

PROCEDURE 4.020

LAMINATE FORE AND AFT SHEAR TIE

In this procedure:

The fore and aft shear ties will be laminated in place. These shear ties have been positioned by the factory.

SUPPLIED MATERIAL

<u>Part Number</u>	<u>Qty</u>	<u>Description</u>
112-12-008	1	Shear Tie, Forward
112-12-009	1	Shear Tie, Aft

Step 1. The Fore and Aft Shear Tie are position in the lower fuselage at the factory. Apply a ¼" Q-cell mixture fillet along the joints on both sides of the shear tie assembly.

Step 2. Laminate three layers of 7781 cloth, (3" wide) centered along the joints on both sides of the shear tie.

Step 3. Repeat steps 1 and 2 for the Aft Shear Tie.

