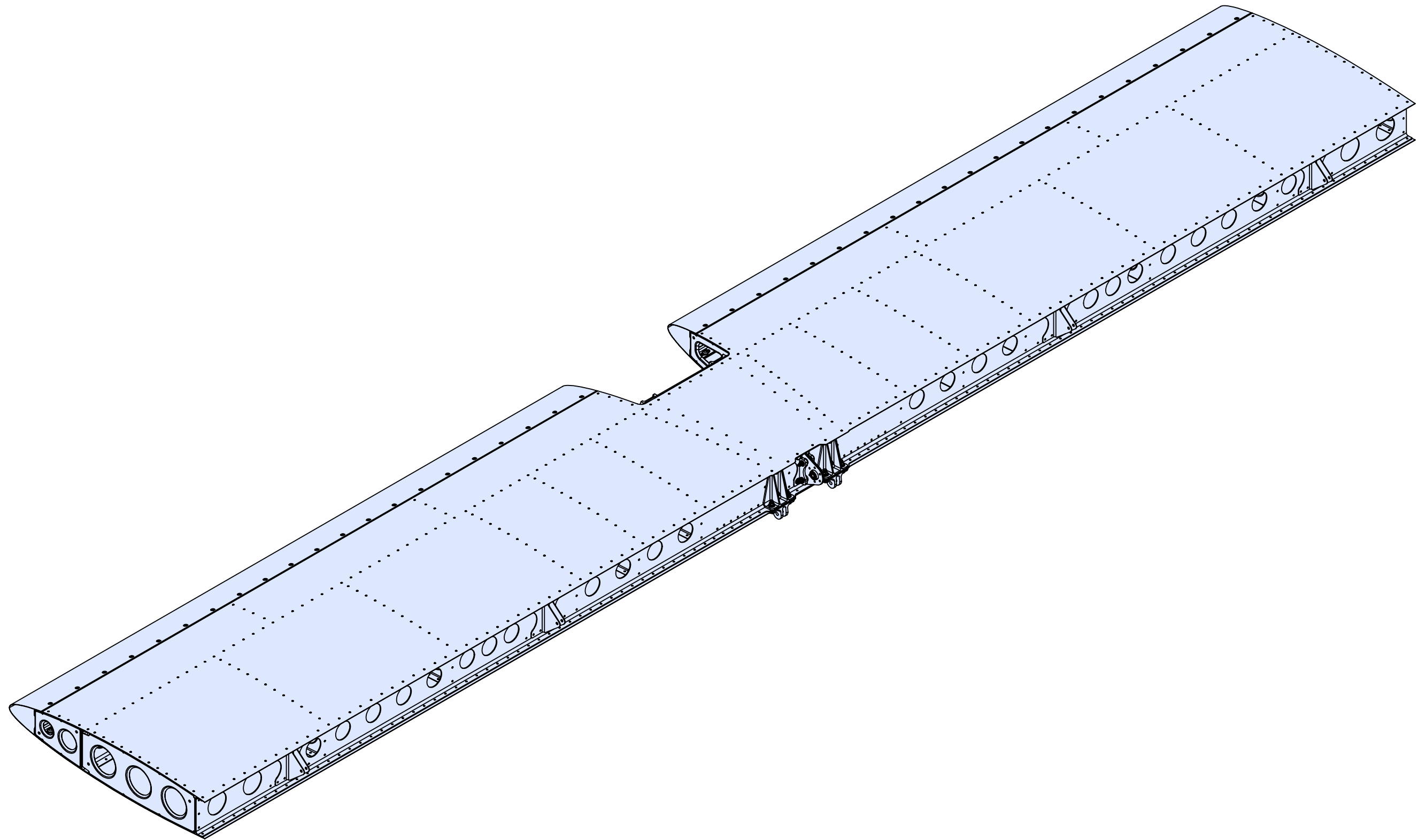


SECTION 08



HS-15505

HORIZONTAL STABILIZER

ASSM PARTS LIST

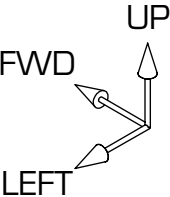
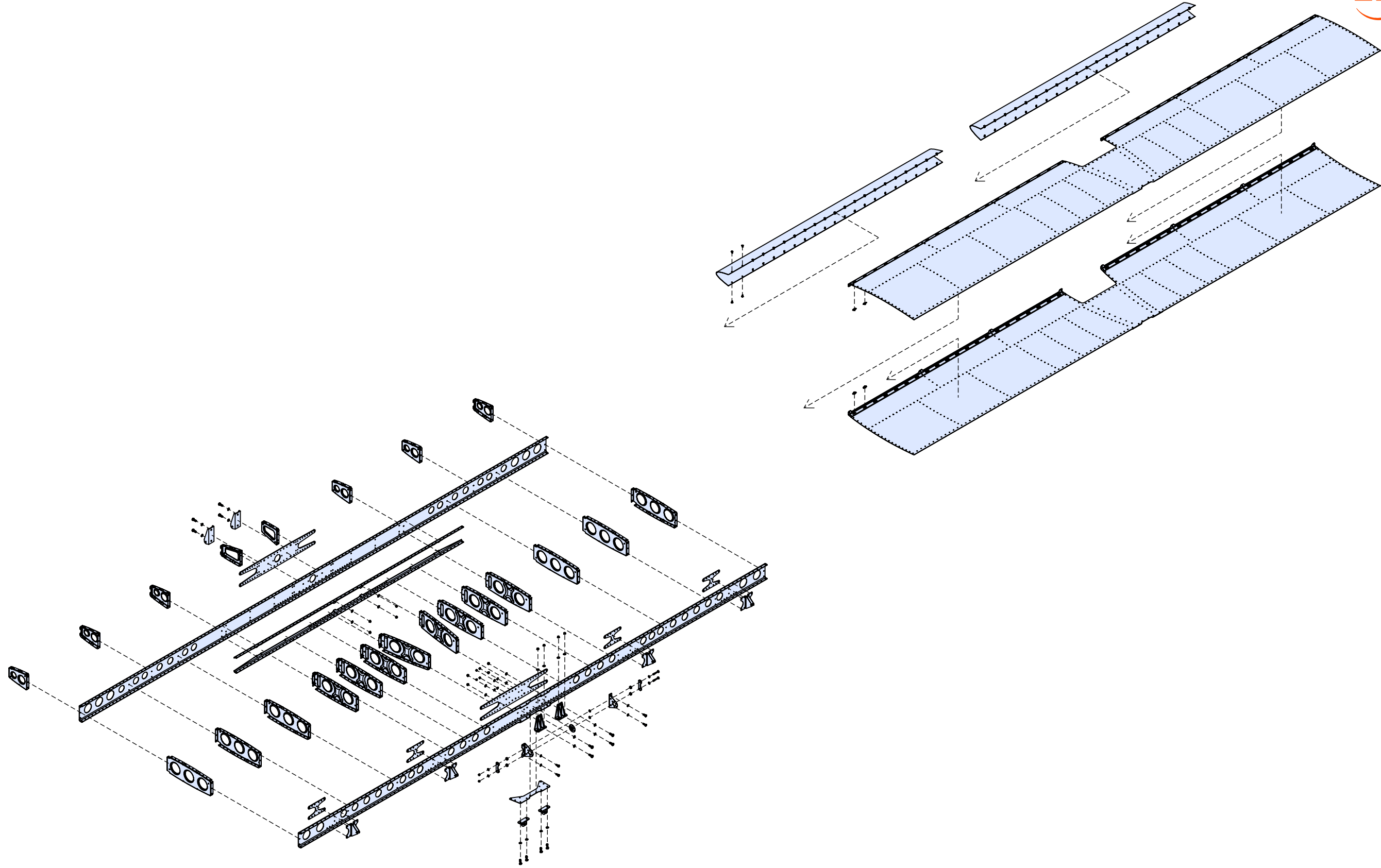


ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	ASSM QTY.
1	HS-15001-001	SKIN, MAIN	.025 2024-T3 ALCLAD SHEET	2
2	HS-15002-001	SPAR, FRONT	.063 2024-T3 ALCLAD SHEET	1
3	HS-15003-001	SPAR, REAR	.063 2024-T3 ALCLAD SHEET	1
4	HS-15004-001	RIB, OTBD	.025 2024-T3 ALCLAD SHEET	6
5	HS-15005-001	RIB, OTBD NOSE	.025 2024-T3 ALCLAD SHEET	6
6	HS-15006-001	RIB, INBD	.025 2024-T3 ALCLAD SHEET	8
7	HS-15007-001	RIB, INBD NOSE	.025 2024-T3 ALCLAD SHEET	2
8	HS-15008-001	DOUBLER, INBD REAR SPAR	.125 2024-T3 ALCLAD SHEET	1
9	HS-15009-001	DOUBLER, FRONT SPAR	.125 2024-T3 ALCLAD SHEET	1
10	HS-15010-001	DOUBLER, HINGE	.063 2024-T3 ALCLAD SHEET	4
11	HS-15011-001	HINGE BRKT, INBD	.050 4130 COND N SHEET	2
12	HS-15012-001	HINGE BRKT, OTBD	.050 4130 COND N SHEET	8
13	HS-15013-001	CAP, FRONT SPAR	.063 2024-T3 ALCLAD SHEET	2
14	HS-15014-001	DOUBLER, AFT SKIN	.032 2024-T3 ALCLAD SHEET	1
15	HS-15015-001	SKIN, L.E.	.025 2024-T3 ALCLAD SHEET	2
16	HS-15016A-001	HINGE BRKT, LOWER AFT SPAR	2024-T351	2
17	HS-15016B-001	HINGE BRKT, UPPER AFT SPAR	2024-T351	2
18	HS-15017-001	ATTACH BRKT, FRONT SPAR	2024-T351	2
19	HS-15018-001	STOP, ELEVATOR	2024-T351	2
20	VA-146	FLANGE BEARNG	2011-T3	1
21	AN3-5A	BOLT	CADMIUM PLATED STEEL	4
22	AN3-13A	BOLT	CADMIUM PLATED STEEL	2
23	AN4-6A	BOLT	CADMIUM PLATED STEEL	8
24	AN4-7A	BOLT	CADMIUM PLATED STEEL	4
25	AN426AD3-3	RIVET, SOLID COUNTERSUNK	ALUMINUM	168
26	AN426AD4-6	RIVET, SOLID COUNTERSUNK	ALUMINUM	12
27	AN470AD4-5	RIVET, SOLID UNIVERSAL	ALUMINUM	24
28	AN470AD4-5.5	RIVET, SOLID UNIVERSAL	ALUMINUM	6
29	AN470AD4-6	RIVET, SOLID UNIVERSAL	ALUMINUM	70
30	AN470AD4-6.5	RIVET, SOLID UNIVERSAL	ALUMINUM	8
31	AN470AD4-7	RIVET, SOLID UNIVERSAL	ALUMINUM	46
32	AN470AD4-8	RIVET, SOLID UNIVERSAL	ALUMINUM	8
33	AN507C832R6	SCREW, FLAT COUNTERSUNK HEAD	STAINLESS STEEL	84
34	BUSH-AL. 189X.500X.190	ALUMINUM BUSHING	2024-T351	4
35	K-1100-08D	NUTPLATE, 8-32 DIMPLED	STEEL	84
36	MS21042-3	METAL LOCK NUT, 10-32	CADMIUM PLATED STEEL	6
37	MS21042-4	METAL LOCK NUT, 1/4-28	CADMIUM PLATED STEEL	12
38	NAS1149F0332P	WASHER, 3/16" THIN FLAT	CADMIUM PLATED STEEL	8
39	NAS1149F0363P	WASHER, 3/16" FLAT	CADMIUM PLATED STEEL	6
40	NAS1149F0432P	WASHER, 1/4" THIN FLAT	CADMIUM PLATED STEEL	16
41	NAS1149F0463P	WASHER, 1/4" FLAT	CADMIUM PLATED STEEL	8
42	RIVET CS4-4	RIVET, BLIND COUNTERSUNK	ALUMINUM	16
43	RIVET-LP4-3	RIVET, BLIND	ALUMINUM	1000

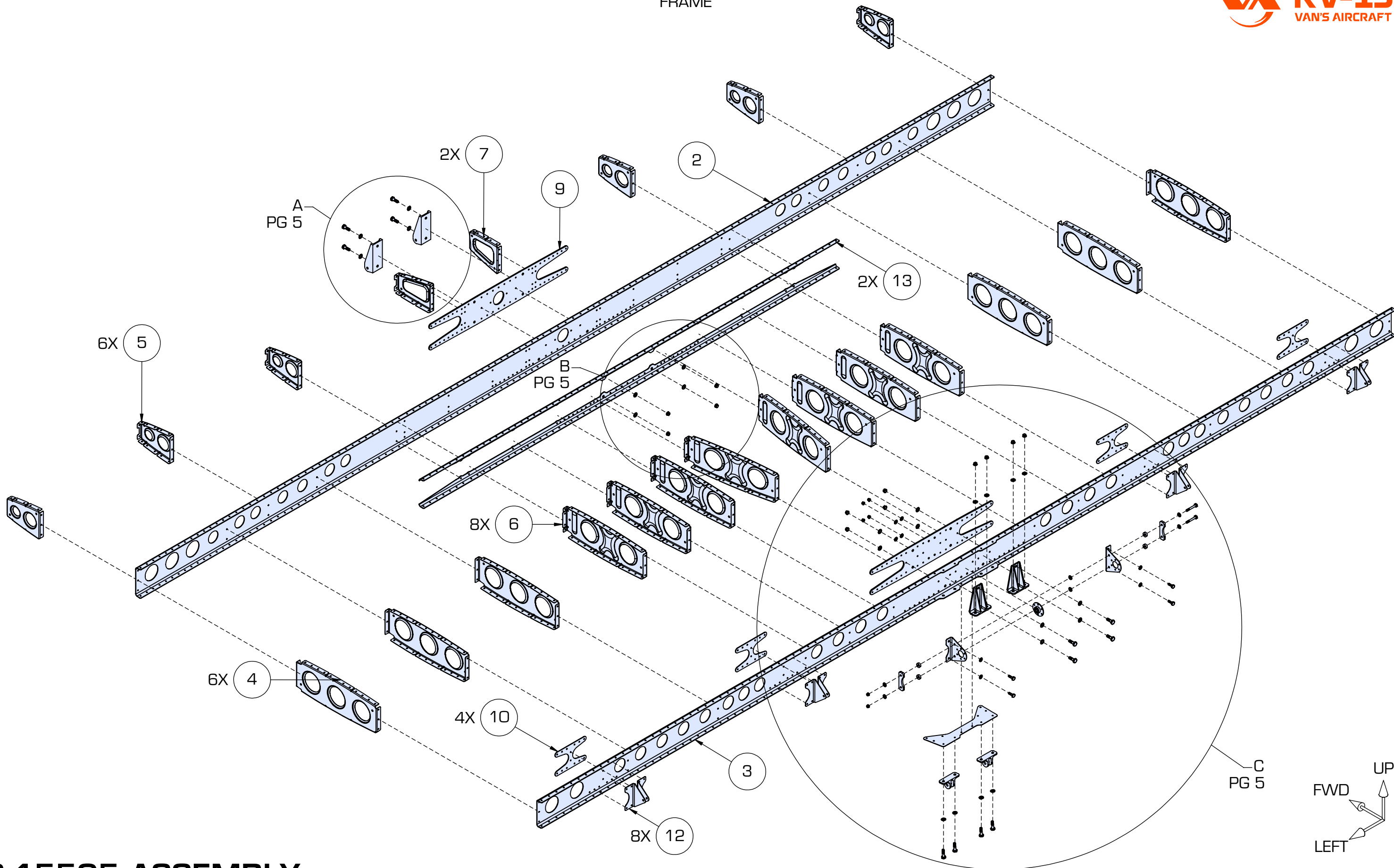
SUBASSEMBLIES BUILT IN THIS SECTION

ITEM NO.	ASSM. NUMBER	DESCRIPTION	QTY.
A1	HS-15500-001	HINGE ASSM	1
A2	HS-15501-001	REAR SPAR ASSM	1
A3	HS-15502-001	FRONT SPAR ASSM	1
A4	HS-15503-001	H-STAB FRAME ASSM	1
A5	HS-15504-001	H-STAB SPAR ATTACH ASSM	1

HS-15505 ASSEMBLY

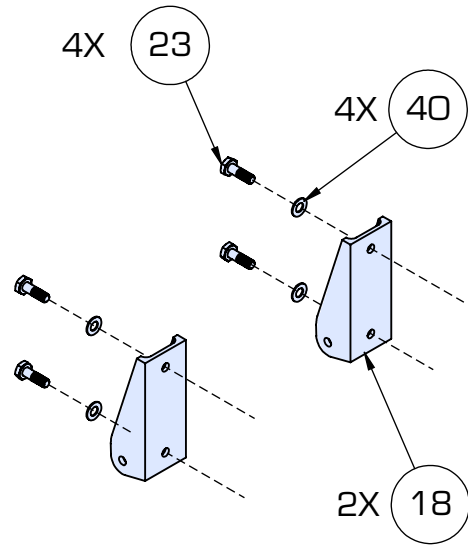


HS-15505 ASSEMBLY

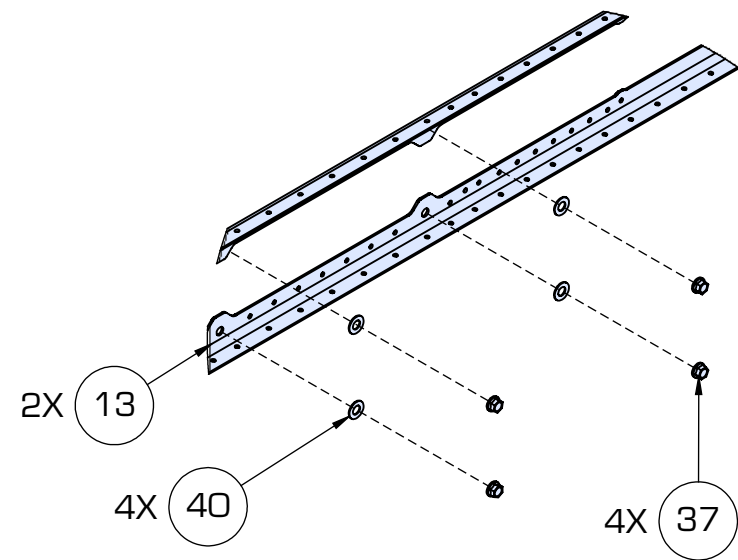


HS-15505 ASSEMBLY

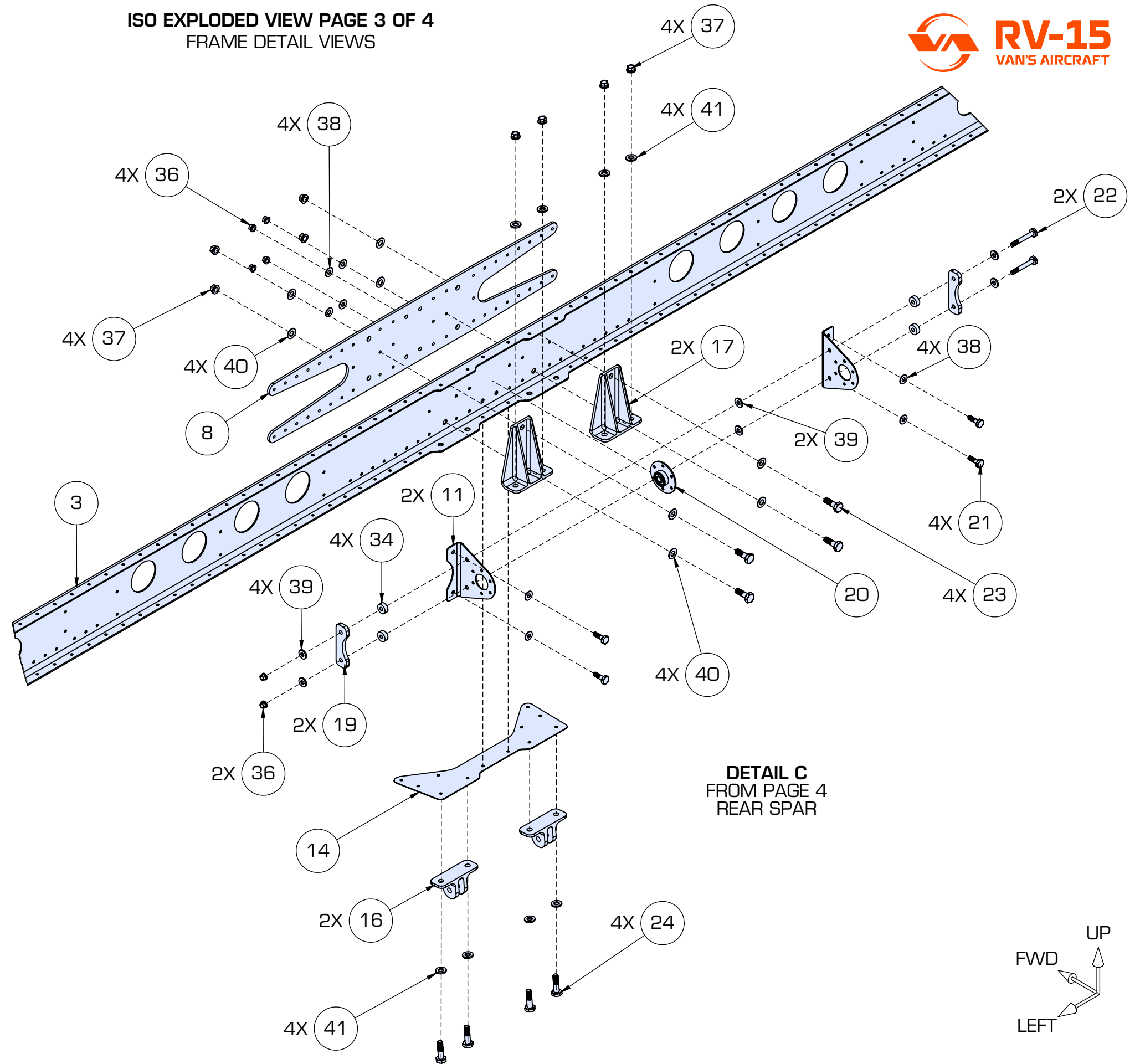
ISO EXPLODED VIEW PAGE 3 OF 4
FRAME DETAIL VIEWS



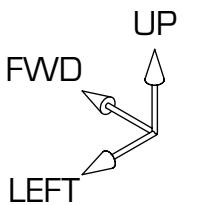
DETAIL A
FROM PAGE 4
FRONT SPAR

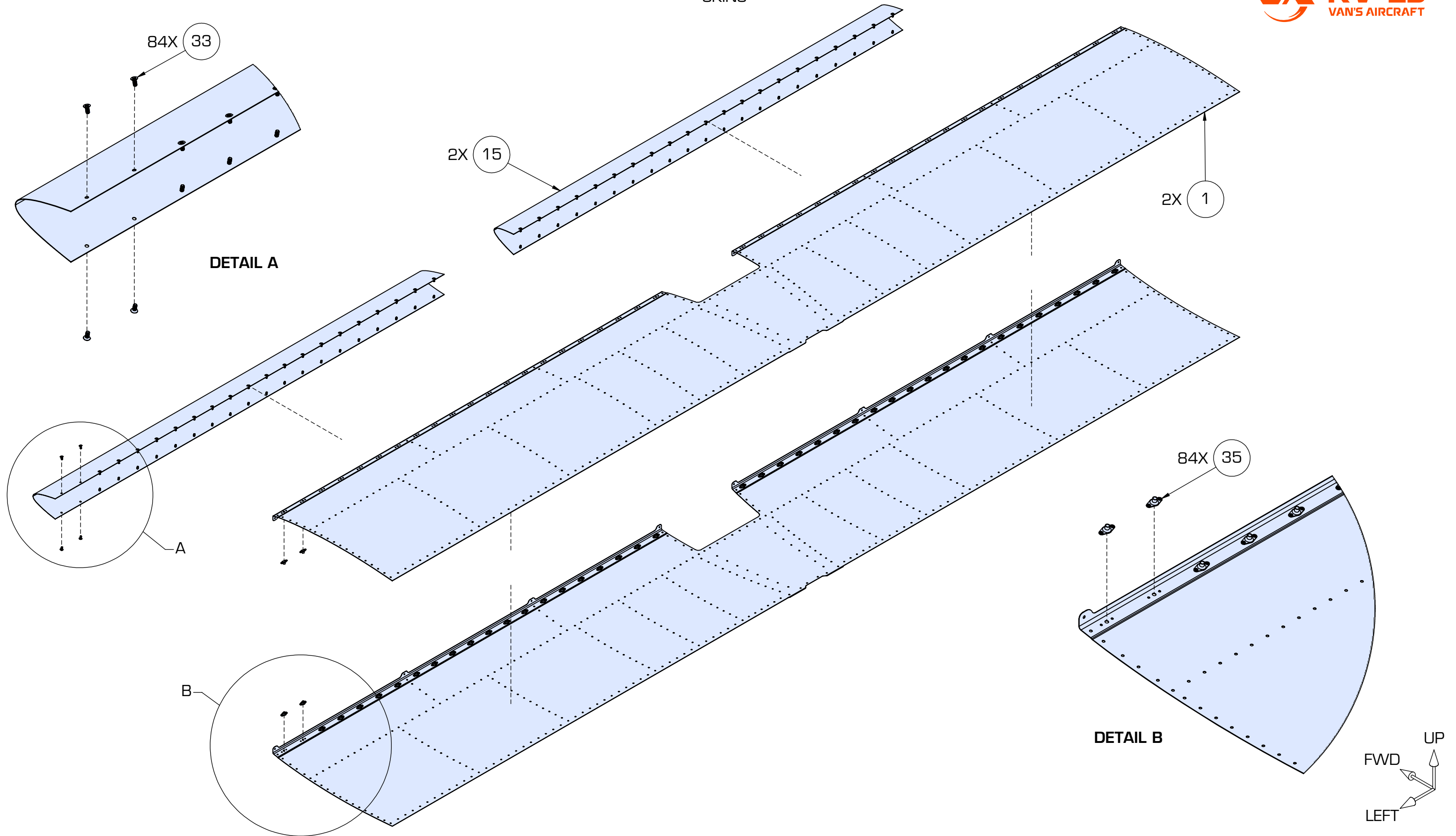


DETAIL B
FROM PAGE 4
FRONT SPAR



DETAIL C
FROM PAGE 4
REAR SPAR





HS-15505 ASSEMBLY

GENERAL NOTES AND COMMON REFERENCES

Applicable Section References:

- **Section 5.1** - Aluminum Priming & Painting
- **Section 5.2** - Edge Finishing, Deburring & Scratch Removal
- **Section 5.3** - Marking Parts
- **Section 5.4** - Riveting
- **Section 5.5** - Countersinking & Dimpling
- **Section 5.12** - Vinyl Coating
- **Section 5.13** - Fluting
- **Section 5.15** - Steel
- **Section 5.16** - Installing Nutplates
- **Section 5.20** - Nut & Bolt Torques
- **Section 5.24** - Drilling, Taps & Dies
- **Section 5.26** - Hardware Reference

Tools & Consumables Used This Section:

- #30 Piloted, 100° Countersink Cutter
- Bench Vice
- Deburring Tools
- Die Set [Flush Head, Universal Head]
- Drill Bits [#30, #12, 1/4"]
- Fluting Tools
- Rivet Puller
- Rivet Squeezer
- Screwdriver [Phillips]
- Sockets & Wrenches [1/4", 5/16", 3/8", 7/16"]
- Spring Clecos [1/8 VANS P/N "TOOL CL18", 3/32 VANS P/N "TOOL CL332"]
- Torque Seal, Cross Check Type
- Torque Wrench [in-lbs]
- Washer Wrench

BUILDER FEEDBACK QR CODE



www.vansaircraft.com/kit-assembly-instructions-feedback/

Part Preparation:

- Step 1:** Layout all parts
- Step 2:** Deburr all edges
- Step 3:** Flute and straighten all rib flanges
- Step 4:** Straighten components as necessary
- Step 5:** Coat (16) (17) and (18) with a suitable corrosion resistant finish. The anodized finish on these components is not intended as a standalone corrosion preventative.
- Step 6:** Prime additional parts as required.

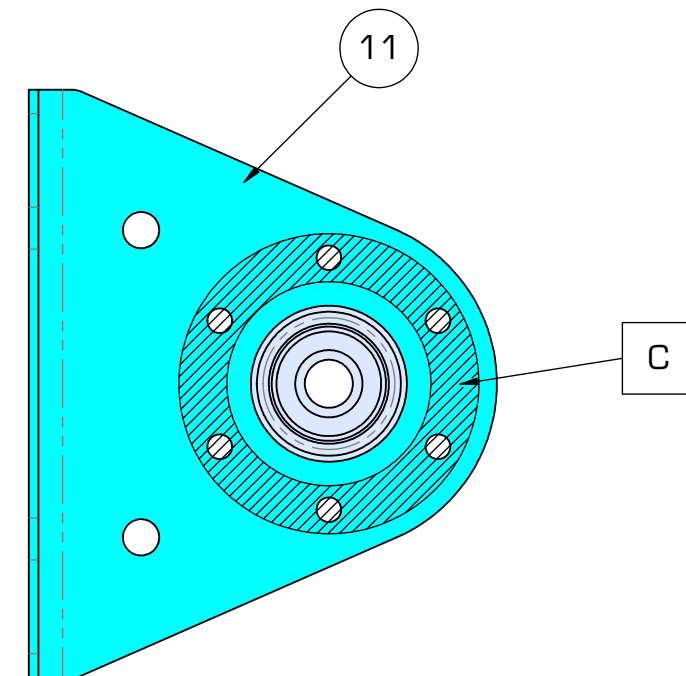
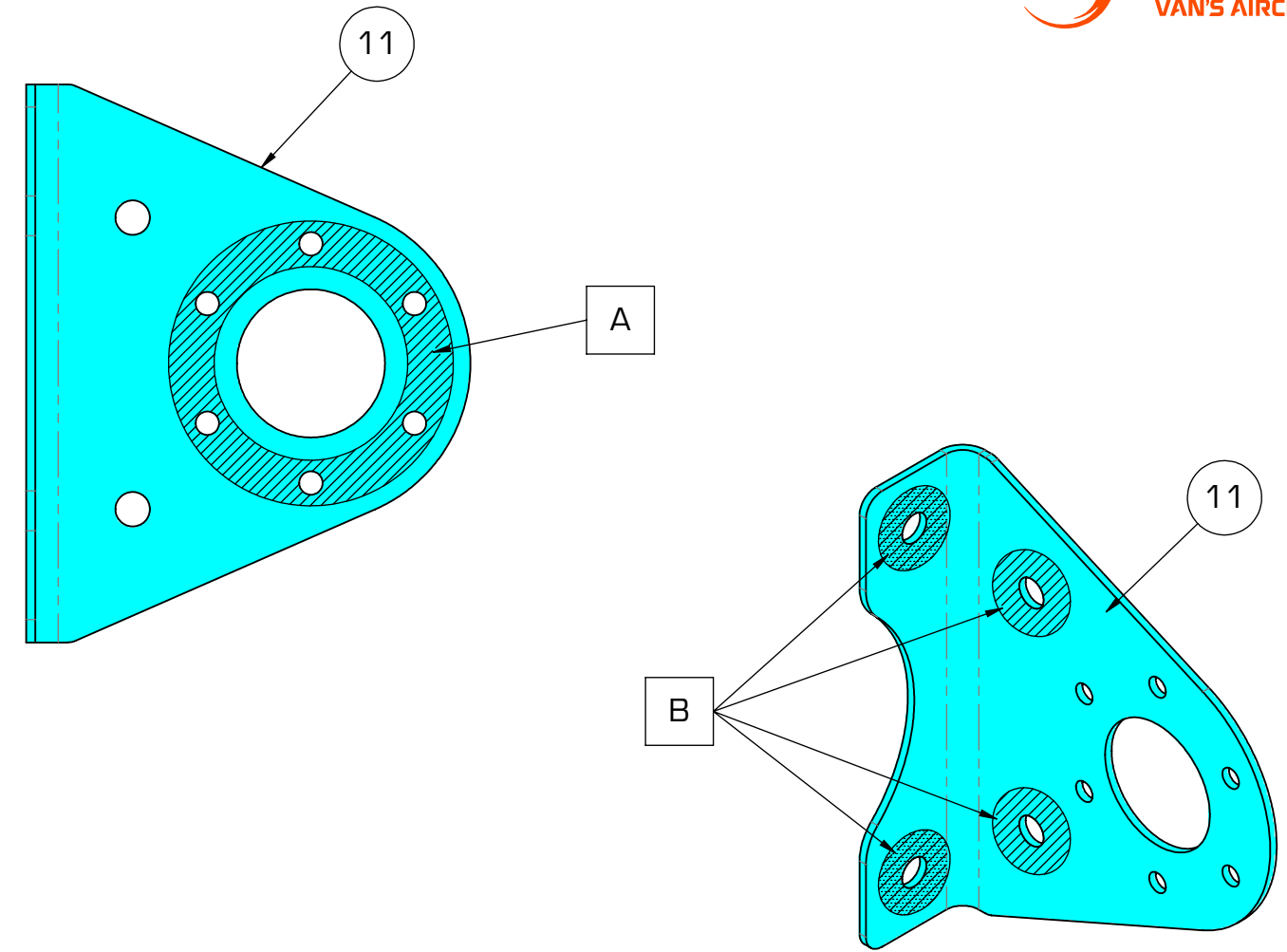
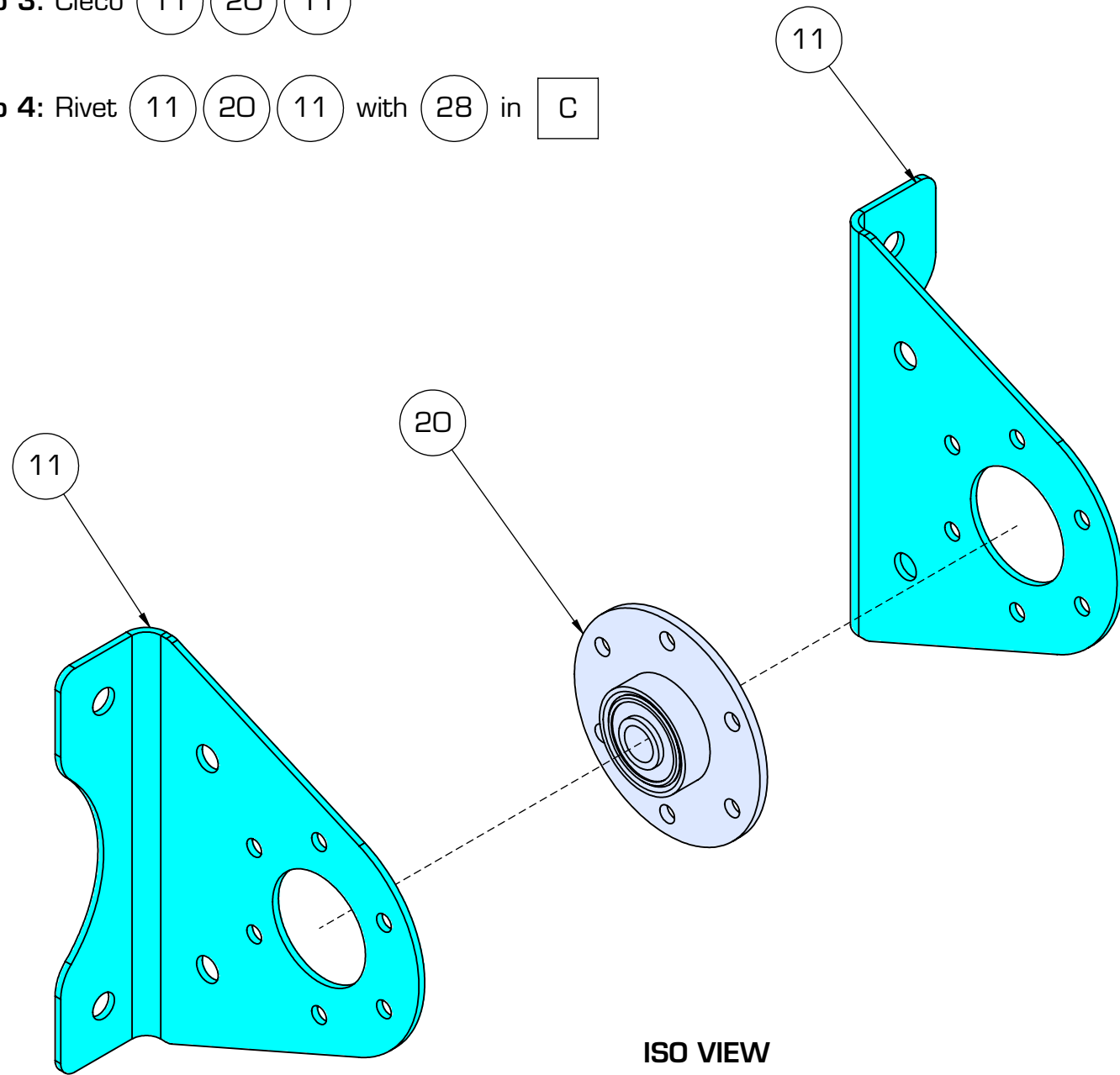
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
11	HS-15011-001	HINGE BRKT, INBD	2
20	VA-146	FLANGE BEARNG	1
28	AN470AD4-5.5	RIVET, SOLID UNIVERSAL	6

Step 1: #30 Final-Drill holes through each (11) in **A** to remove powder coat.

Step 2: #12 Final-Drill holes through each (11) in **B** to remove powder coat.

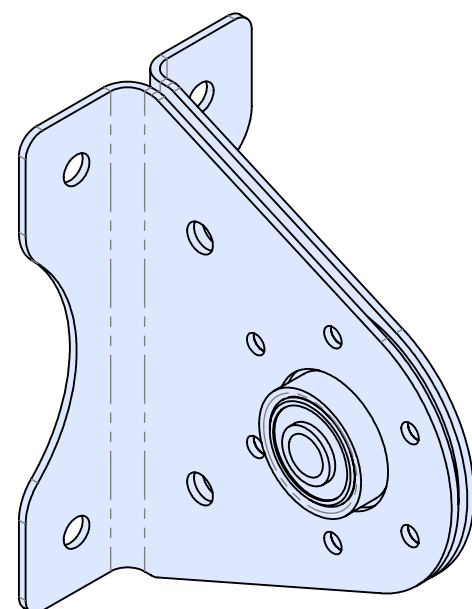
Step 3: Cleco (11) (20) (11)

Step 4: Rivet (11) (20) (11) with (28) in **C**



HS-15500 ASSEMBLY

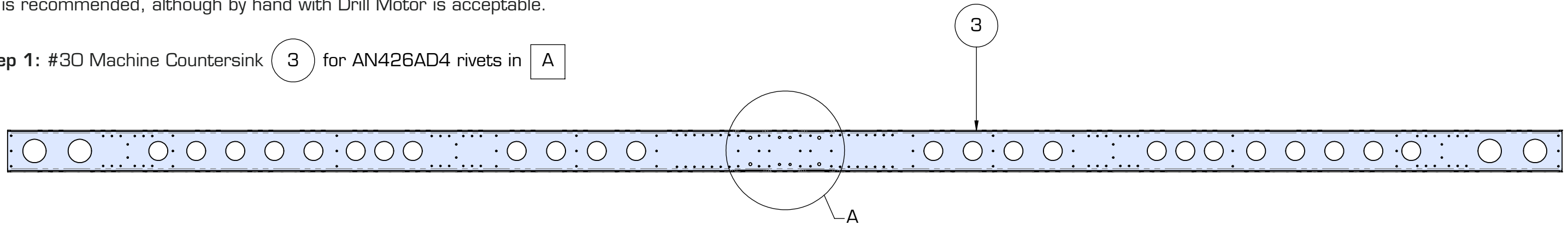
A1 HS-15500-001 HINGE SUBASSEMBLY COMPLETE



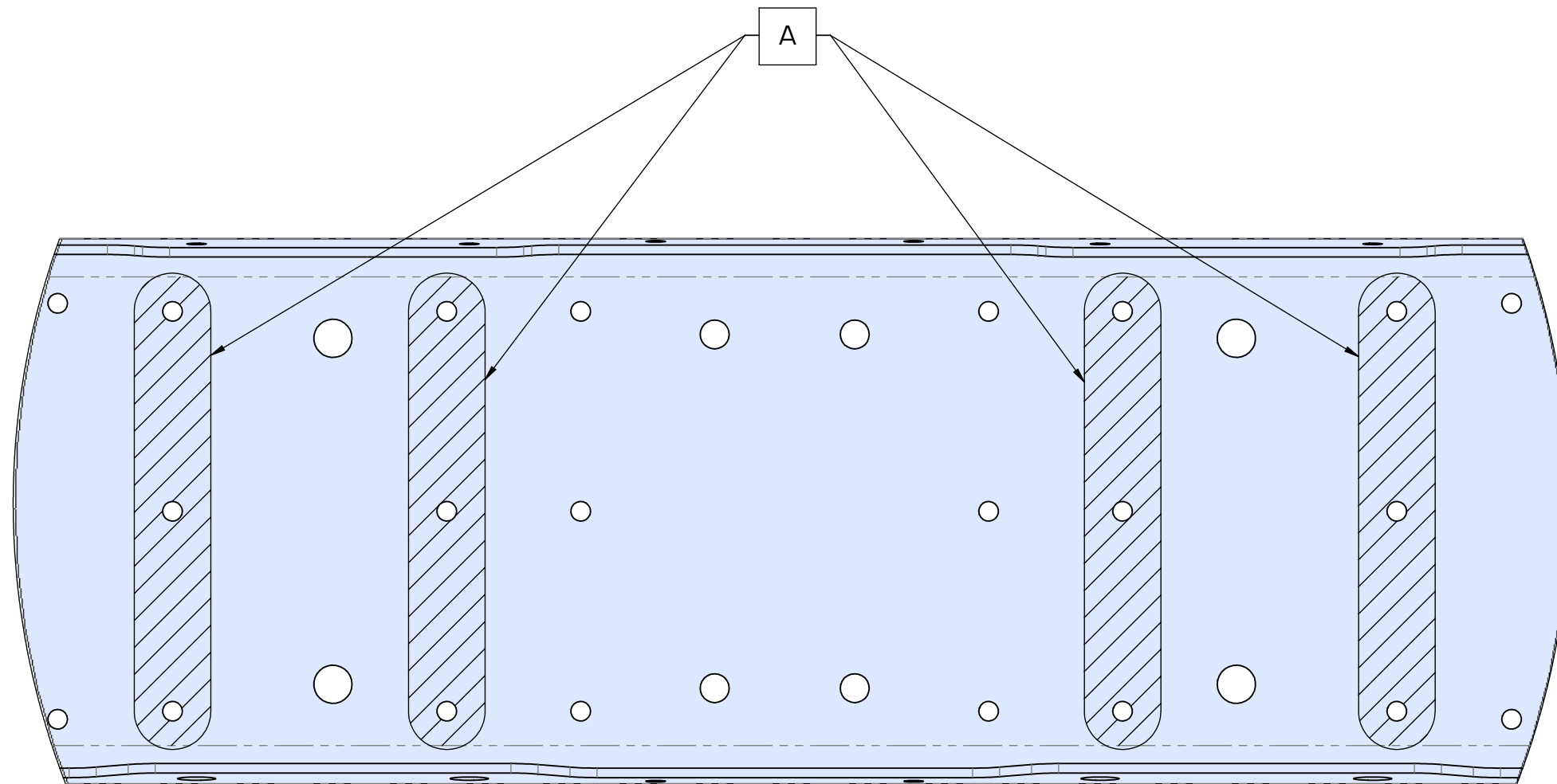
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
3	HS-15003-001	SPAR, REAR	1

NOTE: A Machine Countersink Cage cannot be used in 8 holes adjacent to flanges. A Countersink Cutter can be used with extension. Turning slowly in Drill Press is recommended, although by hand with Drill Motor is acceptable.

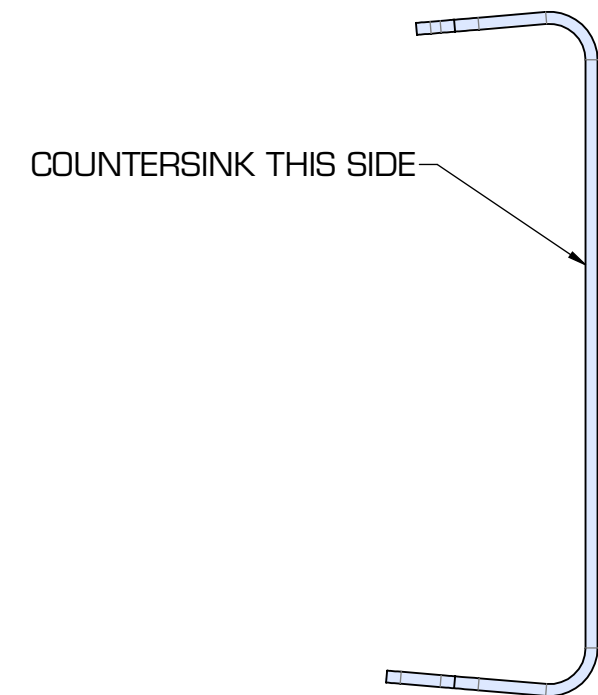
Step 1: #30 Machine Countersink **3** for AN426AD4 rivets in **A**



AFT VIEW LOOKING FORWARD



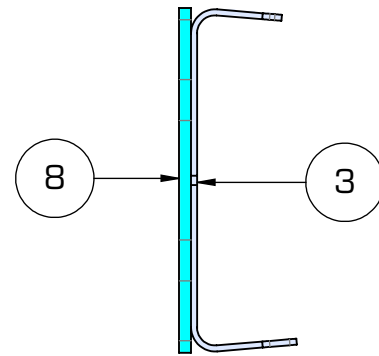
DETAIL A



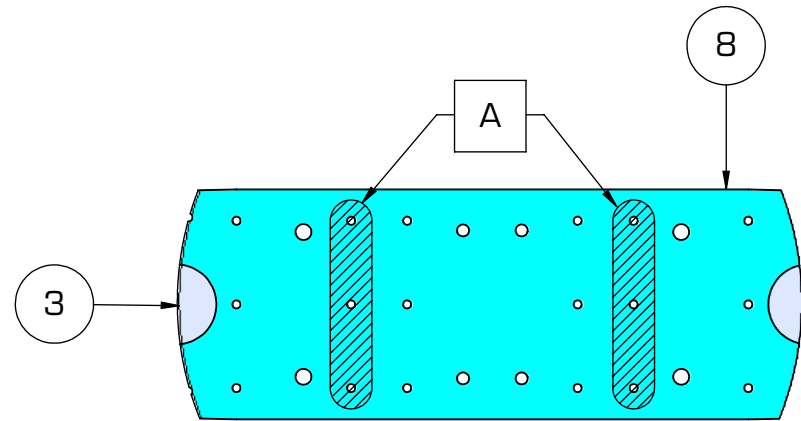
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
3	HS-15003-001	SPAR, REAR	1
8	HS-15008-001	DOUBLER, INBD REAR SPAR	1
26	AN426AD4-6	RIVET, SOLID COUNTERSUNK	6

Step 1: Cleco (8) to (3)

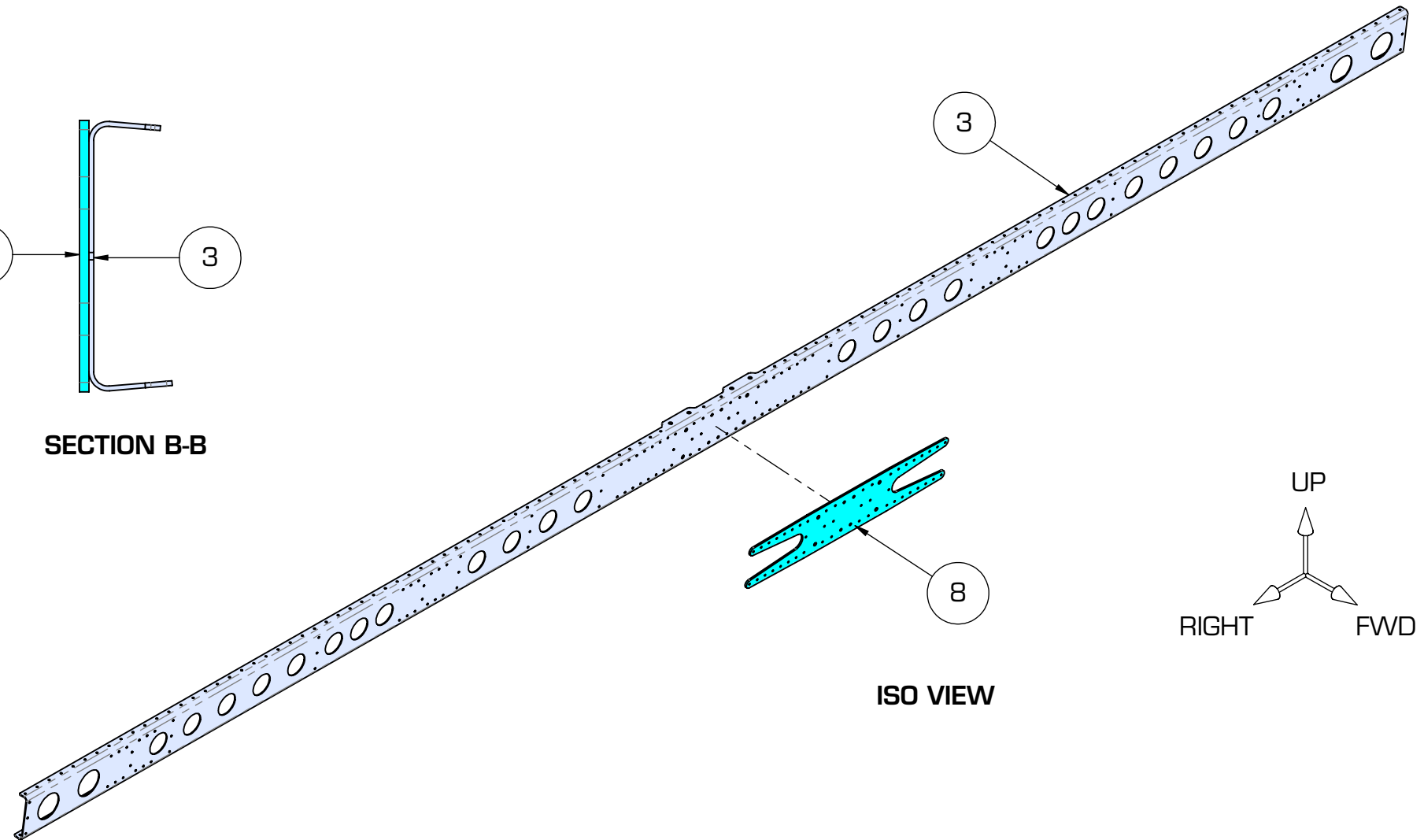
Step 2: Rivet (8) to (3) with (26) in A



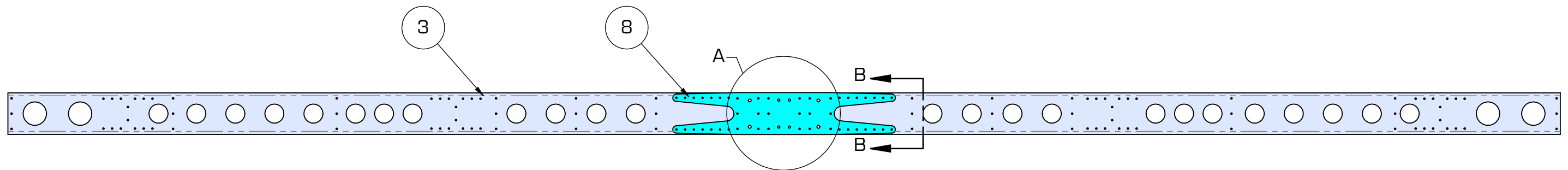
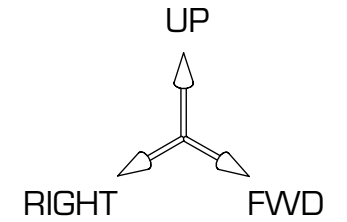
SECTION B-B



DETAIL A



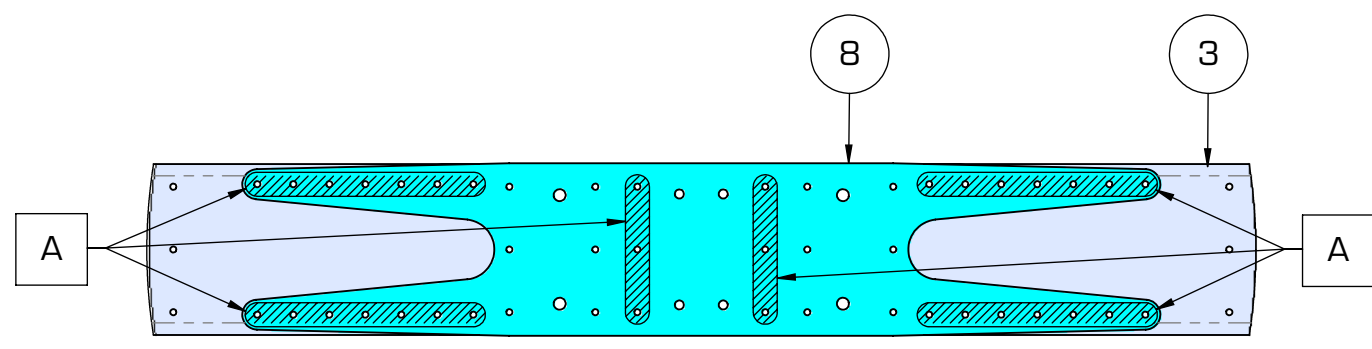
ISO VIEW



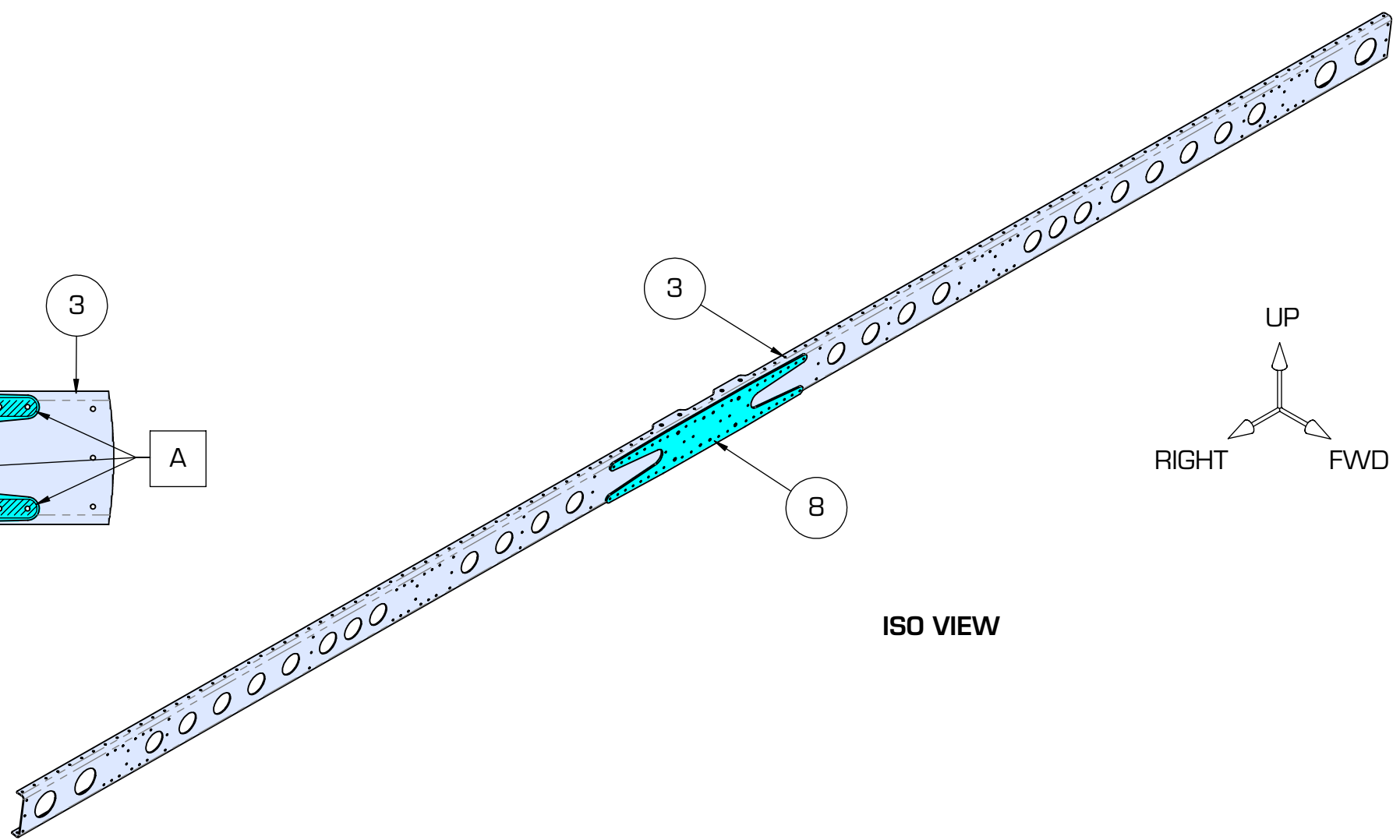
FORWARD VIEW LOOKING AFT

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
3	HS-15003-001	SPAR, REAR	1
8	HS-15008-001	DOUBLER, INBD REAR SPAR	1
29	AN470AD4-6	RIVET, SOLID UNIVERSAL	34

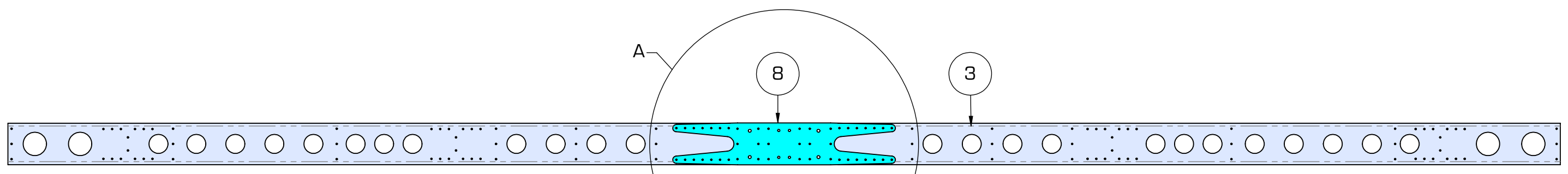
Step 1: Rivet 8 to 3 with 29 in A



DETAIL A



ISO VIEW



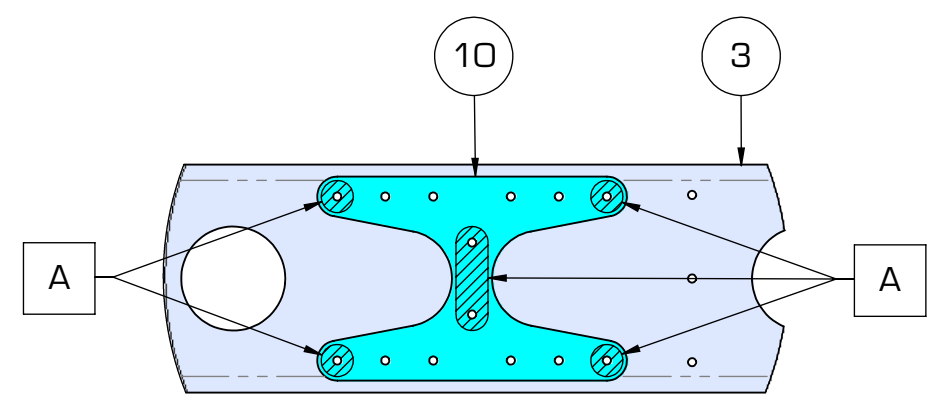
FORWARD VIEW LOOKING AFT

HS-15501 ASSEMBLY

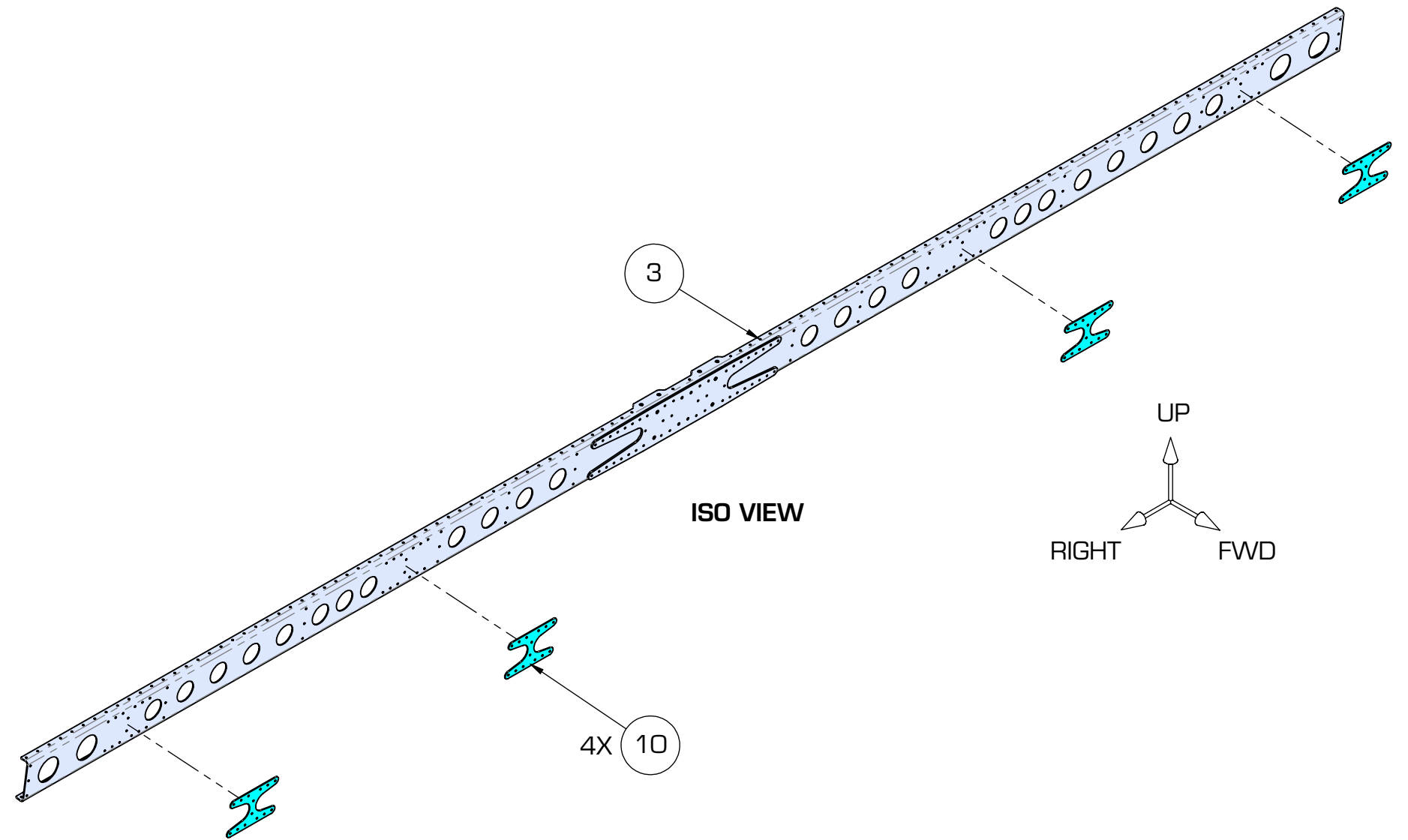
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
3	HS-15003-001	SPAR, REAR	1
10	HS-15010-001	DOUBLER, HINGE	4
27	AN470AD4-5	RIVET, SOLID UNIVERSAL	24

Step 1: Cleco each (10) to (3)

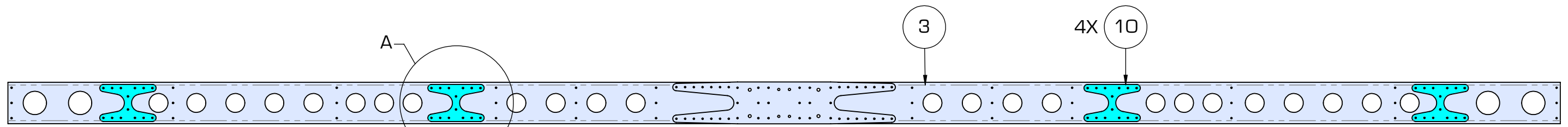
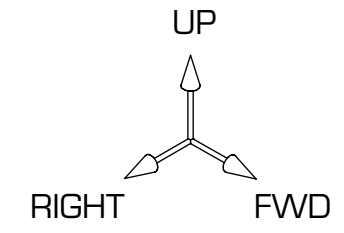
Step 2: Rivet each (10) to (3) with (27) in [A]



DETAIL A



ISO VIEW



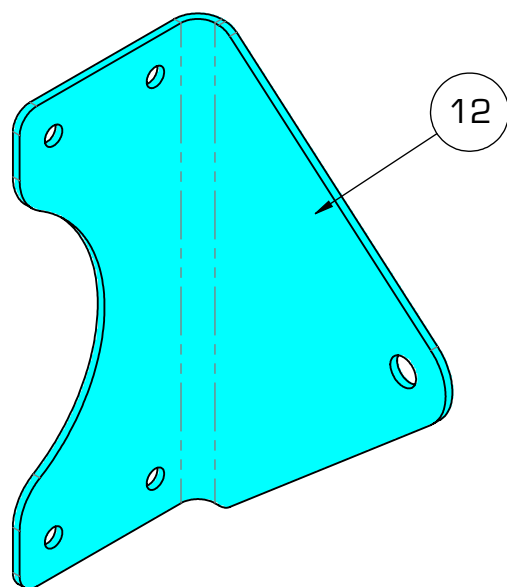
FORWARD VIEW LOOKING AFT

HS-15501 ASSEMBLY

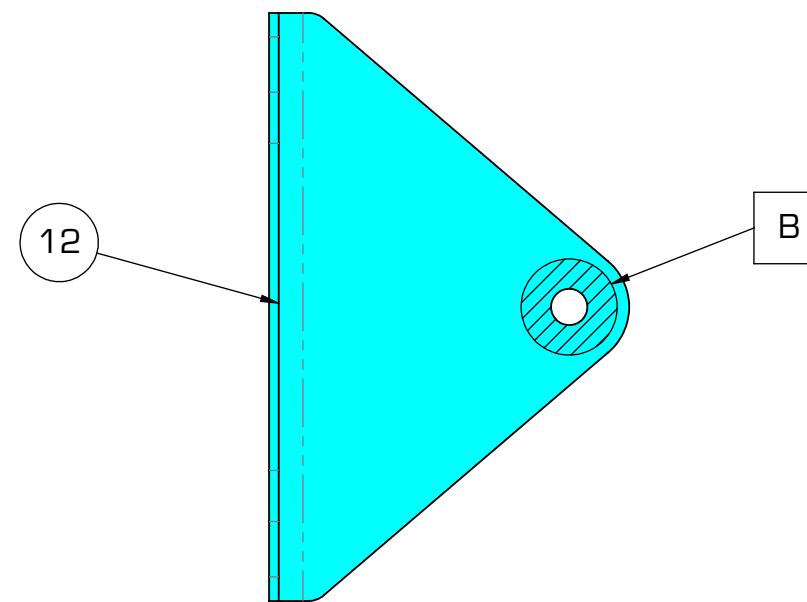
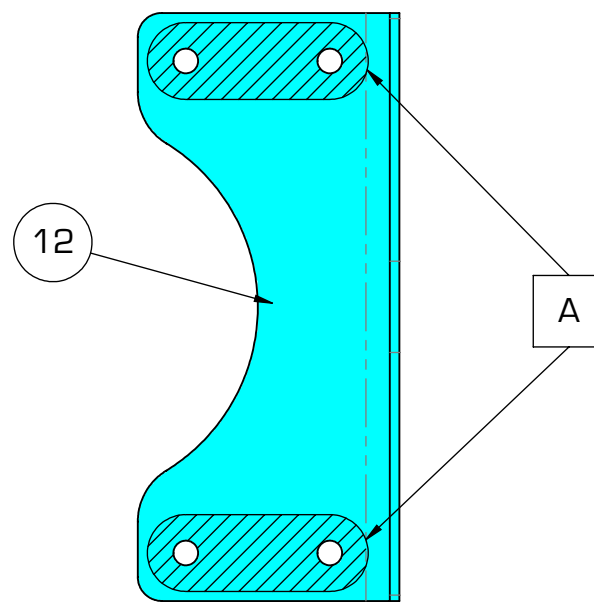
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
12	HS-15012-001	HINGE BRKT, OTBD	8

Step 1: #30 Final-Drill holes through each (12) in A to remove powder coat.

Step 2: #12 Final-Drill holes through each (12) in B to remove powder coat.



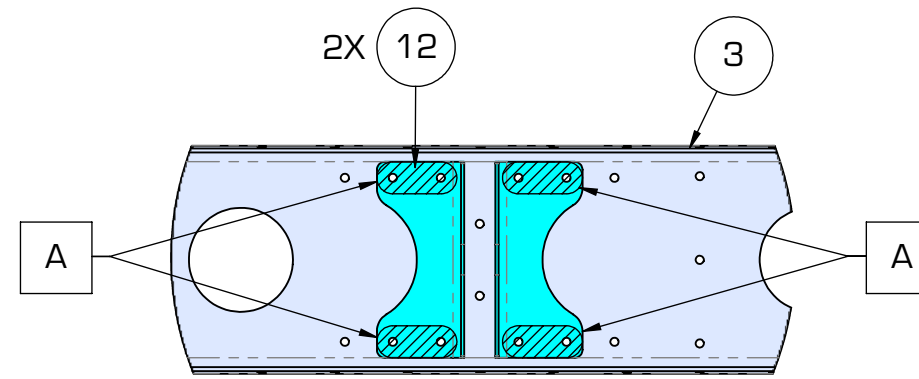
ISO VIEW



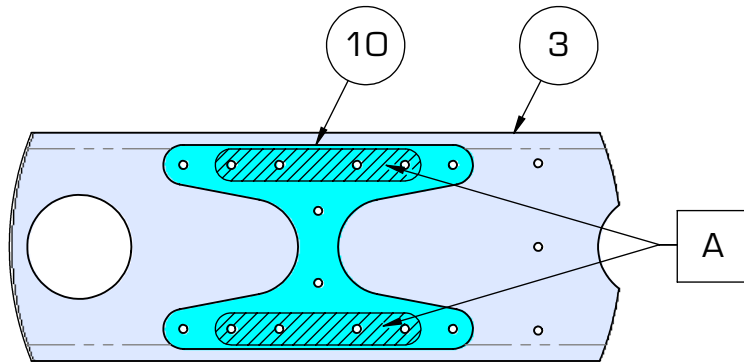
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
3	HS-15003-001	SPAR, REAR	1
10	HS-15010-001	DOUBLER, HINGE	4
12	HS-15012-001	HINGE BRKT, OTBD	8
29	AN470AD4-6	RIVET, SOLID UNIVERSAL	32

Step 1: Cleco each (12) to (3) (10)

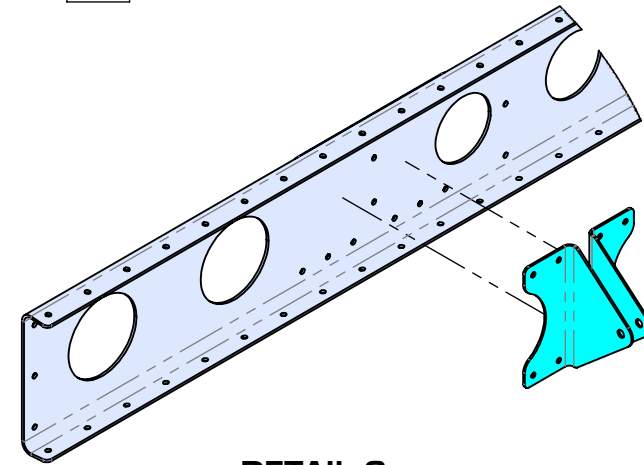
Step 2: Rivet each (12) to (3) (10) with (29) in (A)



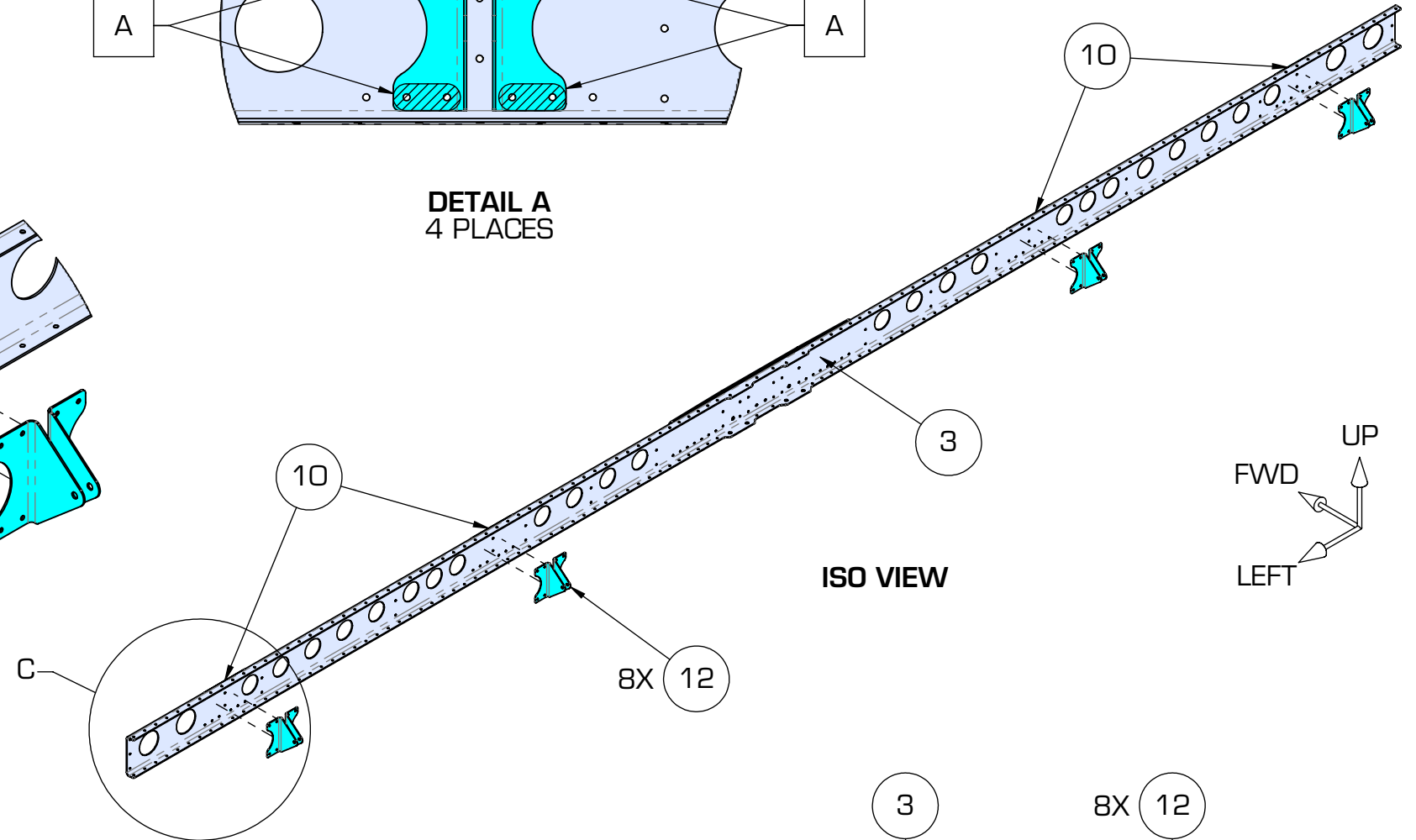
DETAIL A
4 PLACES



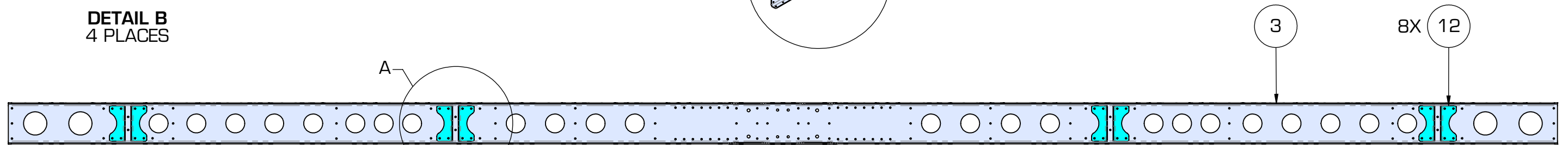
DETAIL B
4 PLACES



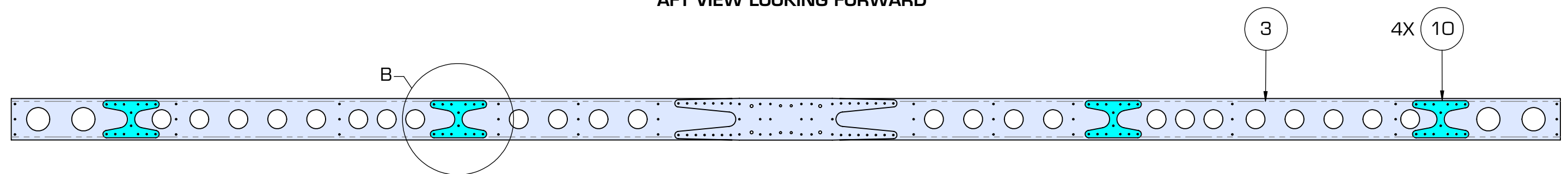
DETAIL C
4 PLACES



ISO VIEW

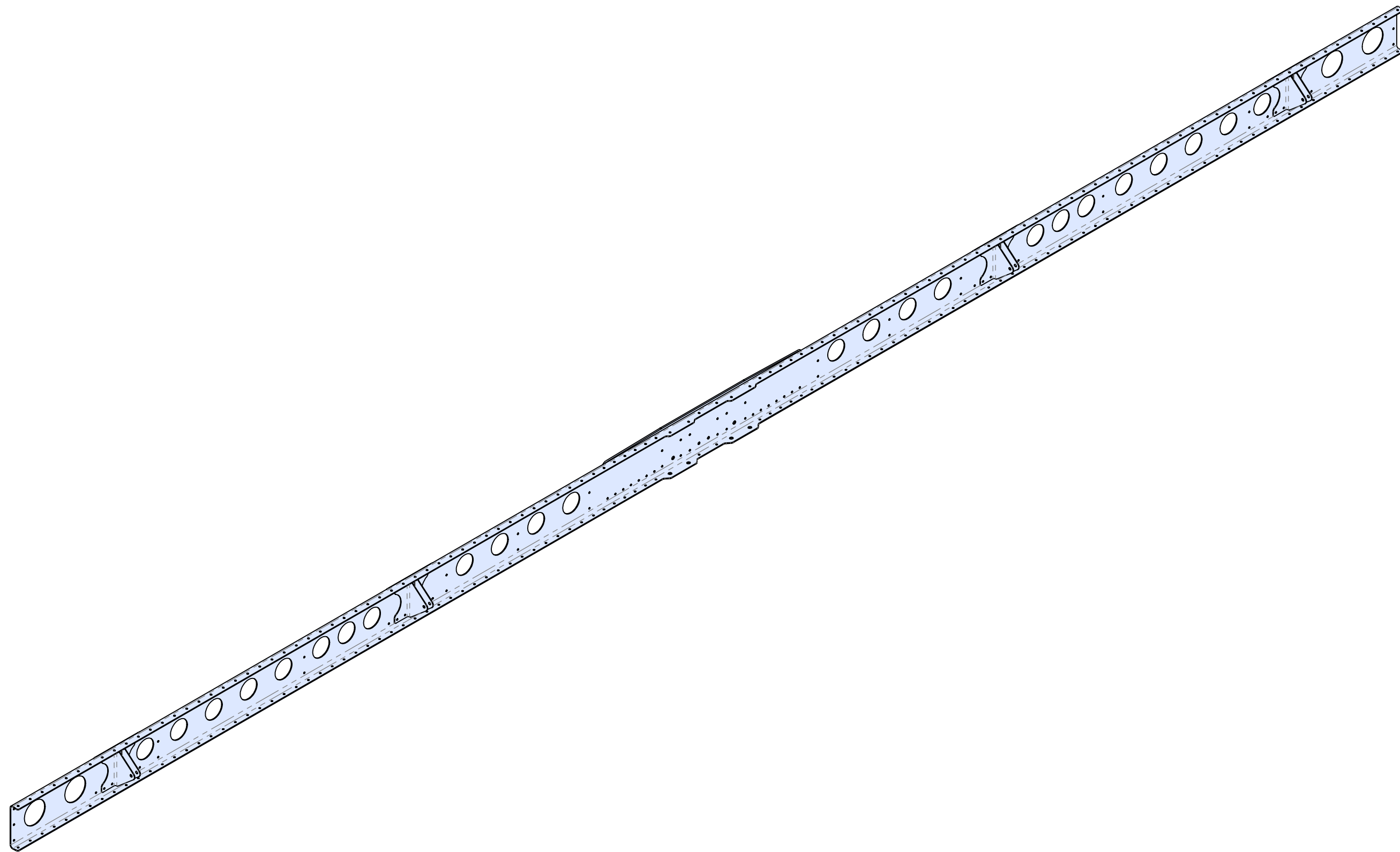


AFT VIEW LOOKING FORWARD



FORWARD VIEW LOOKING AFT

HS-15501 ASSEMBLY

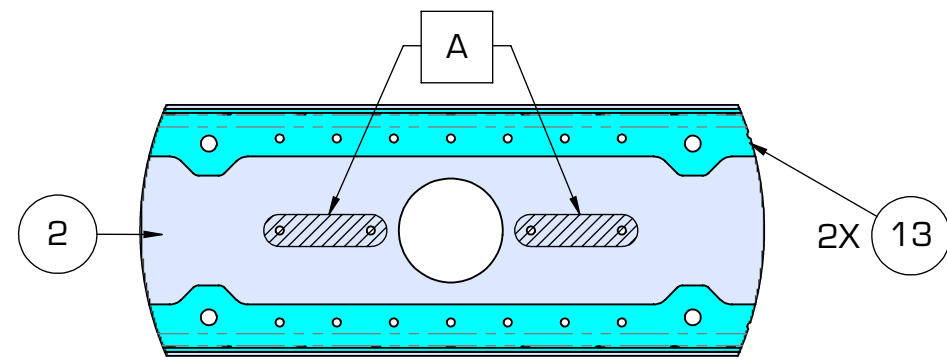


HS-15501 ASSEMBLY

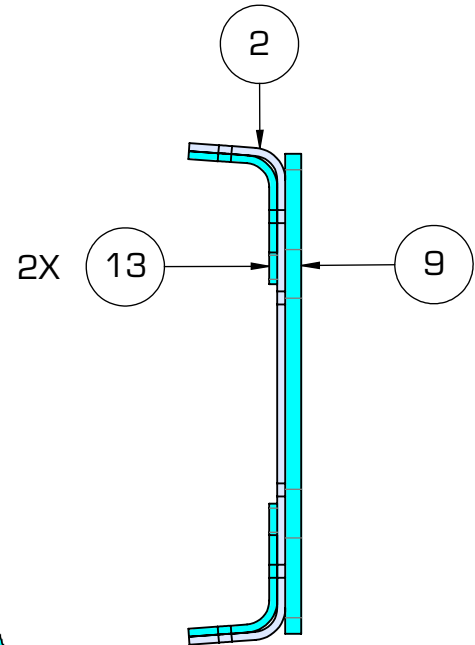
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
2	HS-15002-001	SPAR, FRONT	1
9	HS-15009-001	DOUBLER, FRONT SPAR	1
13	HS-15013-001	CAP, FRONT SPAR	2
29	AN470AD4-6	RIVET, SOLID UNIVERSAL	4

Step 1: Cleco (9) and each (13) to (2)

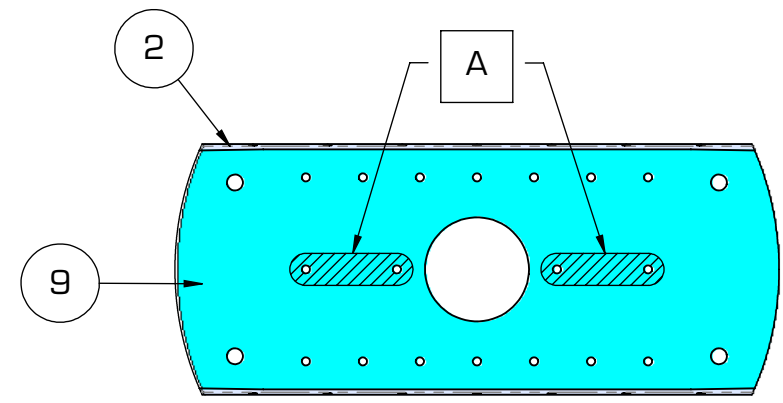
Step 2: Rivet (9) to (2) with (29) in A



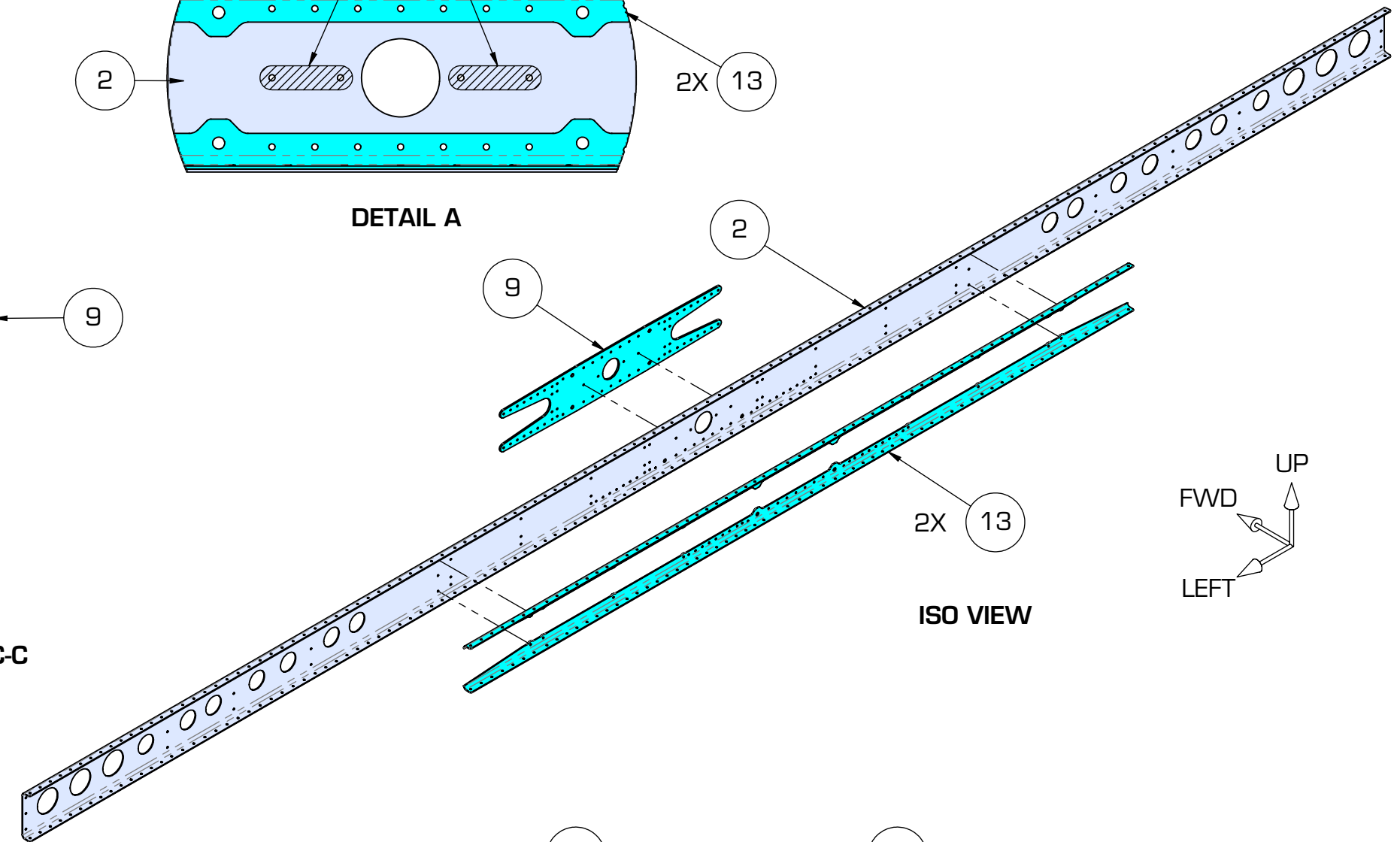
DETAIL A



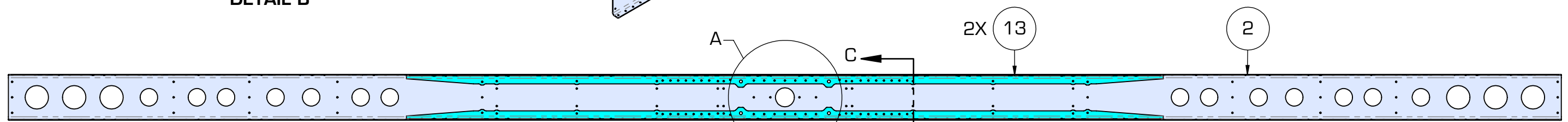
SECTION C-C



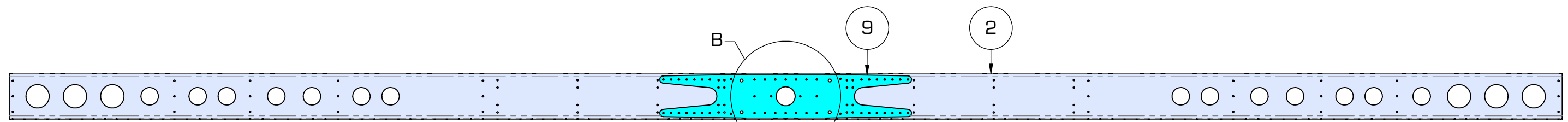
DETAIL B



ISO VIEW



AFT VIEW LOOKING FORWARD

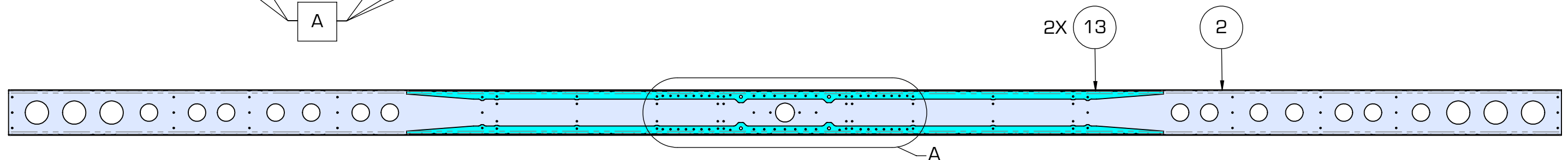
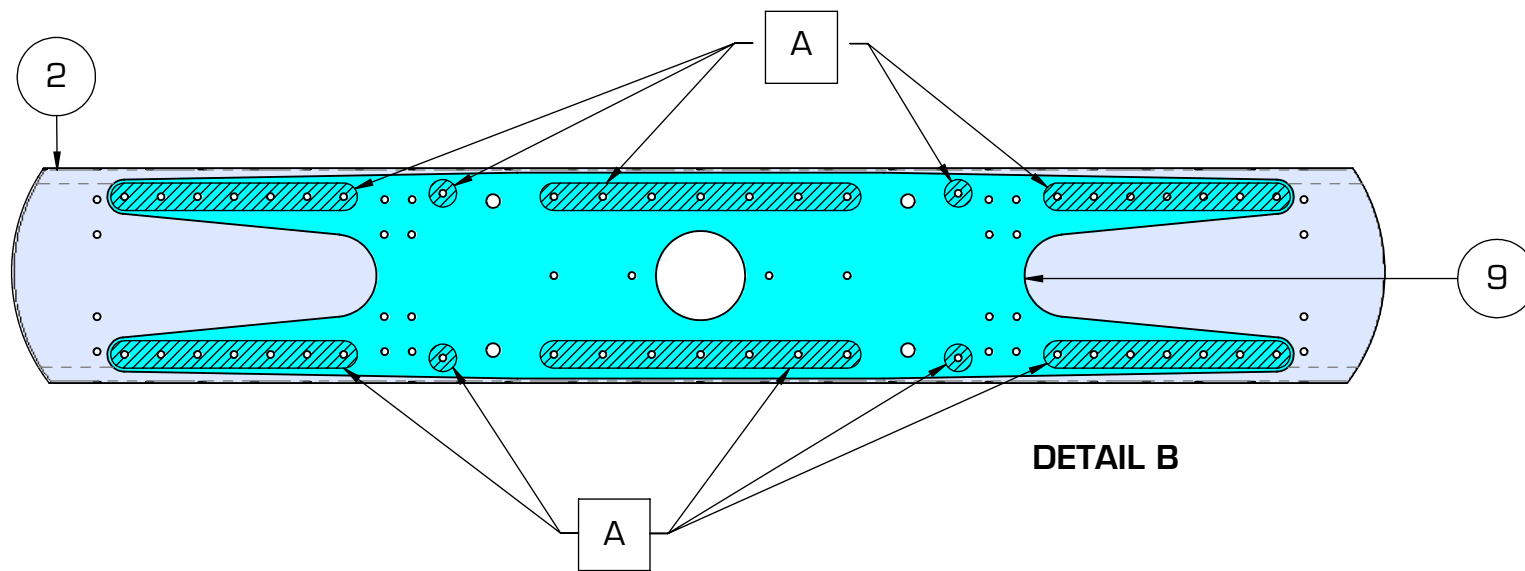
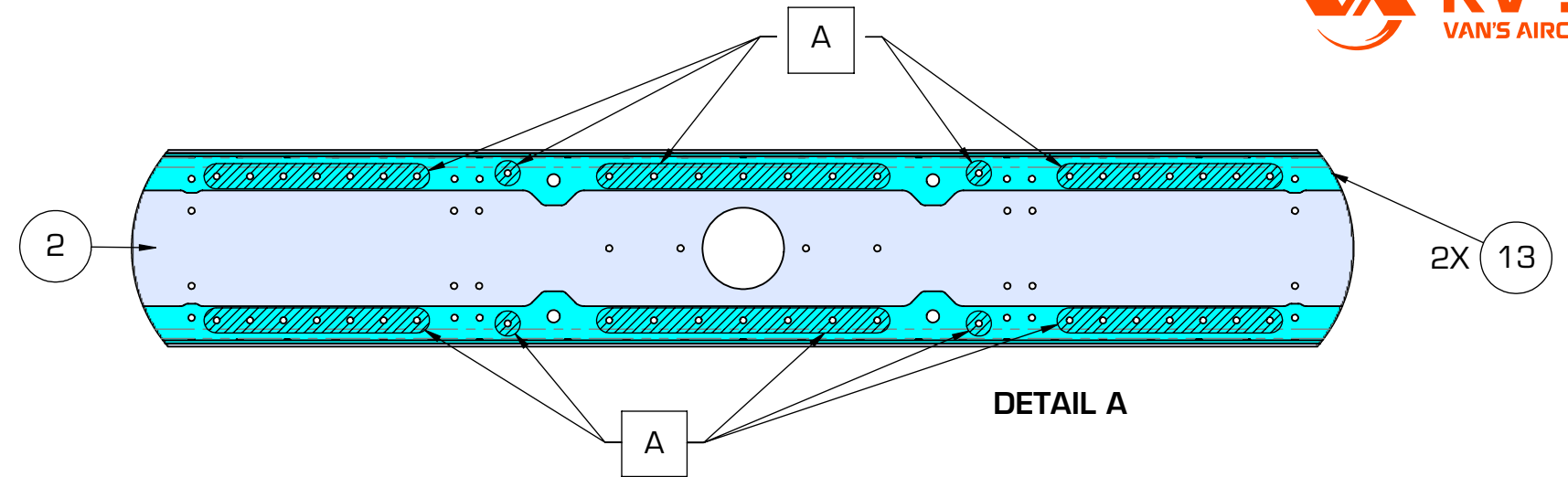


FORWARD VIEW LOOKING AFT

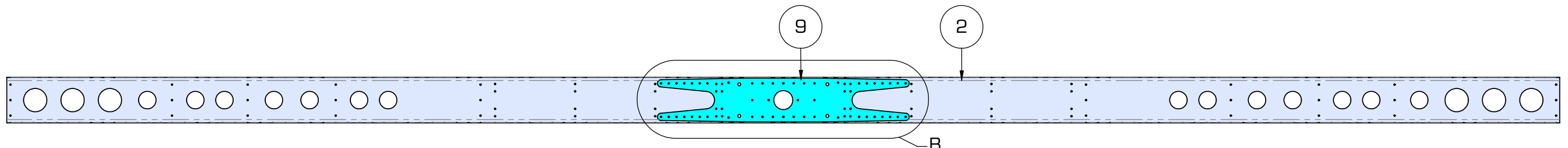
HS-15502 ASSEMBLY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
2	HS-15002-001	SPAR, FRONT	1
9	HS-15009-001	DOUBLER, FRONT SPAR	1
13	HS-15013-001	CAP, FRONT SPAR	2
31	AN470AD4-7	RIVET, SOLID UNIVERSAL	46

Step 1: Rivet each (13) to (2) (9) with (31) in (A)

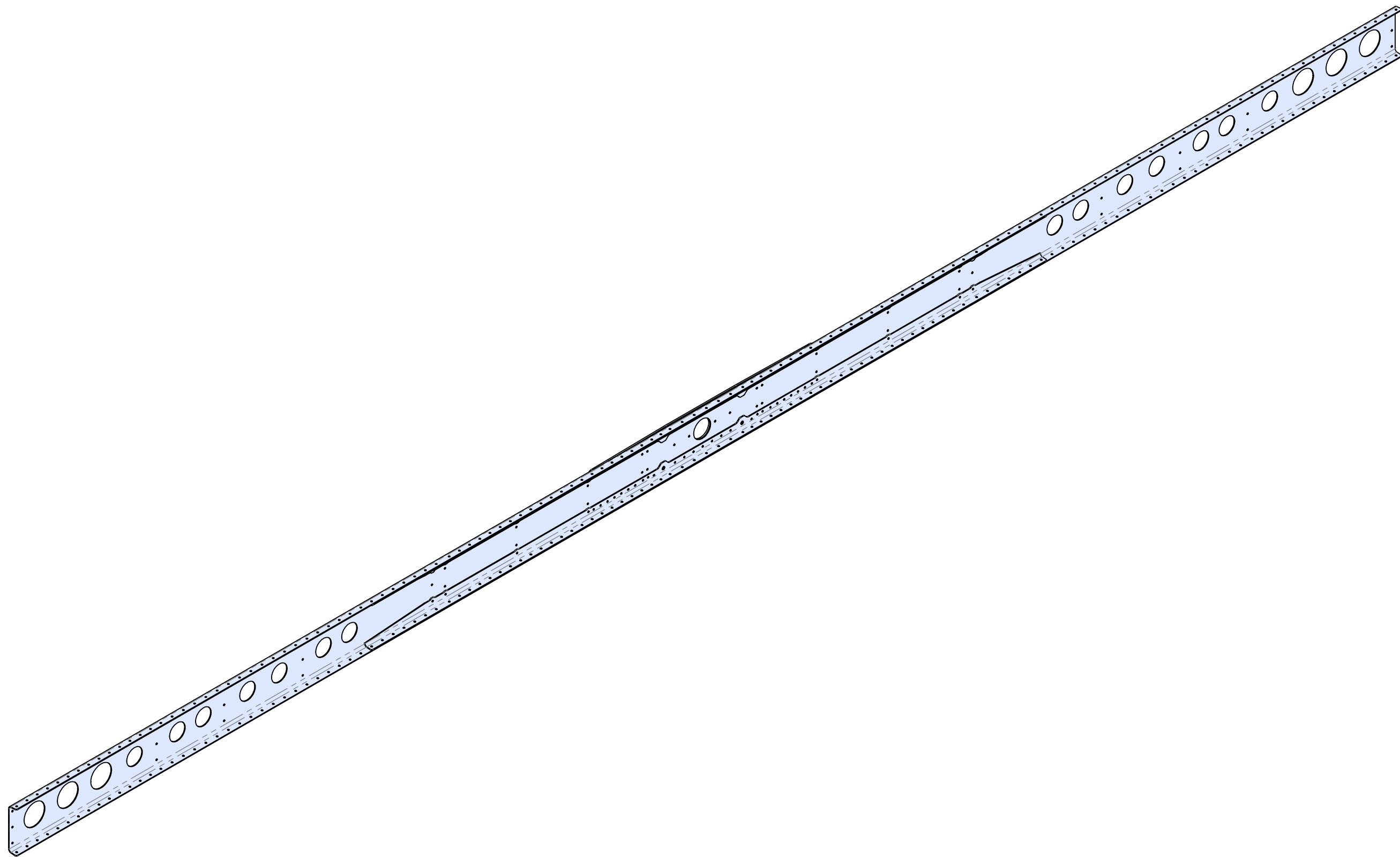


AFT VIEW LOOKING FORWARD



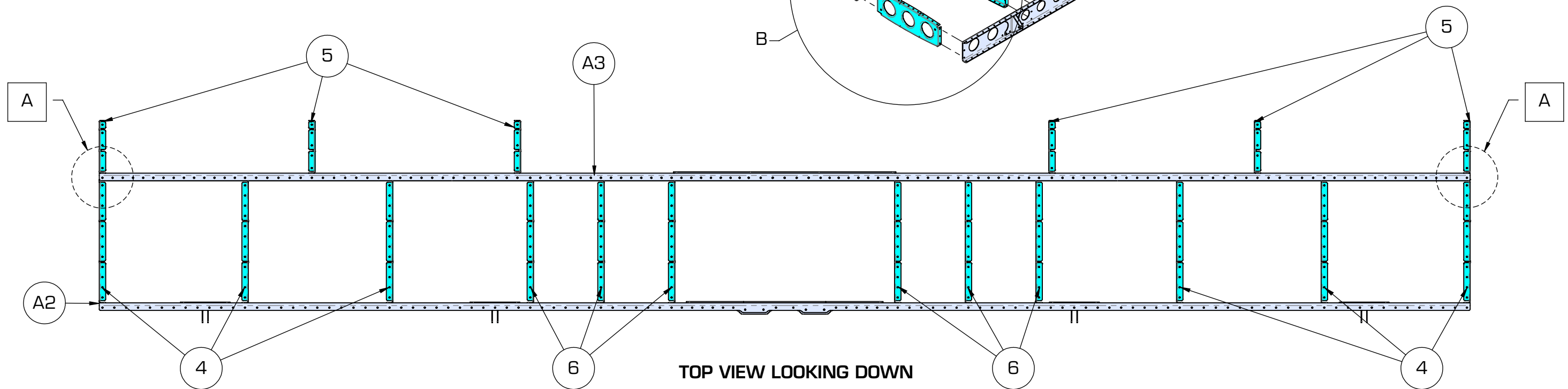
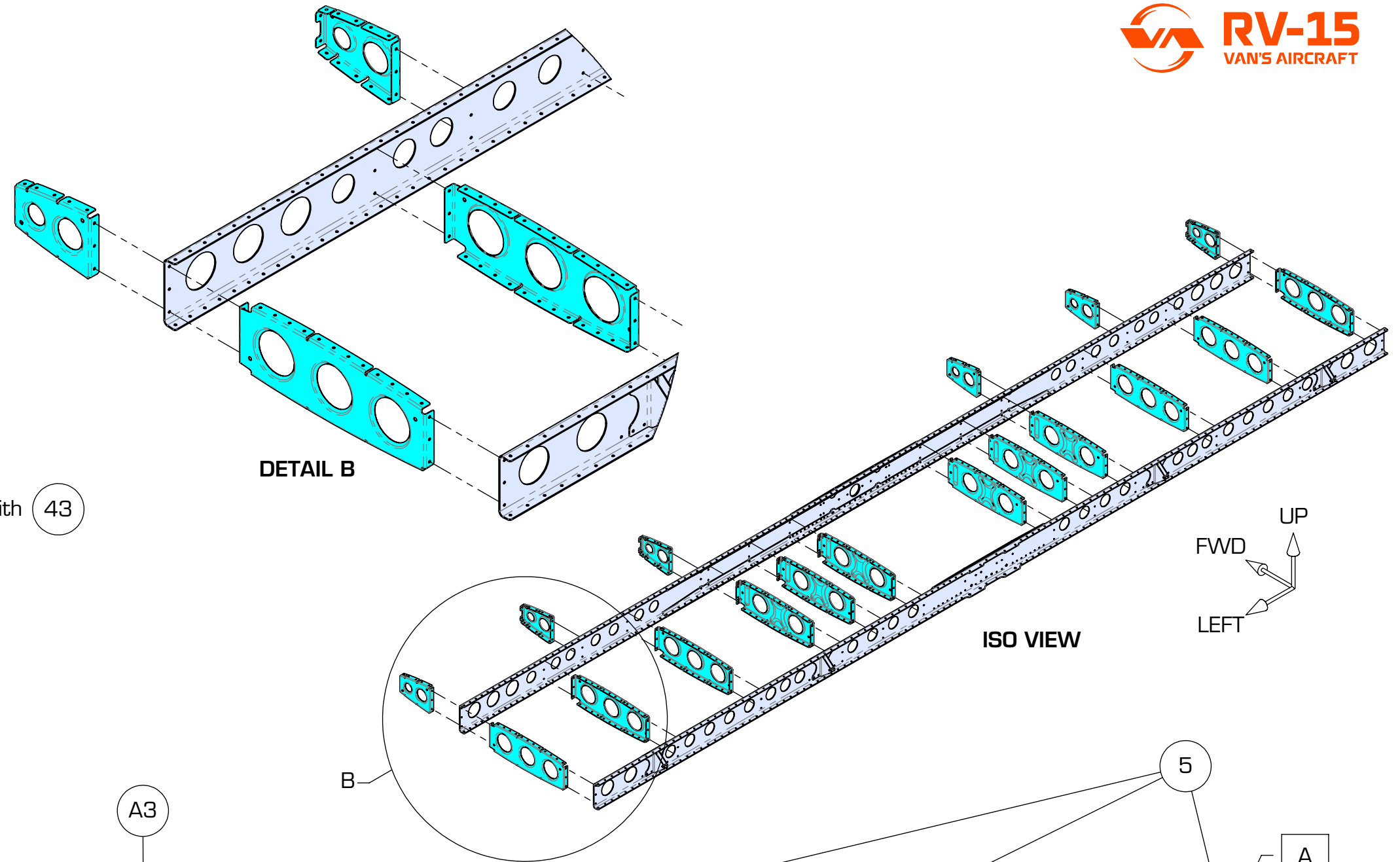
FORWARD VIEW LOOKING AFT

HS-15502 ASSEMBLY



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
A2	HS-15501-001	REAR SPAR ASSM	1
A3	HS-15502-001	FRONT SPAR ASSM	1
4	HS-15004-001	RIB, OTBD	6
5	HS-15005-001	RIB, OTBD NOSE	6
6	HS-15006-001	RIB, INBD	6
43	RIVET-LP4-3	RIVET, BLIND	90

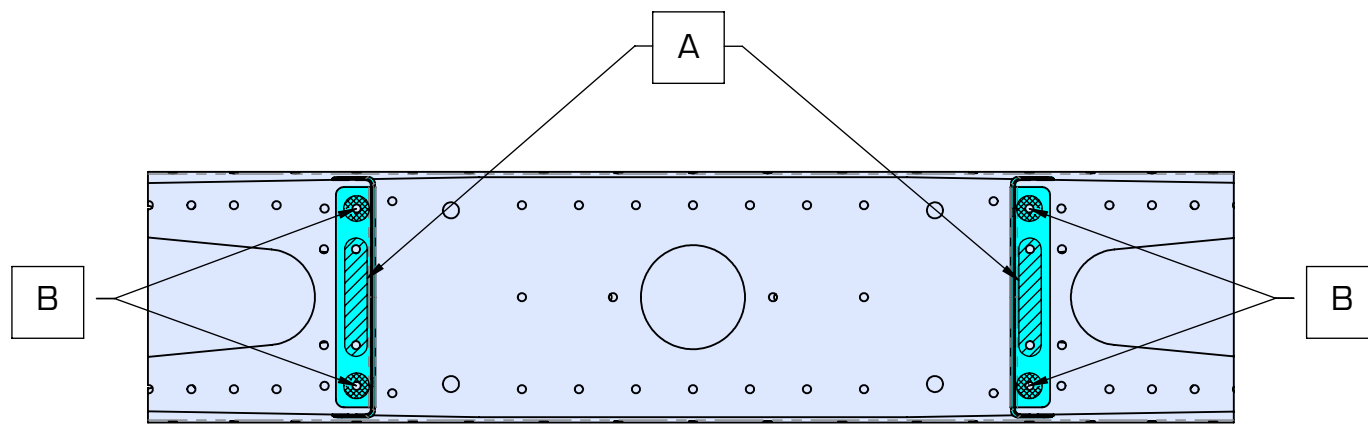
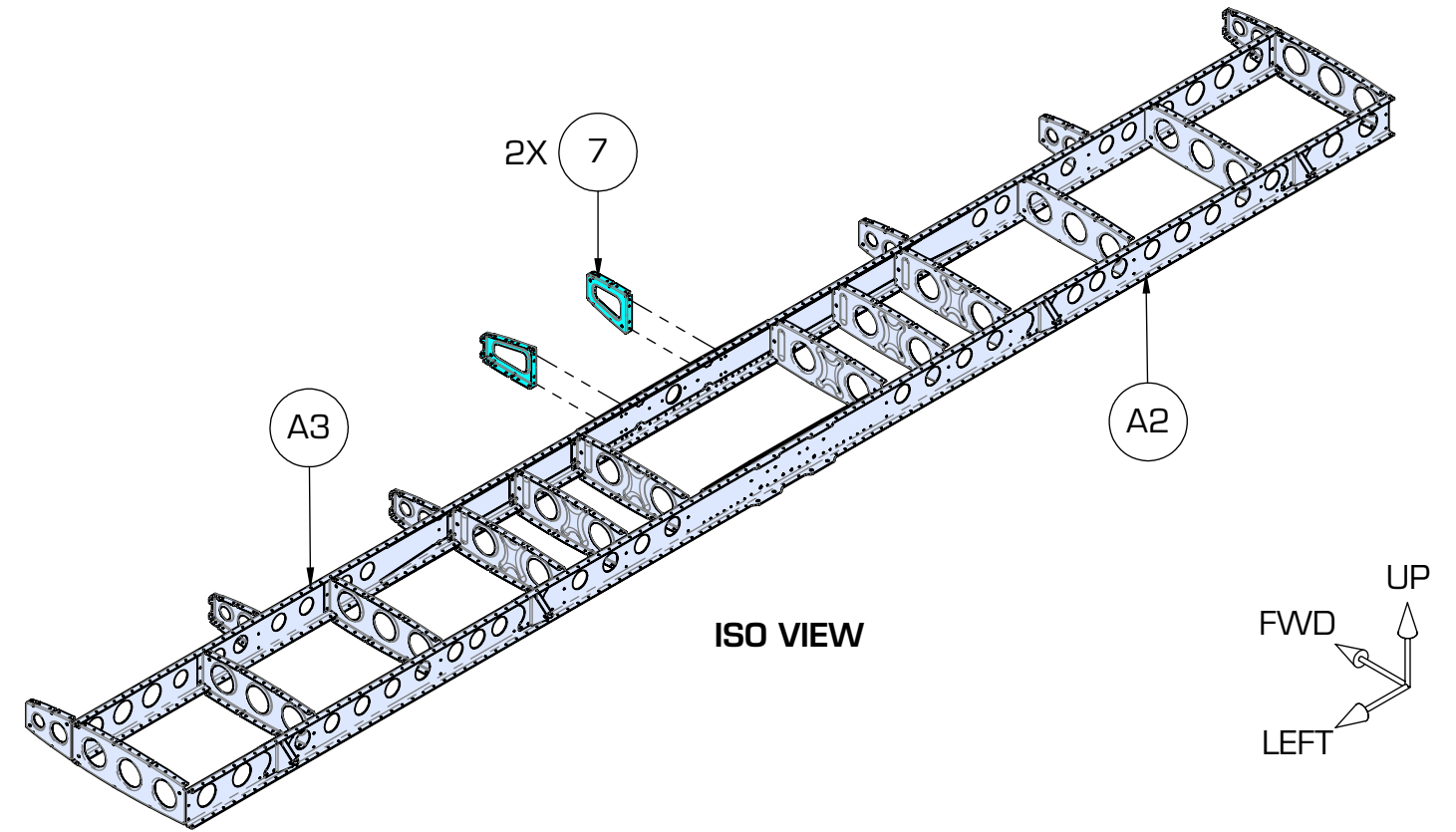
- Step 1: Cleco (5) (A3) (4) in (A)
- Step 2: Cleco each (4) (5) (6) to (A2) and (A3)
- Step 3: Rivet (5) (A3) (4) with (43) in (A)
- Step 4: Rivet each (4) (5) (6) to (A2) and (A3) with (43)



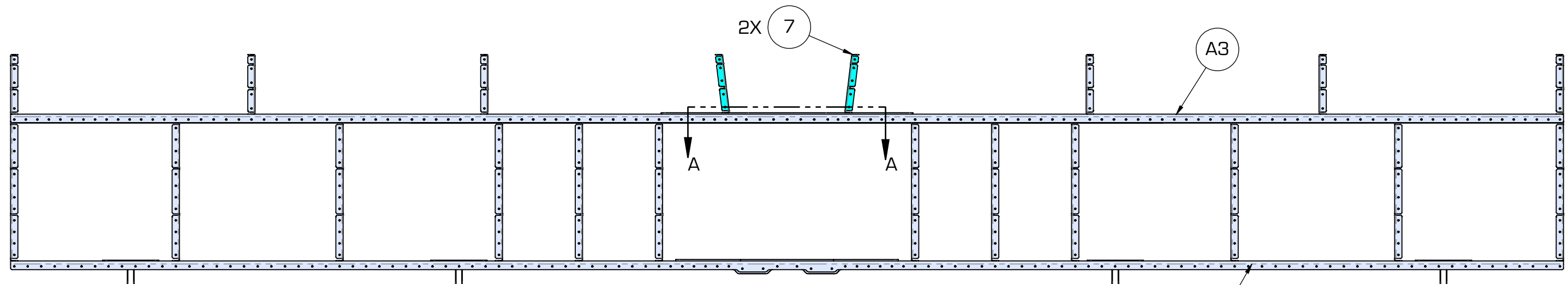
HS-15503 ASSEMBLY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
A2	HS-15501-001	REAR SPAR ASSM	1
A3	HS-15502-001	FRONT SPAR ASSM	1
7	HS-15007-001	RIB, INBD NOSE	2
30	AN470AD4-6.5	RIVET, SOLID UNIVERSAL	4
32	AN470AD4-8	RIVET, SOLID UNIVERSAL	4

- Step 1:** Cleco each (7) to (A3)
- Step 2:** Rivet each (7) to (A3) with (30) in (A)
- Step 3:** Rivet each (7) to (A3) with (32) in (B)



SECTION A-A



TOP VIEW LOOKING DOWN

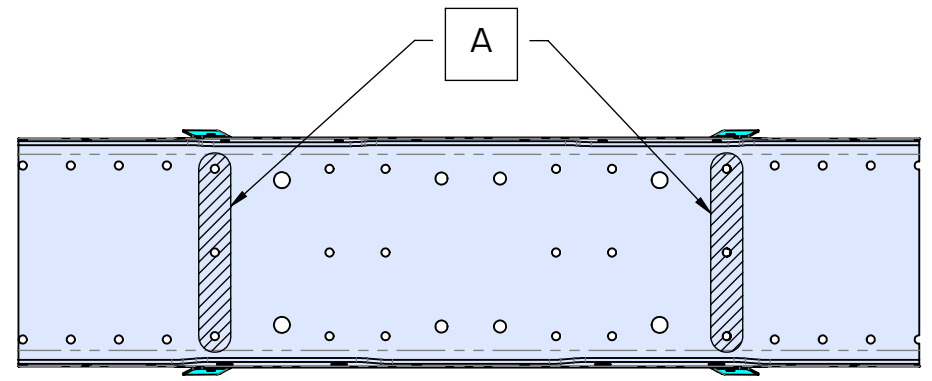
HS-15503 ASSEMBLY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
A2	HS-15501-001	REAR SPAR ASSM	1
A3	HS-15502-001	FRONT SPAR ASSM	1
6	HS-15006-001	RIB, INBD	2
26	AN426AD4-6	RIVET, SOLID COUNTERSUNK	6

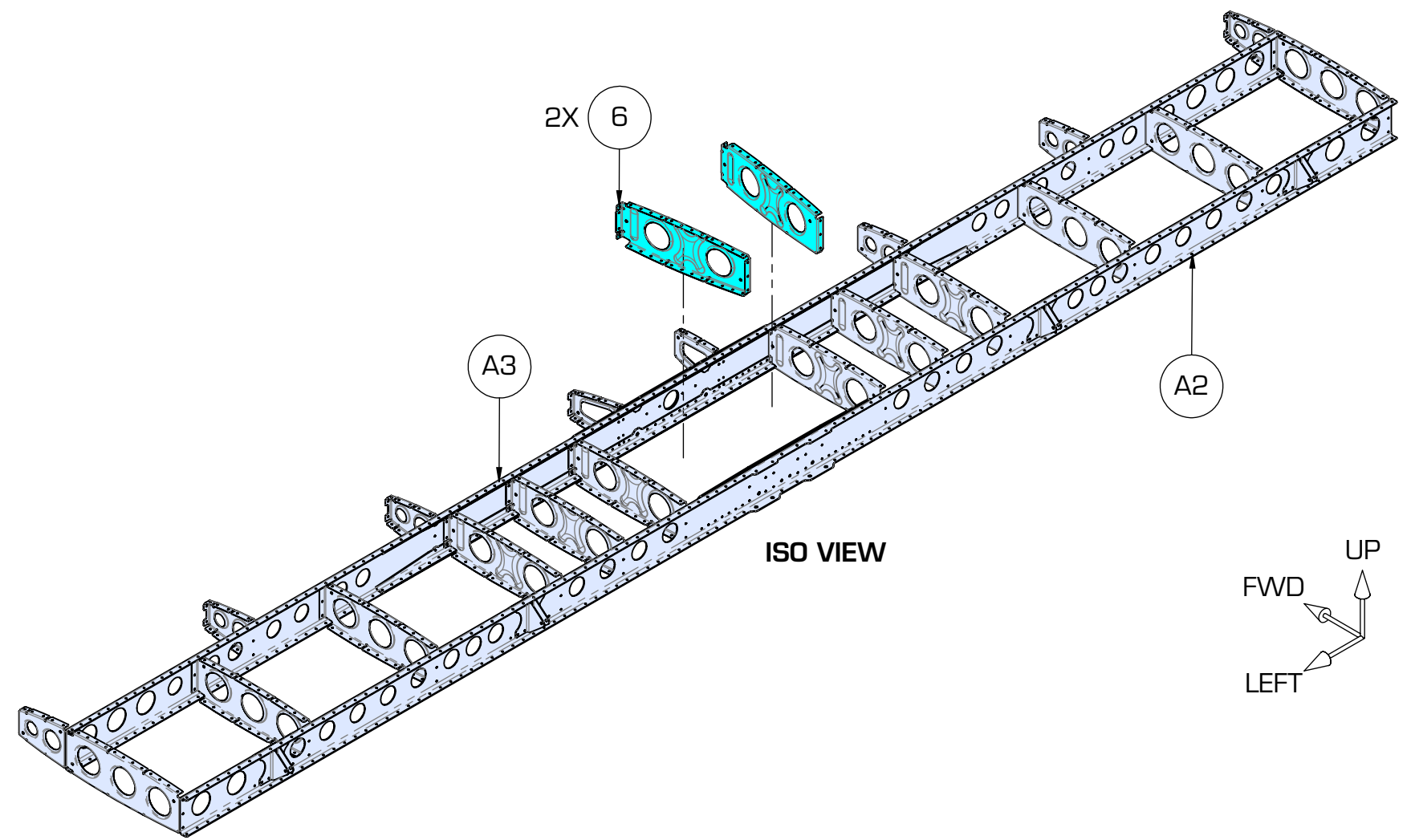
Step 1: Bend forward and aft flanges on (6) to match the angle of attachment to (A2) and (A3)

Step 2: Cleco each (6) to (A2) and (A3)

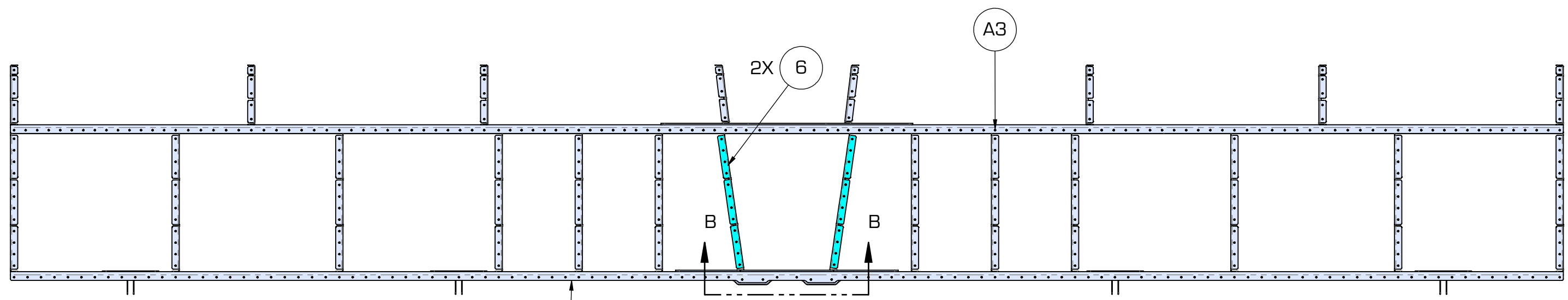
Step 3: Rivet each (6) to (A2) with (26) in (A)



SECTION B-B



ISO VIEW



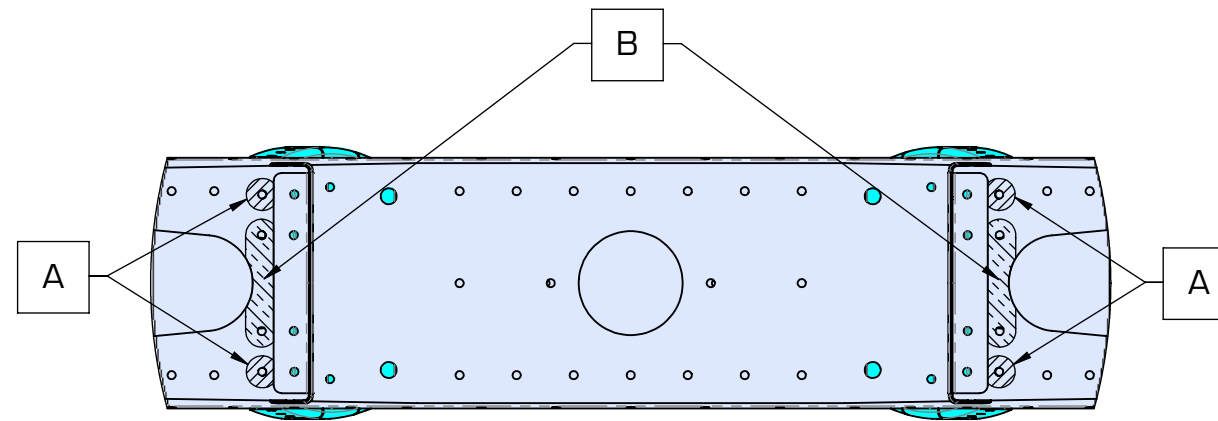
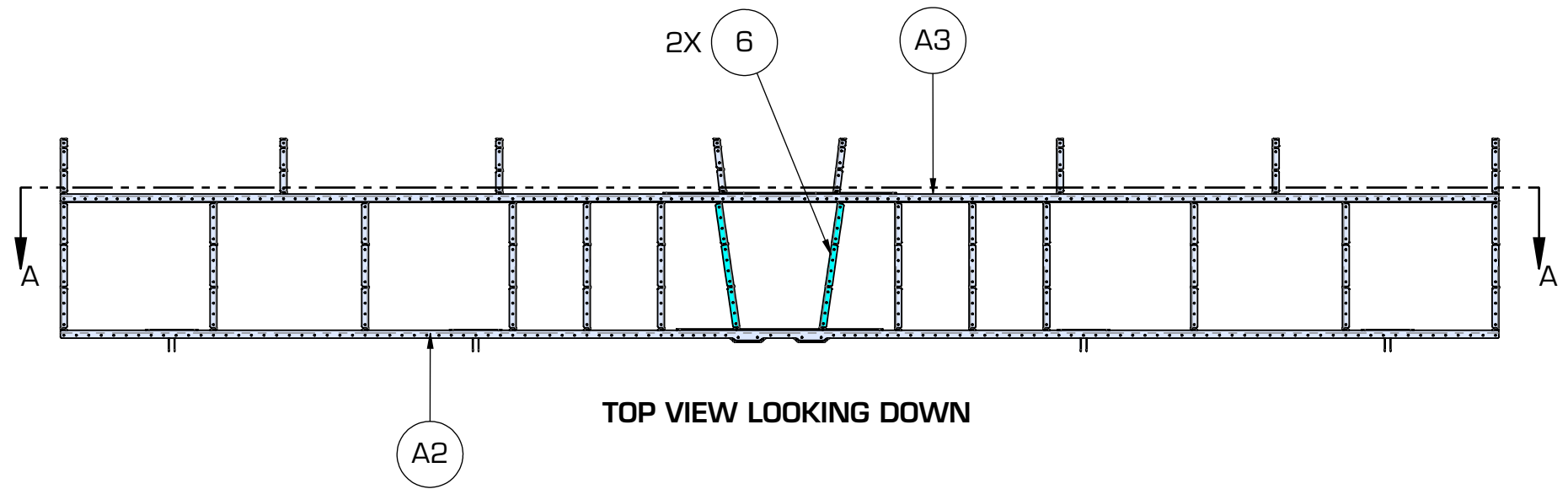
TOP VIEW LOOKING DOWN

HS-15503 ASSEMBLY

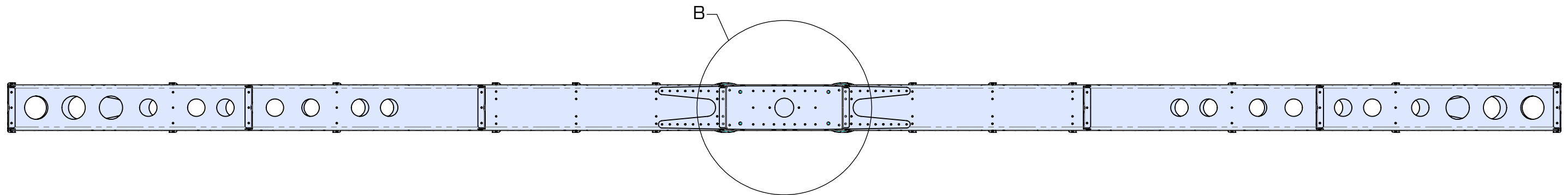
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
A2	HS-15501-001	REAR SPAR ASSM	1
A3	HS-15502-001	FRONT SPAR ASSM	1
6	HS-15006-001	RIB, INBD	2
30	AN470AD4-6.5	RIVET, SOLID UNIVERSAL	4
32	AN470AD4-8	RIVET, SOLID UNIVERSAL	4

Step 1: Rivet each (6) to (A3) with (32) in (A)

Step 2: Rivet each (6) to (A3) with (30) in (B)

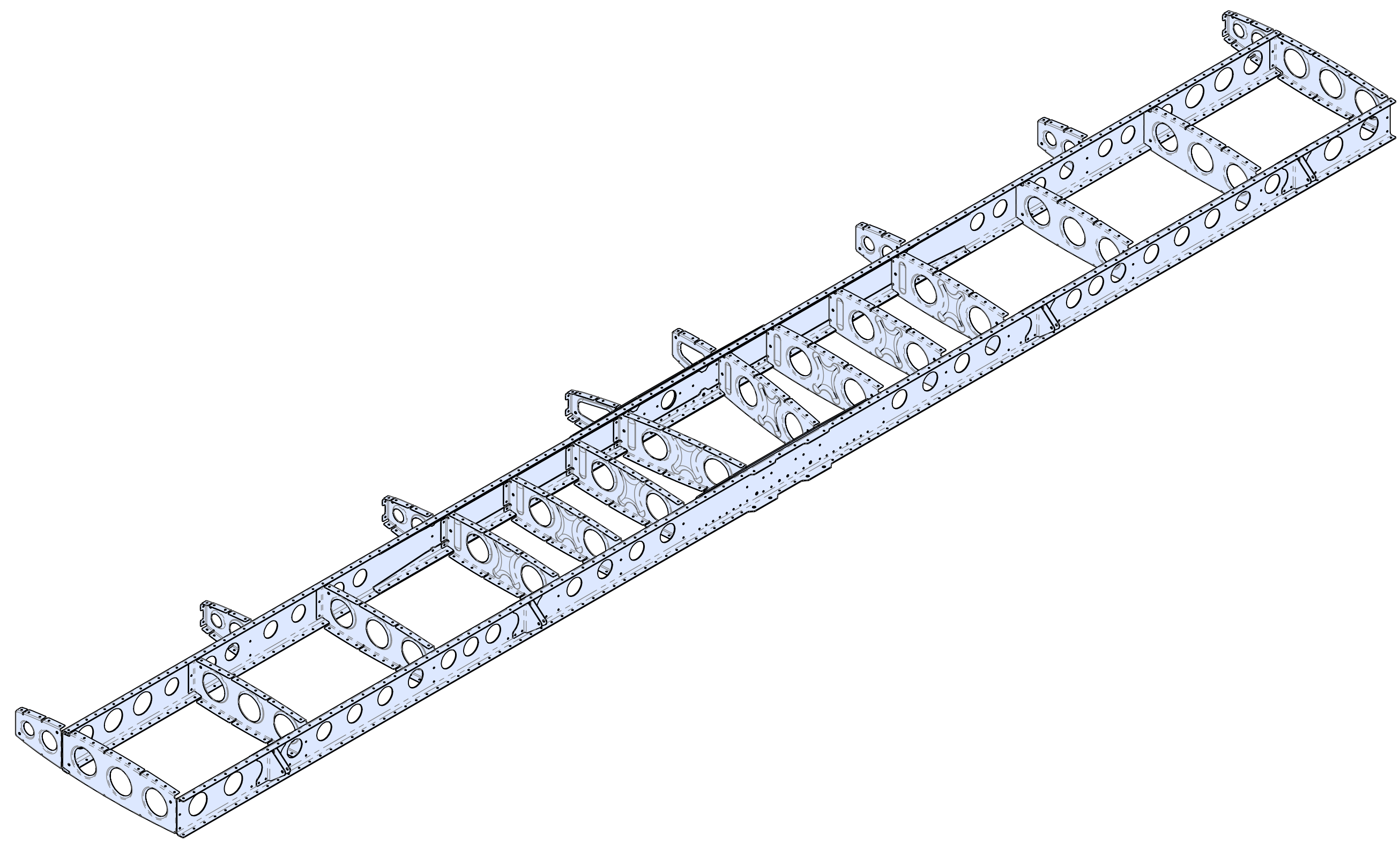


DETAIL B



SECTION A-A

HS-15503 ASSEMBLY



HS-15503 ASSEMBLY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
A4	HS-15503-001	H-STAB FRAME ASSM	1
18	HS-15017-001	ATTACH BRKT, FRONT SPAR	2
23	AN4-6A	BOLT	4
37	MS21042-4	METAL LOCK NUT, 1/4-28	4
40	NAS1149FO432P	WASHER, 1/4" THIN FLAT	8

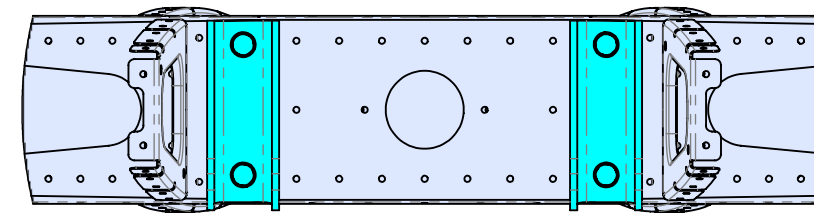
NOTE: See Page 7, Part Preparation Step 5, before installing (18)

NOTE: Ensure (A4) is oriented with 1/4" holes down.

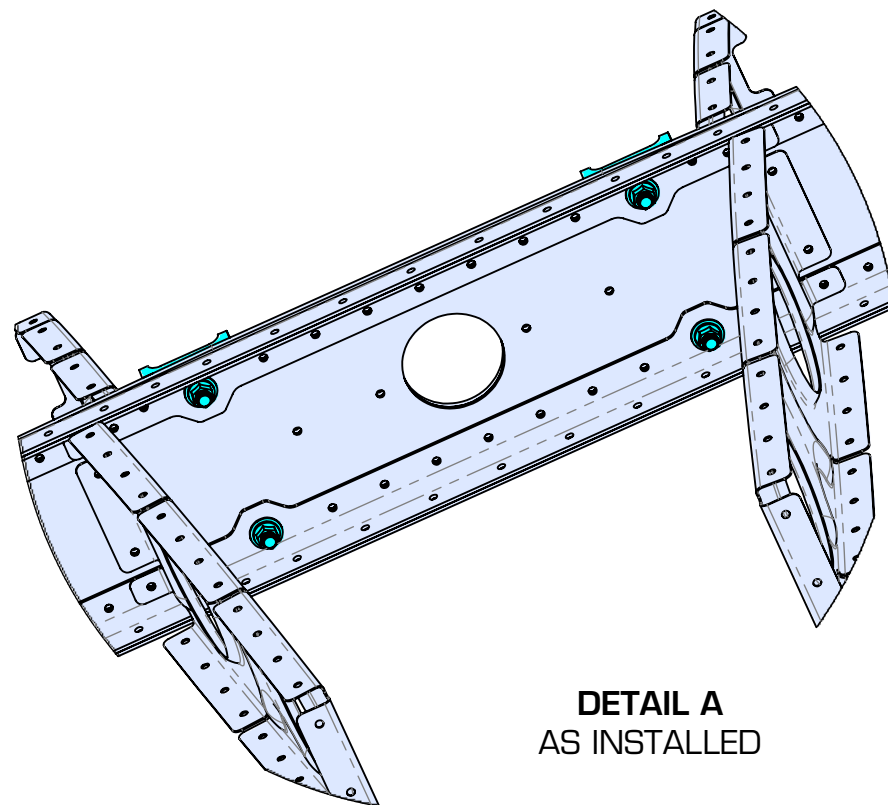
Step 1: Fasten each (18) to (A4) in this order:

(23) (40) (18) (A4) (40) (37) two times.

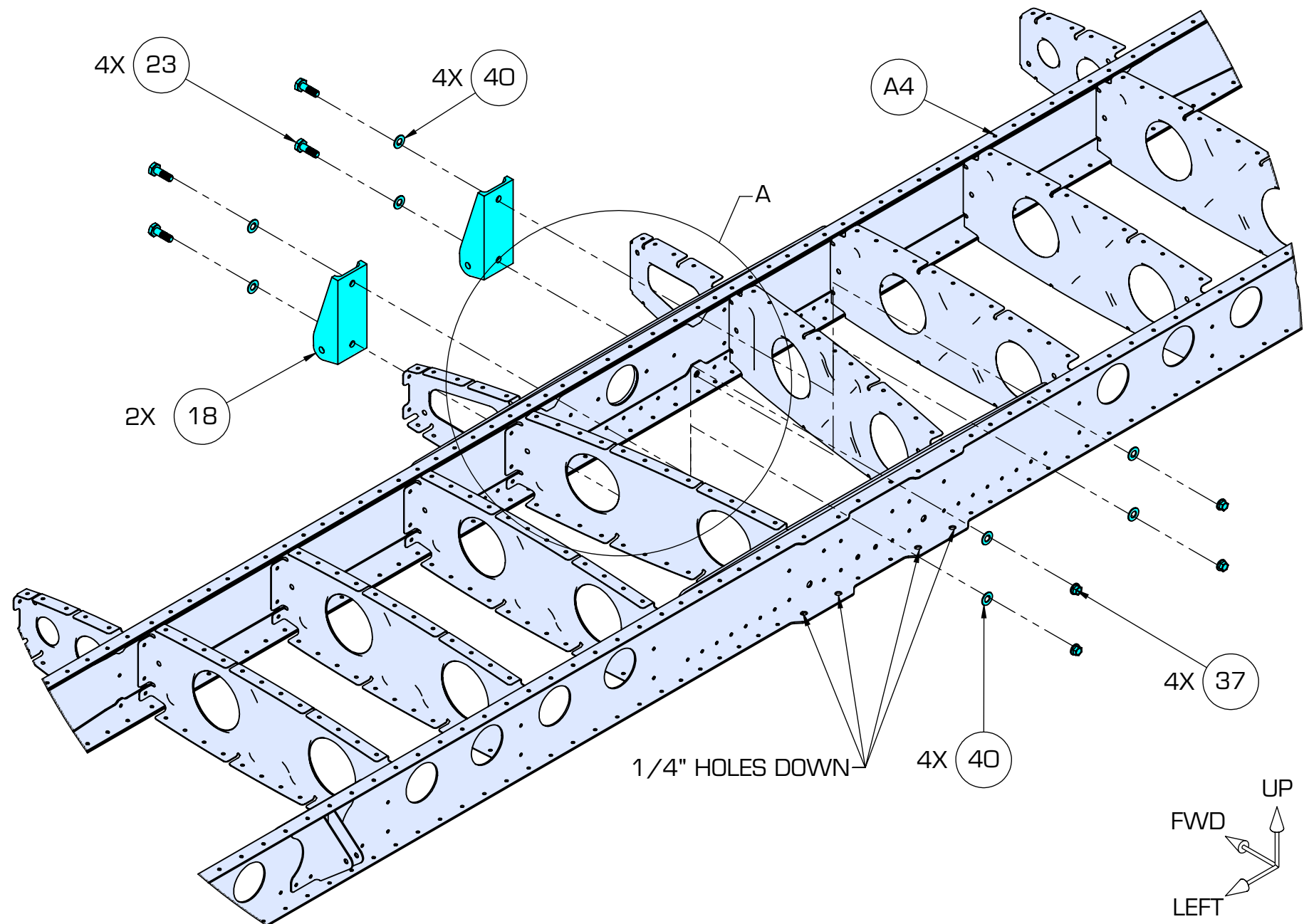
Step 2: Torque and Mark each (37) with stripe of Torque Seal.



FORWARD VIEW LOOKING AFT
AS INSTALLED



DETAIL A
AS INSTALLED



HS-15504 ASSEMBLY

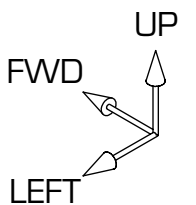
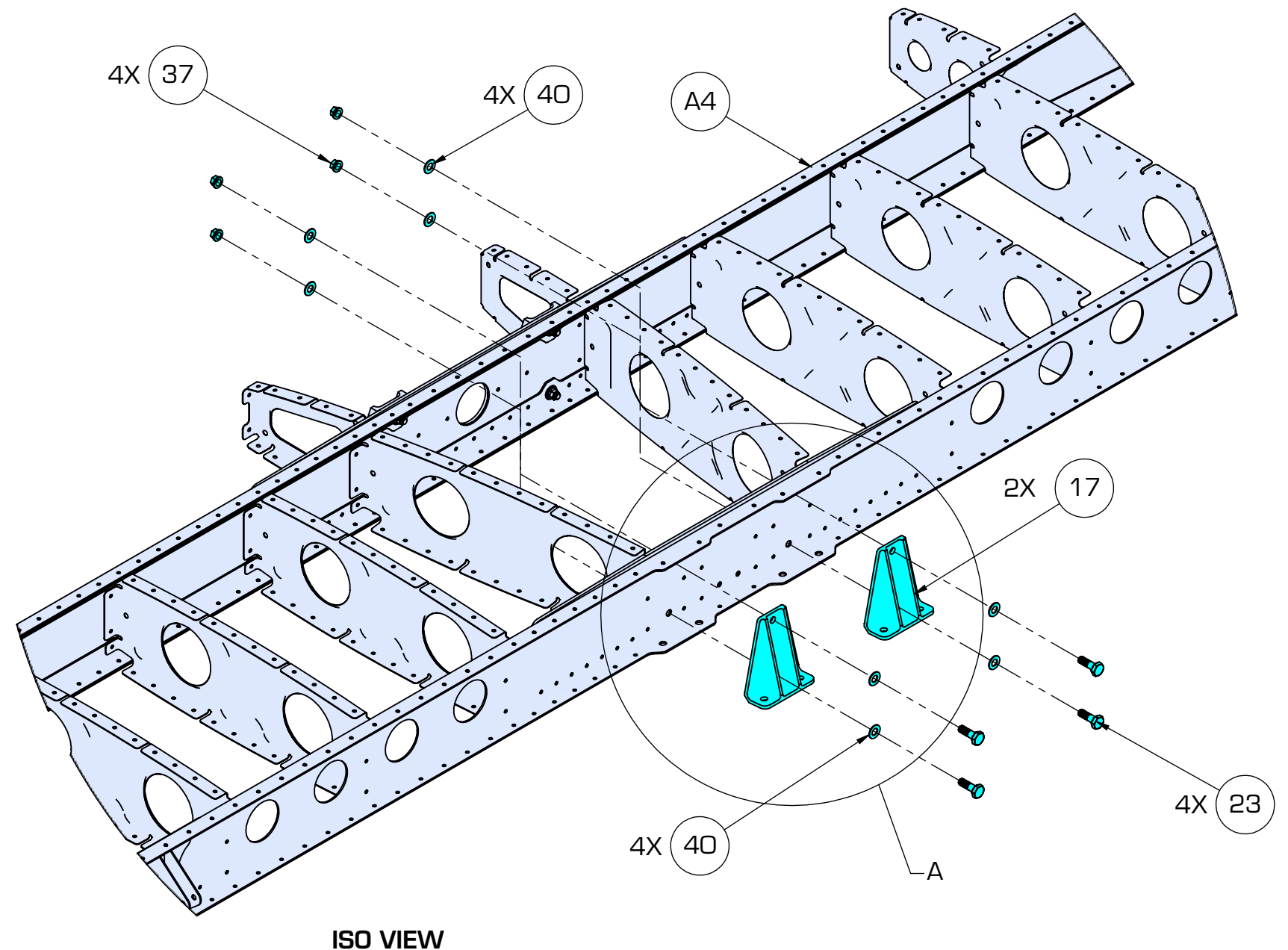
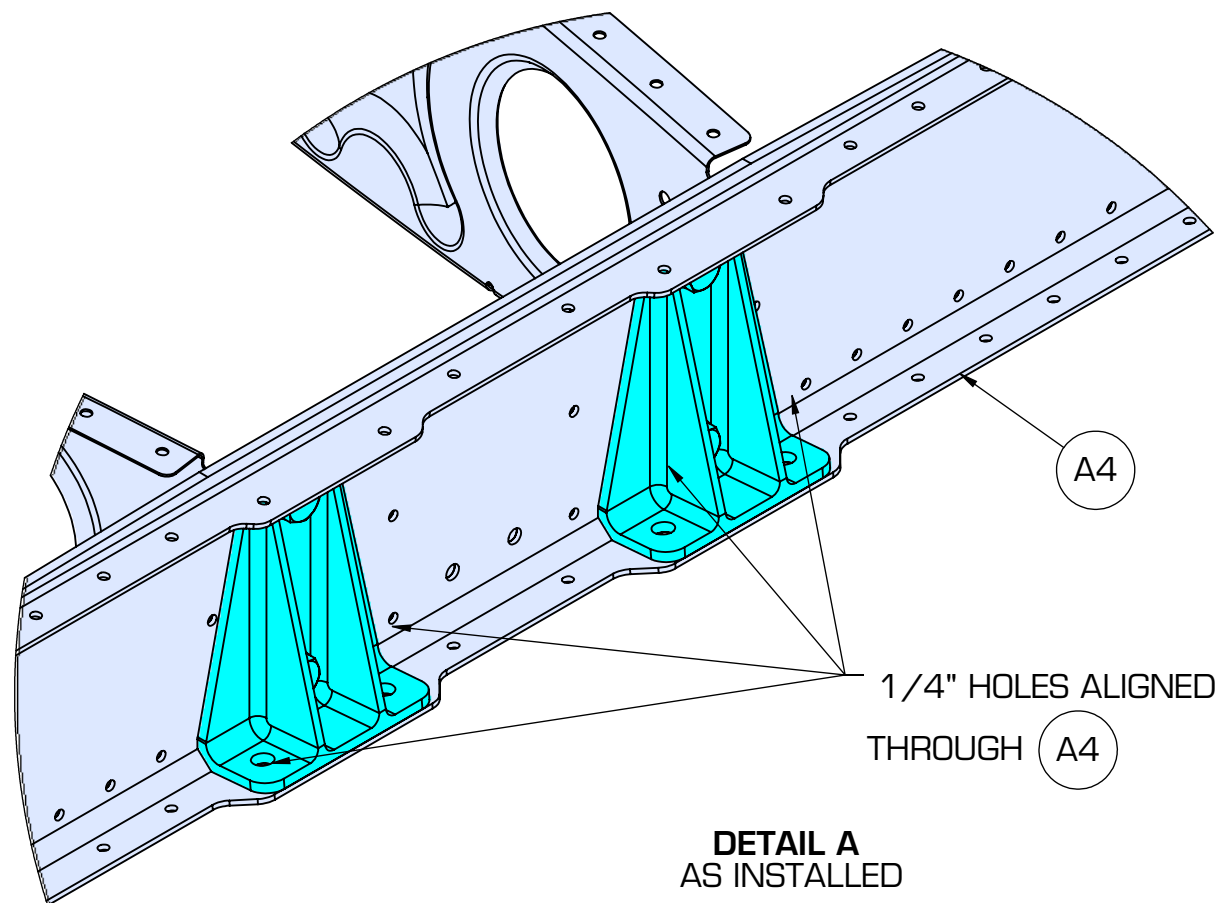
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
A4	HS-15503-001	H-STAB FRAME ASSM	1
17	HS-15016B-001	HINGE BRKT, UPPER AFT SPAR	2
23	AN4-6A	BOLT	4
37	MS21042-4	METAL LOCK NUT, 1/4-28	4
40	NAS1149FO432P	WASHER, 1/4" THIN FLAT	8

NOTE: See Page 7, Part Preparation Step 5, before installing (17)

Step 1: Fasten each (17) to (A4) in this order:

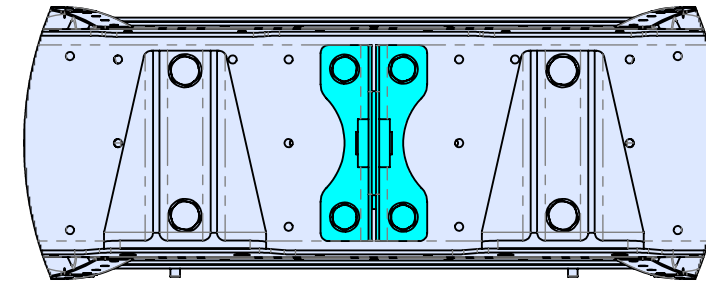
(23) (40) (17) (A4) (40) (37) two times.

Step 2: Torque and Mark each (37) with stripe of Torque Seal.



HS-15504 ASSEMBLY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
A1	HS-15500-001	HINGE ASSM	1
A4	HS-15503-001	H-STAB FRAME ASSM	1
21	AN3-5A	BOLT	4
36	MS21042-3	METAL LOCK NUT, 10-32	4
38	NAS1149FO332P	WASHER, 3/16" THIN FLAT	8

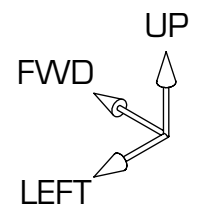
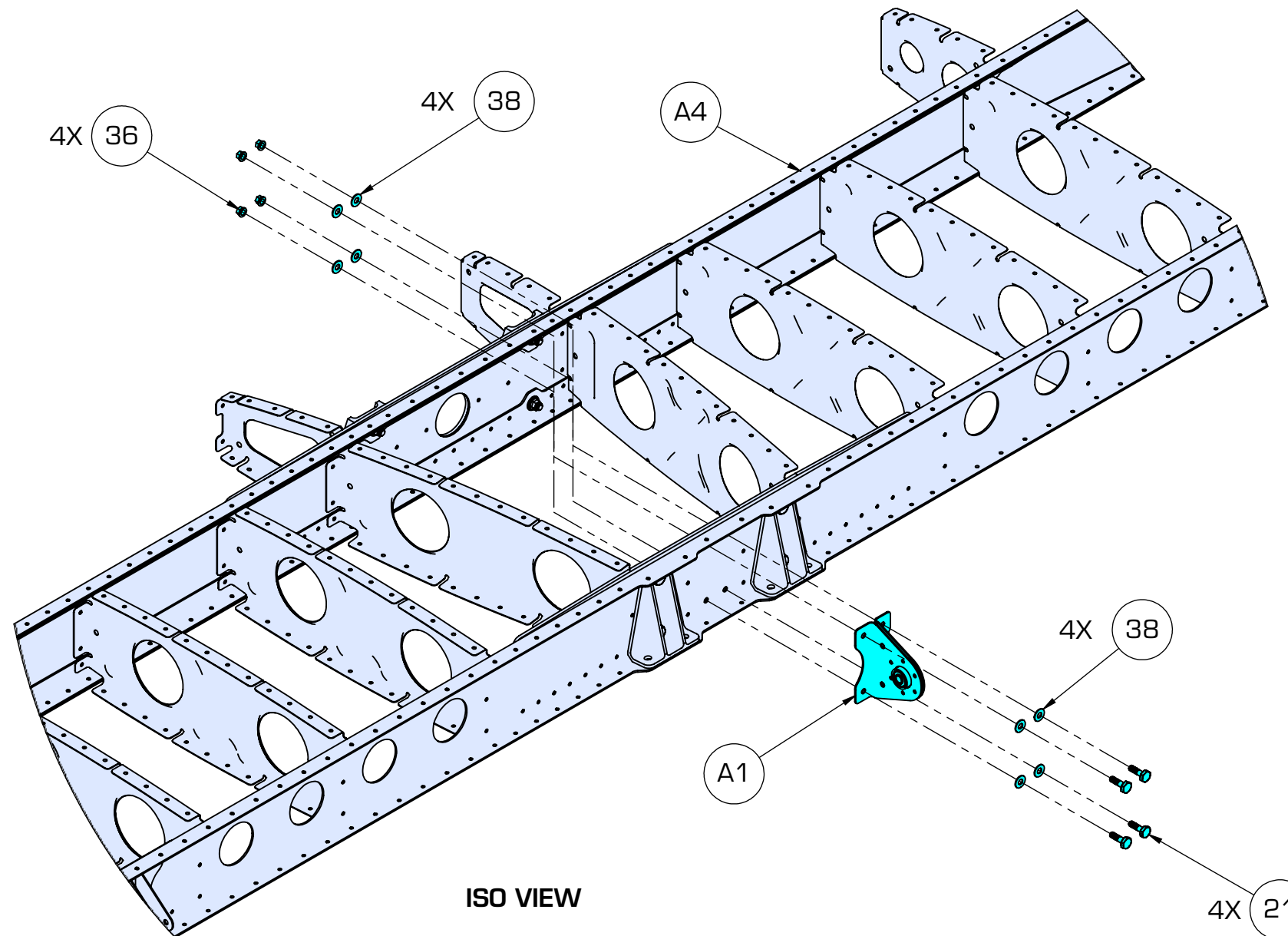


**AFT VIEW LOOKING FORWARD
AS INSTALLED**

Step 1: Fasten (A1) to (A4) in this order:

(21) (38) (A1) (A4) (38) (36) four times.

Step 2: Torque and Mark each (36) with stripe of Torque Seal.



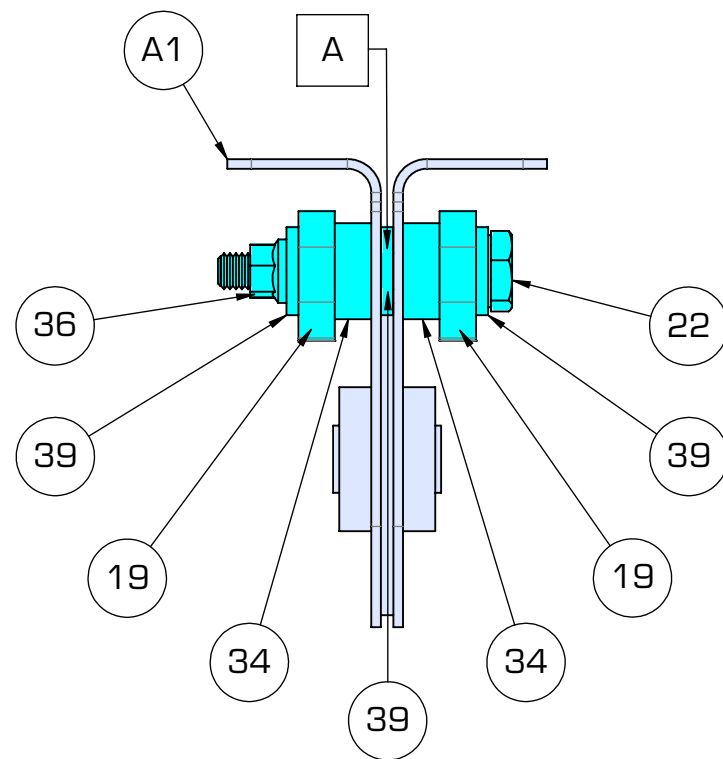
HS-15504 ASSEMBLY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
A1	HS-15500-001	HINGE ASSM	1
A4	HS-15503-001	H-STAB FRAME ASSM	1
19	HS-15018-001	STOP, ELEVATOR	2
22	AN3-13A	BOLT	2
34	BUSH-AL. 189X.500X.190	ALUMINUM BUSHING	4
36	MS21042-3	METAL LOCK NUT, 10-32	2
39	NAS1149FO363P	WASHER, 3/16" FLAT	6

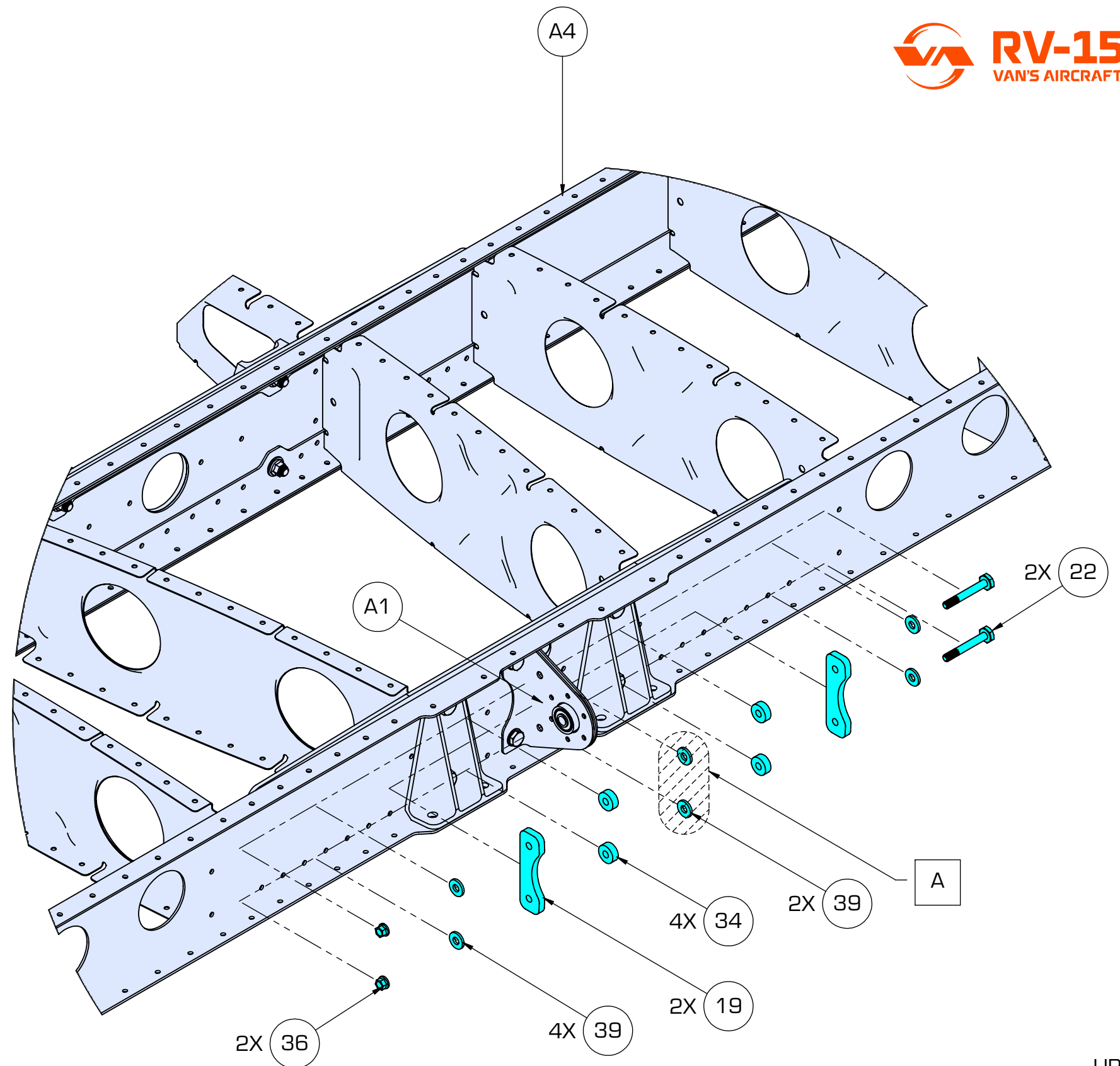
NOTE: Two (39) designated A are inserted between flanges of (A1)
 A Washer Wrench eases installation.

Step 1: Fasten each (19) to (A1) in this order:
 (22) (39) (19) (34) (A1) (39) (A1) (34) (19) (39) (36) two times.

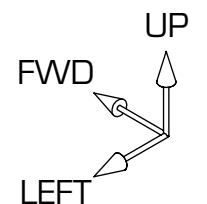
Step 2: Torque and Mark each (36) with stripe of Torque Seal.



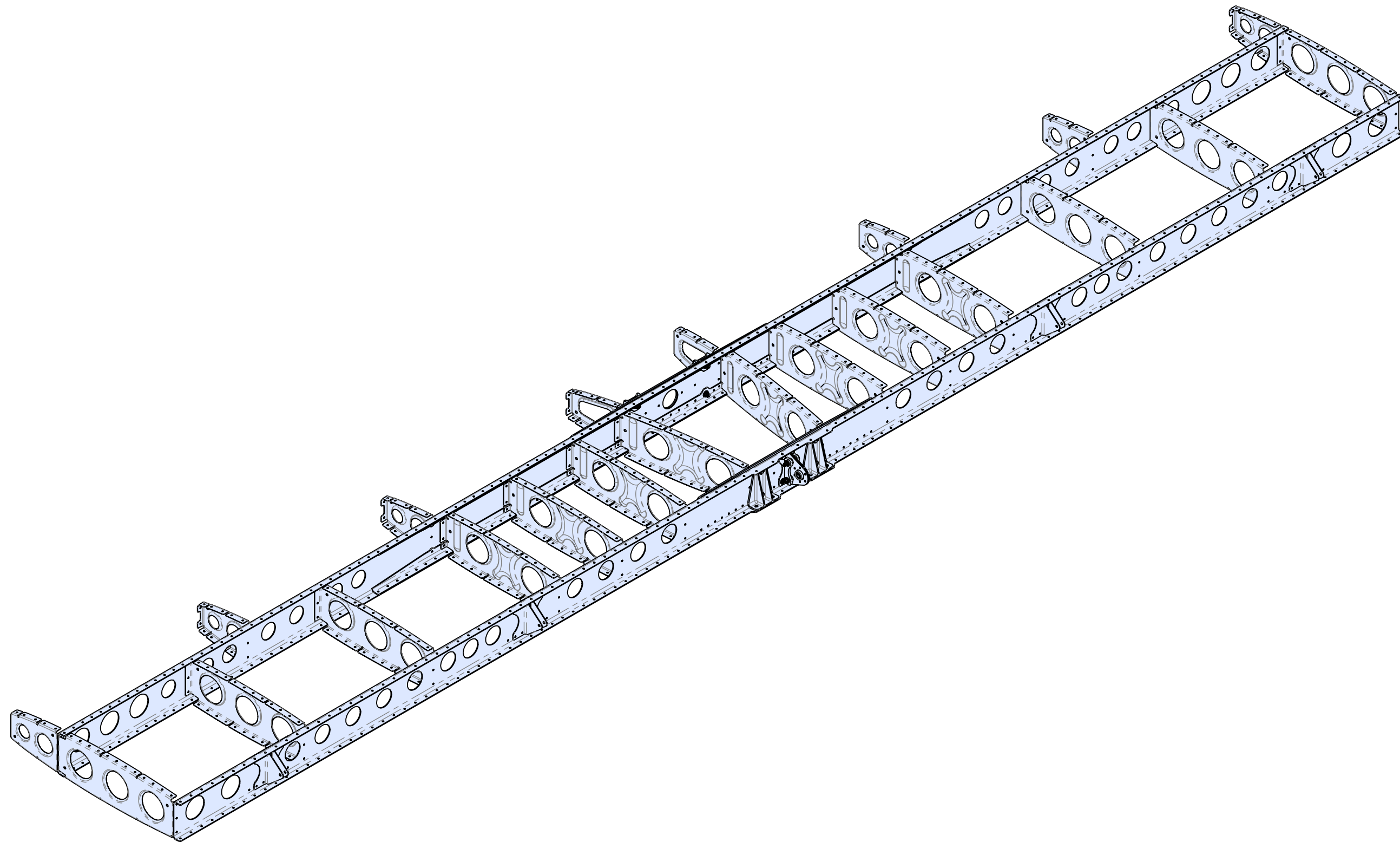
TOP VIEW LOOKING DOWN



ISO VIEW



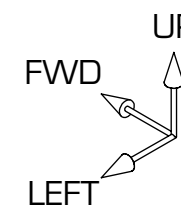
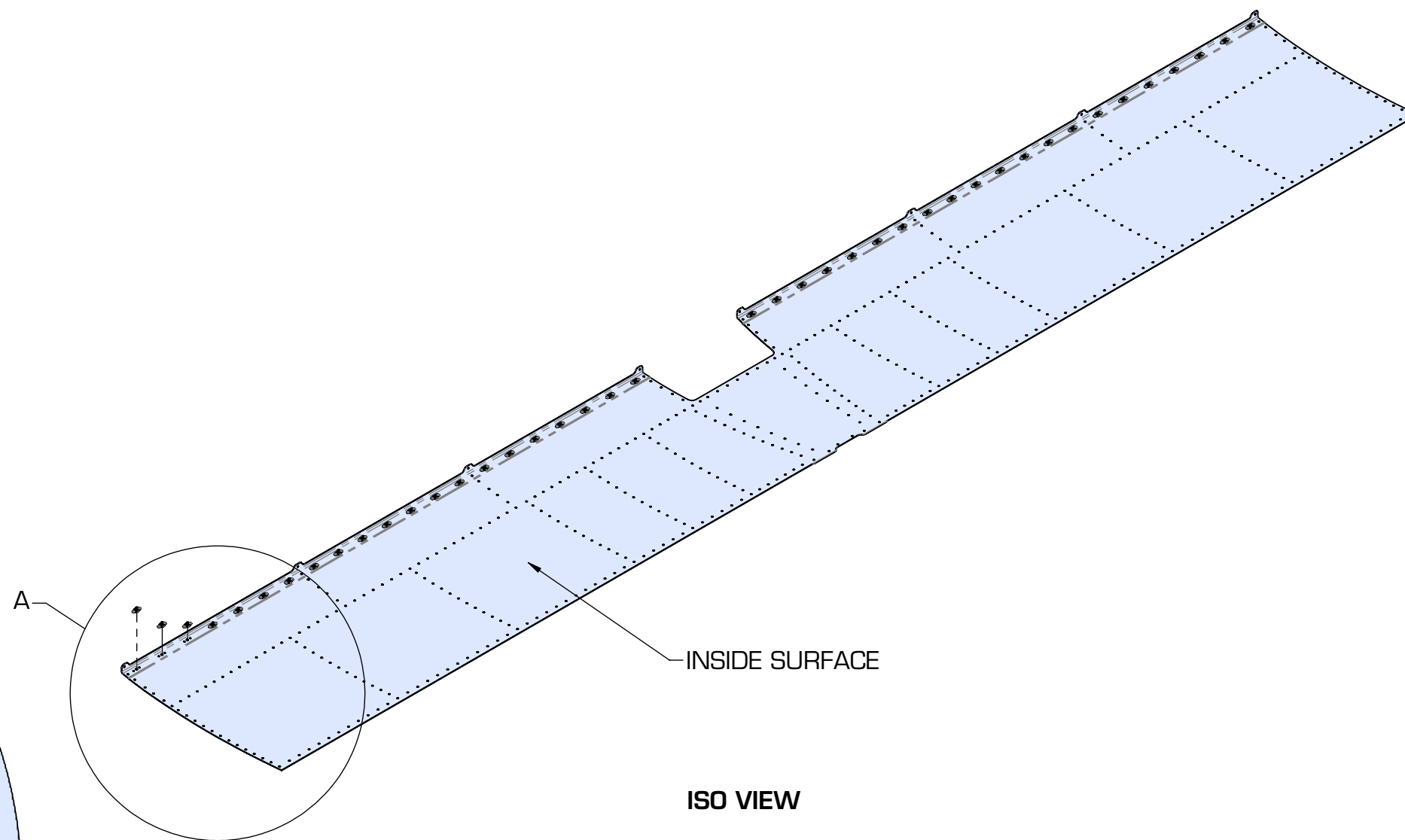
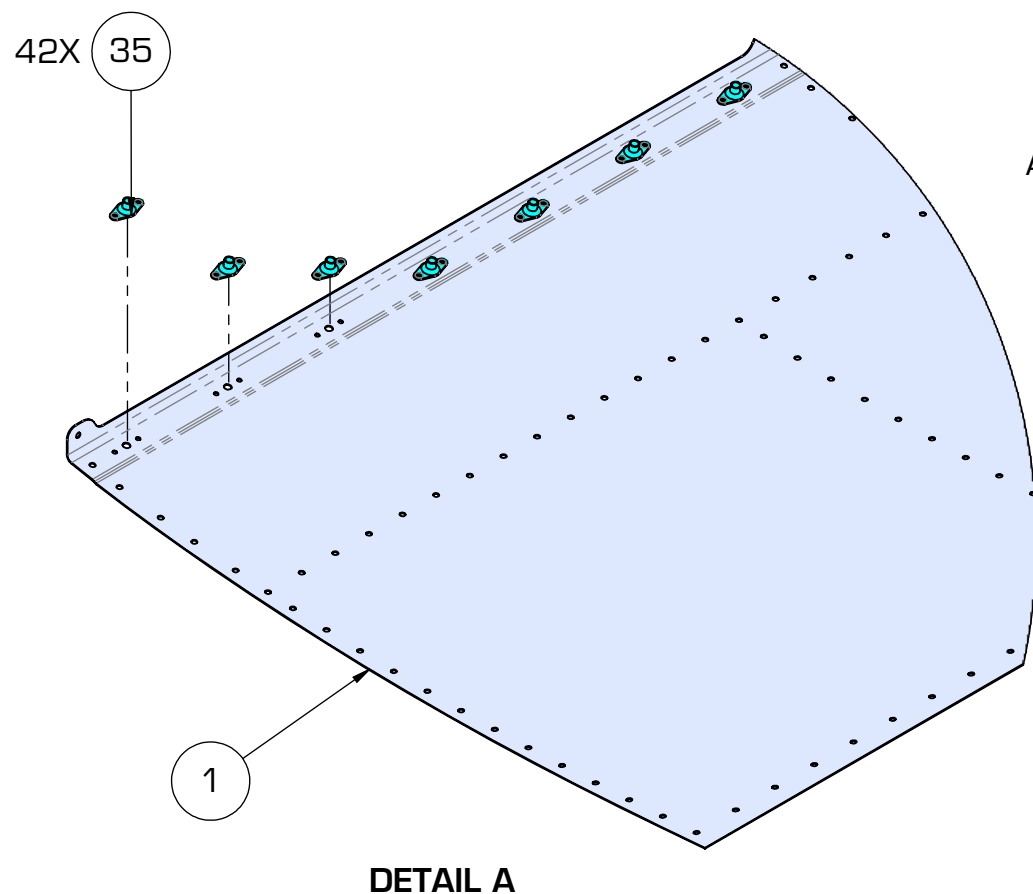
HS-15504 ASSEMBLY



HS-15504 ASSEMBLY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	HS-15001-001	SKIN, MAIN	2
25	AN426AD3-3	RIVET, SOLID COUNTERSUNK	168
35	K-1100-08D	NUTPLATE, 8-32 DIMPLED	84

- Step 1:** Cleco each (35) to Inside Surface of (1)
- Step 2:** Rivet each (35) to Inside Surface of (1) with (25)
- Step 3:** Repeat **Steps 1 and 2** for second (1)



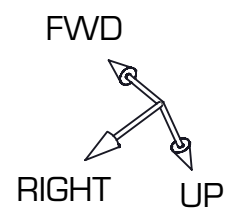
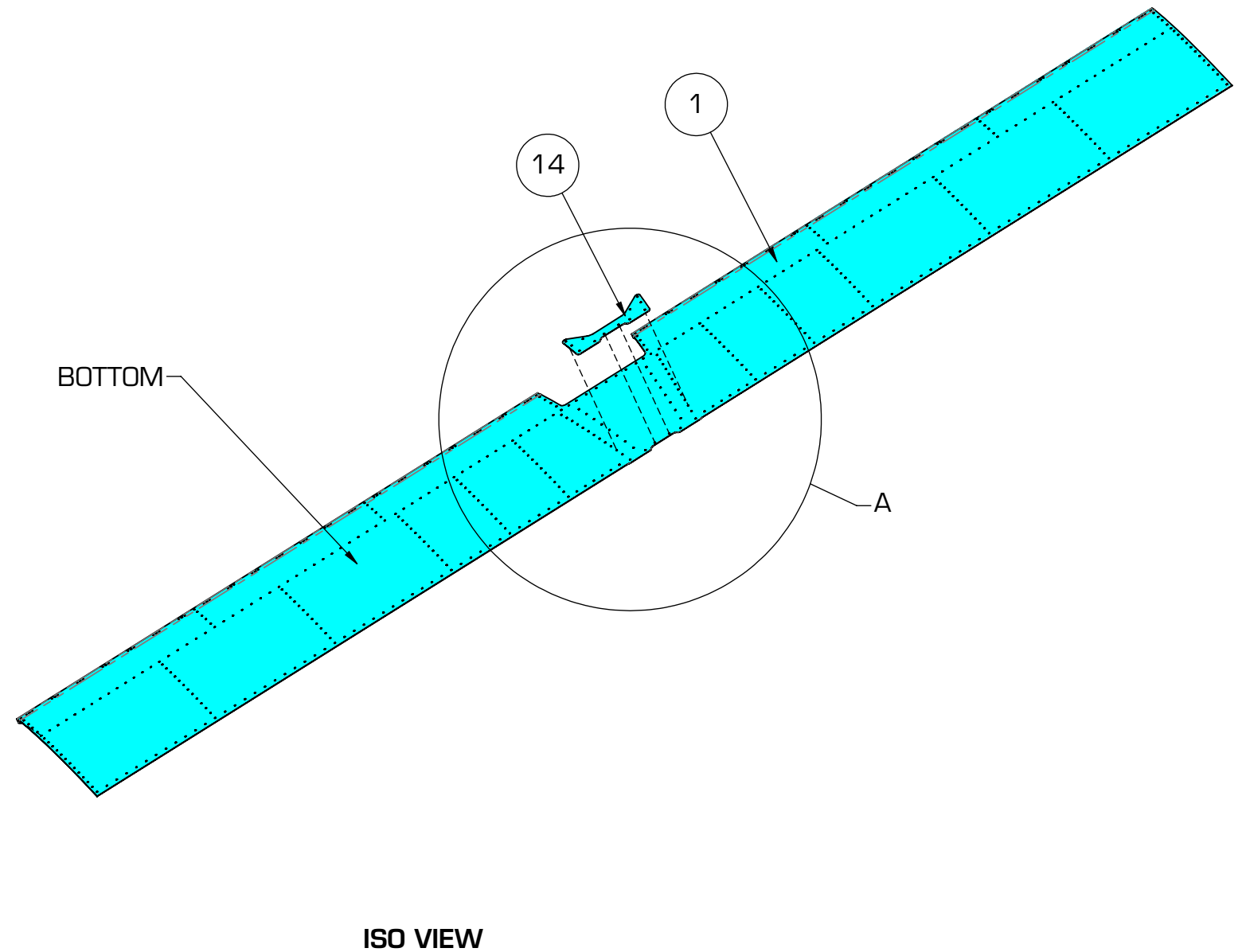
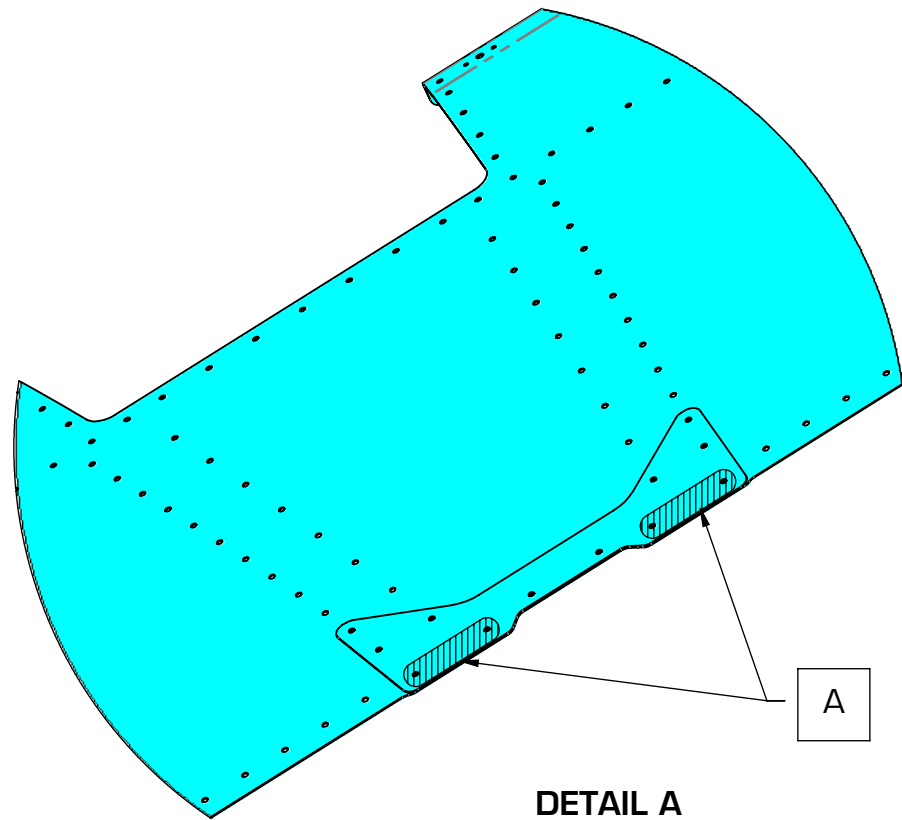
HS-15505 ASSEMBLY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	HS-15001-001	SKIN, MAIN	1
14	HS-15014-001	DOUBLER, AFT SKIN	1

NOTE: The following only performed on bottom (1)

Step 1: Cleco (14) to (1)

Step 2: 1/4" Final Drill, Clean, and Deburr (14) and (1) in A

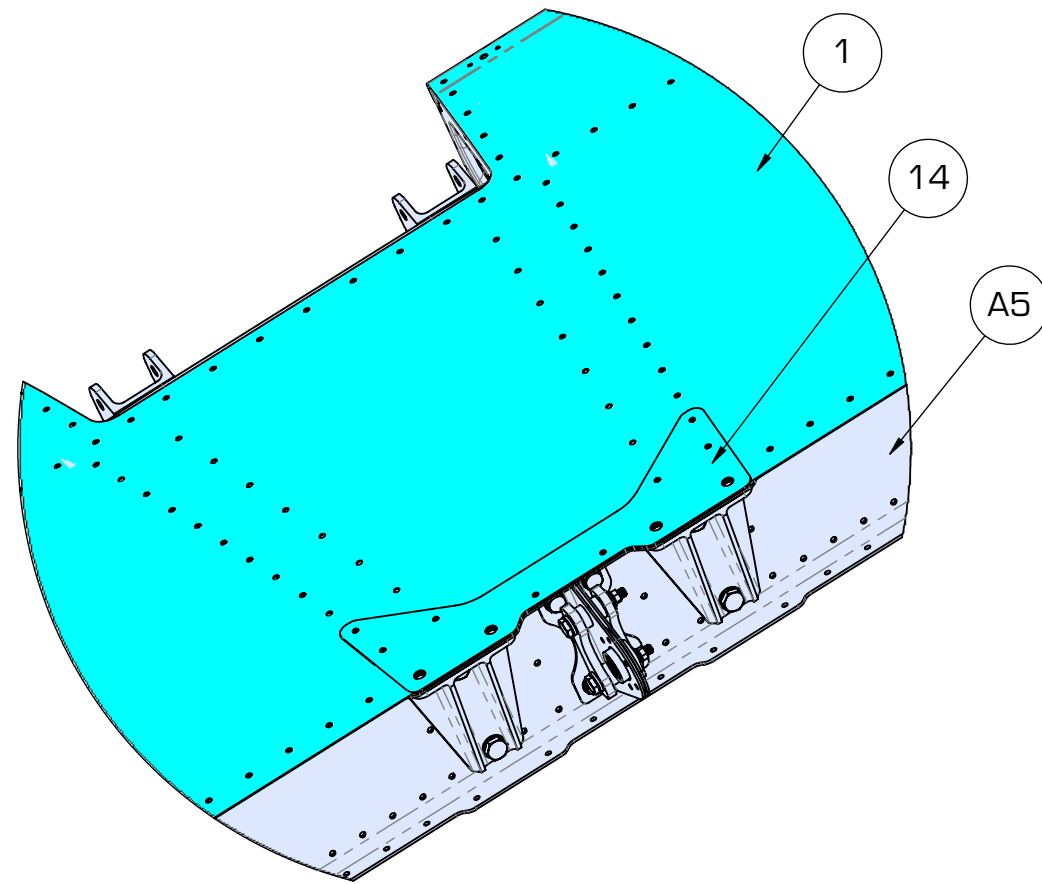


HS-15505 ASSEMBLY

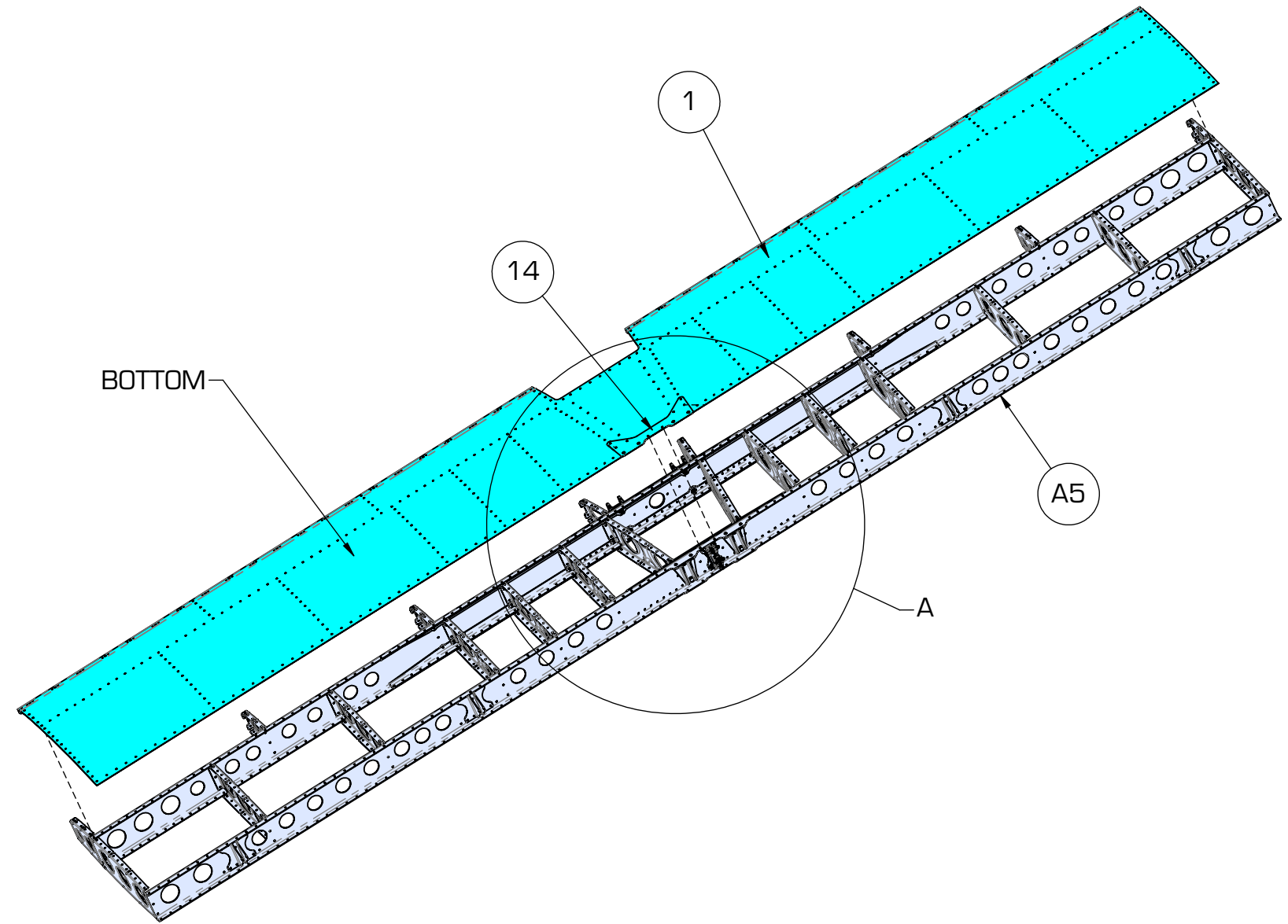
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
A5	HS-15504-001	H-STAB SPAR ATTACH ASSM	1
1	HS-15001-001	SKIN, MAIN	1
14	HS-15014-001	DOUBLER, AFT SKIN	1

NOTE: It is recommended to Cleco skins to spars first, then to ribs.

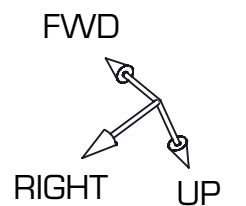
Step 1: Cleco (1) and (14) to Bottom of (A5)



DETAIL A
AS INSTALLED



ISO VIEW



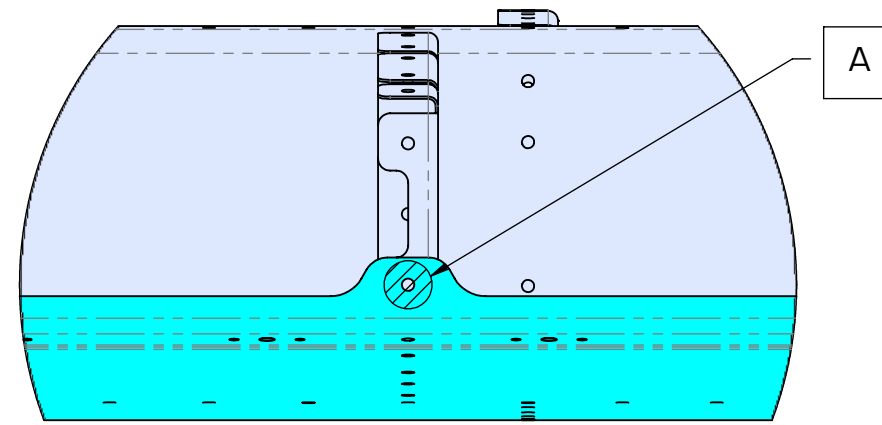
HS-15505 ASSEMBLY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
A5	HS-15504-001	H-STAB SPAR ATTACH ASSM	1
1	HS-15001-001	SKIN, MAIN	1
14	HS-15014-001	DOUBLER, AFT SKIN	1
42	RIVET CS4-4	RIVET, BLIND COUNTERSUNK	8
43	RIVET-LP4-3	RIVET, BLIND	453

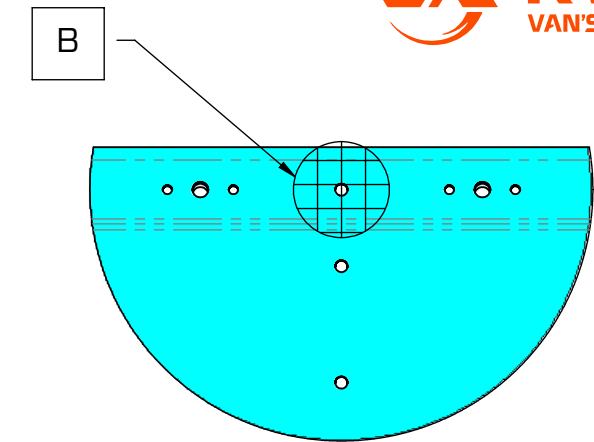
NOTE: It is recommended to Rivet skins to spars first, then to ribs.

Step 1: Rivet (14) and (1) to (A5) with (43) in (A)

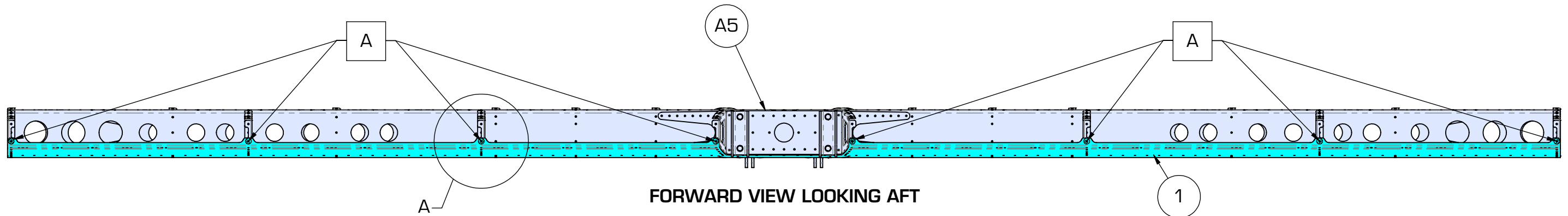
Step 2: Rivet (1) to (A5) with (42) in (B)



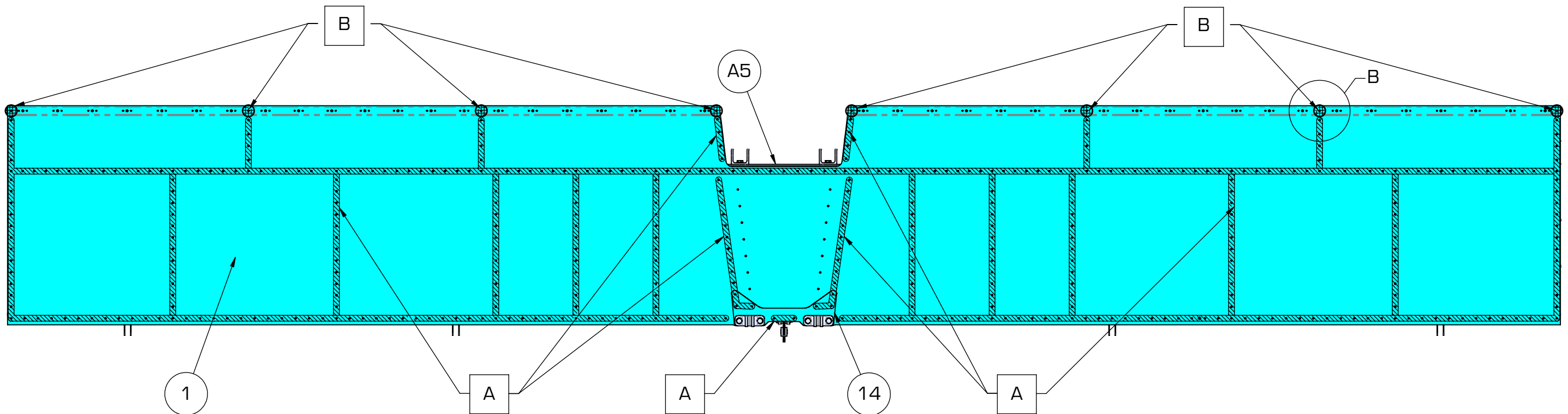
DETAIL A



DETAIL B



FORWARD VIEW LOOKING AFT



BOTTOM VIEW LOOKING UP

HS-15505 ASSEMBLY

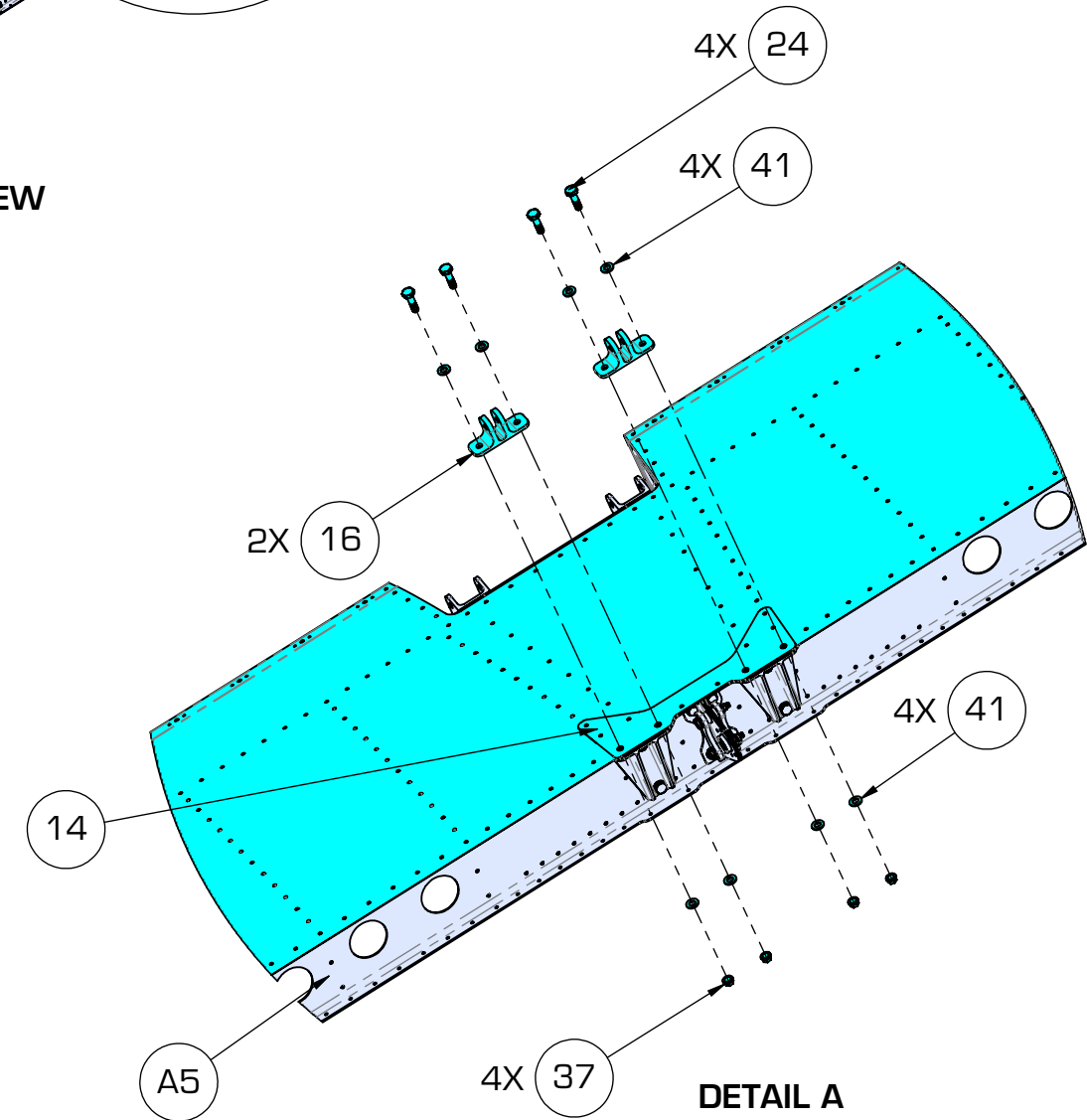
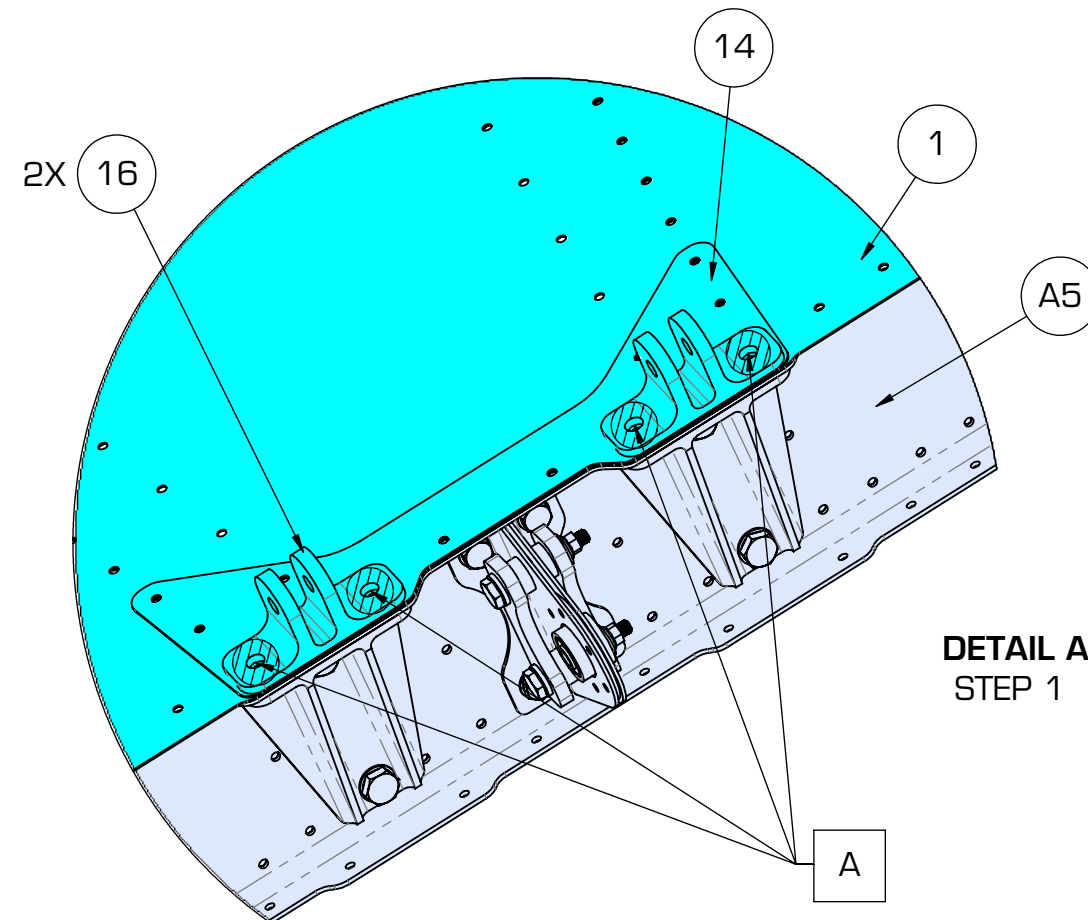
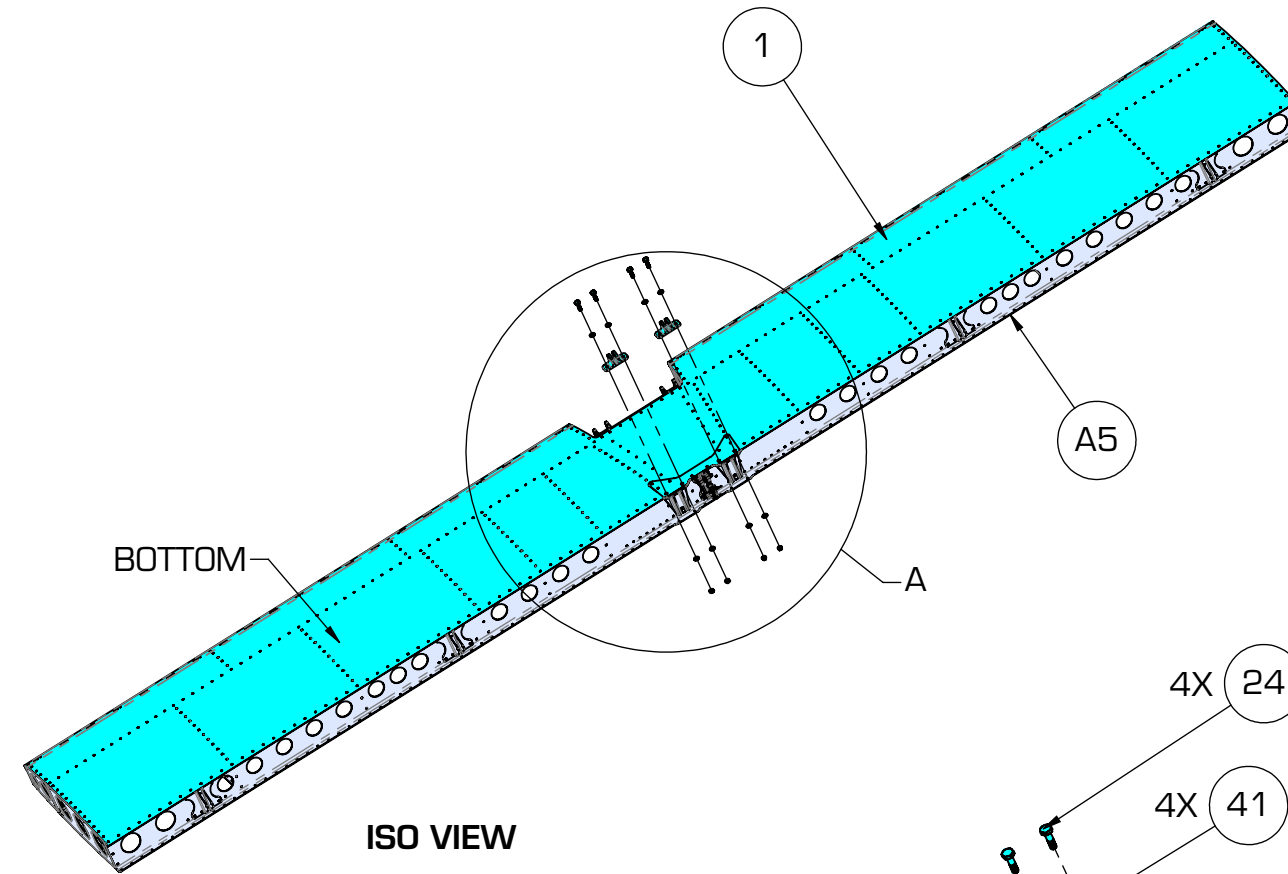
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
A5	HS-15504-001	H-STAB SPAR ATTACH ASSM	1
1	HS-15001-001	SKIN, MAIN	1
14	HS-15014-001	DOUBLER, AFT SKIN	1
16	HS-15016A-001	HINGE BRKT, LOWER AFT SPAR	2
24	AN4-7A	BOLT	4
37	MS21042-4	METAL LOCK NUT, 1/4-28	4
41	NAS1149FO463P	WASHER, 1/4" FLAT	8

NOTE: See Page 7, Part Preparation Step 5, before installing (16)

Step 1: Fasten each (16) to (14) (A5) in this order:

(24) (41) (16) (14) (A5) (41) (37) two times.

Step 2: Torque and Mark each (37) with Torque Seal.



HS-15505 ASSEMBLY

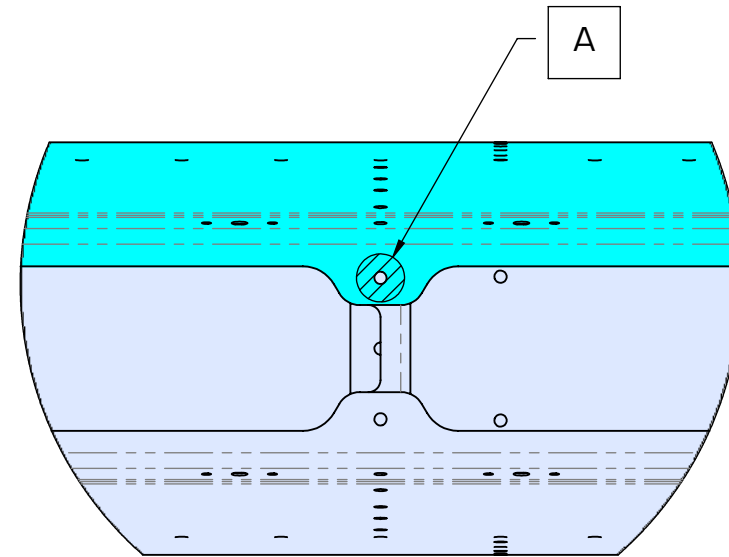
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
A5	HS-15504-001	H-STAB SPAR ATTACH ASSM	1
1	HS-15001-001	SKIN, MAIN	1
42	RIVET CS4-4	RIVET, BLIND COUNTERSUNK	8
43	RIVET-LP4-3	RIVET, BLIND	457

NOTE: It is recommended to Cleco and Rivet skins to spars first, then to ribs.

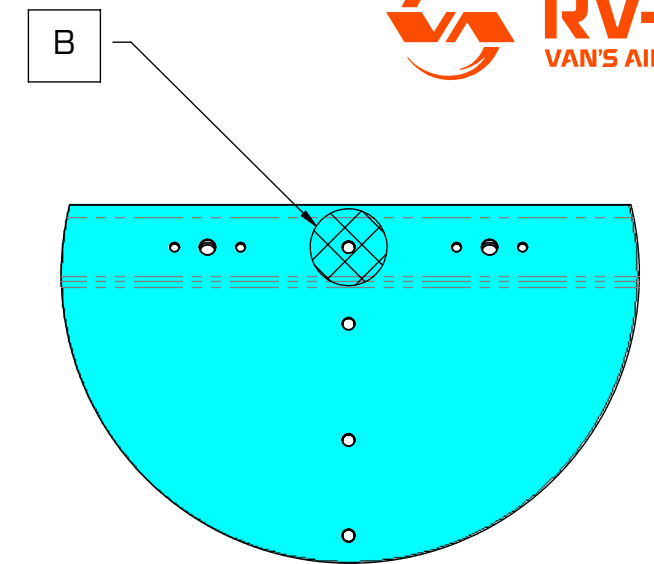
Step 1: Cleco (1) to (A5)

Step 2: Rivet (1) to (A5) with (43) in (A)

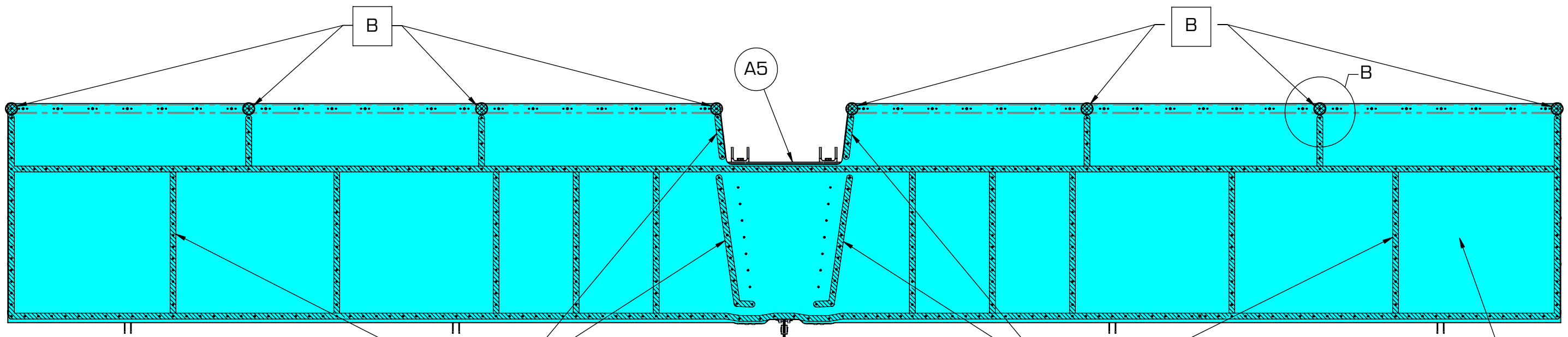
Step 3: Rivet (1) to (A5) with (42) in (B)



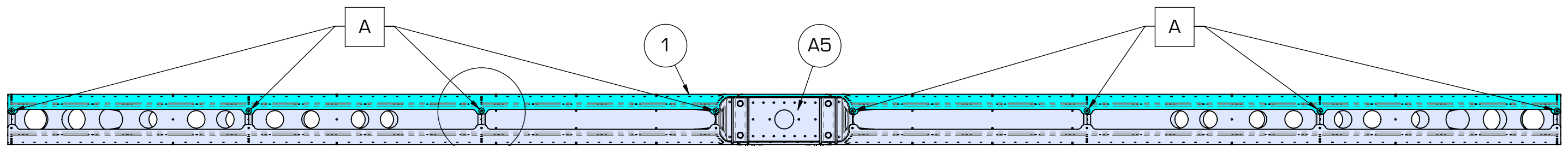
DETAIL A



DETAIL B



TOP VIEW LOOKING DOWN

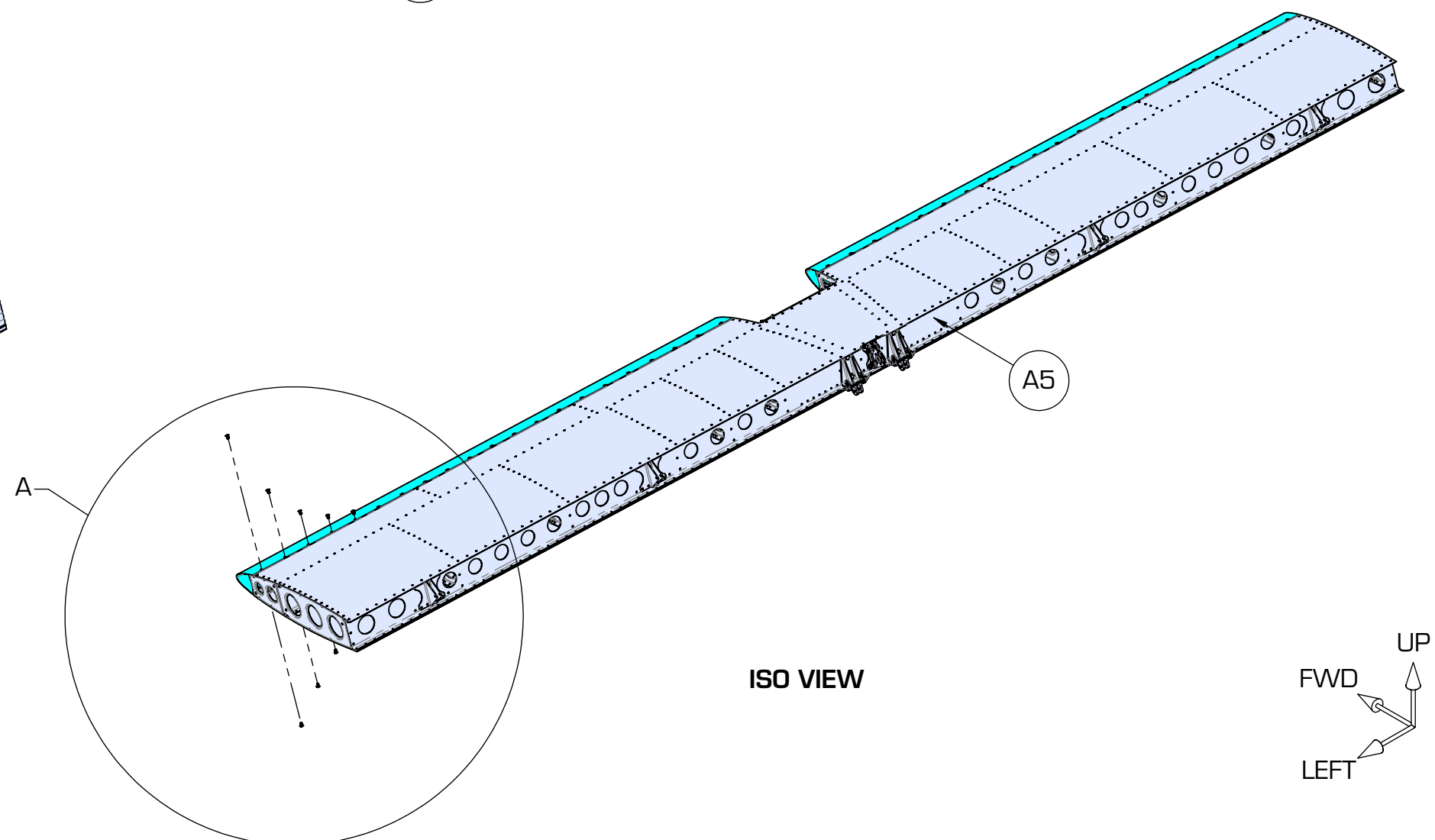
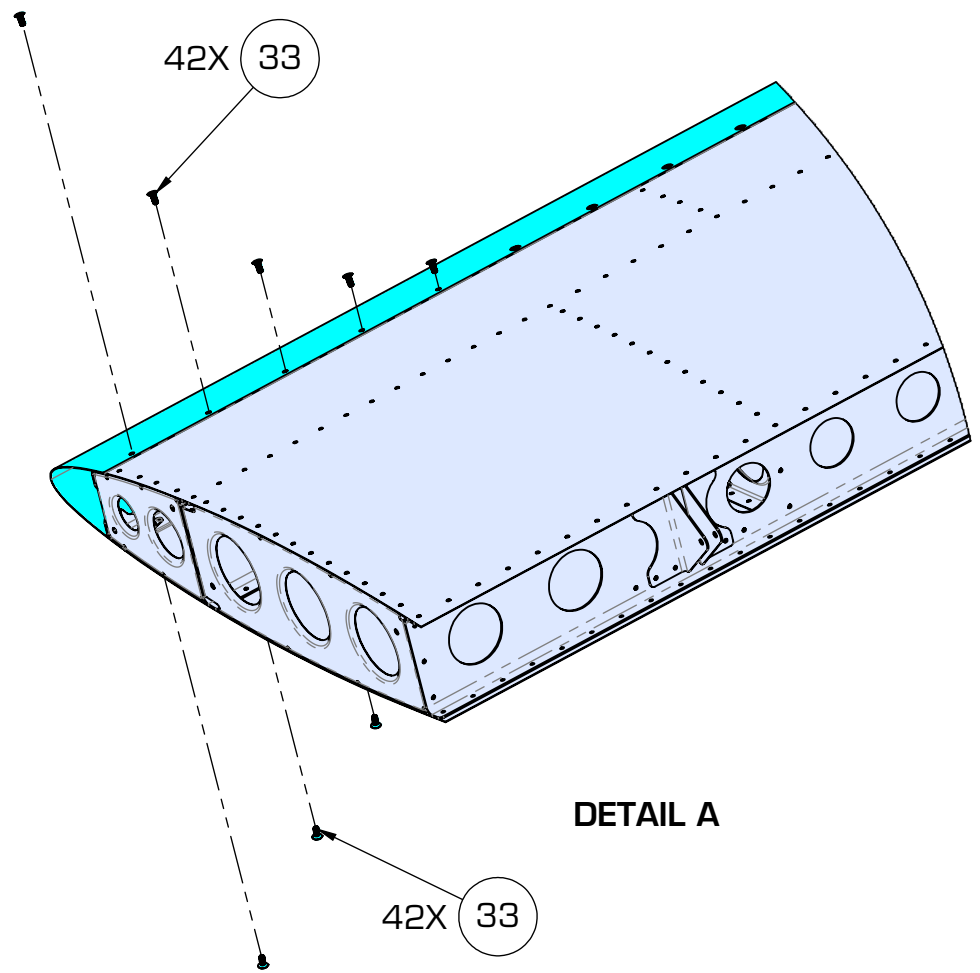
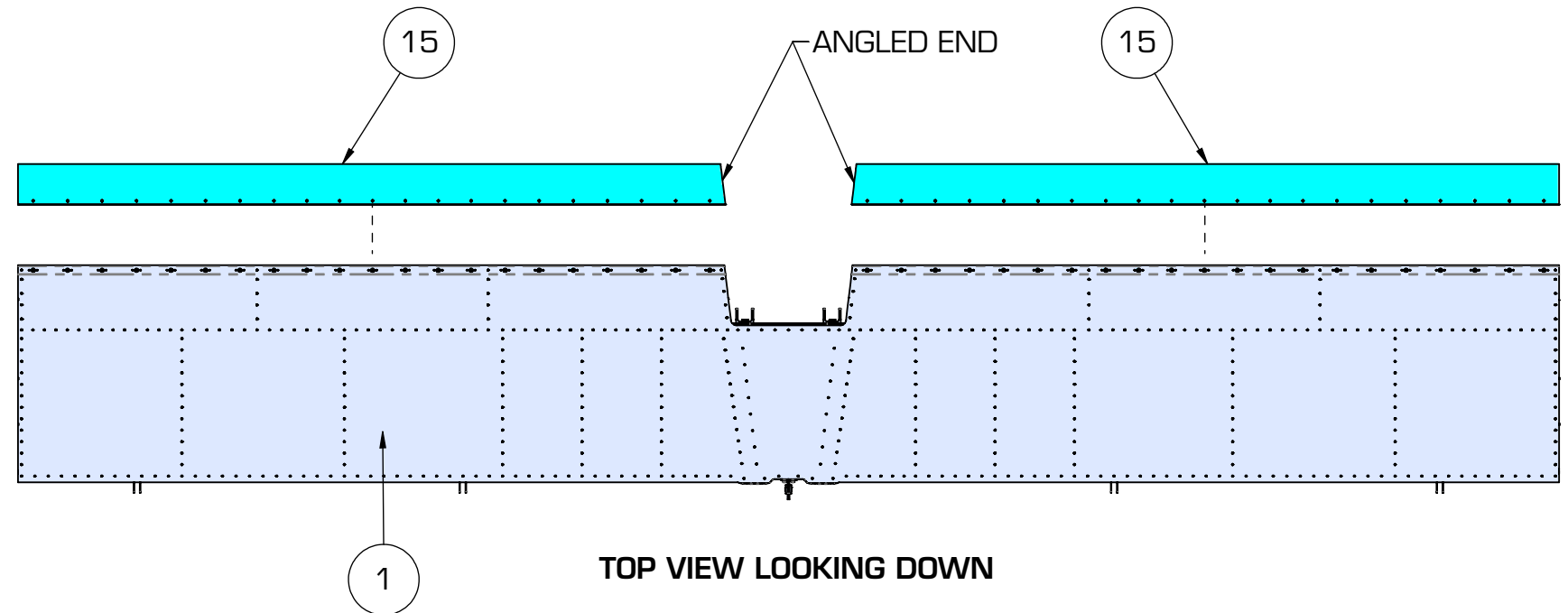


FORWARD VIEW LOOKING AFT

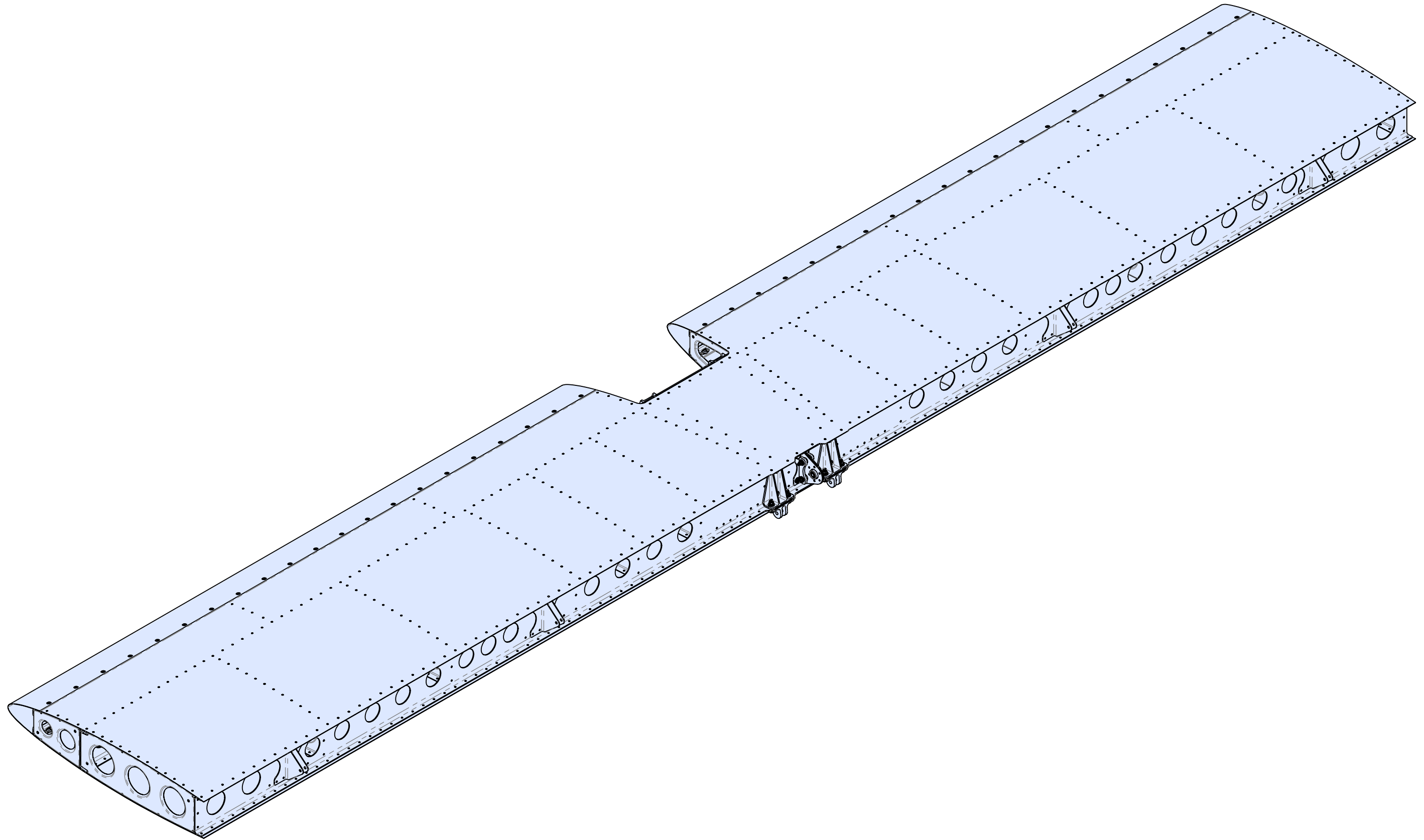
HS-15505 ASSEMBLY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
A5	HS-15504-001	H-STAB SPAR ATTACH ASSM	1
1	HS-15001-001	SKIN, MAIN	2
15	HS-15015-001	SKIN, L.E.	2
33	AN507C832R6	SCREW, FLAT COUNTERSUNK HEAD	84

- Step 1:** Break edges of each (15) for flush fit to Top and Bottom (1)
- Step 2:** Install each (15) onto Top and Bottom (1)
- Step 3:** Fasten each (15) to (1) with (33) on Top and Bottom Sides.



HS-15505 ASSEMBLY



HS-15505 ASSEMBLY



BUILDER 1 NAME _____ SIGNATURE _____ DATE _____
BUILDER 2 NAME _____ SIGNATURE _____ DATE _____
START DATE DATE _____
END DATE DATE _____
HOURS QTY _____
INSPECTED BY NAME _____ SIGNATURE _____ DATE _____

MODIFICATIONS _____
REPAIRS _____
ISSUES _____

NAME _____ SIGNATURE _____ DATE _____

HS-15505 ASSEMBLY