

PROCEDURE 5.050 AILERON INSTALLATION

In this procedure...

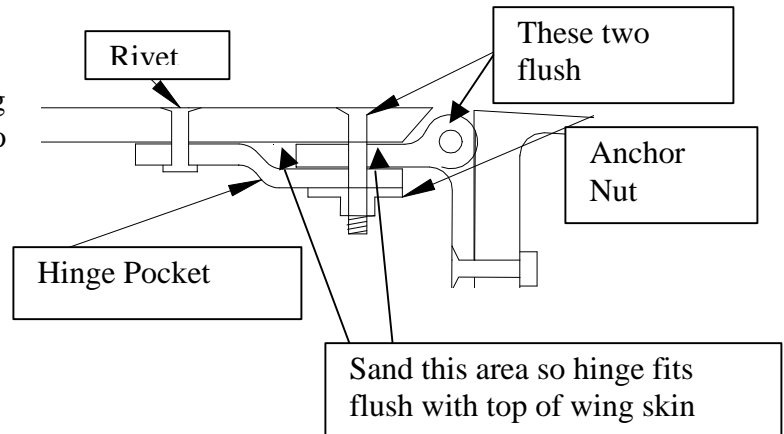
You will install the flight control hinge pockets on the wing, install the anchor nuts and attach the aileron to the wing. Fit the aileron to insure proper travel and clearance.

Materials Supplied

| <u>Part Number</u> | <u>Qty.</u> | <u>Description</u> |
|--------------------|-------------|--------------------|
| 111-14-014 | 4 | Hinge Pocket |
| AN426AD3-5 | 120 | Rivets |
| K2000-3 | 60 | Anchor Nut |
| MS24693C51 | 60 | Screw |

Step 1. Position Aileron

Hold the Aileron in position on the wing and mark the hinge location on the aft edge of the upper wing skin. Sand the under side of the upper wing skin so that the aileron hinge fits flush with the top of the upper wing skin.



Step 2. Position the Hinge Pocket

Position the hinge pockets in the hinge locations and secure to the upper wing using clecos in the corners. Check to make sure the hinge pocket is fitting flat against the wing skin surface.

Step 3. Drill Screw Holes and Install Anchor Nuts.

Lay out the screw pattern at 1" intervals, starting ½" in from the end of the hinge. Drill and counter sink the screw holes. Use caution to drill the holes 90 degrees to the wing surface

Remove the aileron from the wing. Remove the hinge pocket from the wing and install the anchor nuts.

Sand and clean the surfaces of the hinge pocket and wing skin where the hinge pocket will be bonded. Using a thin Milled Fiber mix bond the hinge pocket to the wing. Lay out a rivet pattern along the edge of the wing pocket. Make sure you do not get milled fiber in the recessed area where the hinge will go. Rivet the hinge pocket to the wing using flush rivets. Make sure the screw holes and anchor nuts align.

