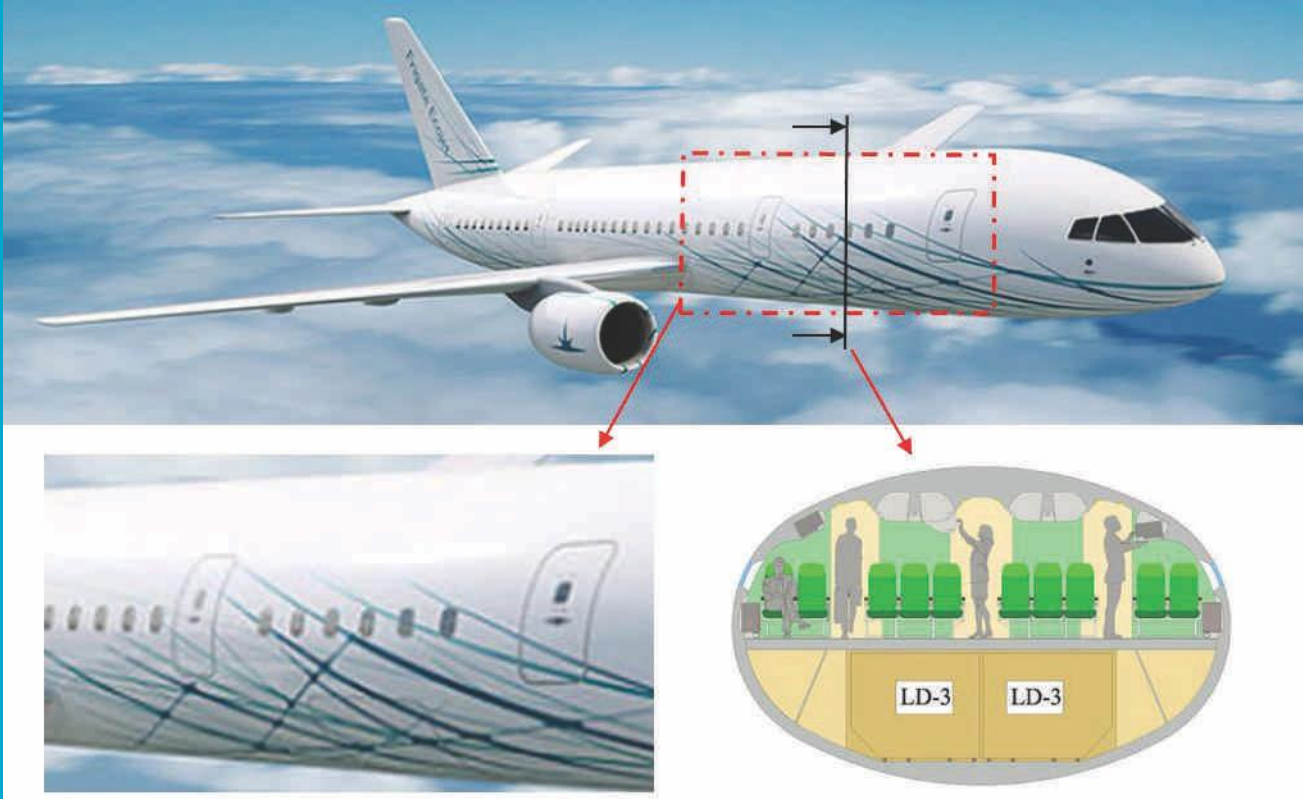
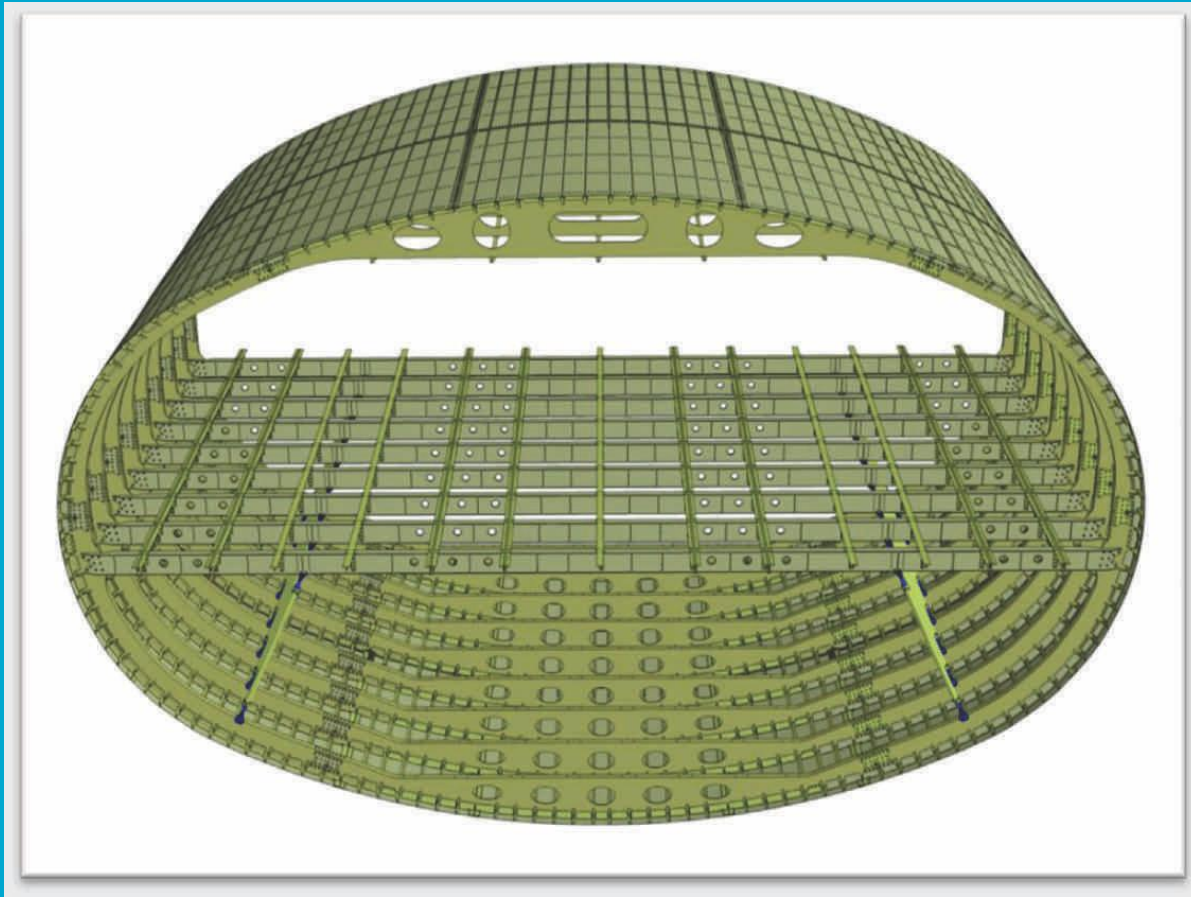


Frigate Ecojet Test Barrel

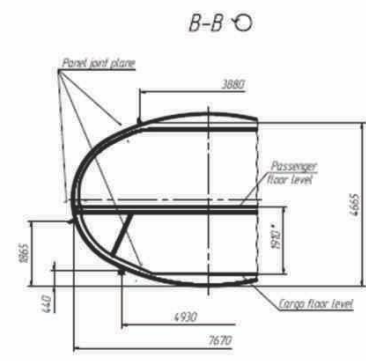
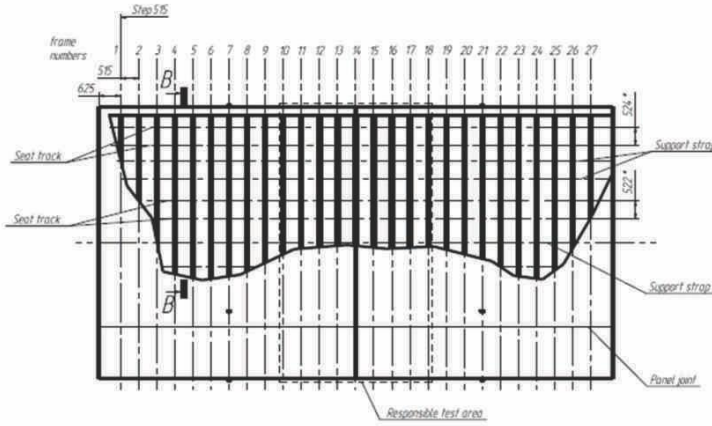
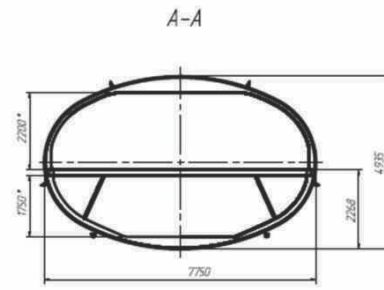
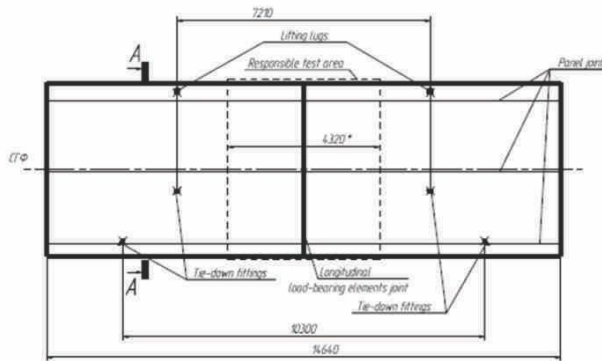
Manufacturing and Assembly Concept







000 000 0020 00 18



007/ACOBAND

Тех. документ 000 7196*
/Космос А.Н./

PRELIMINARY

BT.00.0200.000.000		8400		150	
Fuselage section for testing					
№	ИЗМЕНЕНИЯ	ДАТА	ИЗМЕНЕНИЯ	ИЗМЕНЕНИЯ	ИЗМЕНЕНИЯ
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					
23					
24					
25					
26					
27					





Shell assembly sequence

Load Panel and pre-position into shell assembly jig

Position of stringers to panel using tack holes in stringer and panel

Drill holes to final diameter and rivet stringers.
Leave out riveting of stringer ends for final junction adjustment to next shell

Load Frames and position by means of locating holes on jig

Drill holes to final diameter and rivet frames.
Leave out riveting of frame ends for final junction adjustment to next shell

Position brackets, clips etc. using tack holes in frames and panel

Drill holes to final diameter and rivet brackets, clips etc.

Unload shell assembly from the jig for final fuselage assembly

