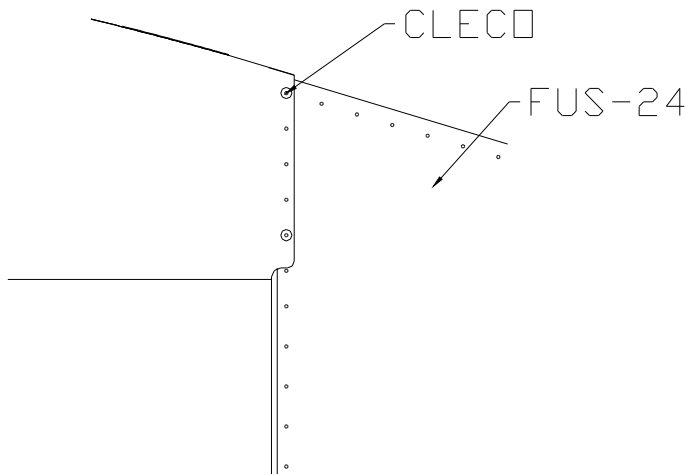


Figure 9.9.3

- 5) Drill five #40 holes through the FUS-27 root rib and the FUS-04 upright. Figure 9.9.4.

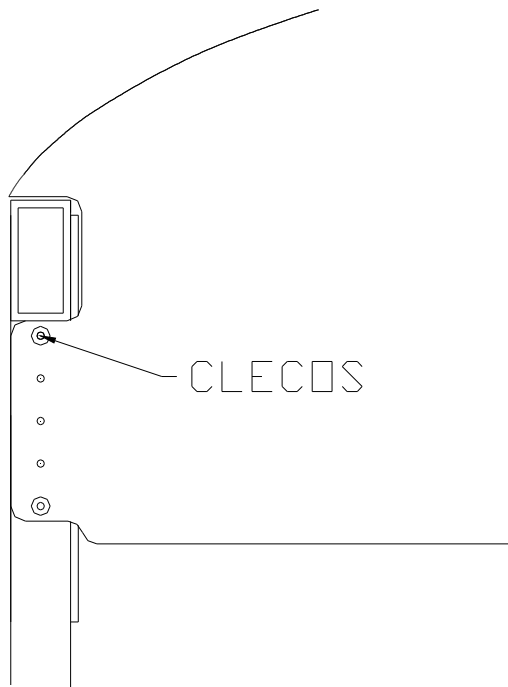
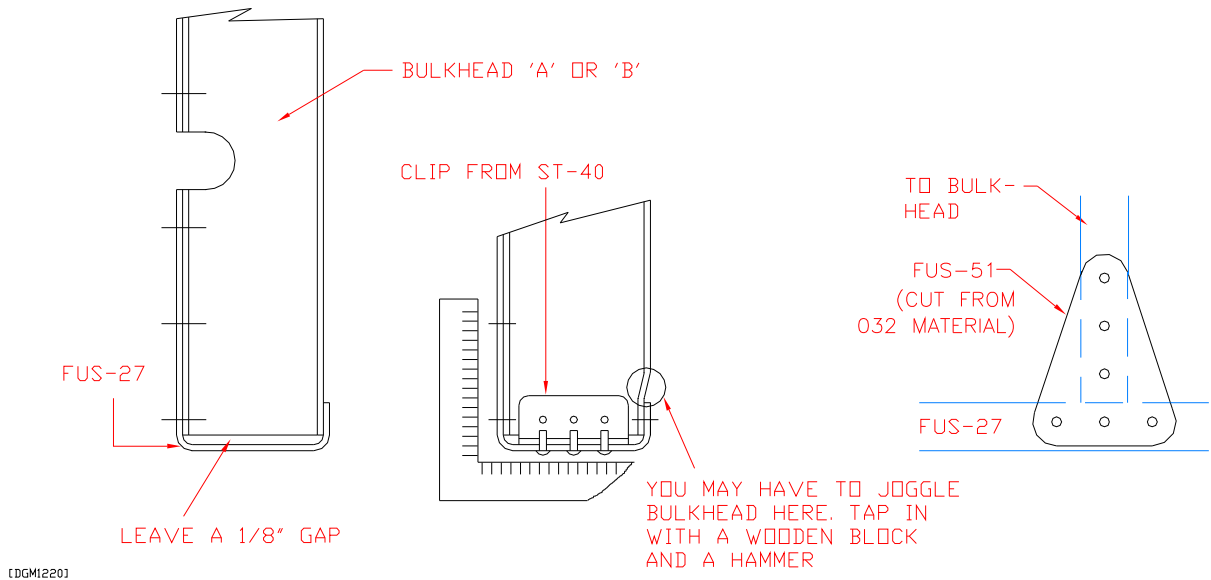


Figure 9.9.4

- 6) Repeat steps for the right side.
- 7) Re-check the cabin area for square.



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Figure 9.9.5

- 8) The two R-BULK 1 assemblies (referred to as “A” and “B” in Fig. 9.9.5.) prepared earlier are to be installed between the two FUS-27 root ribs. Figure 9.9.6. The bulkheads must be tied into the FUS-27’s as in Fig 9.9.5. On each top bulkhead and inside FUS-27’s lower flange install a gusset made from .032 material.

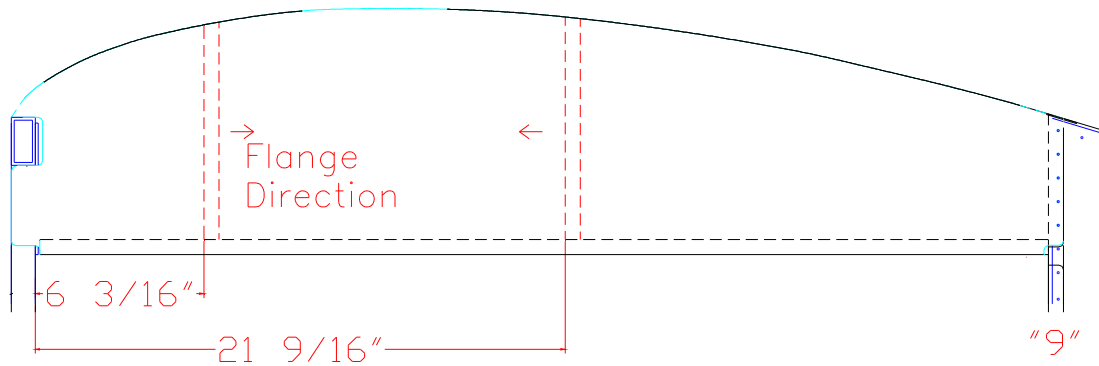


Figure 9.9.6

- 9) Drill #40 rivet lines (nine equally spaced holes allowing for bulkhead cutout) in the FUS-27 root ribs. Fig. 9.9.6.
- 10) Trim and fit the forward bulkhead between the two FUS-27's. Be sure the top flange of the bulkhead is tight against the top flange of the FUS-27 root rib.
- 11) Drill #40 through the FUS-27 into the Bulkhead and cleco into position.
- 12) Install the aft root bulkhead in the same manner as you did the forward bulkhead.
- 13) Drill all #40 holes to #30 except for the ones identified in Figure 9.9.7. **NOTE:** Also leave the forward and aft rows at #40 on the bottom skin (FUS-432).

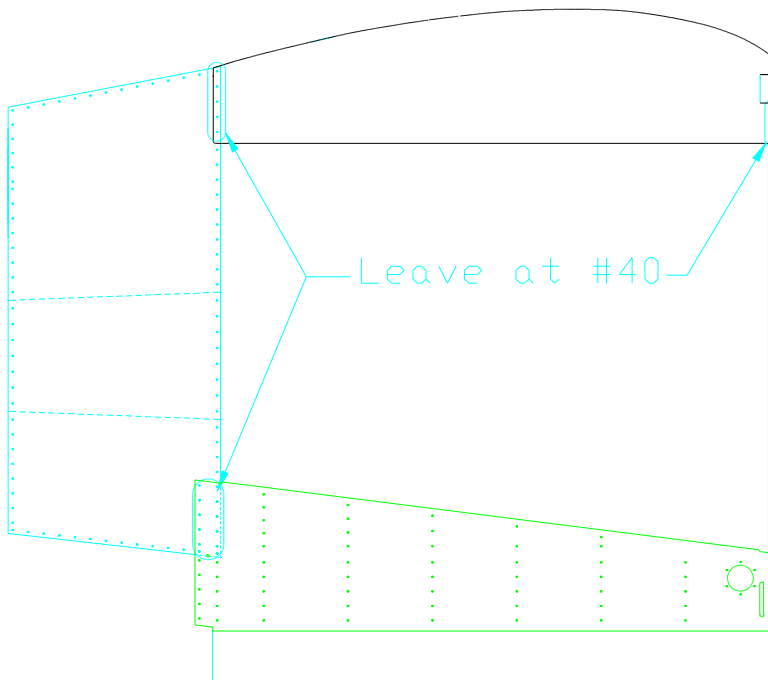


Figure 9.9.7

- 14) Carefully label all your parts. Disassemble, debur, chromate and rivet.