



Step 1: Fabricate the F-1211G Tail Skid Bracket from the AEX Tie Down extrusion using the F-1211G-DT Drill Template as shown in Figure 1.

Remove drill template, deburr.

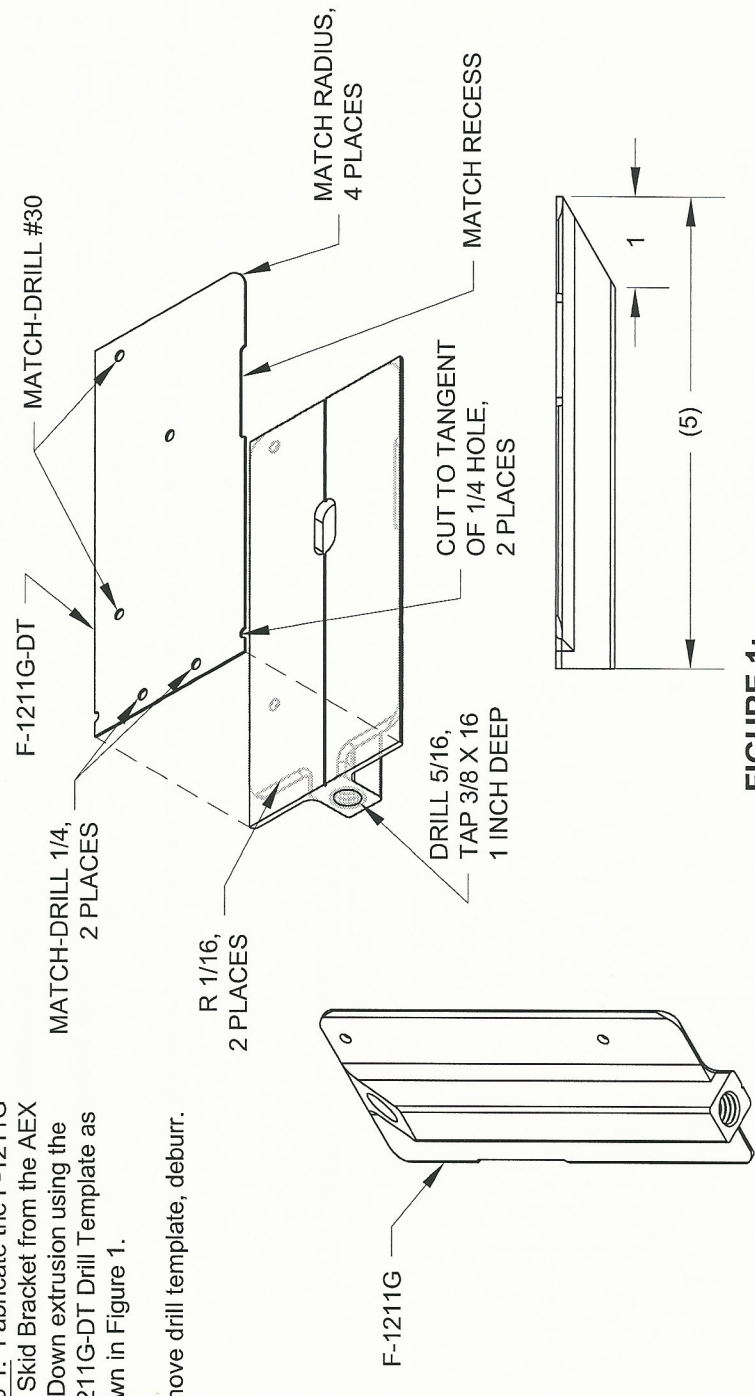


FIGURE 1:
F-1211G FABRICATION

Step 2: Remove the tabs from the F-1211B Bulkhead Doubler and deburr the bends called out in Figure 2.

Step 3: Machine countersink the holes in the F-1211B Bulkhead Doubler called out in Figure 2.

Step 4: Separate the F-1211D Attach Brackets by removing the material called out in Figure 3. Deburr.

MACHINE COUNTERSINK, FLUSH THIS SIDE, AN426AD3, 16 PLACES

REMOVE TABS, 4 PLACES

DEBURR BEND EDGES, 4 PLACES

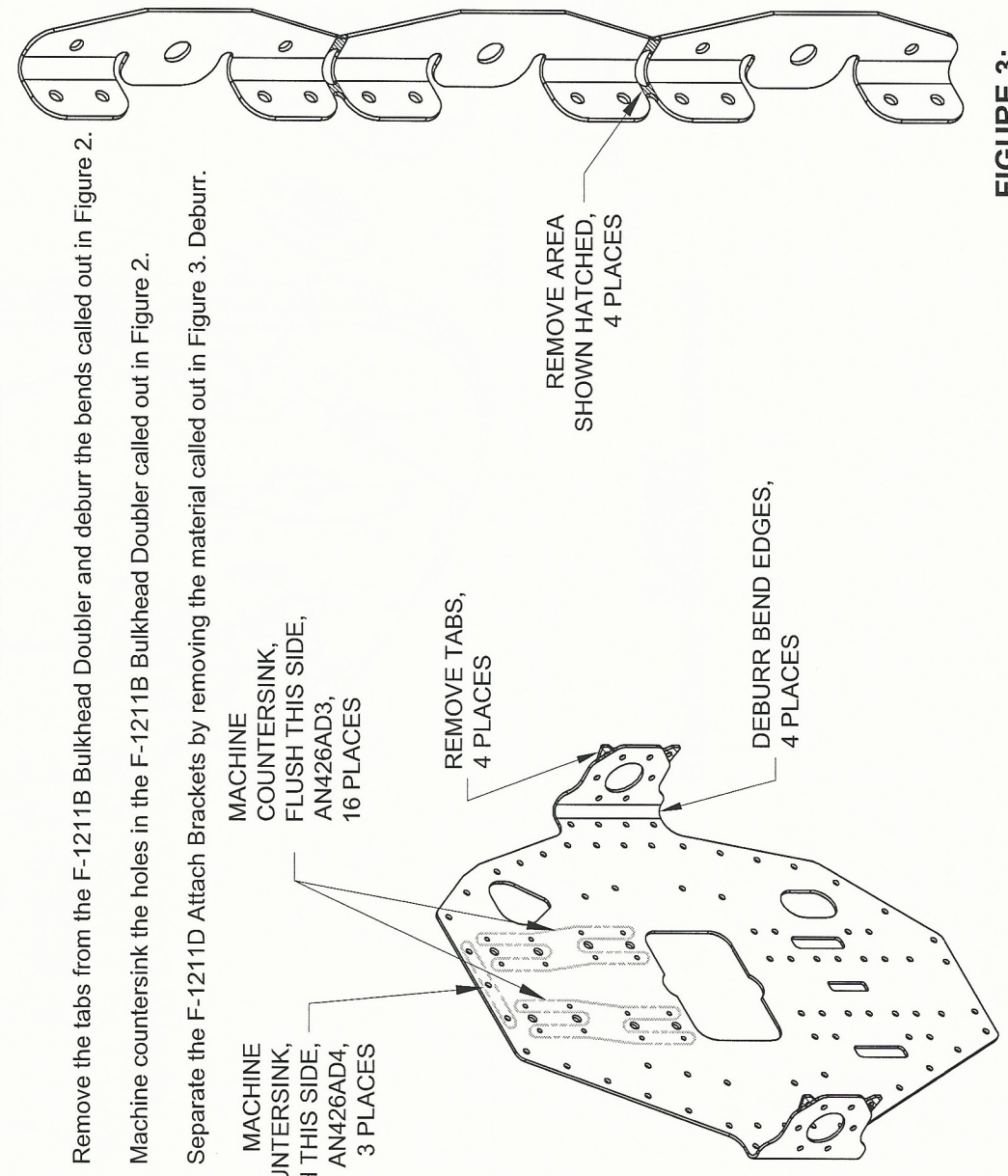


FIGURE 2:
F-1211B PREPARATION

Step 5: Mark, then separate the F-1284-L & -R Shear Clips by removing the areas shown hatched in Figure 4.

Step 6: Mark, then separate the F-1211C-L & -R Hinge Brackets by removing the areas shown hatched in Figure 5.

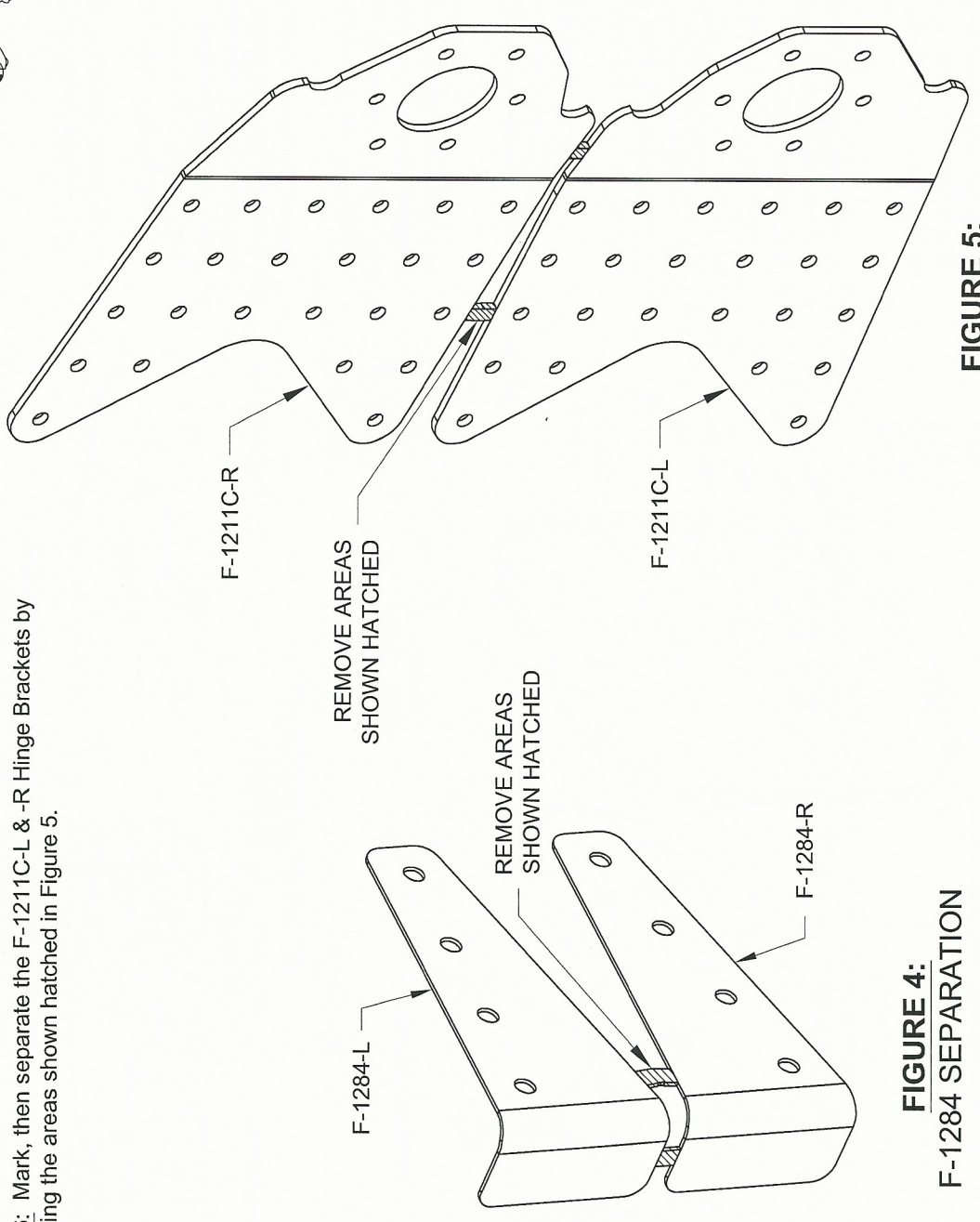


FIGURE 4:
F-1284 SEPARATION

FIGURE 5:
F-1211C SEPARATION

Step 7: Mark the F-1283 J-Stiffener with the part numbers called out in Figure 6. Remove the area shown hatched to separate the F-1283A, B, & C J-Stiffeners.

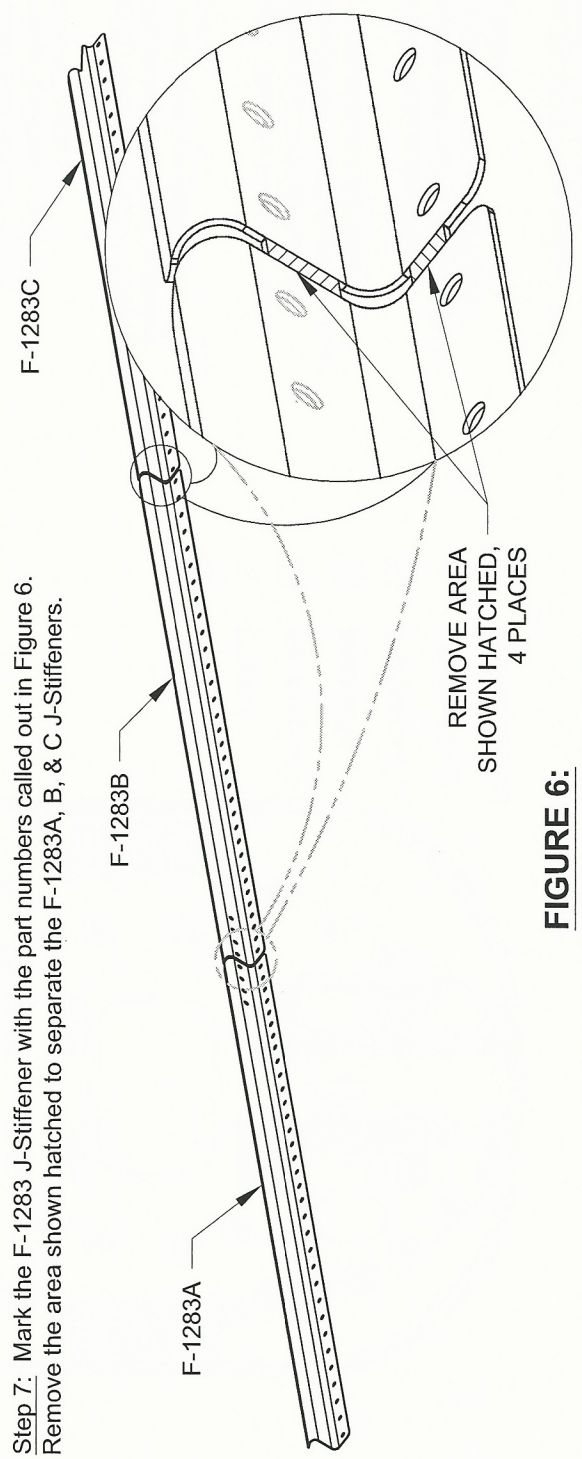


FIGURE 6:
F-1283A, B, AND C SEPARATION

FIGURE 3:
F-1211D SEPARATION