



Step 1: Install the HS-1213A Inbd and HS-1213B Outbd Hinge Brackets to the HS-1202 Fwd Spar using the hardware called out in Figure 1.

Step 2: Install the HS-1210 Bushings between the HS-1213A Inbd and HS-1213B Outbd Hinge Brackets using the hardware called out in Figure 1. When installing each bushing or tightening the bolt the inbd and outbd hinge brackets should not yield to the bushings. Trim or replace bushings as necessary to maintain the spacing and angle of the inbd and outbd hinge brackets.

NOTE: Ribs attached to the Spar Box Assembly not shown in Figure 1.

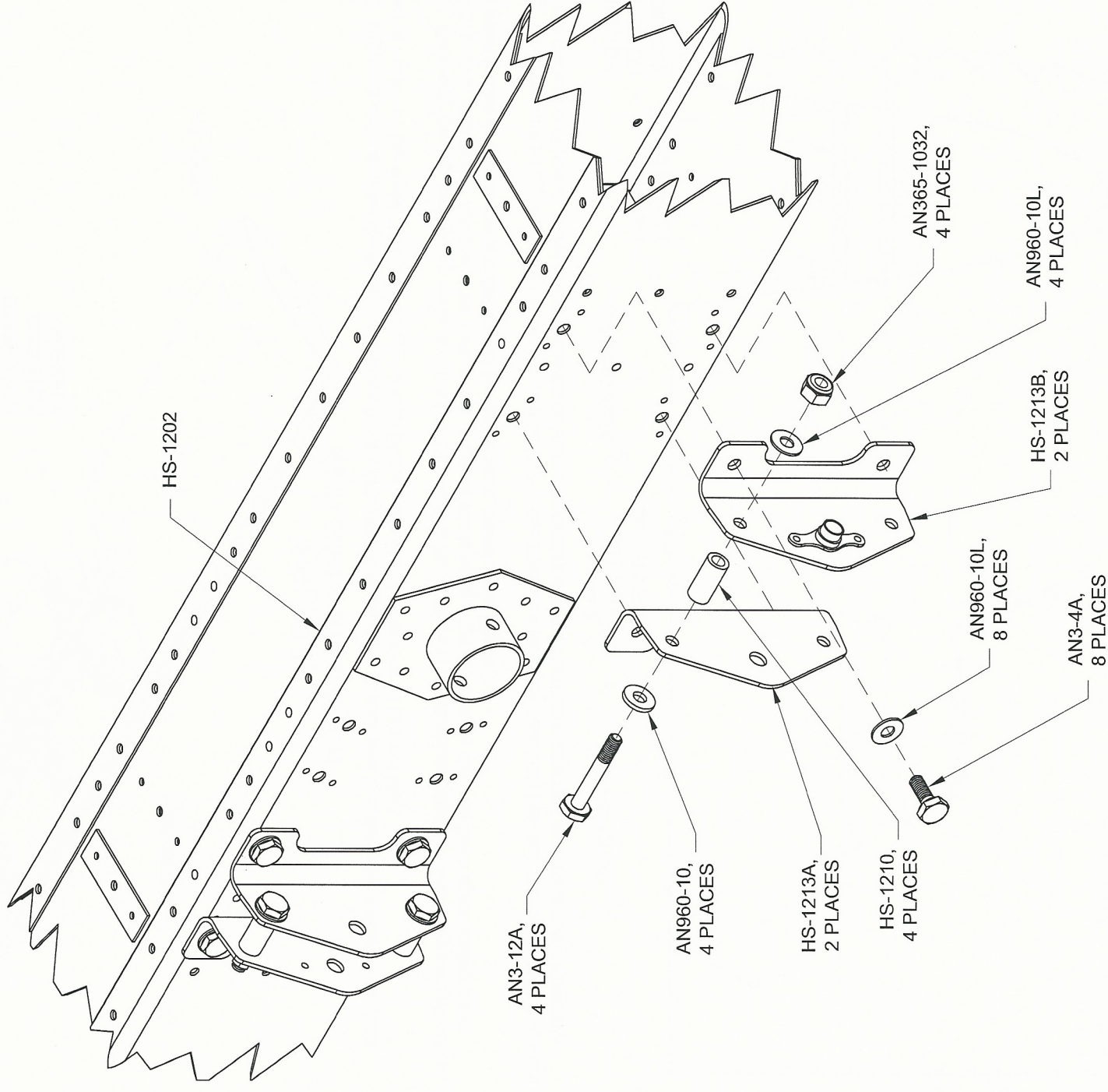


FIGURE 1:
HINGE BRACKET INSTALLATION

NOTE: The HS-1218A Aft Hinge halves were cut to length on Page 8-3, Step 4.

Step 3: Mark one of the HS-1218A Aft Hinge halves as right and the other as left, and label the inboard end of each hinge as indicated in Figure 2.

Step 4: Apply masking tape to the HS-1218A-R and HS-1218A-L Aft Hinges as shown in Figure 2. Count from the same end of both hinge halves. Mask the HS-1218A-L at the 14th eyelet and the 28th eyelet. Mask the HS-1218A-R at the sixth eyelet and the 20th eyelet. These areas will be omitted when drilling in Step 5.

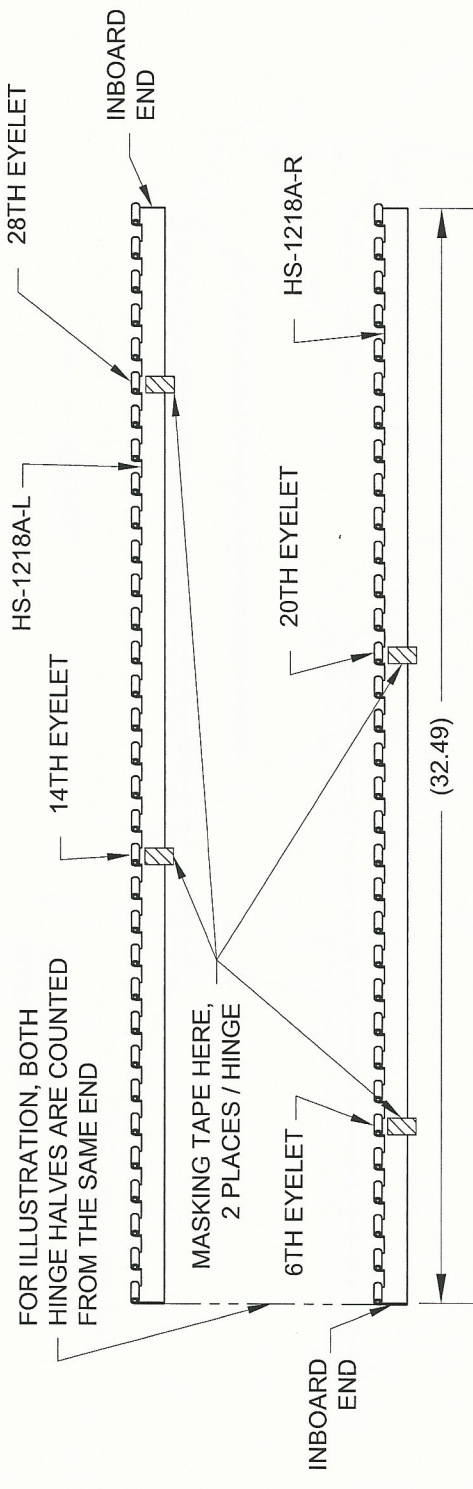


FIGURE 2:
STAB HINGE MASKING

CAUTION: Before performing Step 5 study the HS-1223 Drill Guide to identify the difference between the notched edges (used in Section 8) and the un-notched edges used in this section.

NOTE: For tips using the HS-1223 Drill Guide refer to Page 8-3, Figure 5.

Step 5: Match-Drill #30 the HS-1218A-R Aft Hinge using the HS-1223 Drill Guide as called out in Figure 3. Orient the un-notched inset edges of the drill guide to be flush against the eyelets of the aft hinge half. Clamp the drill guide onto the aft hinge half. Use only the holes that are centered below each aft hinge eyelet, as shown in Figure 3. Omit the holes that align with the masking tape applied in Step 4. Reposition the drill guide and repeat Step 5 until the aft hinge half is match-drilled at each eyelet, except where the masking tape is applied.

Repeat Step 5 for the HS-1218A-L Aft Hinge.

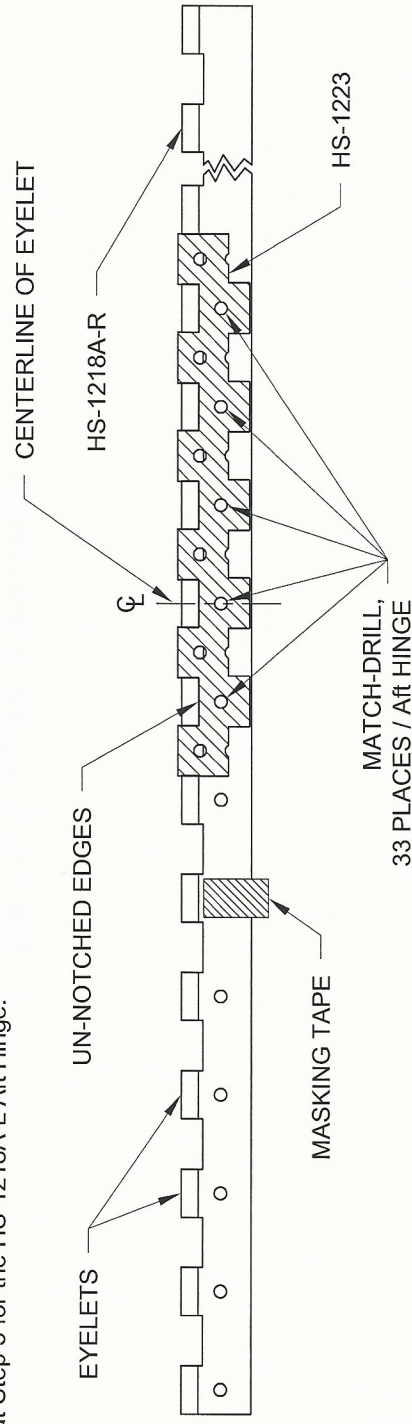


FIGURE 3:
STAB HINGE INITIAL DRILLING