

Step 1: Mark and separate the F-1220-LR AST Control Horns per call-outs in Figure 1.

Step 2: Machine countersink the HS-1220-L AST Control Horn for a 3/32 inch rivet per call-out in Figure 2.

Step 3: Orient the AST Control Horn to pass through the AST control horn cut-out. Rivet the HS-1220-L AST Control Horn to the inboard HS-1222 AST Rib as shown in Figure 2.

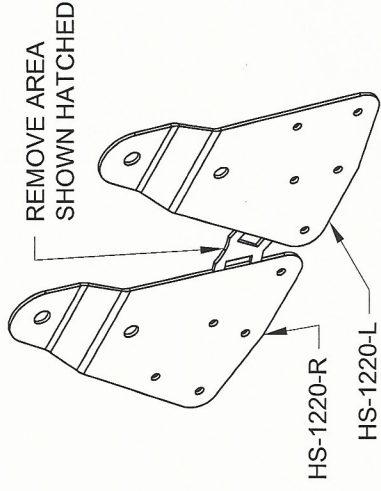


FIGURE 1:
AST CONTROL HORN SEPARATION

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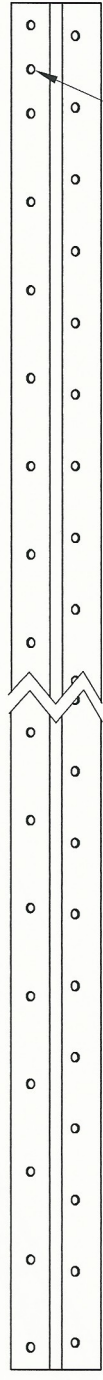


FIGURE 2:
AST CONTROL HORN INSTALLATION

FIGURE 3:
HS-1219-L REFERENCE HOLE

CAUTION: Rivet only the upper flange of the skin to the spar at this time per Step 4.

Step 4: The HS-1219-L AST spar must be installed on the inside surface of the HS-1221-L AST skin as shown in Figure 4. The reference hole in the AST spar, shown in Figure 3, must be oriented up and outboard. Rivet the AST Spar to the AST Skin per call-out in Figure 4. Omit the reference hole when riveting.

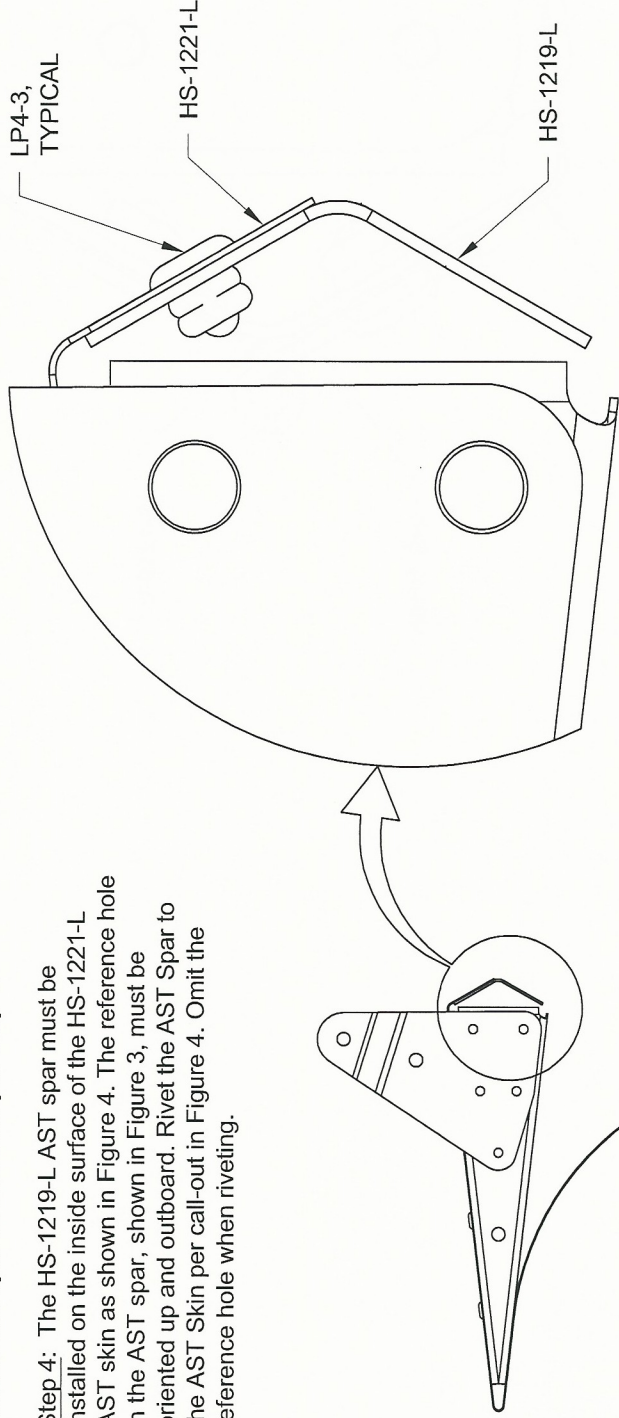


FIGURE 4:
AST SPAR INSTALLATION

Step 5: Remove the hinge pin from one AN257-P3X6' (also known as MS20257-3) Piano Hinge. Cut each of the hinge halves into two lengths per dimensions given in Figure 5.

Locate cuts so that there are hinge eyelets at both ends of all four hinge halves.

Two hinge half lengths will be the left and right HS-1218B AST Hinges. The other two lengths will be the left and right HS-1218A Aft Stab Hinges. The aft stab hinges will be installed during Section 9, Stabilator Assembly. The hinge pins will be installed during Section 11, Empennage Attach.

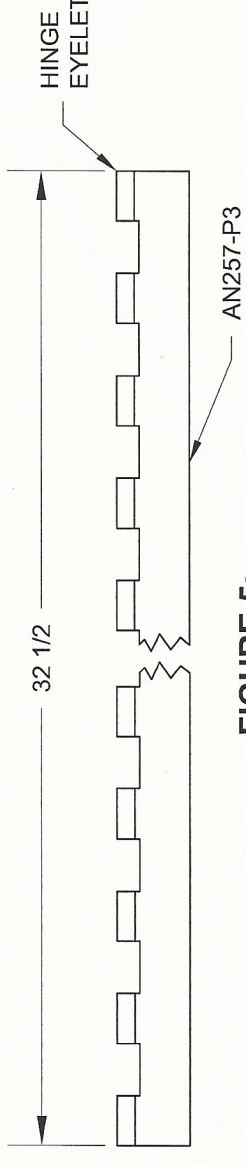
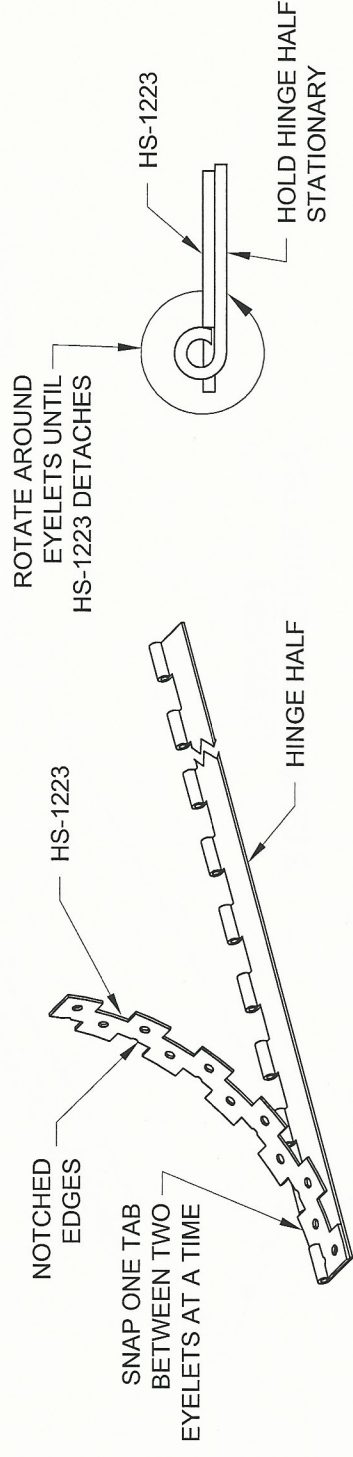


FIGURE 5:
MAKE FOUR HINGE HALVES

NOTE: Save the HS-1223 Drill Guide called out in Figure 6 and 7, it will be used again during Section 9, Stabilator Assembly.

Step 6: Position the HS-1223 Drill Guide per Figure 6, Detail A. Orient the notched edges of the drill guide adjacent to the eyelets of the AST hinge half, then clamp the drill guide onto the AST hinge half.



DETAIL A:
PLACEMENT

DETAIL B:
REMOVAL

FIGURE 6:
DRILL GUIDE TIPS

Step 7: Match-Drill #30 the Hinge Half, using the HS-1223 Drill Guide per Figure 7. Refer to Figure 6, Detail B to remove the drill guide. Repeat Step 6 and Step 7 until the entire hinge half has been drilled to make the HS-1218B AST Hinge Half.

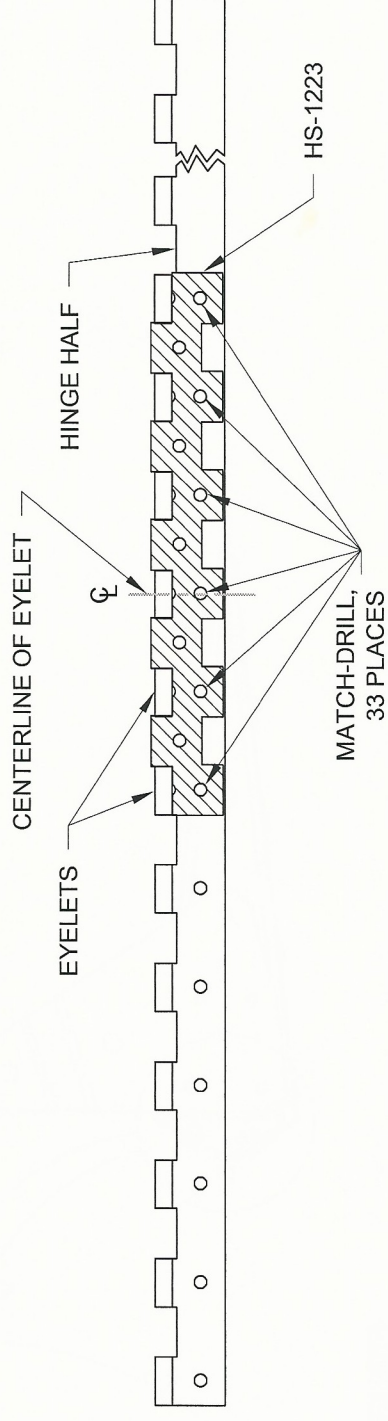


FIGURE 7:
DRILLING THE AST HINGE