

AT THIS STAGE OF ASSEMBLY, DO NOT INSTALL RIVETS IN LOCATIONS MARKED "X" (12 PLACES)

SEE DRAWING B97-INS-0878 FOR FURTHER DETAILS ON MOUNTING DOUBLERS

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

NOTE: HAT SECTIONS ARE COMBINED THE SAME AS REAR SPAR.

INSTALL TW92-27 RIB STIFFENERS BEHIND THE HAT SECTION (MANUAL FLAPS ONLY)

INTERMEDIATE SPAR (S) TW92-25 (SS) TW01-131 TW92-28 FLAP MOUNT HAT SECTION (MANUAL FLAPS ONLY)

INTERMEDIATE SPAR FLANGE TO RIB RIVET LINE. OUTER HOLES MUST BE A MIN. OF 1/2" IN FROM THE EDGE. 5 HOLES EQUALLY SPACED.

INTERMEDIATE SPAR TO CENTER SECTION RIB RIVET LINE. OUTER HOLES MUST BE A MIN. OF 1/2" IN FROM THE EDGE OF THE REAR SPAR. 5 HOLES EQUALLY SPACED.

ONLY RIVET THESE (2) SURFACES.

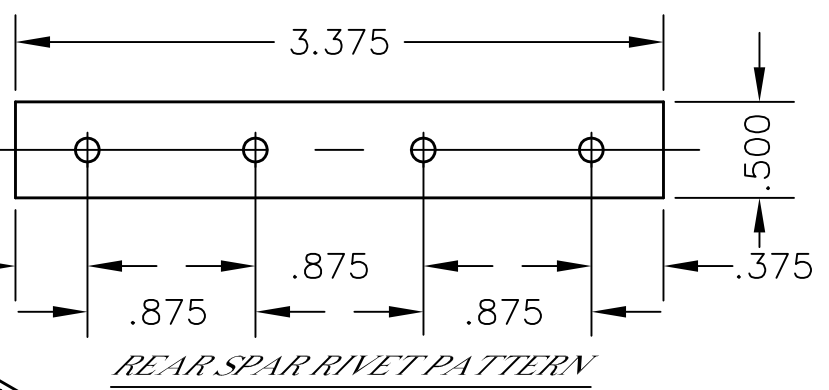
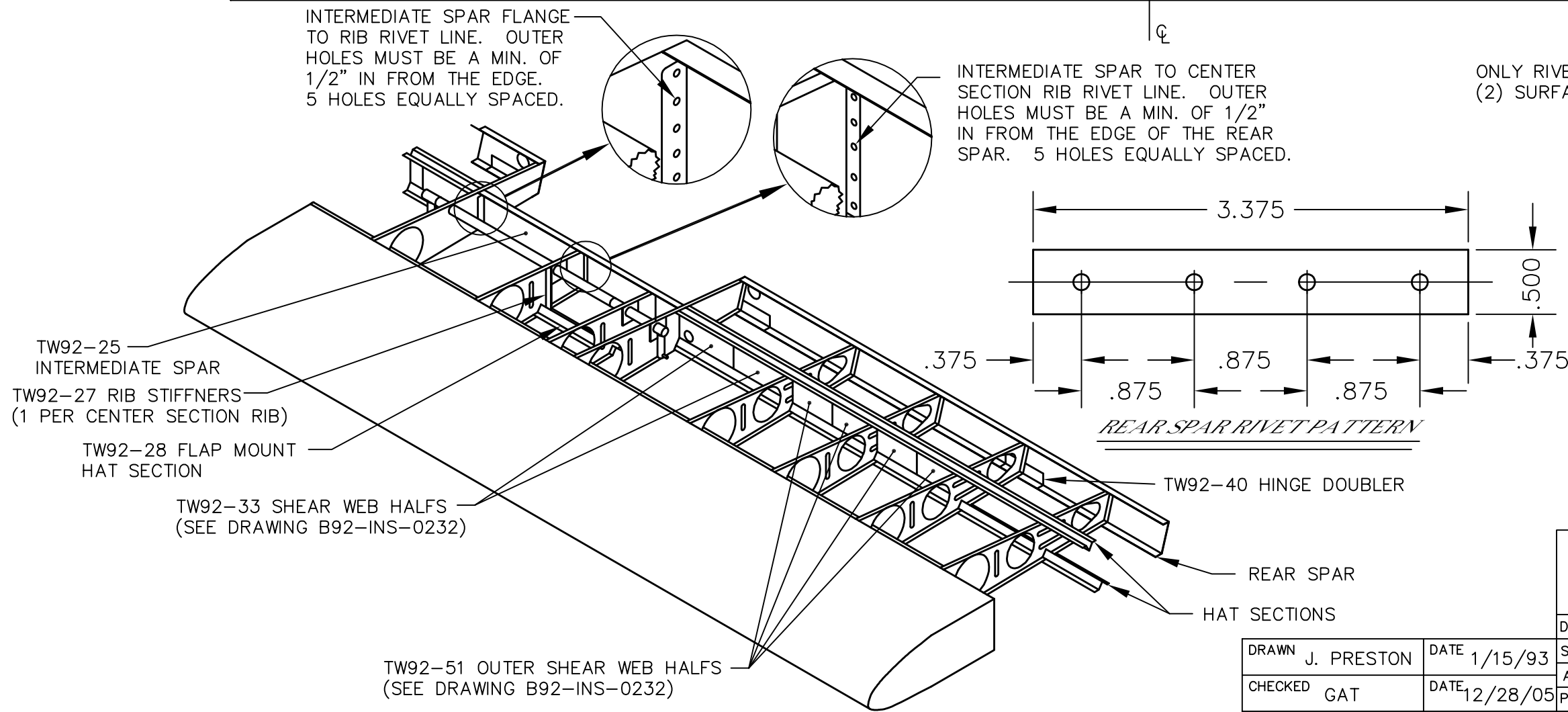
ONLY RIVET THRU THIS SURFACE.

HAT SECTION RIVET SURFACES

REAR SPAR AND INTERMEDIATE SPAR RIVET SURFACES.

NOTES:

- ALL DIMENSIONS ARE INCHES.
- TO INSURE WING SKINS WILL LAY FLAT, DO NOT RIVET ON OUTER SURFACE OF RIBS.
- *CAUTION* RIBS ARE FLEXIBLE. BE SURE THE ENTIRE RIB REMAINS SQUARE WITH THE SPAR AND HAT SECTION DURING THE ENTIRE DRILLING AND RIVETING PROCESS.
- DRILL ALL RIVET HOLES WITH #30 DRILL (.1285 DIA.)
- RIVET WITH SD42BS RIVETS. (1/8 DIA X 17/64 LONG)



REAR SPAR RIVET PATTERN

FOR FURTHER DETAILS ON WING CONSTRUCTION AND REAR SPAR INSTALLATION, SEE DRAWING B96-INS-0749 AND B95-INS-0635

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

DETAIL NAME	HAT SECTION AND AFT SPAR LAYOUT
SCALE	PART NO.
ASSEMBLY NAME	26 FOOT WING
PART NO.	DRAWING NO.
DRAWING NO.	B 96-INS-0703-E

DRAWN	J. PRESTON	DATE	1/15/93
CHECKED	GAT	DATE	12/28/05
APPROVED	JW	DATE	12/28/05

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