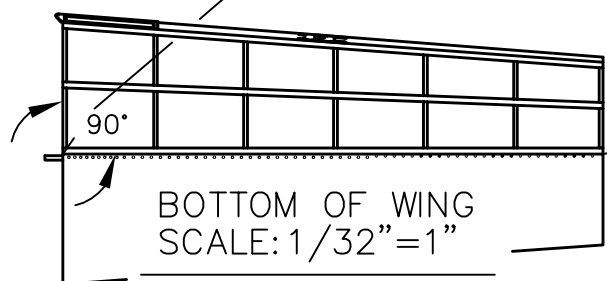
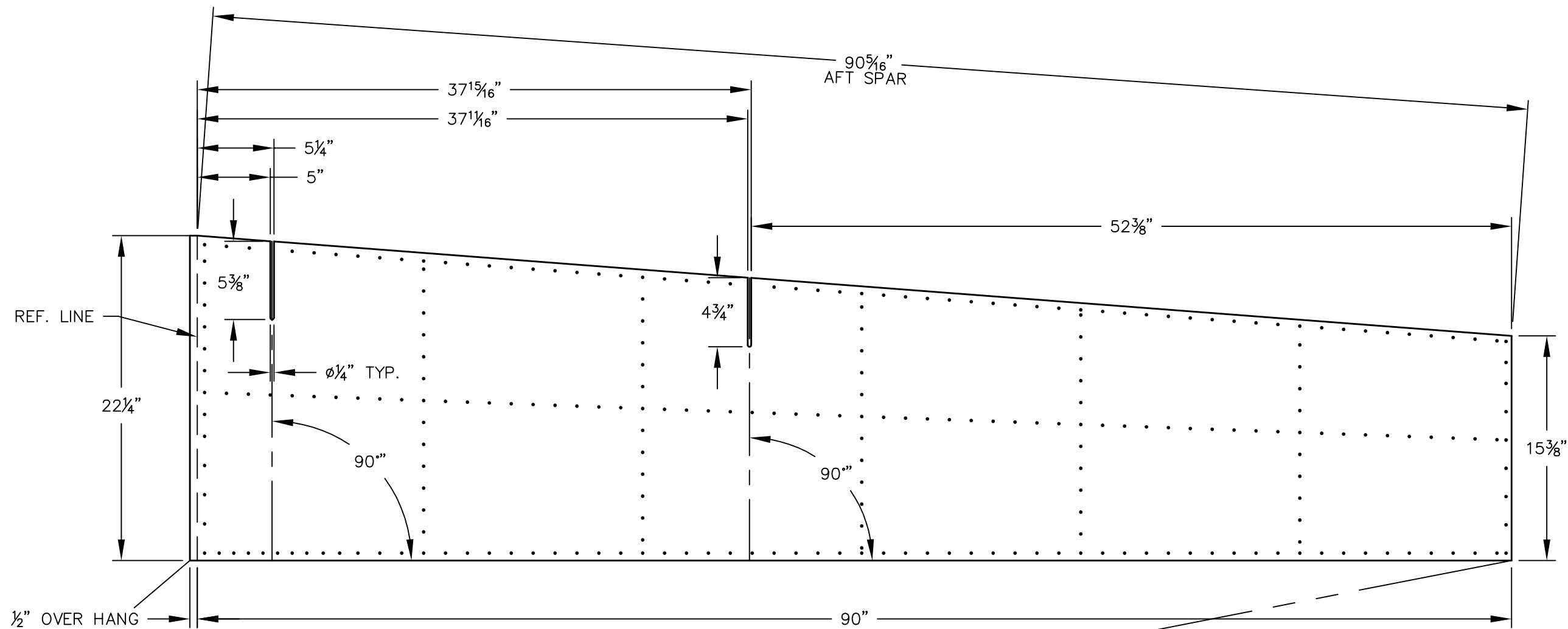


- NOTE:**
- REMOVE THE SKIN FROM THE WING STRUCTURE AFTER DRILLING ALL HOLES.
  - LAYOUT THE FLAP BRACKET SLOTS AS SHOWN. THE FLAP BRACKETS MUST BE 90° FROM THE MAIN SPAR.
  - CUT-OUT THE 1/4" FLAP BRACKET SLOTS AND DEBURR.
  - RE-INSTALL THE SKIN WITH CLECOES. (THIS WILL STABILIZE THE WING STRUCTURE FOR FURTHER ASSEMBLY.)
  - DIMENSIONS ARE FROM THE REFERENCE LINE. THE REFERENCE LINE IS TO BE ALIGNED WITH THE INBOARD EDGE OF THE AFT SPAR. EXCESS SKIN MATERIAL WILL BE TRIMMED LATER WHEN THE WING IS FIT TO THE CENTER SECTION.

REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	DRAWING RELEASED	BH	2/10



**TITAN AIRCRAFT SUPPLY**  
 1419 STATE ROUTE 45 SOUTH  
 AUSTINBURG, OHIO 44010

DETAIL NAME		FLAP BRACKET SLOT LAYOUT	
SCALE 1/8"=1"	PART NO.		
ASSEMBLY NAME FOR A/C SERIAL # 152 & LATER			
PART NO.		DRAWING NO. S13	
DRAWING NO. <b>B T51-10-INS-1875-A</b>			

DRAWN B. HARE	DATE 2/16/10
CHECKED R. INGLE	DATE 2/16/10
APPROVED K. BROOKS	DATE 2/16/10

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