

**Procedure 3.140****Installation of Tie Down Ribs**

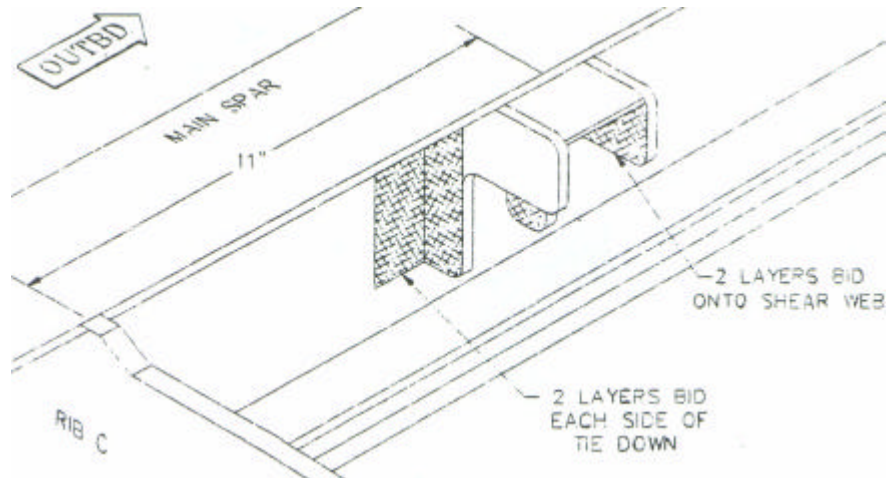
**In this procedure...**

**The wing tie down ribs will be installed.**

<b><u>Part Numbers</u></b>	<b><u>Description</u></b>	<b><u>Quantity</u></b>
<b>111-12-001</b>	<b>Tie Down Rib</b>	<b>2</b>

**Step 1. Laminate tie down to wing.**

Locate the tie down on the aft side of the main spar, so the center is 11" outboard from the center of rib C, measured along the spar. Remember the wing is inverted so the tie down will be placed at the top of the spar as it sits in the jig. Place the tie down with the plate facing up, and tuck it under the spar cap so the long edges of the ribs meet the main spar shear web. Sand it if necessary to get a good fit, and then clamp the plate to the spar cap.



Wet out the area under the spar cap, clamp in place, then laminate the tie down to the main spar using 2 layers of bid on each side. Lap a minimum of 1" onto the ribs, spar cap and shear web. Lay-up 2 layers inside the tie down, that laps

onto both ribs and the shear web. The tie down hole will be drilled in the wing closeout section.