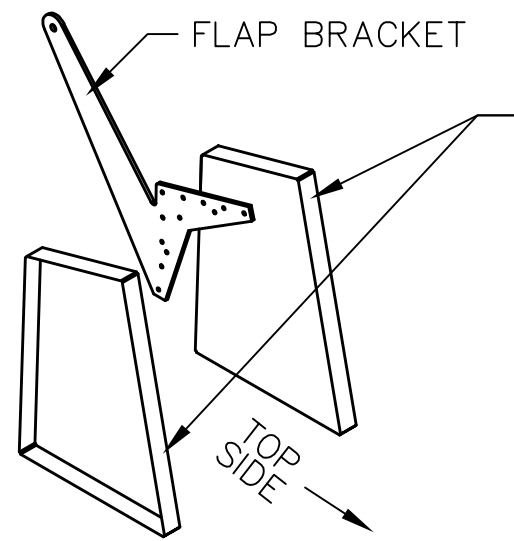


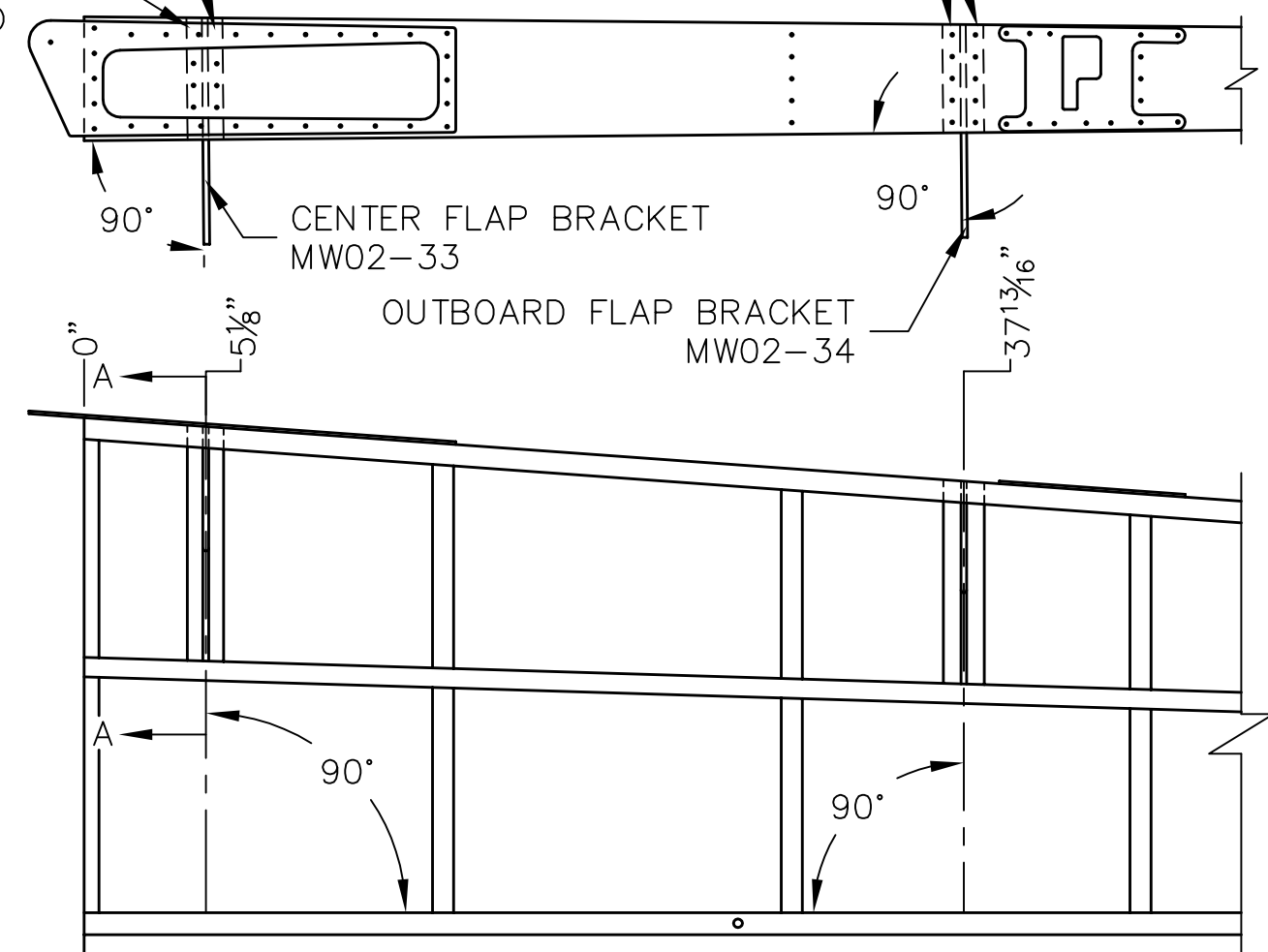
REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	DRAWING RELEASED	BH	2/10



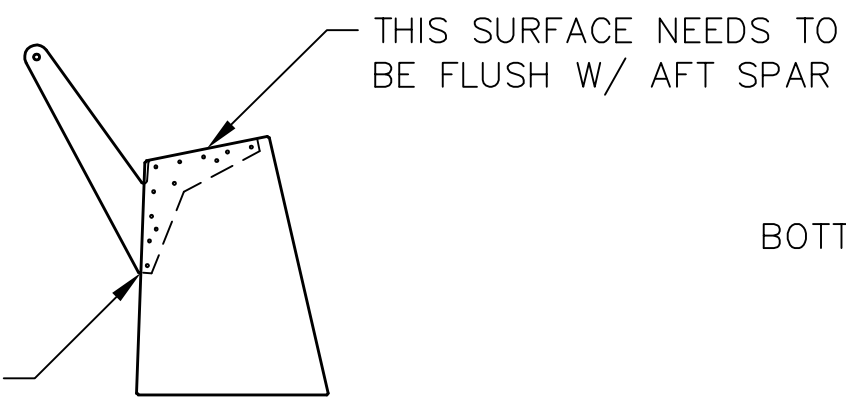
— WHEN ASSEMBLED INSIDE THE WING, DRILL AND RIVET ALL STUB RIB FLANGES TO THE AFT SPAR, WING SKINS, AND INTERMEDIATE WEBS.
 — DRILL AND RIVET ON APPROX. 1½" CENTERS

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

OUTER STUB RIB FLAP BRACKET — LH & RH
 MW02-147 & MW02-148
 (2) OF EACH REQ'D



NOTES:
 — LAYOUT FLAP BRACKET CENTERLINES ON THE WING STRUCTURE.
 — INSTALL STUB RIBS INSIDE OF THE WING STRUCTURE, PLACE A FLAP BRACKET IN BETWEEN EACH OF THEM, AND TEMPORARILY CLAMP THE ASSEMBLY.
 — BEFORE DRILLING, DOUBLE CHECK THE DIMENSIONS OR USE THE FLAP STRUCTURE ITSELF AS A SETUP FIXTURE. THE IDEAL WAY WOULD BE TO ASSEMBLE THE OUTBOARD WING STRUCTURE TO THE CENTER SECTION AND BOLT THE FLAP TO THE INBOARD AND OUTBOARD FLAP BRACKETS, LETTING THE CENTER BRACKET FALL INTO PLACE. THE THREE HOLES MUST ALIGN WITH EACH OTHER TO GET PROPER MOVEMENT OF THE FLAP.
 — USE THE CORRECT HARDWARE FOR TRIAL FITTING, BONDING, AND FINAL ASSEMBLY, REFER TO DRAWINGS T51-10-INS-1876 AND T51-09-INS-1871.
 — DRILL AND CLECO THE STUB RIBS AND BRACKETS INTO PLACE WHEN SATISFIED WITH THE FITMENT OF THE FLAP. WHEN RIVETING THESE PIECES INTO PLACE USE THE FLAP TO HOLD EVERYTHING IN PLACE.



SECTION A-A

BOTTOM OF R.H. WING

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

DRAWN B. HARE		DATE 2/16/10	DETAIL NAME FLAP BRACKET STUB RIBS & FLAP BRACKET INS	
CHECKED R. INGLE		DATE 2/16/10	SCALE 1/8"=1"	PART NO.
APPROVED K. BROOKS		DATE 2/16/10	ASSEMBLY NAME FOR A/C SERIAL # 152 & LATER	
			PART NO.	DRAWING NO. S12
			DRAWING NO. B T51-10-INS-1874-A	

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