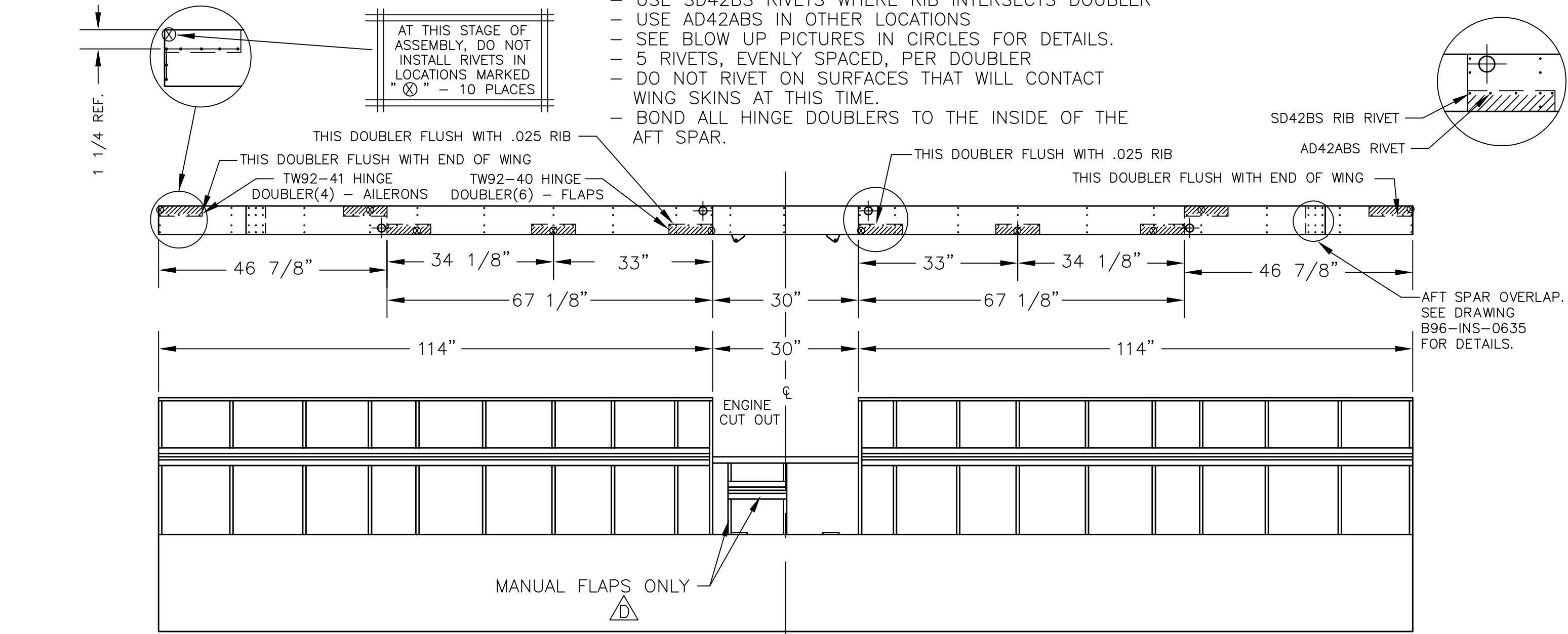


NOTE FOR HINGE DOUBLER INSTALLATION - 10 PLACES:
 - USE SD42BS RIVETS WHERE RIB INTERSECTS DOUBLER
 - USE AD42ABS IN OTHER LOCATIONS
 - SEE BLOW UP PICTURES IN CIRCLES FOR DETAILS.
 - 5 RIVETS, EVENLY SPACED, PER DOUBLER
 - DO NOT RIVET ON SURFACES THAT WILL CONTACT WING SKINS AT THIS TIME.
 - BOND ALL HINGE DOUBLERS TO THE INSIDE OF THE AFT SPAR.



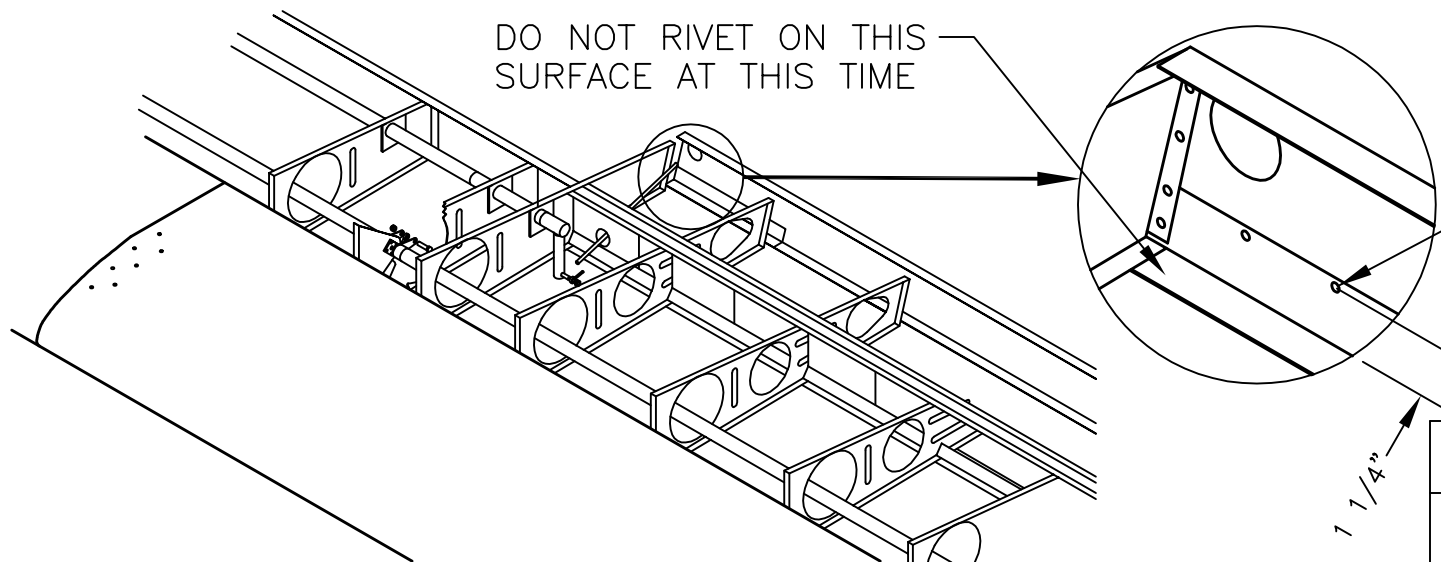
SD42BS RIB RIVET
 AD42ABS RIVET

AFT SPAR OVERLAP.
 SEE DRAWING
 B96-INS-0635
 FOR DETAILS.

MANUAL FLAPS ONLY
 ⚠

DO NOT RIVET ON THIS SURFACE AT THIS TIME

HINGE DOUBLER RIVET LINE. DRILL 1 1/4\"



FOR FURTHER DETAILS ON WING CONSTRUCTION AND REAR SPAR INSTALLATION, SEE DRAWING B92-INS-0327 AND B95-INS-0635.

		TITAN AIRCRAFT SUPPLY 1419 STATE ROUTE 45 SOUTH AUSTINBURG, OHIO 44010	
DETAIL NAME		HINGE DOUBLER INSTALLATION	
SCALE	N/A	PART NO.	
ASSEMBLY NAME		23 1/2 FOOT WING	
PART NO.		DRAWING NO.	
DRAWING NO.		B 96-INS-0749-D	

DRAWN	K. BOHRER	DATE	9/30/96
CHECKED	GAT	DATE	10/4/05
APPROVED	JW	DATE	10/5/05

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