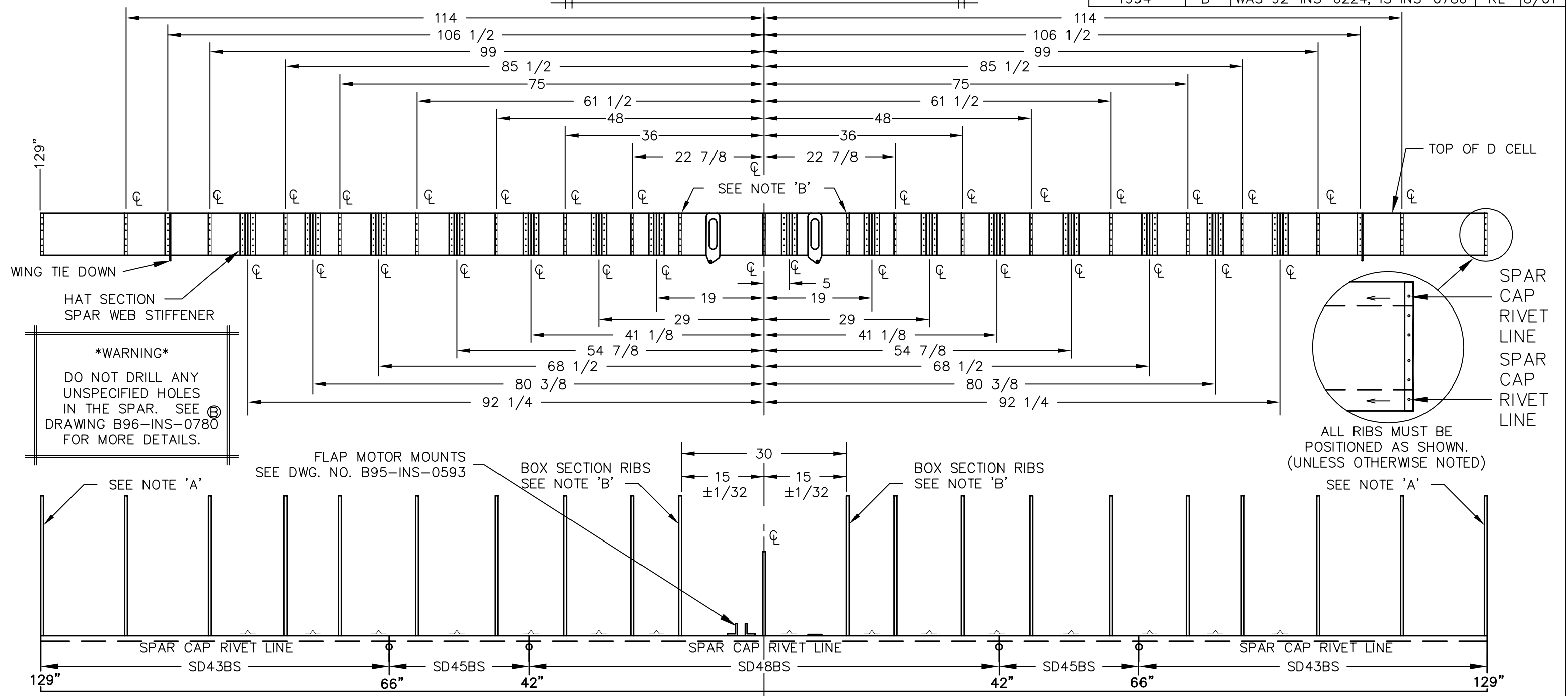


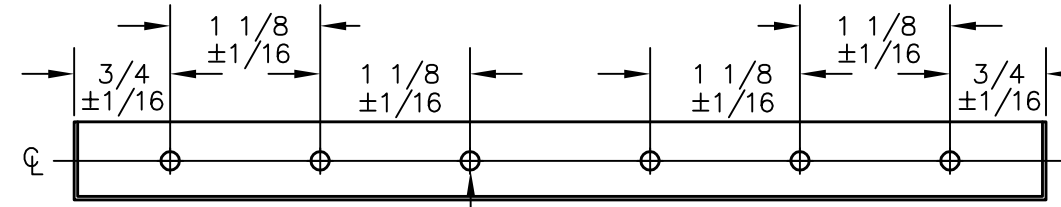
WARNING
DO NOT DRILL ANY UNSPECIFIED HOLES IN THE SPAR.
SEE DRAWING B96-INS-0780 FOR MORE DETAILS.Ⓟ

REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	DRAWING RELEASED	KL	6/01
1994	B	WAS 92-INS-0224, IS INS-0780	KL	8/01



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

ALL RIBS MUST BE POSITIONED AS SHOWN. (UNLESS OTHERWISE NOTED)
SEE NOTE 'A'



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

- 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: ±1/8, UNLESS OTHERWISE SPECIFIED.
 - E) INSERT FLAP CONTROL SYSTEM BEFORE PERMANENTLY MOUNTING RIBS.

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

DRAWN K. LIPLIN	DATE 6/12/01
CHECKED G. TRUFX	DATE 10/25/01
APPROVED B. PASSAFIUME	DATE 10/25/01

DETAIL NAME RIB AND HAT SECTION LAYOUT	PART NO.
SCALE N/A	ASSEMBLY NAME TORNADO S & SS W/ 23.5' WING
PART NO.	DRAWING NO.
DRAWING NO. B 01-INS-1248-B	

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