Step 1: Rivet the HS-1214 Rib Clips to the HS-1203 Aft Spar per call-outs in Figure 1. Note the orientation of each rib clip, and be sure that all three holes of each rib clip align to all three holes of the aft spar before riveting.

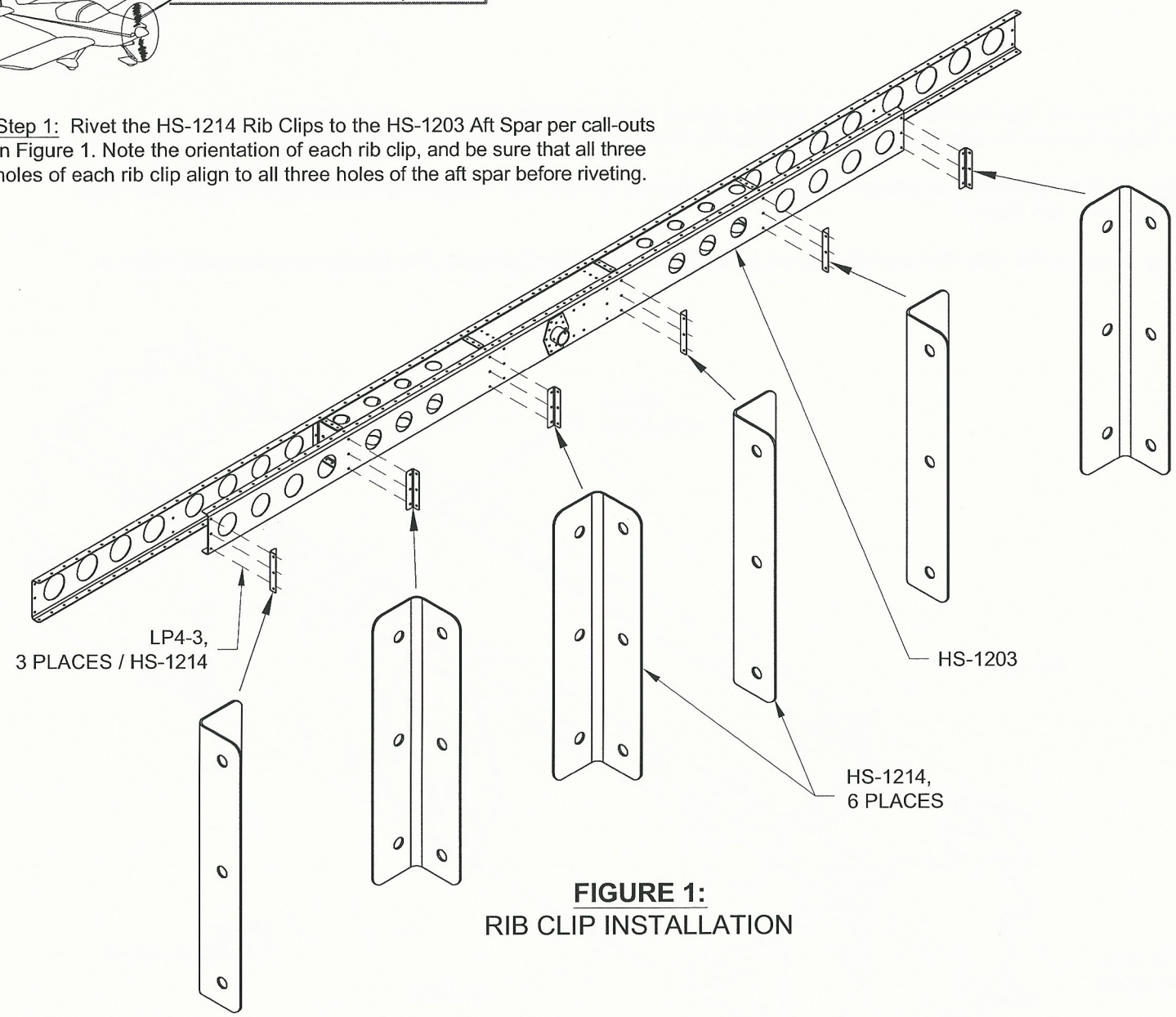

FIGURE 1:
RIB CLIP INSTALLATION

Step 2: Radius the edges at the narrow end of the HS-1204 Fwd Inbd Ribs and HS-1205 Fwd Outbd Ribs as shown in Figure 2.

A great way to form the radius is with a fine file.
Deburr all of the ribs.

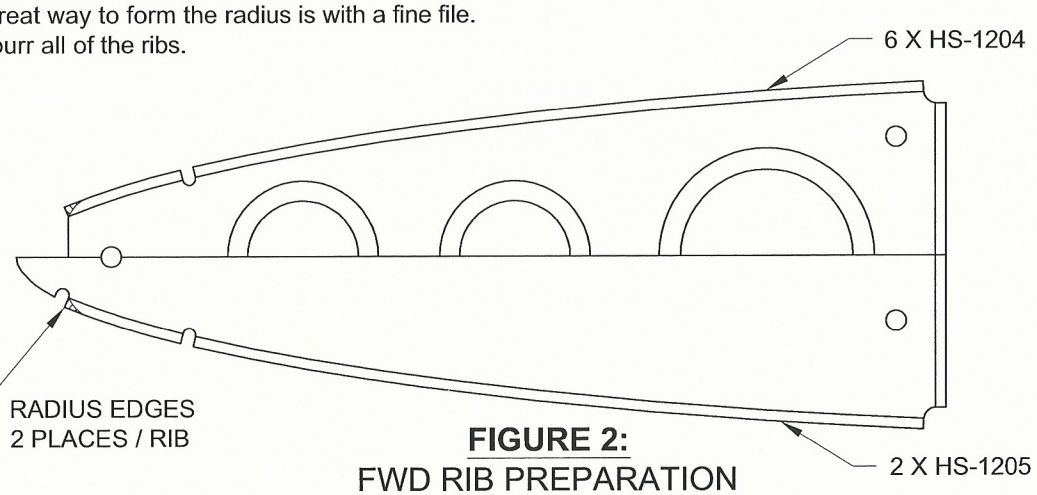

FIGURE 2:
FWD RIB PREPARATION

NOTE: Figure 3 illustrates the installation of the ribs for the right side of the stabilator. Steps 3, 4, and 5 describe installation for the ribs on the right side of the stabilator. Installation for the ribs on the left side of the stabilator is a mirror of the right. Perform the remaining steps on this page on both sides of the stabilator. Flute ribs as necessary per Section 5N.

Step 3: Rivet the HS-1216 Aft Main Ribs and the HS-1206 Inbd Main Rib to the HS-1214 Rib Clips per call-out in Figure 3.

Step 4: Rivet the HS-1204 Fwd Inbd Ribs to the HS-1202 Fwd Spar per call-out. Include the forward flange of the HS-1206 Inbd Main Rib when installing the outer most fwd inbd rib. Orient all the rib flanges as shown in Figure 3.

Step 5: Rivet the HS-1205 Fwd Outbd Rib to the HS-1207 Outbd Main Rib through the HS-1202 Fwd Spar. Orient the flanges of the fwd outbd rib and the outbd main rib so that they point inboard as shown in Figure 3.

Hereafter refer to the Spar Box Assembly with all of the ribs attached as the Stabilator Skeleton Assembly.

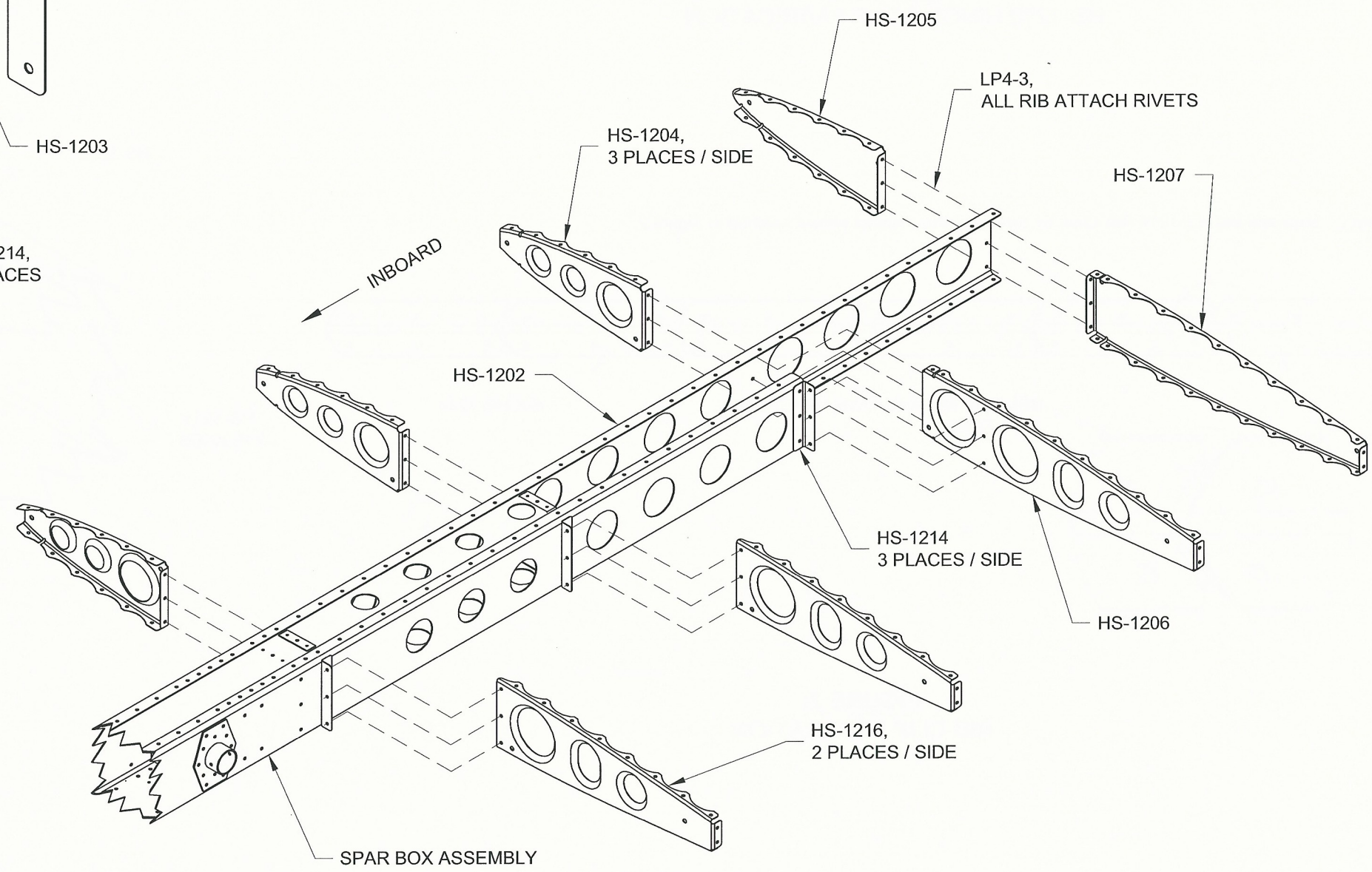

FIGURE 3:
STABILATOR SKELETON ASSEMBLY