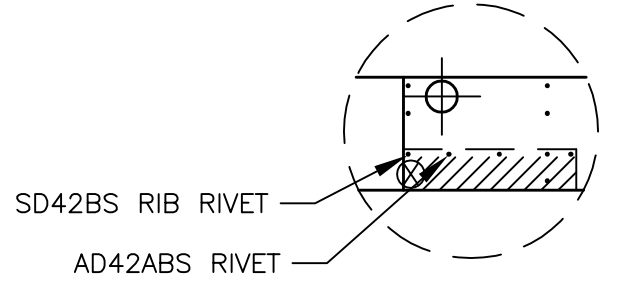


AT THIS STAGE OF ASSEMBLY, DO NOT INSTALL RIVETS IN LOCATIONS MARKED "⊗" - 12 PLACES

NOTE FOR HINGE DOUBLER INSTALLATION - 12 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.



DO NOT RIVET ON THIS SURFACE AT THIS TIME

HINGE DOUBLER RIVET LINE. DRILL 1 1/4" IN FROM EDGE OF REAR SPAR. TO AID IN THE SKINNING PROCESS, ALSO BOND THE DOUBLERS IN PLACE.

NOTE:  
FLAPS ARE 81.250 LONG.

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FOR FURTHER DETAILS ON WING CONSTRUCTION AND REAR SPAR INSTALLATION, SEE DRAWING B96-INS-0703 AND B95-INS-0635.

		<b>TITAN AIRCRAFT SUPPLY</b> 1419 STATE ROUTE 45 SOUTH AUSTINBURG, OHIO 44010	
DRAWN	K. BOHRER	DATE	6/18/97
CHECKED	GAT	DATE	12/28/05
APPROVED	JW	DATE	12/28/05
SCALE		N/A	PART NO.
ASSEMBLY NAME		26 FOOT WING ASSEMBLY	
PART NO.		DRAWING NO.	
DRAWING NO.		B 97-INS-0878-D	