

Procedure 3.140A

INSTALLATION OF TIE DOWN RIBS

In this procedure...
The wing tie down ribs will be assembled and installed.

<u>Part Numbers</u>	<u>Description</u>	<u>Qty</u>
111-12-001	Tie Down Rib	2 Per Wing

Step 1. ASSEMBLE TIE DOWN.

Assemble tie-down per Fig. 140.1.

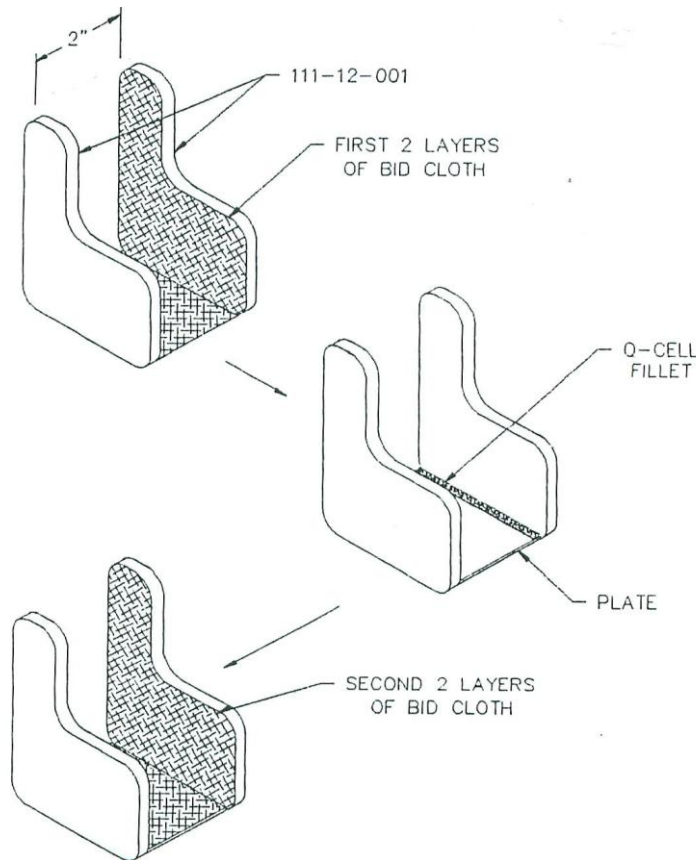


Fig. 140.1

Step 2. LAMINATE TIE DOWN TO WING.

Locate the tie down on the aft side of the main spar, so the center is at BL 123.50 (Fig. 140.2). Remember the wing is inverted so the tie down will be placed at the top of the spar as it sits in the jig. Place the tie down with the plate facing up, and tuck it under the spar cap so the long edges of the ribs meet the main spar shear web. Sand it if necessary to get a good fit, and then clamp the plate to the spar cap.

**Fig. 140.2**

Wet out the area under the spar cap, clamp in place, then laminate the tie down to the main spar using 2 layers of bid on each side. Lap a minimum of 1" onto the ribs, spar cap and shear web. Lay-up 2 layers inside the tie down, lapping onto both ribs and the shear web (Fig. 140.3).

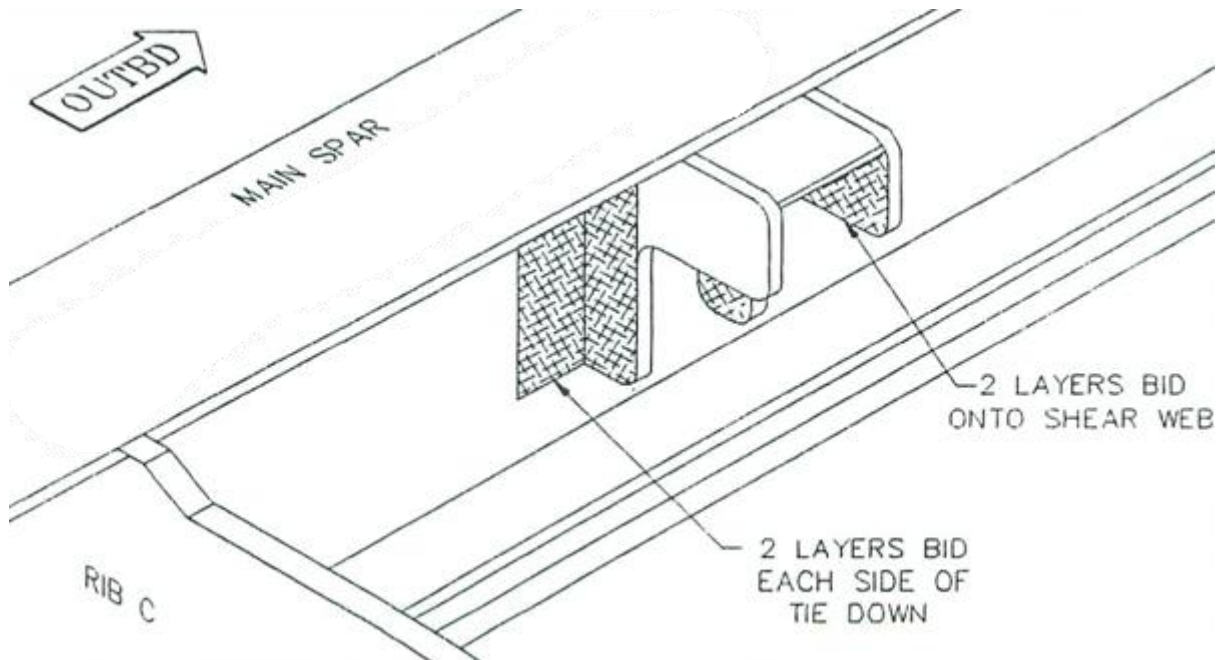


Fig. 140.3

Step 3. BOND ANCHOR NUT TO TIE-DOWN RIB

Drill 3/8" hole through center of tie-down rib and approx. 1/2" from spar cap. Coat threads of 5/16" NC nut with heavy grease. Center 5/16" nut on 3/8" hole and attach to underside of tie-down rib with Cabosil. Reinforce with 7781 cloth.