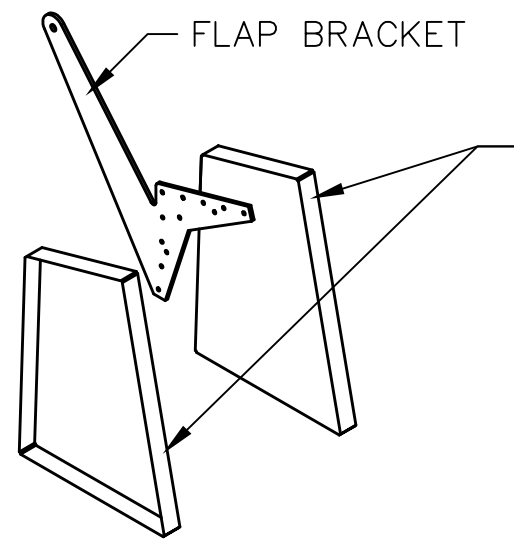
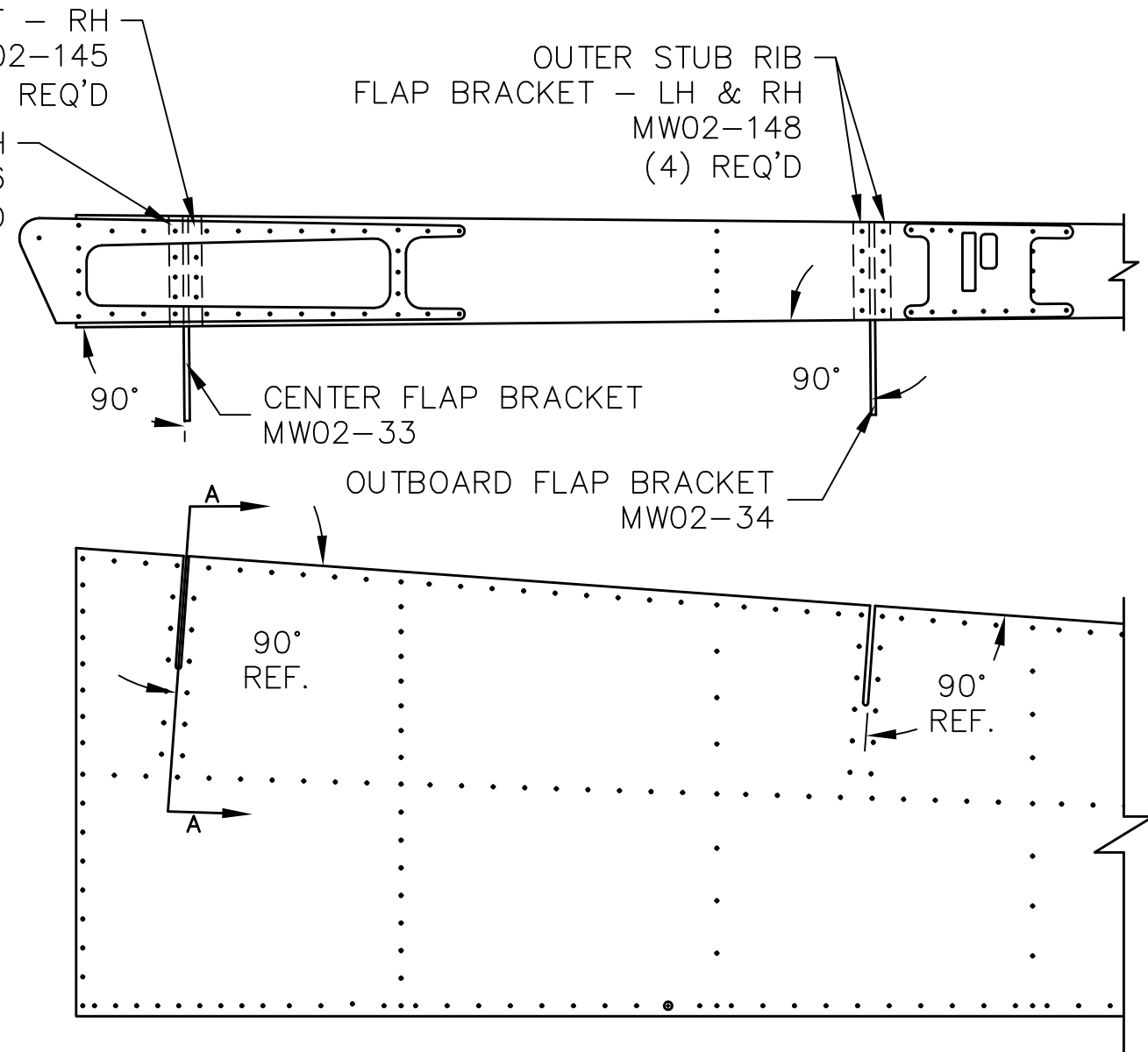


REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
0515	B	ADDED PART NUMBERS	SH	8/07
0866	C	NOTES ADDED	SH	2/09
1037	D	FOR EARLY STYLE BRACKETS	BH	2/10



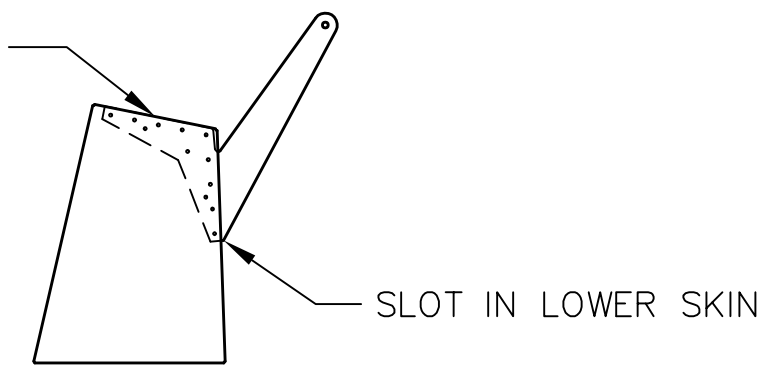
– WHEN ASSEMBLED INSIDE THE WING, DRILL AND RIVET ALL STUB RIB FLANGES TO THE AFT SPAR, WING SKINS, AND INTERMEDIATE WEBS.  
 – DRILL AND RIVET ON APPROX. 1 1/2" CENTERS

CENTER STUB RIB FLAP BRACKET – RH  
 MW02-145  
 (2) REQ'D  
 CENTER STUB RIB FLAP BRACKET – LH  
 MW02-146  
 (2) REQ'D



**NOTES:**  
 – REFER TO DRAWING T51-02-INS-0542 FOR BRACKET AND SLOT LOCATIONS.  
 – CLECO THE LOWER SKIN IN PLACE BEFORE FITTING FLAP BRACKETS AND STUB RIBS.  
 – MATCH DRILL THE FLAP BRACKET STUB RIBS TO THE FLAP BRACKETS.  
 – BE SURE THE TRAILING EDGES ARE FLUSH & CENTERED AS SHOWN BELOW.  
 – CLECO ONLY AT THIS TIME \*\*DO NOT RIVET STUB RIBS OR BRACKETS UNTIL THE ARE POSITIONED IN THE WING.\*\*  
 – ASSEMBLE THE FLAP BRACKETS AND STUB RIBS INSIDE OF THE WINGS AS SHOWN.  
 – THE FLAP BRACKETS SHOULD BE CENTERED IN THE LOWER WING SKIN SLOTS AND POSITIONED 90° FROM THE LOWER WING SURFACE. (THE SLOTS IN THE LOWER SKIN SHOULD HOLD THE FLAP BRACKETS AT 90°)  
 – WHEN SATISFIED WITH THE POSITIONING DRILL, BOND, & RIVET ALL STUB RIB FLANGES IN PLACE USING SD41BS OR SD42BS RIVETS. (BE SURE TO MAKE ALL RIVET SPACING 1 1/2" ON CENTER.)

THIS SURFACE NEEDS TO BE FLUSH & CENTERED



SECTION A-A  
 FLAP STUB RIB  
 ASSEMBLY

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

DETAIL NAME FLAP BRACKET STUB RIBS & FLAP BRACKET INS	
SCALE 1/8"=1"	PART NO.
ASSEMBLY NAME FOR A/C SERIAL # 151 & EARLIER	
PART NO.	DRAWING NO. W12
DRAWING NO. <b>B T51-02-INS-0543-D</b>	

DRAWN K. LIPLIN	DATE 10/30/02
CHECKED R. INGLE	DATE 2/16/10
APPROVED K. BROOKS	DATE 2/16/10

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