

PROCEDURE 5.020
FLAP CONSTRUCTION PROCEDURES

In this procedure...

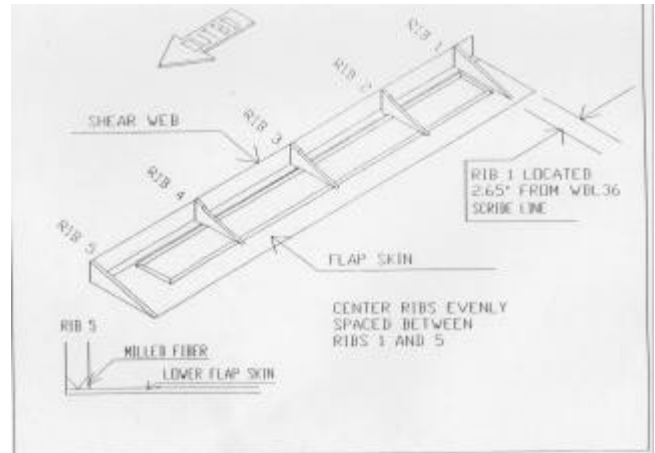
The flap ribs will be bonded to the lower flap skin, brackets will be installed and the upper flap skin will be bonded on. Methods used to close out the flap will be identical to those used in the close out of the aileron.

For this procedure, the following parts will be required:

<u>Part Number</u>	<u>Description</u>	<u>Quantity</u>
111-11-011	Skin, Flap Left Upper	1
111-11-012	Skin, Flap Right Upper	1
111-11-013	Skin, Flap Left Lower	1
111-11-014	Skin, Flap Right Lower	1
111-11-009	Flap Spar	2
111-12-027	Flap Rib	2
111-12-028	Flap Rib	2
111-12-029	Flap Rib	2
111-12-030	Flap Rib	2
111-12-031	Flap Rib	2
111-14-013	Hinge, Wing Control Surface	6
111-14-015	Hinge, Backing Plate	6
111-14-059	Flap Bracket	4
AD426-3-4	Rivet	60
K2000-4	Anchor Nut	6
AN4-10A	Bolt	6
AN960-416	Rivet	12
111-14-014	Hinge Pocket 10"	6

Step 1. Installation of the flap spar and ribs is identical to that of the aileron.

Position the flap ribs as shown in the picture on the right. (Note: Rib number 1 must be set so that it aligns with the flap push-pull tube in the wing. The measurement at the right is a nominal setting.)



Step 2. Install Flap push-pull tube bracket.

Position the bracket as shown. Make sure the rod end bearing has sufficient clearance with the flap spar.

Step 3. Close out Flap.

Using the procedures described in the aileron close out procedures bond the upper flap skin to the lower skin and rib assembly.

