



Step 1: Cleco the HS-1215 Skin Splice Plate to the aft flanges where the HS-1201-R & -L Main Skins meet as shown in Figure 1.

Step 2: Match-Drill #52 the 1/16 holes in the HS-1215 Skin Splice Plate into the aft flanges of the HS-1201-R & -L Main Skins called out in Figure 1.

Remove the skin splice plate, deburr holes and clear away any chips.

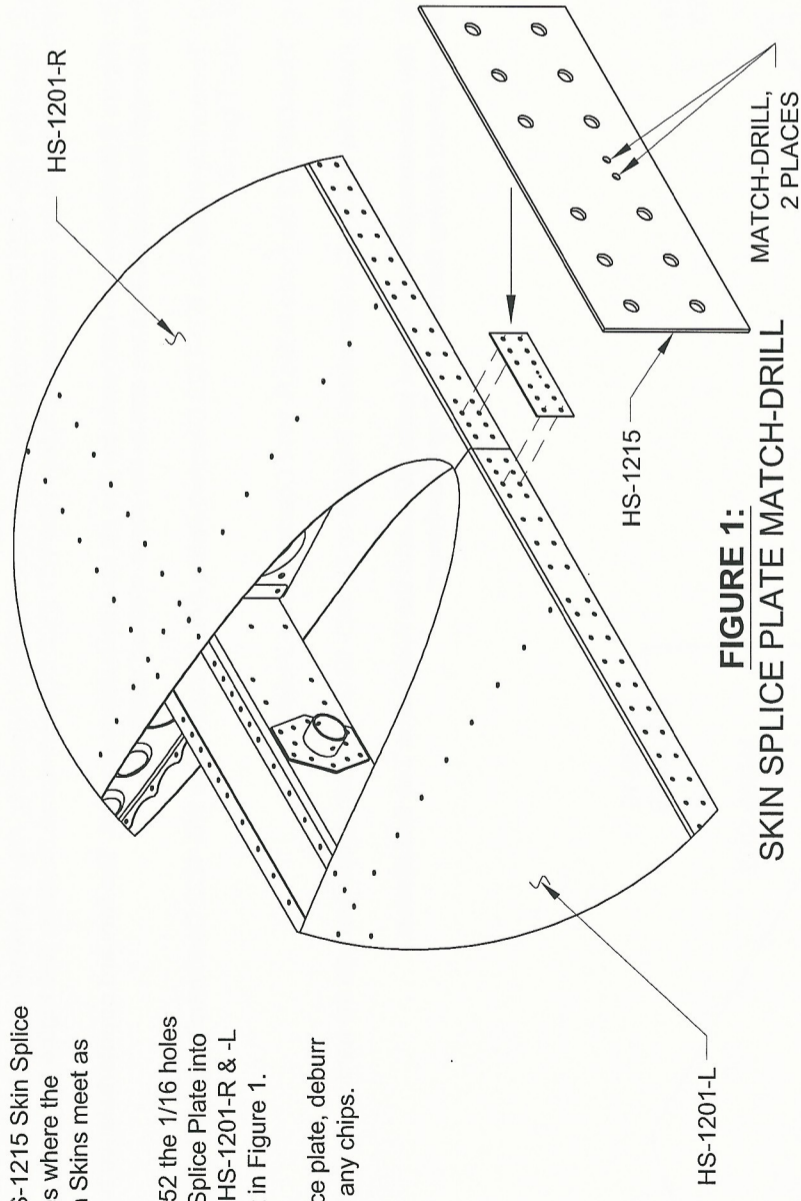


FIGURE 1:
SKIN SPLICE PLATE MATCH-DRILL

NOTE: Step 3 through Step 5 describe installation for parts on the right side of the Stabilator Assembly, installation for parts on the left side is a mirror of the right.

Step 3: Rivet the HS-1218A-R Aft Hinge to the HS-1201-R Main Skin. Include the HS-1216 Aft Main Ribs when riveting the holes common to the aft hinge, main skin and aft main ribs. Include the HS-1215 Skin Splice Plate, on the inside surface of the aft flange, when riveting the holes common to the aft hinge, main skin and skin splice plate. See Figure 2.

Step 4: Rivet one of the HS-1208 Aft Ribs through the HS-1201-R Main Skin to the HS-1207 Outbd Main Rib. Rivet one of the HS-1208 Aft Ribs through the HS-1201 Main Skin to the HS-1206 Inbd Main Rib. Orient the rib flanges as shown in Figure 2.

Step 5: Rivet all of the remaining holes in the aft flanges of the HS-1201-R Main Skin. See Figure 2.

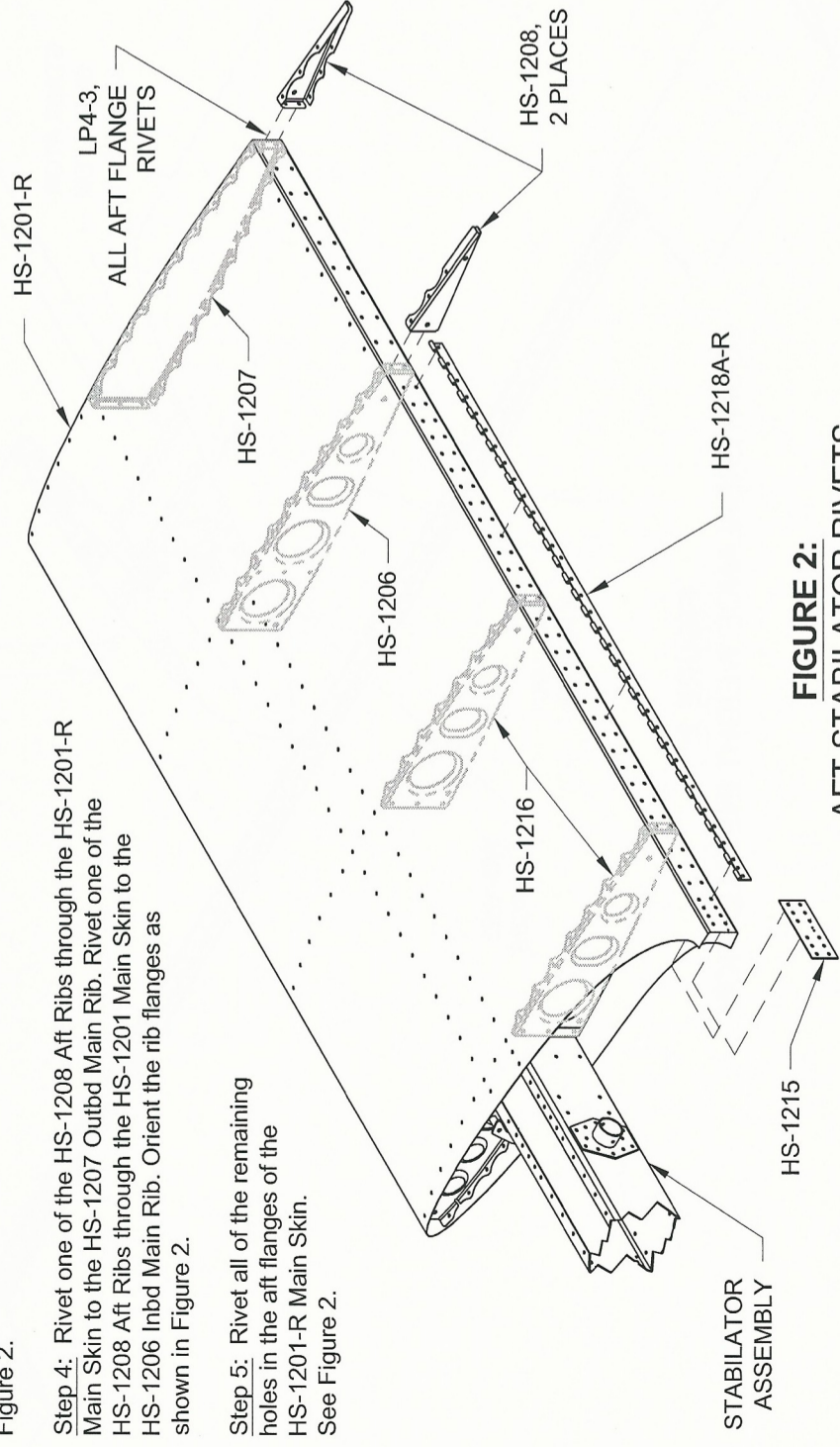


FIGURE 2:
AFT STABILATOR RIVETS

Step 6: Separate the HS-1217 Aft Skins by removing the material called out in Figure 3.

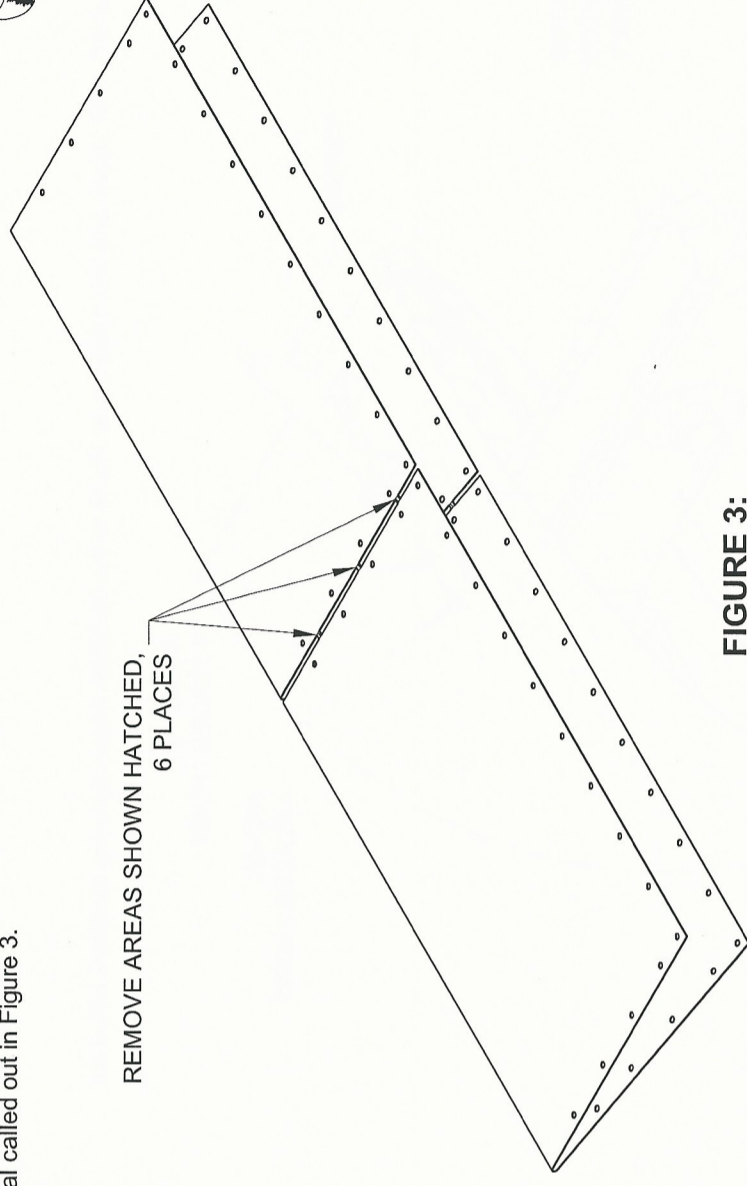


FIGURE 3:
HS-1217 AFT SKIN SEPARATION

NOTE: Figure 2 illustrates the installation of the HS-1217 Aft Skin for the right side of the Stabilator Assembly. Installation for the aft skin on the left side is a mirror of the right.

Step 7: Pinch the aft edge of the HS-1217 Aft Skin until the open end lays flat on the aft edge of the main skin. Cleco the aft skin to the HS-1201-R Main Skin and the HS-1208 Aft Ribs.

Step 8: Match-Drill #30 the holes from the HS-1217 Aft Skin into the HS-1208 Aft Ribs called out in Figure 4.

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

Step 9: Rivet the HS-1217 Aft Skin to the HS-1208 Aft Ribs and the HS-1201-R Main Skin using rivets called out in Figure 4.

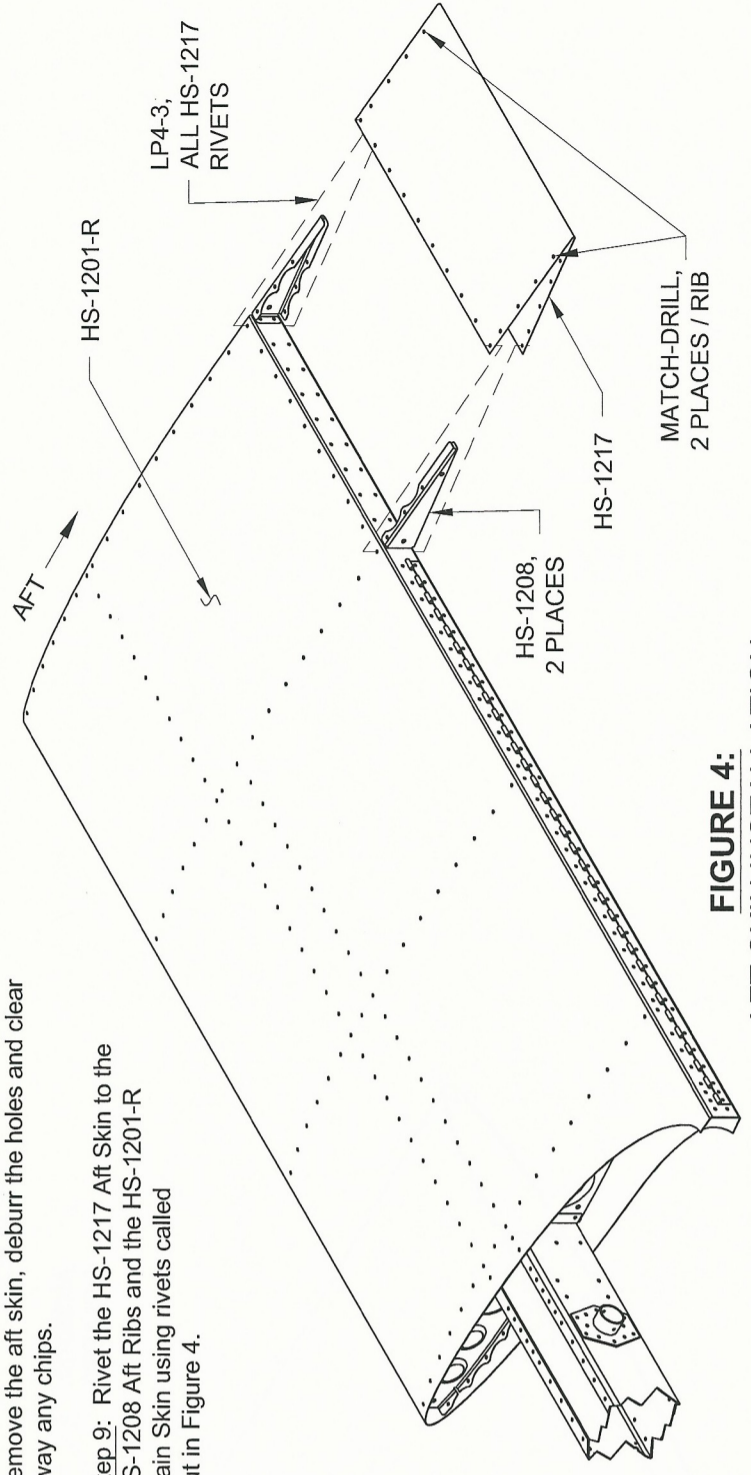


FIGURE 4:
AFT SKIN INSTALLATION