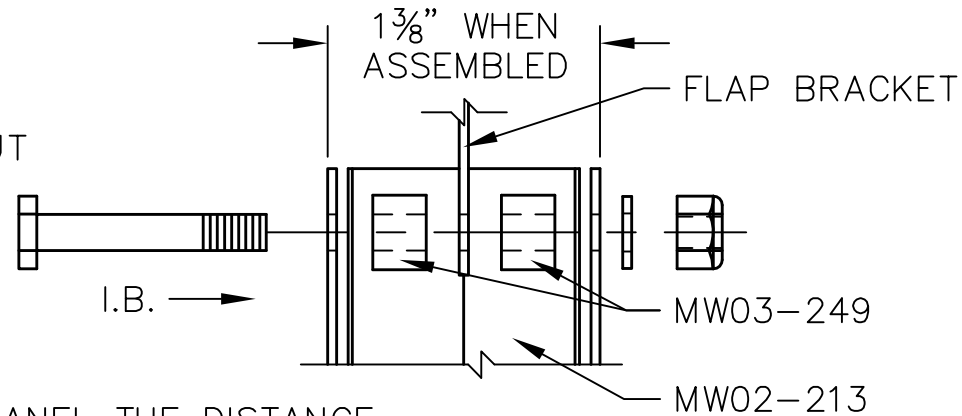


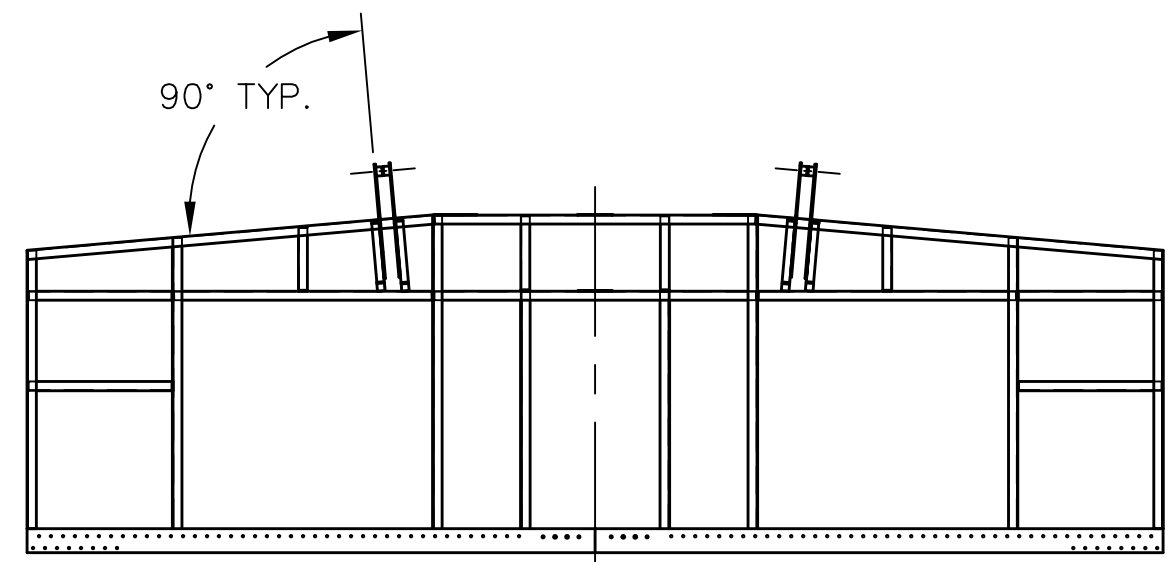
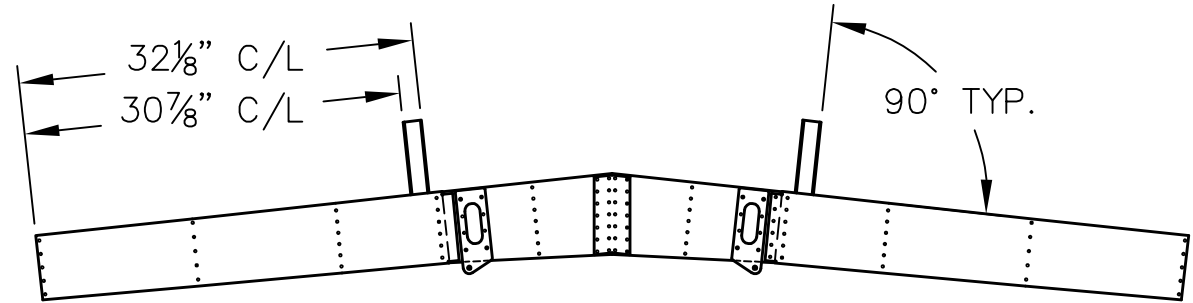
- STUB RIB, INNER FLAP BRACKET #1-RH (MW02-39)
- STUB RIB, INNER FLAP BRACKET #1-LH (MW02-40)
- STUB RIB, INNER FLAP BRACKET #2-RH (MW02-41)
- STUB RIB, INNER FLAP BRACKET #2-LH (MW02-42)

- INBOARD FLAP BRACKET MW02-22
- INBOARD FLAP BRACKET WEB MW02-213
- FLAP HINGE SPACER (2) MW03-249

- AN4-12A BOLT
- AN960-416 WASHER
- AN365-428 LOCK NUT

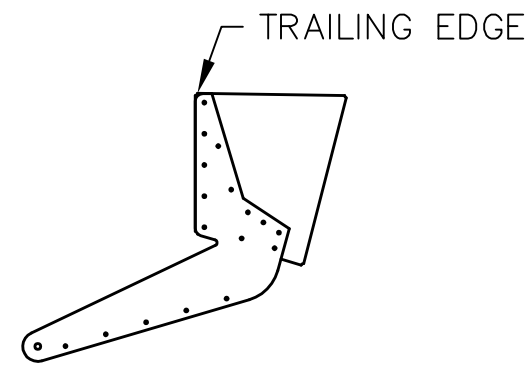


REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
0372	C	NUT & WASHER CHNG'D	SH	11/06
0918	D	BOLT CHANGED	SH	3/09
1015	E	FOR EARLY STYLE BRACKETS	BH	2/10



**NOTES:**

- MOUNT AILERON & FLAP ON OUTER WING PANEL THE DISTANCE BETWEEN FLAP AND AILERON SHOULD BE APPROX. 1/8" TO 3/16".
- PLACE FLAP BRACKET #1 STUB RIB INTO THE CENTER SECTION FIRST. INSERT THE INBOARD FLAP BRACKET INTO THE CENTER SECTION. THEN USING THE 1/2" NYLON SPACERS BOLT THE FLAP BRACKETS AND FLAP HINGE TOGETHER TIGHTLY AS SHOWN. PLACE INNER FLAP BRACKET #2 STUB RIB IN PLACE.
- MAKING SURE THAT THE FLAP BRACKETS ARE IN POSITION AGAINST THE AFT SPAR SLIDE #1 AND #2 FLAP STUB RIB INTO POSITION NEXT TO FLAP BRACKETS.
- TRACE THE BRACKETS POSITION ONTO THE STUB RIBS.
- REMOVE THE STUB RIBS AND ASSEMBLY.
- MATCH DRILL INNER FLAP BRACKET #1 & #2 STUB RIBS (MW02-39, MW02-40, MW02-41 & MW02-42) TO INBOARD FLAP BRACKETS TRACING.
- BE SURE TRAILING EDGES ARE FLUSH AND CENTERED AS SHOWN BELOW.
- CLECO ONLY AT THIS TIME. \*\*DO NOT RIVET UNTIL PARTS ARE ASSEMBLED INSIDE THE CENTER SECTION.
- MAKE SURE ALL PARTS THAT WILL NEED BONDED ARE SANDED AND READY FOR BONDING. ASSEMBLE THE INNER FLAP BRACKET (MW02-39 OR MW02-40) AND STUB RIBS INSIDE THE CENTER SECTION AS SHOWN.




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

DETAIL NAME		INBOARD FLAP BRACKET INSTALLATION		
SCALE	N/A	PART NO.		
ASSEMBLY NAME		FOR A/C SERIAL # 151 & EARLIER		
PART NO.		DRAWING NO. CS13		
DRAWING NO.		B T51-03-INS-0650-E		

DRAWN	K. LIPLIN	DATE	3/13/03
CHECKED	R. INGLE	DATE	2/16/10
APPROVED	K. BROOKS	DATE	2/16/10

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