Frigate Ecojet Test Barrel

Manufacturing and Assembly Concept
Shell assembly sequence

1. Load Panel and pre-position into shell assembly jig

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

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

4. Load Frames and position by means of locating holes on jig

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

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

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

8. Unload shell assembly from the jig for final fuselage assembly