



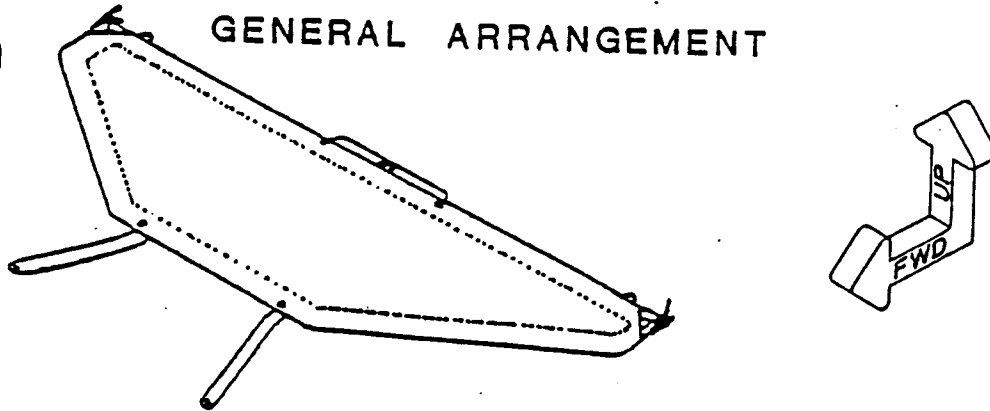
STABILIZER LEADING EDGE ASSEMBLY

1. Refer to Figure 2. Slightly bend each Stabilizer Frame half (1) as illustrated a 1/2" (12.7 mm) (around a car tire) to help tension the Stabilizer Cover (4) to be installed later.
2. Mark, center-punch, drill and deburr FOUR 3/16" (4.7 mm) diameter holes through ONE side ONLY located at 1" (25.4 mm) and 4" (101.6 mm) INBOARD from each END of the Sleeve (2).
3. Place the Stabilizer Frame halves (1) on a flat surface and insert each one EXACTLY HALFWAY into the Sleeve (2).
4. Rotate the Sleeve (2) until ALL FOUR holes are 45 degrees AFT from the TOP CENTERLINE of the Stabilizer Frame.
5. Mark the Frame through the holes or back-drill FOUR 3/16" (4.7 mm) holes through the Sleeve into ONE side of the Stabilizer Frame (1) ONLY. Deburr and secure with FOUR Rivets (3).

Item	P/N	Qty	Description
1...	40265...	1...	Stabilizer Frame
2...	40266...	1...	Stabilizer Sleeve
3...	20210...	4...	3/16" x 3/8" Grip Aluminum Rivet (AAP-66)
4...	50047...	1...	Stabilizer Cover
5.....			Center-Punch

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FIG. 1 GENERAL ARRANGEMENT



1/2"
(12.7 MM)

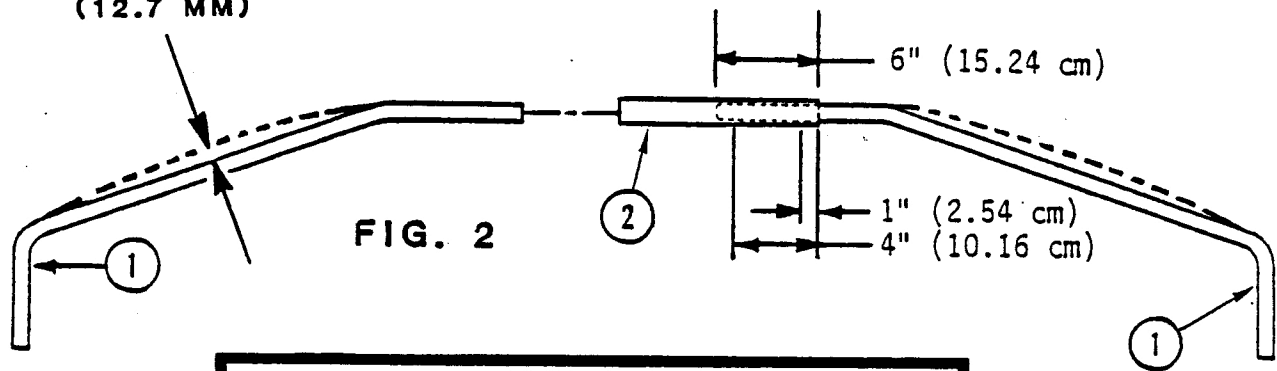


FIG. 2

FIG. 3

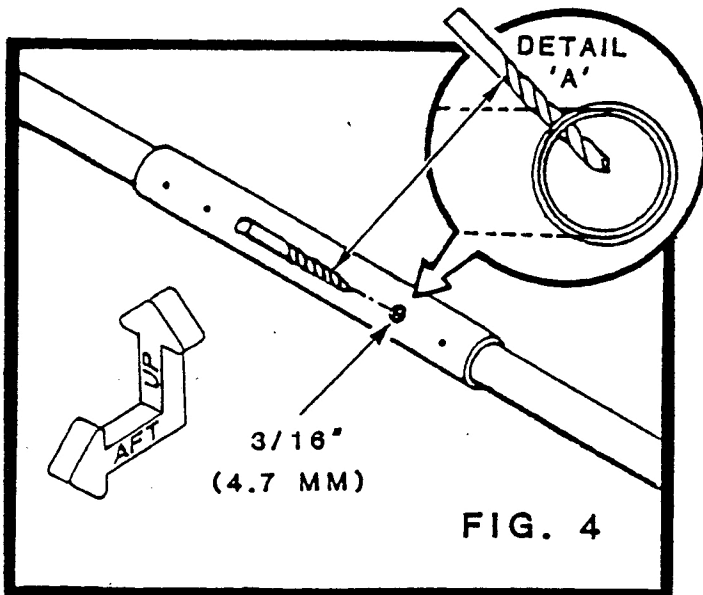
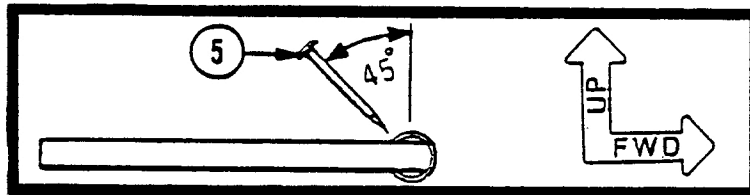


FIG. 4

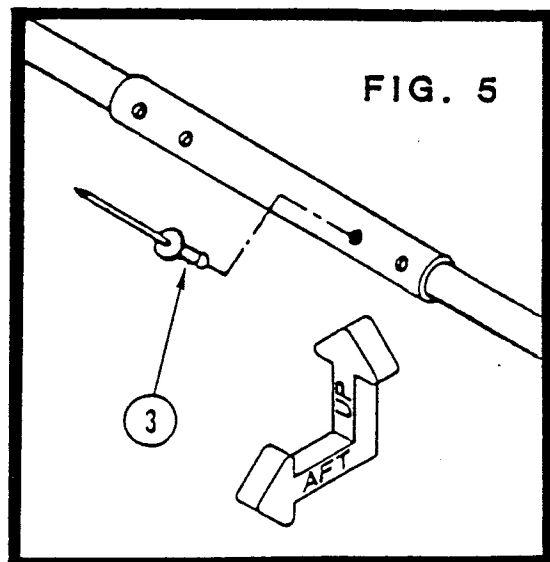


FIG. 5

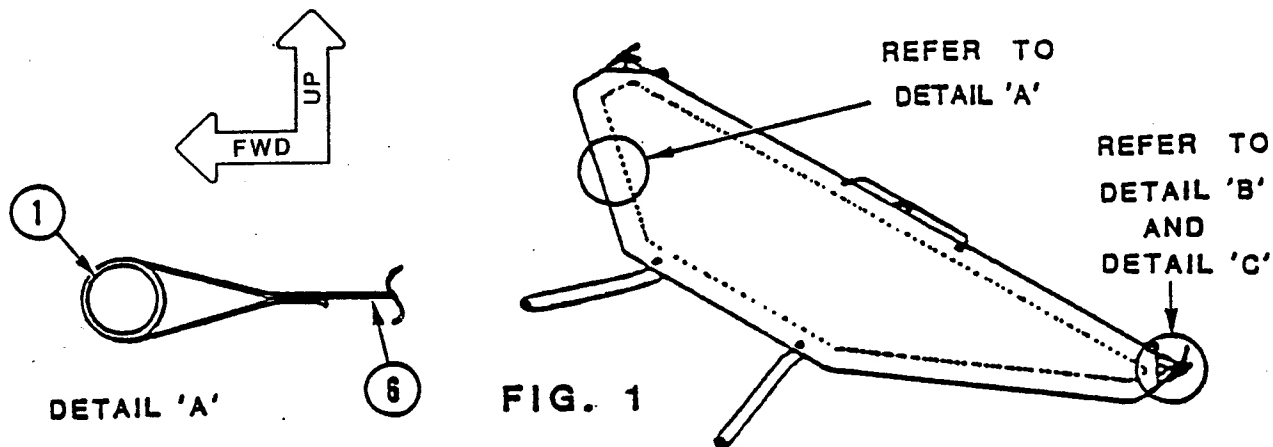


STABILIZER ASSEMBLY

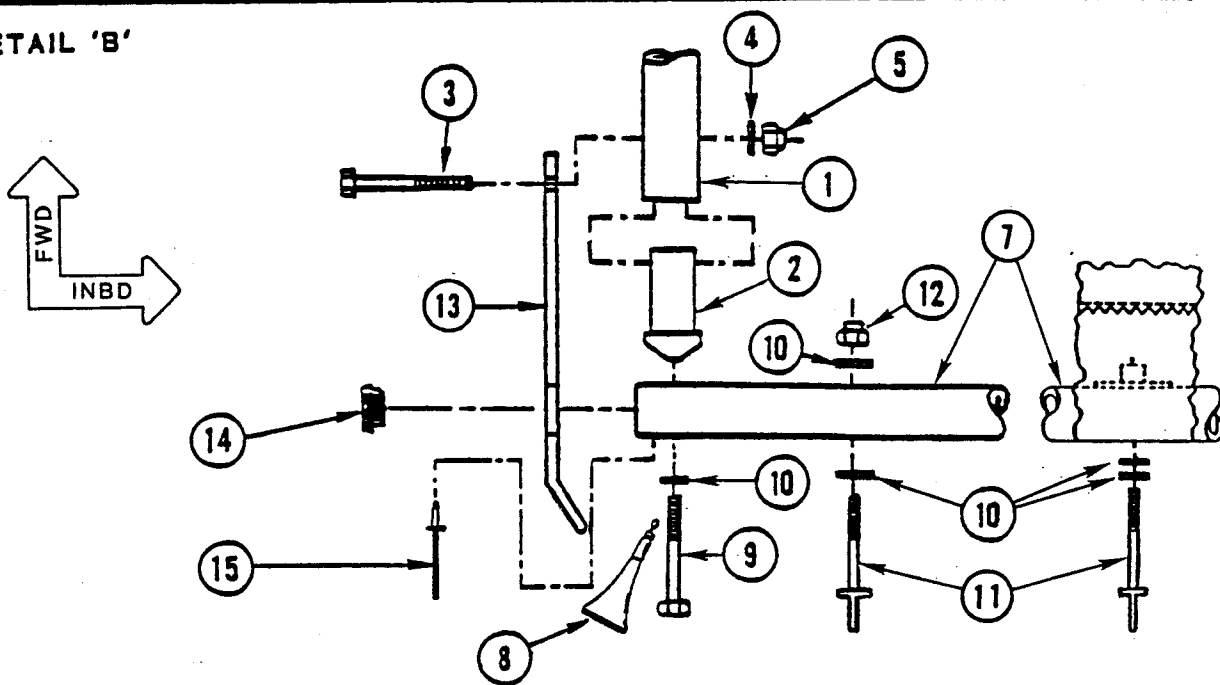
1. Refer to Figure 1 and Detail 'A'. Slide the Stabilizer Frame into the FORWARD Leading Edge Pocket of the Stabilizer Cover (6). The edge of the fold is on the BOTTOM surface.
2. Refer to Detail 'B'. Attach a Tube Connector (2) TEMPORARILY with a Bolt (3). Repeat on the opposite side.
3. Refer to Detail 'C'. Slide the Stabilizer Trailing Edge (7) into the AFT Pocket of the Stabilizer Cover (6) (Nutplate in CENTER and Rivets face INBOARD or FORWARD). Use a large screwdriver to CAREFULLY lever the Stabilizer Trailing Edge onto the Tube Connector (2) as illustrated or refer to Step 4 for another method.
4. Detail 'D' illustrates another method of levering the Stabilizer Trailing Edge (7) into place. Rest the Tube Connector (2) on a block of wood. Support the opposite end of the Stabilizer Trailing Edge on another block of wood. Insert a smaller block of wood over the Stabilizer Trailing Edge, as illustrated. Use your foot and/or body weight to push the Stabilizer Trailing Edge into alignment with the Tube Connector. At the SAME time push or pull the Stabilizer Trailing Edge into the Tube Connector.
5. Refer to Detail 'B'. Attach with hardware (9) and (10) using Thread Adhesive (8). Tighten to correct torque. DO NOT distort the tube. TEMPORARILY remove the Bolt (3) and attach an Elevator Stop Bracket (13) as illustrated. Assemble as illustrated. Secure all hardware to correct or proper torque as required. Attach opposite side in mirror image. Locate the CENTER hole thru the cover then reveal and heat seal. Attach the CENTER Eyebolt with TWO washers UNDER the head.

Item	P/N	Qty	Description
1...	40265	Stabilizer Frame
2...	20446	...2....	1" Aluminum Tube Connector
3...	10035	...2....	AN3-13A Bolt
4...	10550	...2....	3/16" Washer
5...	10500	...2....	3/16" Locknut
6...	50047	...1....	Stabilizer Cover
7...	40275	...1....	Stabilizer Trailing Edge Spar Assembly
8...	60591	..A/R...	Thread Adhesive (Loctite 290)
9...	10400	...2....	1/4" x 1 3/4" Grade 5 Bolt
10...	10560	...8....	1/4" Washer
11...	10350	...3....	AN43B-14A Eyebolt
12...	10510	...3....	1/4" Locknut
13...	42000	...2....	Elevator Stop Bracket
14...	20400	...2....	7/8" Tube Cap
15...	20200	...2....	1/8" x 1/4" Grip Aluminum Rivet (AAP-44)
16...	60592	..A/R...	Contact Cement

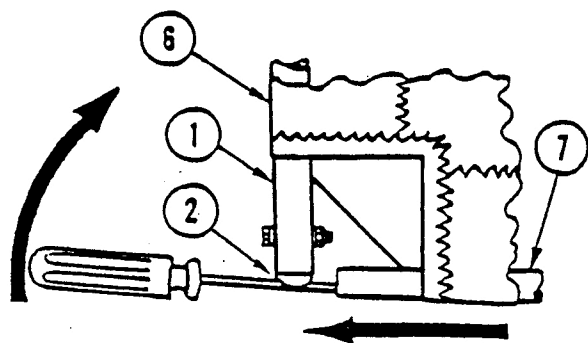
STABILIZER ASSEMBLY



DETAIL 'B'



DETAIL 'C'



DETAIL 'D'

