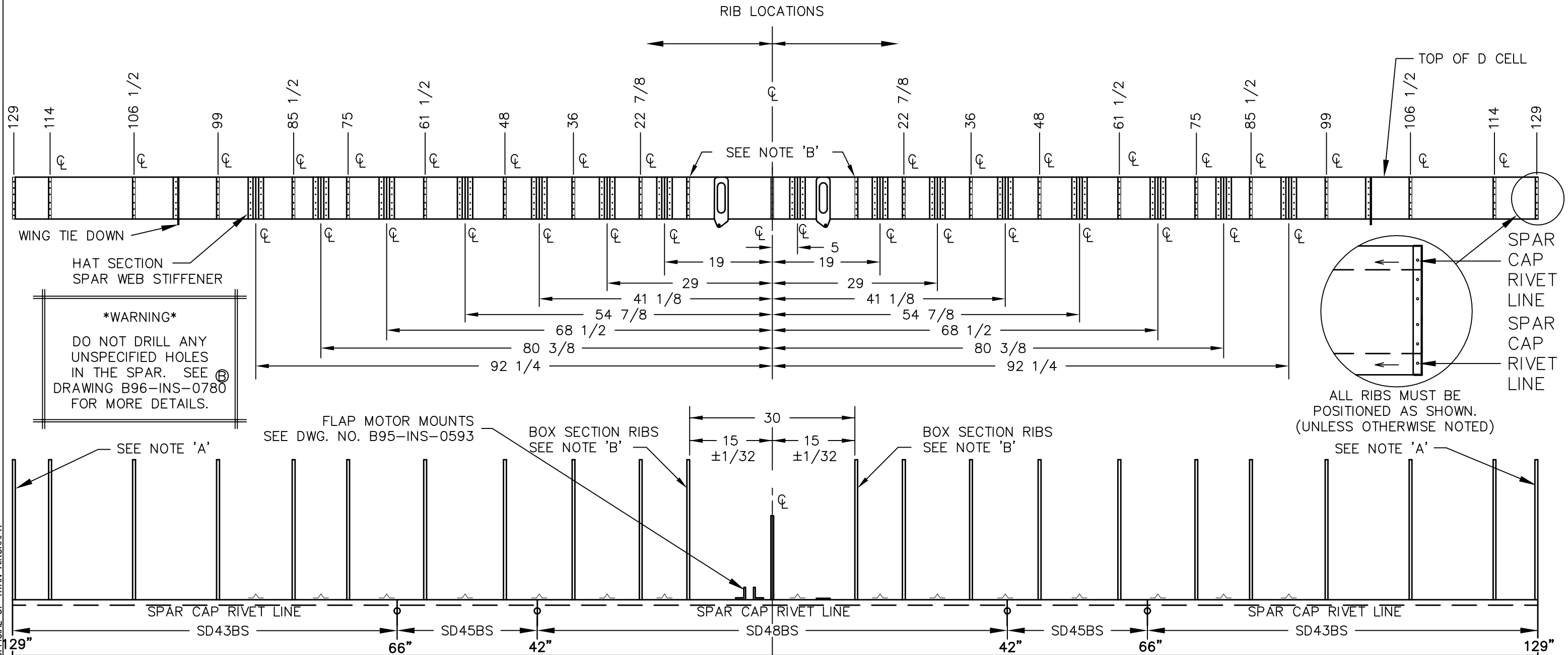


**\*WARNING\***  
DO NOT DRILL ANY UNSPECIFIED HOLES IN THE SPAR.  
SEE DRAWING B96-INS-0780 FOR MORE DETAILS.Ⓟ

REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	DRAWING RELEASED	CE	12/05
2186	B	CORRECTED DIMENSIONS	CE	1/05
2197	C	NOTE "A" IN WRONG SPOT	SH	8/06

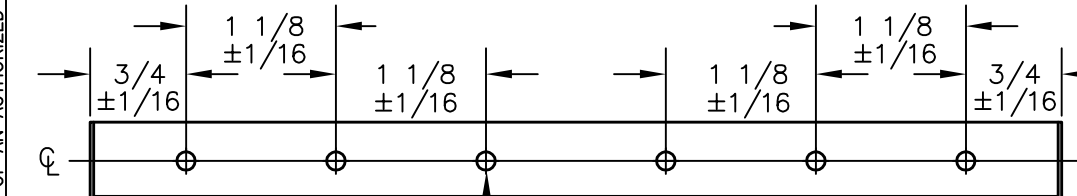


**\*WARNING\***  
DO NOT DRILL ANY UNSPECIFIED HOLES IN THE SPAR. SEE Ⓟ DRAWING B96-INS-0780 FOR MORE DETAILS.

FLAP MOTOR MOUNTS  
SEE DWG. NO. B95-INS-0593

BOX SECTION RIBS  
SEE NOTE 'B'

BOX SECTION RIBS  
SEE NOTE 'B'



- ASSEMBLY NOTES:**
- A) OUTSIDE SURFACE OF THESE RIBS ARE TO BE MOUNTED FLUSH WITH EDGE OF D-CELL.
  - B) THESE RIBS ONLY HAVE ONE LIGHTENING HOLE. ALSO NOTE THEY ARE NOT DIMENSIONED FROM THEIR CENTER LINE BUT FROM THEIR INSIDE SURFACE. THEIR FLAT SURFACE MUST ALSO BE TOWARD THE CENTER OF THE WING (THERE IS A RIGHT AND LEFT SIDE).
  - C) ALL DIMENSIONS ARE INCHES.
  - D) TOLERANCE:  $\pm 1/8$ , UNLESS OTHERWISE SPECIFIED.
  - E) INSERT FLAP CONTROL SYSTEM BEFORE PERMANENTLY MOUNTING RIBS.

**MOUNTING HOLE NOTES:**  
- THE OUTER TWO RIVETS WILL PASS THRU THE SPAR CAPS & MUST BE SIZED CORRECTLY. SEE SPAR CAP RIVET LINE ABOVE FOR CORRECT RIVET SIZES. SEE DWG. NO. INS-780.

- RIVET FOUR INNER HOLES WITH SD42BS RIVETS. (1/8 DIA X 17/64 LONG) #30 DRILL (.1285 DIA) THRU (6) PLACES  
MOUNTING HOLE DETAILS FOR HAT SECTION AND RIBS

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

DRAWN C. EMERY	DATE 12/28/05
CHECKED G. TRUEX	DATE 8/16/06
APPROVED J. WILLIAMS	DATE 2/14/07

DETAIL NAME	RIB AND HAT SECTION LAYOUT
SCALE	N/A
ASSEMBLY NAME	TORNADO SS
PART NO.	DRAWING NO.
DRAWING NO. <b>B 05-INS-1438-C</b>	

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