

PROCEDURE 5.060 FLAP INSTALLATION

In this procedure...

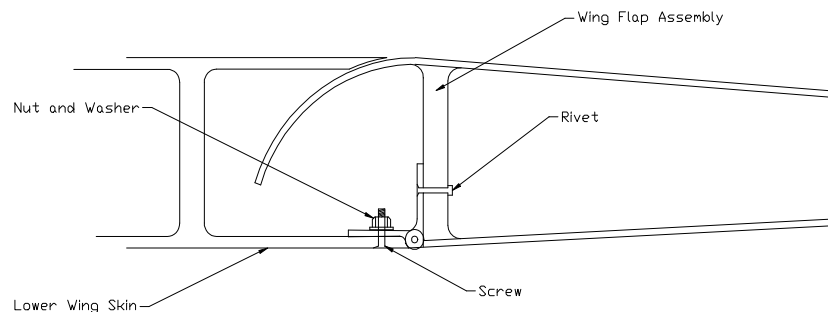
You will install the flap assembly to the lower wing skin. Fit the flap to insure proper travel and clearance.

Materials Supplied

<u>Part Number</u>	<u>Qty.</u>	<u>Description</u>
AN365-832.	60	Nut
MS24693C51	60	Screw
AN960-8.	60	Washer
111-24-007	2	Flap Push Pull Tube
AN3-14A	2	Bolt
AN3-12A	2	Bolt
AN960-10	6	Washer
AN365-1032	4	Nut
GMW-3M-570	2	Bearing
AN316-5	4	Check Nut

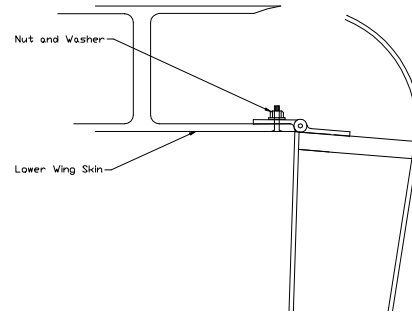
Step 1. Position the Flap onto the Wing Skin/Aileron

Place the Flap in position and mark the hinge location on the aft edge of the lower wing skin. Sand the lower wing skin so that the flap hinges fit flush with the bottom side of the lower wing skin. There should be a smooth transition from the wing skin to the flap skin.



Step 2. Position the Flap on the Wing.

Hold the flap in position against the wing skin. With the flap extended in the full down position drill two screws holes and install clecos to hold the flap in position. Use a one-inch spacing and drill the holes for the 10 mounting screws. Install two screws in each hinge to hold the flap in position during the rigging process.

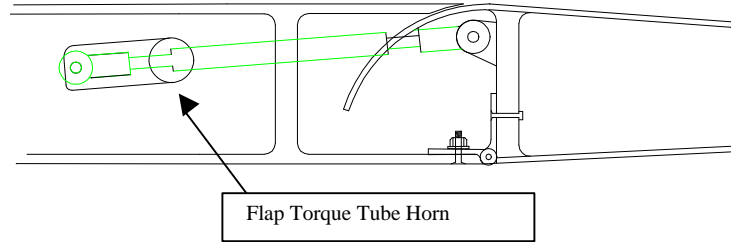
**Step 3. Attach the Flap Push/Pull Tube to Flap**

Attach the flap push/pull tube to the bracket attached to the flap. Check to insure that the passage cut through the aft shear web allows the push pull tube to pass through the shear web and attach to the flap torque tube horn without rubbing on the shear web. Also make sure the push/pull tube is centered in the torque tube horn.



Step 4. Attach Push /Pull Tube to Torque Tube Horn.

With the flap clamped in the UP position, adjust the Push/Pull tube to the shortest possible length with the torque tube horn 90° to the flap bracket. Temporarily install the bolts in the push/pull tube ends and check flap rotation to insure 40° of flap travel. The push/pull tube should be centered in the Torque Tube Horn and should not touch the sides of the horn.

**Step 5. Final Installation**

Once you have insured proper fit, and operation of the flap assembly install the flap using ten (10) screws per hinge. Be sure to use washers and new Fiber Lock Nuts.