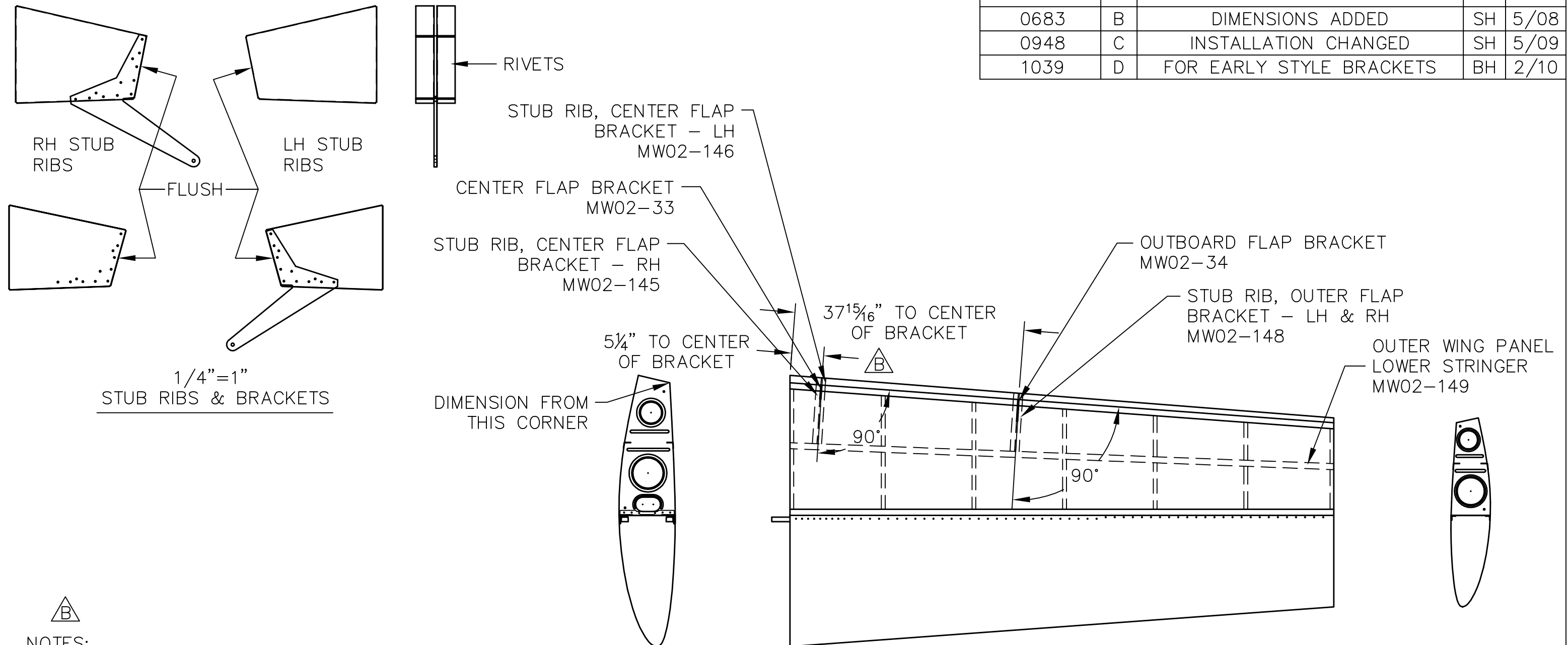


REVISIONS

E.C. NO.	REV.	DESCRIPTION	BY	DATE
0683	B	DIMENSIONS ADDED	SH	5/08
0948	C	INSTALLATION CHANGED	SH	5/09
1039	D	FOR EARLY STYLE BRACKETS	BH	2/10



NOTES:

- THE BOTTOM WING SKIN SHOULD BE CLECOED IN PLACE WITH THE CENTER AND OUTER FLAP BRACKETS CUT-OUT.
- DRILL THE STUB RIBS USING THE FLAP BRACKETS AS DRILL GUIDES.
- SANDWICH EACH FLAP BRACKET BETWEEN THE LH & RH STUB RIBS. (USE SD45BS RIVETS TO ASSEMBLE.)
- FIT THE FLAP BRACKET ASSEMBLIES IN THE WING USING THE WING SKIN SLOTS AS GUIDES.
- DRILL AND RIVET THE FLAP BRACKETS TO THE REAR SPAR AND INTERMEDIATE WEBS. (USE SD42BS RIVETS)
- DIMENSIONS ARE TAKEN FROM THE BOTTOM EDGE OF THE REAR SPAR.
- ALSO REFER TO DRAWING T51-02-INS-0543 FOR ADDITIONAL INFORMATION.

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

DETAIL NAME		FLAP STUB RIB INSTALLATION	
SCALE	1/16"=1"	PART NO.	
ASSEMBLY NAME		FOR A/C SERIAL # 151 & EARLIER	
PART NO.		DRAWING NO. W11	
DRAWING NO.		B T51-02-INS-0499-D	

DRAWN	K. LIPLIN	DATE	10/10/02
CHECKED	R. INGLE	DATE	2/16/10
APPROVED	K. BROOKS	DATE	2/16/10

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