



NOTE: This section describes the Anti-Servo Tab (AST) construction for the left side. Construction for the right side is a mirror of the left, and should be done at the same time.

Step 1: Read all steps prior to construction.

Step 2: Remove the material shown hatched from the bottom half of the HS-1221-L AST Skin as shown in Figure 1.

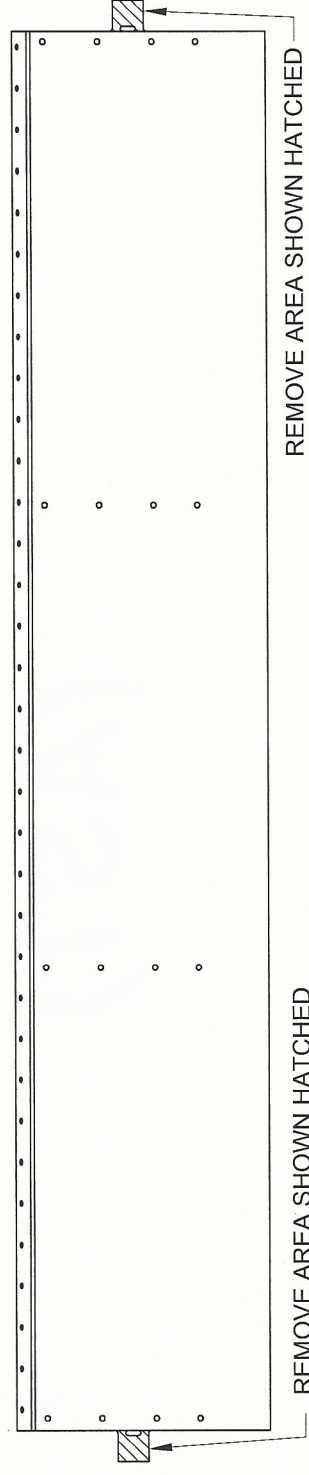


FIGURE 1:
HS-1221-L TAB REMOVAL

NOTE: The top surface and inboard end of the HS-1221-L AST Skin can be identified by the AST Control Horn cutout, called out in Figure 4.

Step 3: Cleco the top and bottom flanges of the four HS-1222 AST Ribs to the inside of the HS-1221-L AST Skin. Orient the flanges of the three inboard ribs to point outboard. Orient the flanges of the outboard rib to point inboard as shown in Figure 2.

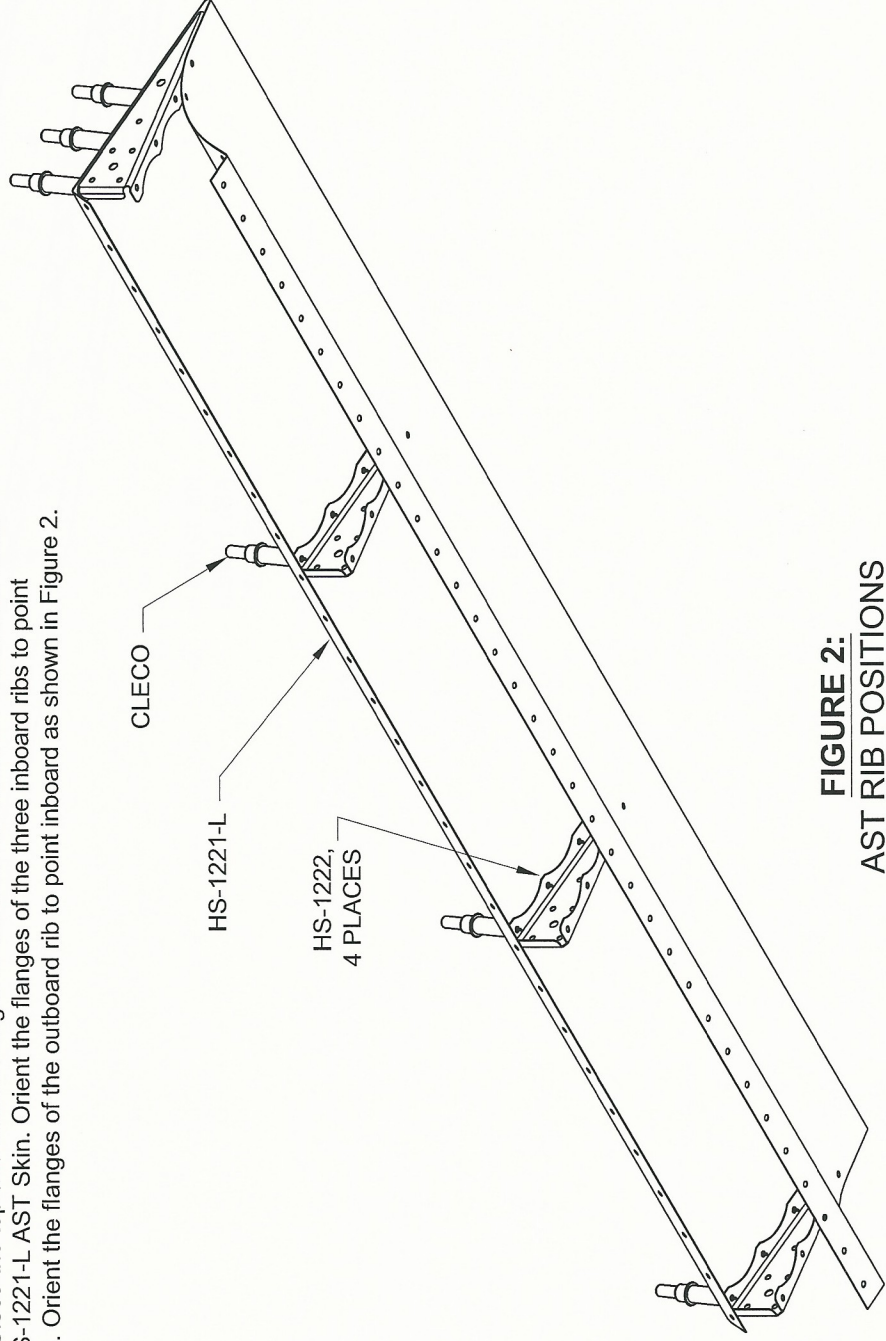


FIGURE 2:
AST RIB POSITIONS

Step 4: Final-Drill #30 the HS-1222 AST Ribs using the holes in the HS-1221-L AST Skin nearest to the trailing edge as a guide. Mark the rib locations to return them to the same position as drilled for final assembly.

Disassemble, deburr holes and remove any chips.

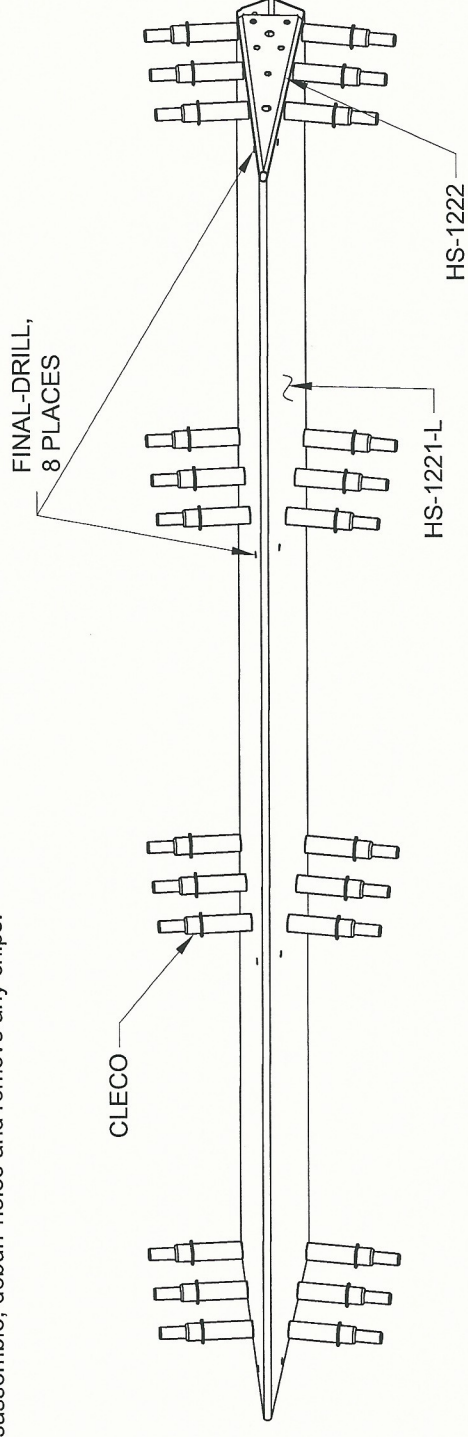


FIGURE 3:
MATCH-DRILL RIBS

Step 5: Rivet only the top flange of the four HS-1222 AST Ribs inside the top surface of the HS-1221-L AST Skin per rivet call-out in Figure 4.

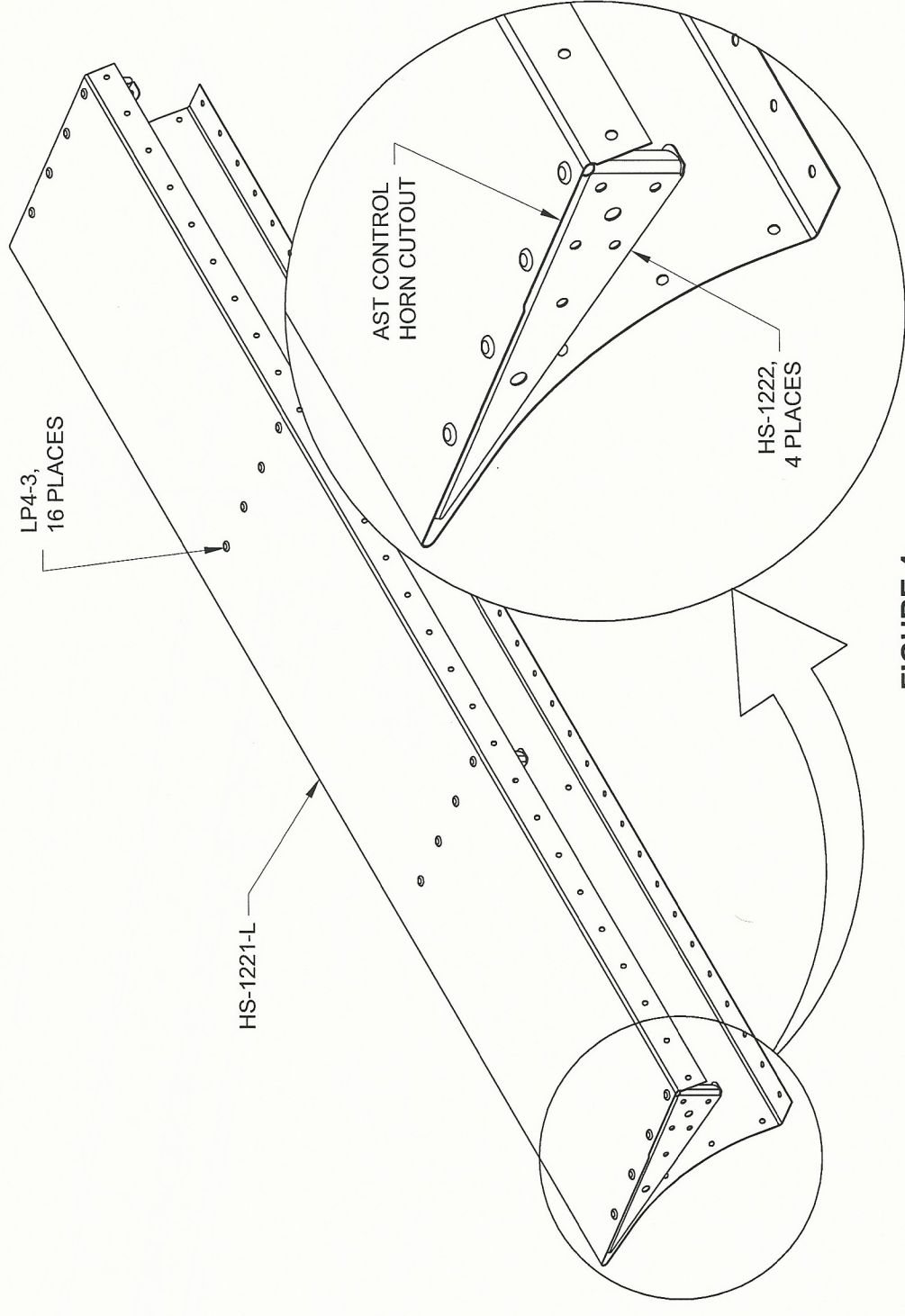


FIGURE 4:
AST SKIN RIVETS