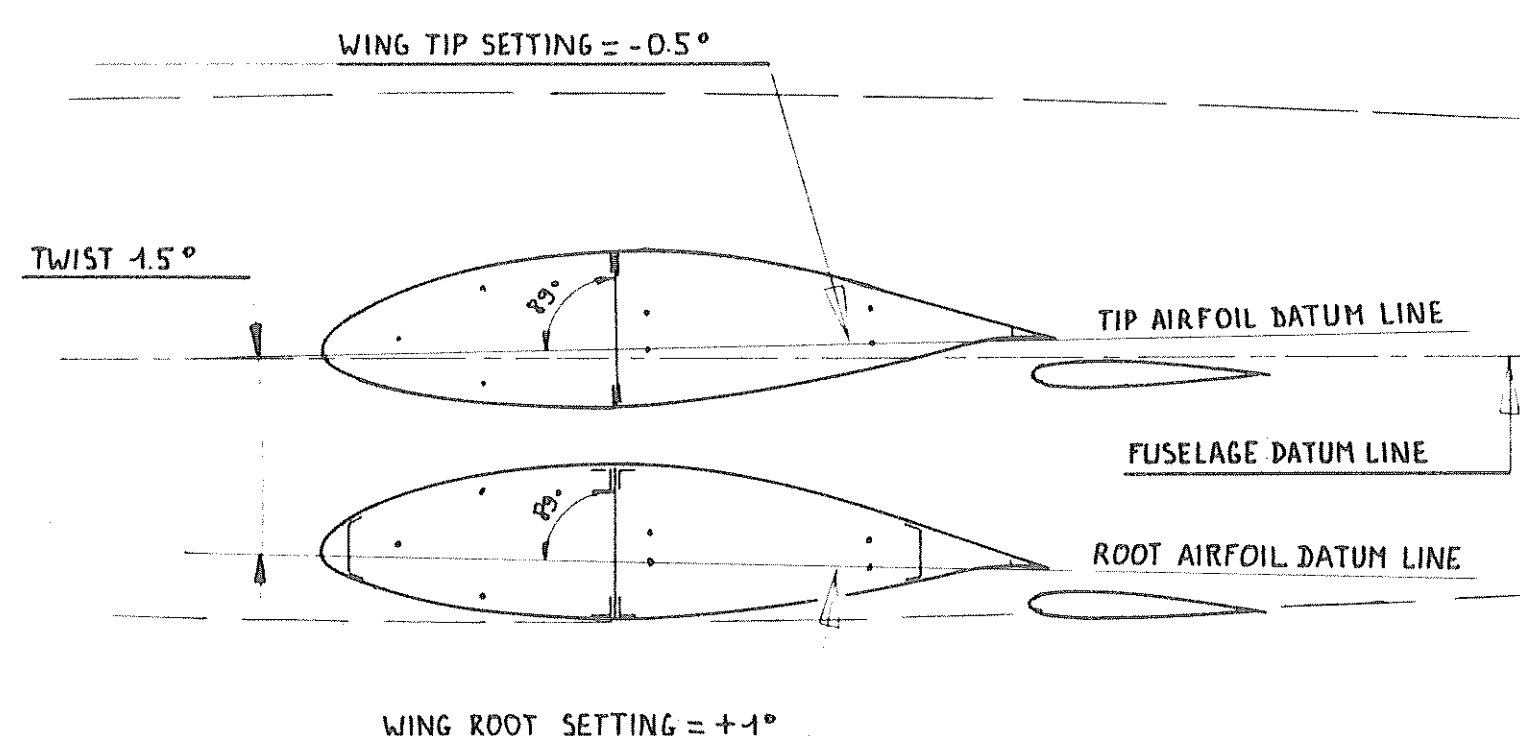


AIRFOIL CO-ORDINATES			
Xu	Yu	Xl	Yl
1.00	6.74	3.80	-6.09
2.04	8.47	5.49	-7.38
4.15	11.52	7.85	-9.38
9.80	17.09	14.20	-12.92
21.49	25.20	26.51	-17.75
33.36	31.56	38.64	-24.39
45.33	36.85	50.67	-24.44
69.42	45.58	74.58	-29.43
93.65	52.42	98.35	-33.34
117.96	57.68	122.04	-36.20
142.33	61.84	145.67	-38.24
166.73	64.04	169.27	-39.34
191.16	65.12	192.84	-39.44
215.59	64.88	216.44	-38.60
240.00	63.37	240.00	-36.89
264.38	60.76	263.62	-34.48
288.74	57.14	287.29	-31.43
312.98	52.51	311.02	-27.78
337.17	46.63	334.83	-23.30
361.24	39.24	358.76	-17.76
		382.84	-11.49
		407.03	-6.04
		431.34	-1.66
		455.66	2.73
480.00	0.50	480.00	0.50

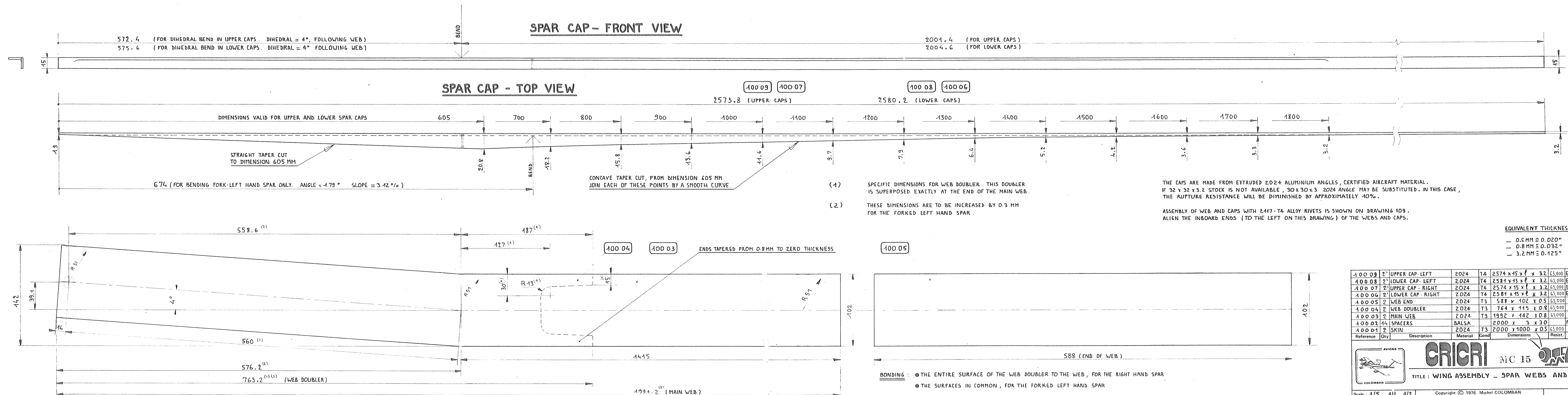


THE RIBS, ALL IDENTICAL, ARE BONDED TO THE UNTWISTED SPAR. THE -15° NEGATIVE TWIST IS PRODUCED WHEN THE SKIN IS BONDED ON, BY THE BONDING FIXTURE, ITSELF TWISTED -15°.

THE ANGLE OF -15° CORRESPONDS TO A SLOPE OF 2.6/1000

RIB TEMPLATES : BUTT-JOIN TWO SHEETS OF ALUMINIUM AT THE SPAR WEB DATUM LINE. LAY OUT THE PROFILE, CUT OUT AND FINISH AS TOUGH MAKING A SINGLE TEMPLATE. SEPARATE THE FRONT AND REAR SECTIONS AFTERWARD.

WING SETTING IS THE ANGLE FORMED BY THE AIRFOIL AND FUSELAGE DATUM LINES. IT IS POSITIVE WHEN THE LEADING EDGE IS ABOVE THE FUSELAGE REFERENCE.



- (1) SPECIFIC DIMENSIONS FOR WEB DOUBLER. THIS DOUBLER IS SUPERPOSED EXACTLY AT THE END OF THE MAIN WEB.
- (2) THESE DIMENSIONS ARE TO BE INCREASED BY 0.3 MM FOR THE FORKED LEFT HAND SPAR.

THE CAPS ARE MADE FROM EXTRUDED 2024 ALUMINIUM ANGLES, CERTIFIED AIRCRAFT MATERIAL. IF 32 x 32 x 3.2 STOCK IS NOT AVAILABLE, 30 x 30 x 3 2024 ANGLE MAY BE SUBSTITUTED. IN THIS CASE, THE RUPTURE RESISTANCE WILL BE DIMINISHED BY APPROXIMATELY 10%.

ASSEMBLY OF WEB AND CAPS WITH 2417-T4 ALLOY RIVETS IS SHOWN ON DRAWING 109. ALIGN THE INBOARD ENDS (TO THE LEFT ON THIS DRAWING) OF THE WEBS AND CAPS.

EQUIVALENT THICKNESS:

- 0.5 MM ± 0.020"
- 0.8 MM ± 0.032"
- 3.2 MM ± 0.125"

Reference	Qty	Description	Material	Cond	Dimensions	Resist	Comments
100 09	2	UPPER CAP- LEFT	2024	T4	2574 x 45 x 6 x 3.2	63,000	EXTRUSION
100 08	2	LOWER CAP- LEFT	2024	T4	2574 x 45 x 6 x 3.2	63,000	EXTRUSION
100 07	2	UPPER CAP- RIGHT	2024	T4	2574 x 45 x 6 x 3.2	63,000	EXTRUSION
100 06	2	LOWER CAP- RIGHT	2024	T4	2574 x 45 x 6 x 3.2	63,000	EXTRUSION
100 05	2	WEB END	2024	T3	588 x 102 x 0.5	63,000	E = 0.5 MM
100 04	2	WEB DOUBLER	2024	T3	764 x 115 x 0.8	63,000	E = 0.8 MM
100 03	2	MAIN WEB	2024	T3	1992 x 142 x 0.8	63,000	E = 0.8 MM
100 02	14	SPACERS	BALSA		2000 x 3 x 3.0		FOR ASSEMBLY
100 01	2	SKIN	2024	T3	2000 x 1000 x 0.5	63,000	E = 0.5 MM