Step 1: Mark one of the HS-1201 Main Skins as HS-1201-R, that will be the right main skin. Mark the other main skin as HS-1201-L, that will be the left main skin.

Step 2: Cleco the HS-1218A-L & -R Aft Hinge to the HS-1201-R Main Skin. Orient the hinges flush to the inside surface of the aft flange aligned to the hole pattern nearest to the bend of the aft flange as shown in Figure 1.

Step 3: Match-Drill #30 the holes at each masking tape location from the HS-1201-R Main Skin into the HS-1218A-L & -R Aft Hinges. Match-Drill #30 the hole at the inboard end of both aft hinges.

Remove the aft hinges, deburr the holes and clear away any chips.

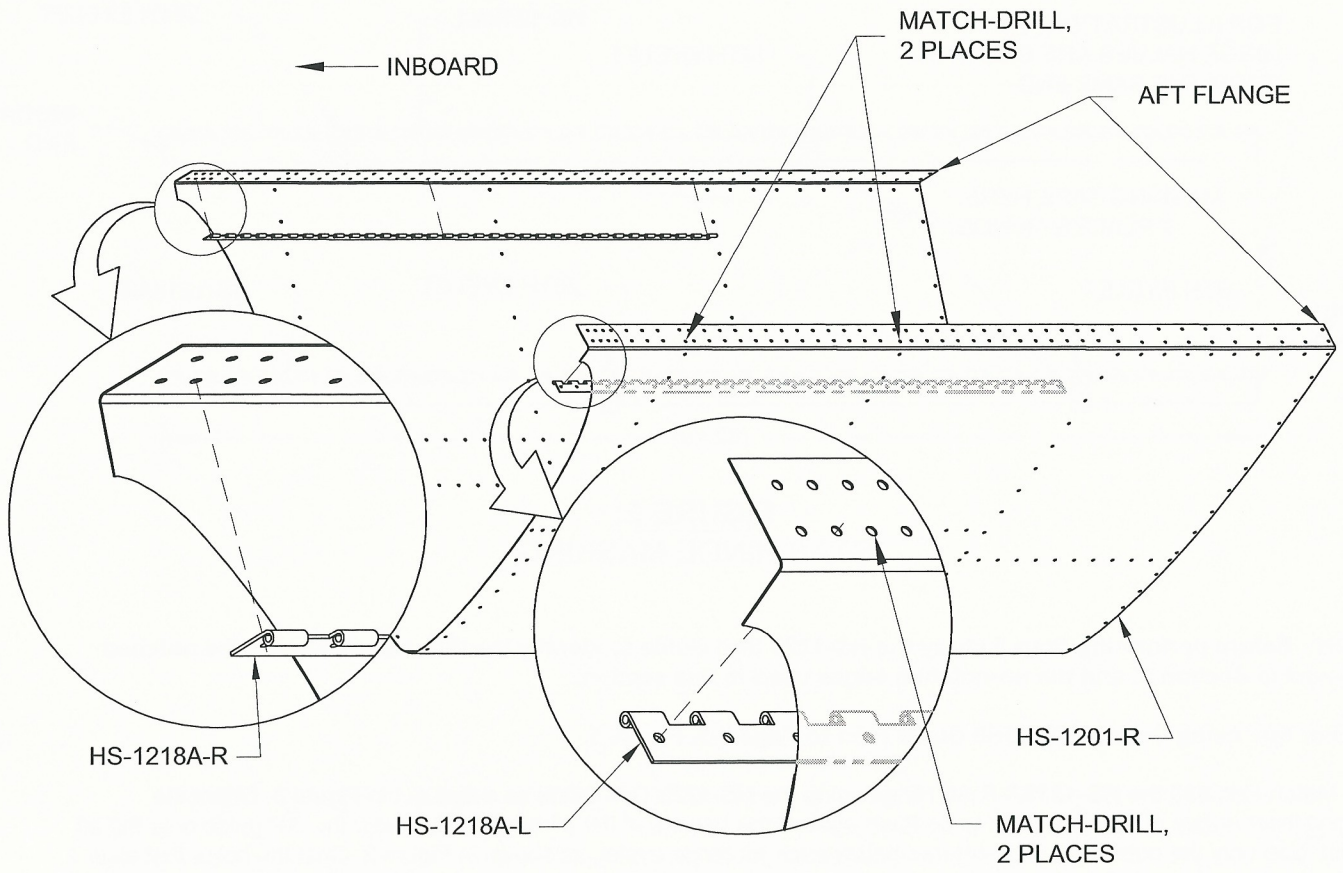

FIGURE 1:
STAB HINGE MATCH-DRILLING

Step 4: Cleco the HS-1201-R & -L Main Skins to the Stabilator Skeleton Assembly as shown in Figure 2. Cleco all of the holes in the bottom side of one of the main skins. Guide the upper aft flange of the main skin to the outside of the lower aft flange. Then cleco all of the holes on the top side.

Complete Step 5 with the first main skin. Then repeat this step for the remaining main skin.

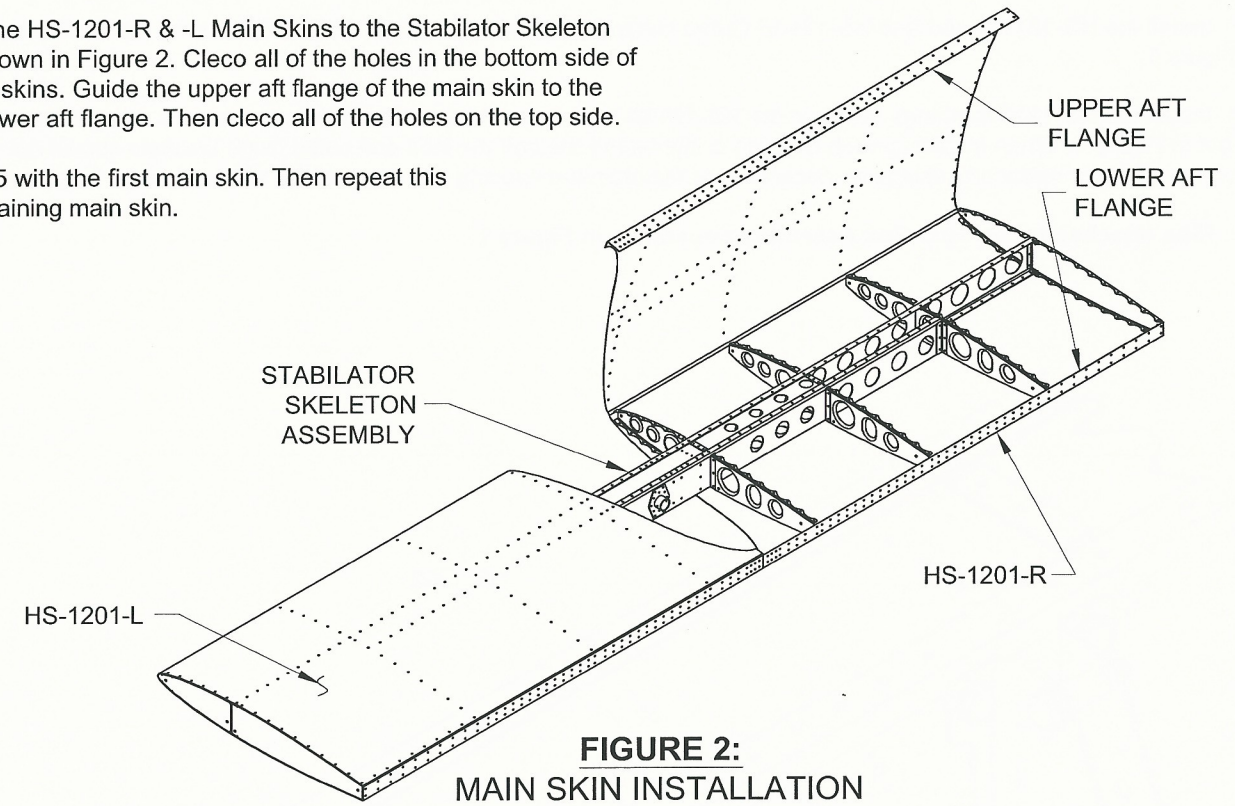

FIGURE 2:
MAIN SKIN INSTALLATION

NOTE: Figure 3 calls out the rivets and locations for the HS-1201-R Main Skin. Rivets and locations for the left side main skin are a mirror of the right. The entire bottom side of the main skin is a mirror of the top side.

Step 5: Rivet only the top and bottom surface of the HS-1201-R & -L Main Skins to the Stabilator Skeleton Assembly per call-outs in Figure 3. Leave open the aft flanges of the main skins. Begin at the leading edge of the main skin and finish at the trailing edge. Leave open the aft outboard row of holes on the top and bottom, called out in Figure 3.

Step 6: Rivet the remaining open holes in the top and bottom of the Stabilator Skeleton Assembly between the HS-1201-R & -L Main Skins per call-out in Figure 3. Refer to the Stabilator Skeleton Assembly with the main skins attached as the Stabilator Assembly.

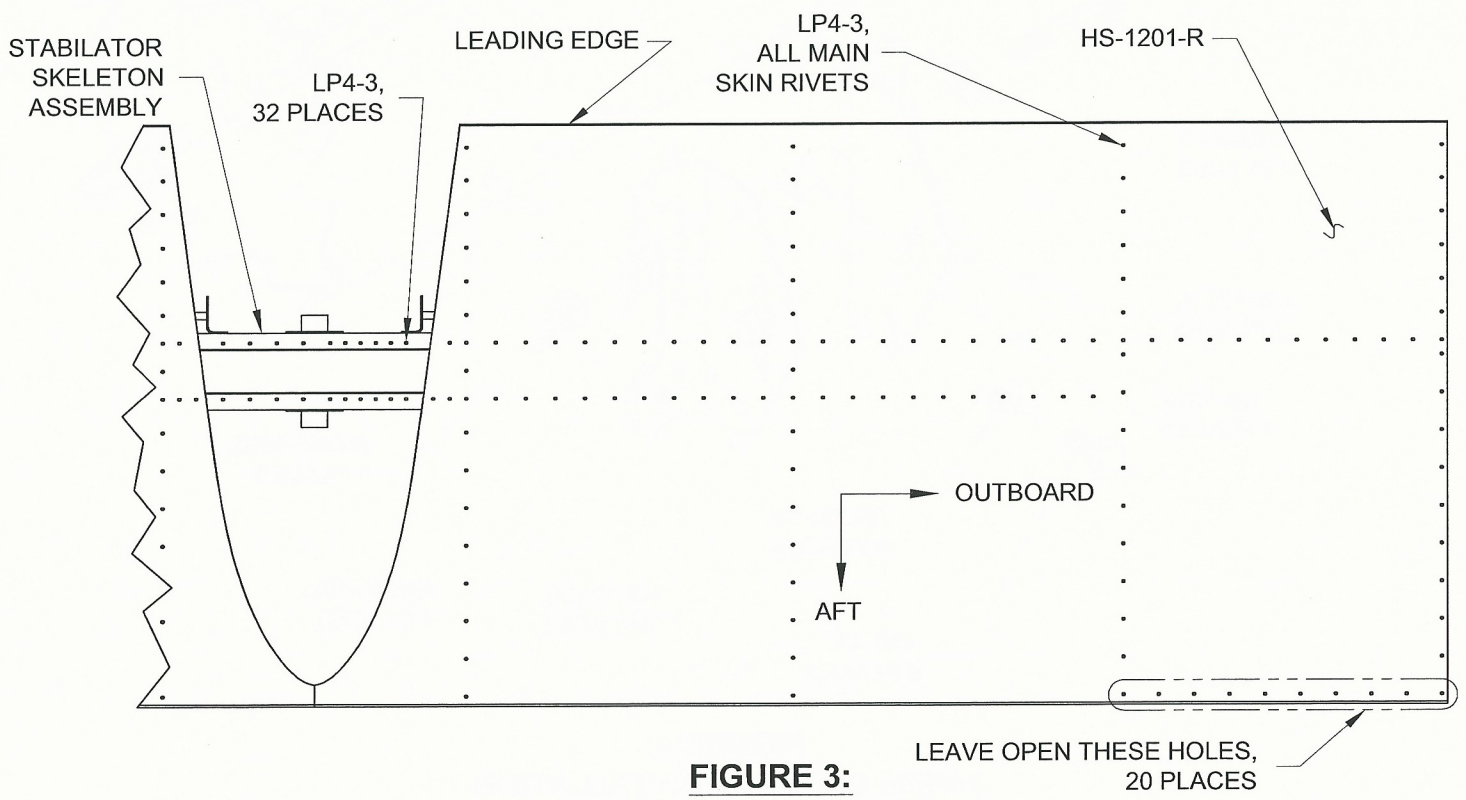

FIGURE 3:
MAIN SKIN RIVETS