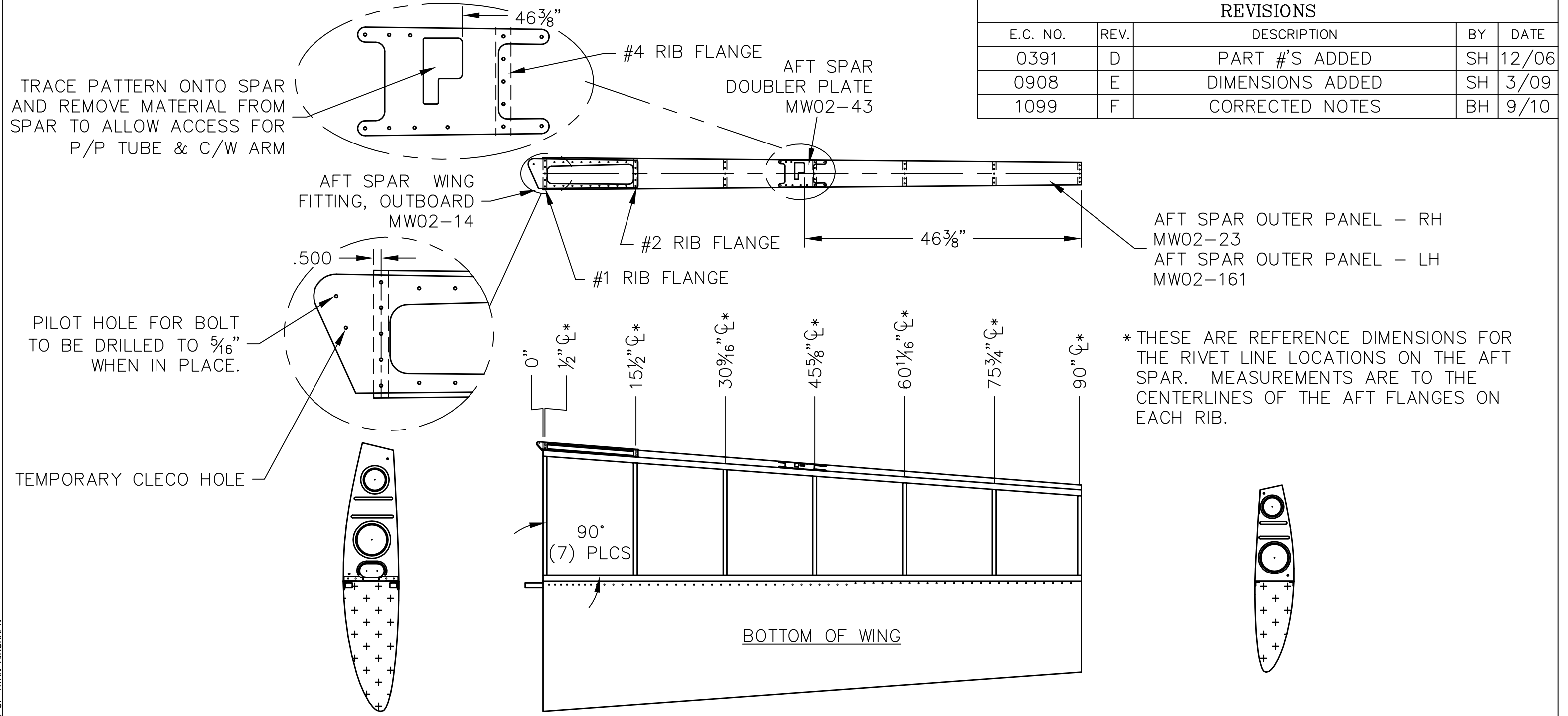


REVISIONS

E.C. NO.	REV.	DESCRIPTION	BY	DATE
0391	D	PART #'S ADDED	SH	12/06
0908	E	DIMENSIONS ADDED	SH	3/09
1099	F	CORRECTED NOTES	BH	9/10



TRACE PATTERN ONTO SPAR AND REMOVE MATERIAL FROM SPAR TO ALLOW ACCESS FOR P/P TUBE & C/W ARM

PILOT HOLE FOR BOLT TO BE DRILLED TO 5/16" WHEN IN PLACE.

TEMPORARY CLECO HOLE

AFT SPAR OUTER PANEL - RH MW02-23
AFT SPAR OUTER PANEL - LH MW02-161

* THESE ARE REFERENCE DIMENSIONS FOR THE RIVET LINE LOCATIONS ON THE AFT SPAR. MEASUREMENTS ARE TO THE CENTERLINES OF THE AFT FLANGES ON EACH RIB.

- NOTES:
- ALIGN ALL RIBS 90° OFF MAIN SPAR, ALL RIBS MUST REMAIN PARALLEL TO EACH OTHER ± 1/16".
 - FITTINGS NEED TO BE CLECOED IN PLACE ON THE AFT SPAR, WHEN RIB MOUNTING HOLES ARE DRILLED.
 - USE (5) RIVETS PER AFT RIB FLANGES.
 - ALL RIVETS THRU FITTINGS ARE SD43BS RIVETS, ALL OTHER RIVETS ARE SD42BS.

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

DETAIL NAME AFT SPAR RIVET LOCATIONS & FITTING INSTALLATION

DRAWN K. LIPLIN	DATE 8/20/02	SCALE 1/16"=1"	PART NO.
CHECKED K. BROOKS	DATE 9/27/10	ASSEMBLY NAME	
APPROVED B. KOLENO	DATE 12/9/10	PART NO.	DRAWING NO. W4
		DRAWING NO. B T51-02-INS-0387-F	

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