

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.

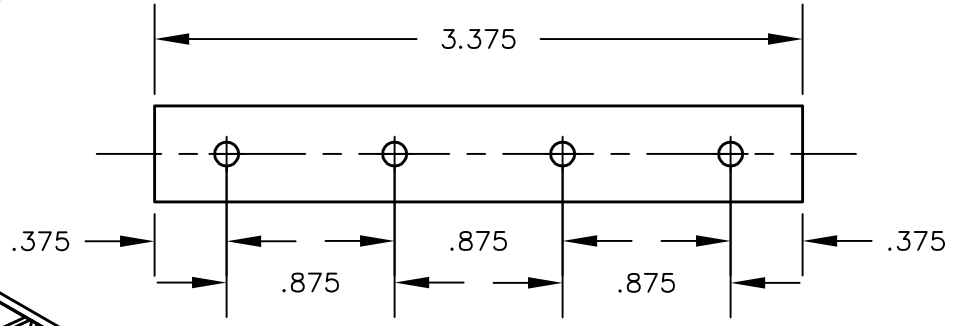
ONLY RIVET THRU THIS SURFACE.

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)



TW92-25 INTERMEDIATE SPAR
TW92-27 RIB STIFFNER (1 PER CENTER SECTION RIB)

TW92-28 FLAP MOUNT HAT SECTION

TW92-33 SHEAR WEB HALFS (SEE DRAWING B92-INS-0232)

TW92-51 OUTER SHEAR WEB HALFS (SEE DRAWING B92-INS-0232)

TW92-40 HINGE DOUBLER

TW92-58 REAR SPAR

TW92-17 HAT SECTIONS

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

DRAWN	J. PRESTON	DATE	1/15/93
CHECKED	GAT	DATE	10/4/05
APPROVED	JW	DATE	10/5/05

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

DETAIL NAME	HAT SECTION AND REAR SPAR LAYOUT		
SCALE	PART NO.		
ASSEMBLY NAME	23 1/2 FOOT WING		
PART NO.	DRAWING NO.		
DRAWING NO.	B 92-INS-0327-D		