

Procedure 3.030A

INSTALL RIB R AND J FLANGE.

In this procedure...

You will fabricate main gear rib caps (Rib R and J) prior to full laminates and gear clamp installation.

Step 1. Fit skin to wing. Trim ribs for fit as if for final close

Step 2. Locate and mark BL 23.50 and BL 36.00 aft rib locations onto lower skin (upper in jig). Remove wing panel. Apply 3 layers duct tape 2 strips wide over centerline of rib locations from spar cap E.O.P. to forward side of aft shear web (Fig. 30.1)

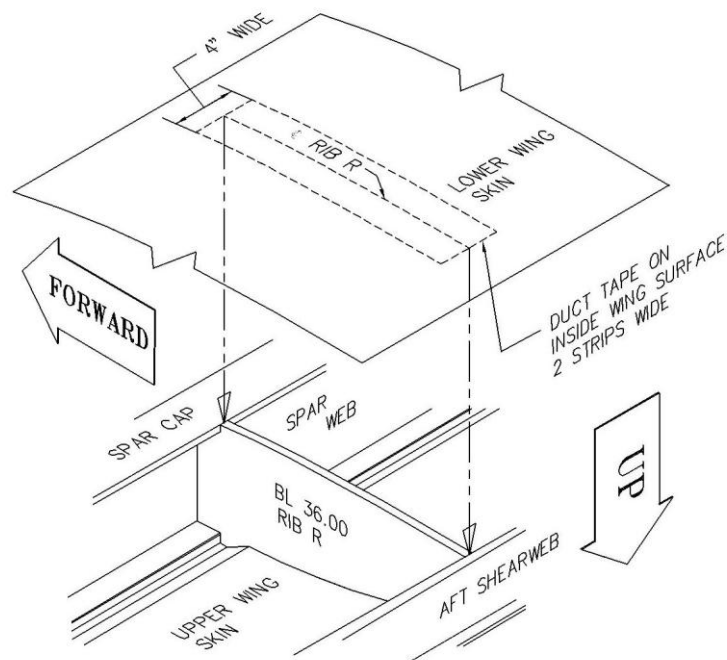


Fig. 30.1

Step 3. Apply (1) layer aluminum tape or create tape over duct tape, then wax this surface. Mask tape around edges.

Step 4. Apply (2) 4” wide plies of uni-directional to tape and (1) 7781 BID over uni-directional. Let cure.

Step 5. When set up, re-position wing skin to wing assembly and remove material from ribs R and J to accept build-ups just applied. When wing is refitted, continue.
Note: Make sure wing skin can be secured in position quickly.

Step 6. Sand prep ribs and caps on wing skin to ensure proper bond of rib cap laminates.

Step 7. Apply resin, Mill-Fiber, Cabosil to top of rib R and J (as it sits in jig) and position wing skin in place. Secure so as not to move or “slide”.

Step 8. When cured, remove wing skin, leaving caps bonded to rib. Trim edges smooth. (Fig. 30.2)



Fig. 30.2

Now you are ready for BL 36.00 (rib R) and BL 23.50 (rib J) full tie-in laminates.

Refer to *Express* wing assembly manual Section 3, Procedure 3.040 for main landing gear bracket installation.