

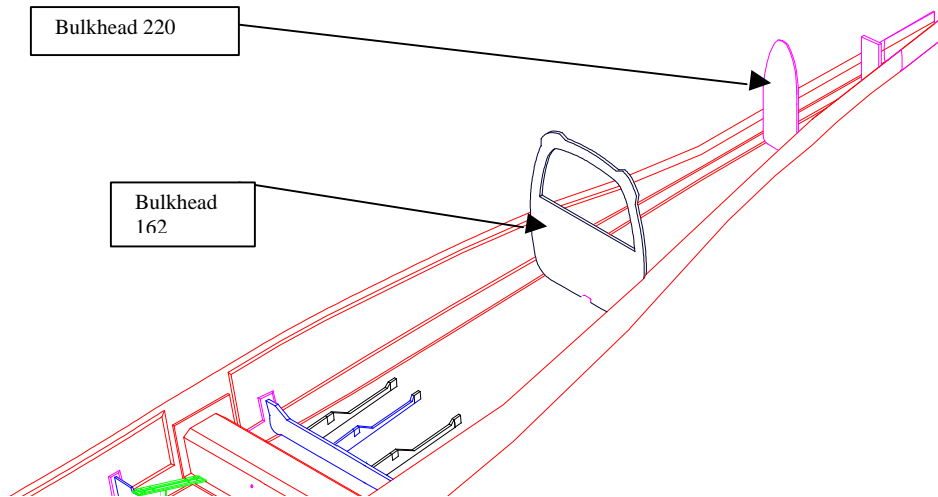
PRECEDURE 4.060

INSTALLING FUSELAGE BULKHEAD 162 AND 220

In this procedure...

A fuselage bulkhead is installed at Stations 162 and 220, behind the rear seats. It stiffens the aft section of the upper and lower fuselage halves.

<u>Part No.</u>	<u>Qty</u>	<u>Description</u>
112-12-010	1	Bulkhead 162
112-12-011	1	Bulkhead 220

**Step 1. Locate Sta. 162 bulkhead in fuselage.**

On kits delivered after December 2000, the Factory positions bulkhead 162 and 220. Kits delivered prior to this time will have to locate these bulkheads.

The reference lines drawn on the shop floor when you set up your fuselage jig included a line at Sta. 162. The forward face of saddle 2 was aligned with this line.

The Sta. 162 bulkhead will be aligned with the same reference line. Check that saddle 2 is still aligned with the reference line by dropping a plumb-bob to the line. Reset saddle 2 if necessary and check that it is vertical. Mark the location of the forward face of the saddle on the fuselage sides at the top EOP. These marks will be the reference points for the forward face of the bulkhead.

Step 2. Bevel Bulkhead 162.

Bevel bulkhead 162 (112-12010) to match the taper of the fuselage sides. Bevel the bottom edge to conform to the slope of the fuselage floor.

Step 3. Prep area to be bonded.

Prep sand the area across the fuselage bottom and up the sides where the bulkhead will be located. Carefully fit the bulkhead in place. Use your level to make sure its vertical, with the forward face aligned at the reference points.

Do not glue, fillet, or apply bid cloth to the area above the foam core along the fuselage sides. This area must be left open for later installation of the fuselage upper half. When you are satisfied with the fit of the part, tack it in place with hot glue at points a-long the bottom and up the sides to the point where the foam core stops. Apply a Q-cell mixture fillet along the joints on both sides of the part. Laminate two layers of 2.0" wide bid cloth on each side along the joints, except across the cable notch area.

Seal all the exposed foam on the inside of the baggage access opening with one layer of bid cloth. Trim flush to faces when green cured.

Step 3. Installation of Bulkhead 220

Locate Bulkhead 220 at Station 220 and laminate using the same procedures described in Step 1,2 and 3.

