



PRODUCTION START DATE \_\_\_\_/\_\_\_\_/\_\_\_\_

MODEL:

# TANK PRODUCTION CYCLE

REV. 0

REFERENCE FIGURE

REV.

CHECKED

DATE \_\_\_\_/\_\_\_\_/\_\_\_\_

SIG.

PRODUCTION END DATE \_\_\_\_/\_\_\_\_/\_\_\_\_

APPROVED

DATE \_\_\_\_/\_\_\_\_/\_\_\_\_

SIG.

M	Step	Description	table	V		hours of work		Operator	
				R	L	R	L	R	L
	1	Countersink the holes of the web of the ribs outwards.	fig 1, 2						
	2	Mark a line on the rib lips (T-RB1/2/3/4/5/6) and spar lips(T-CAPS) to mark the centre line	fig 2						
	3	Cleco to Ø2,4 the ribs on the spar in the relative positions and lay the skin (T-SKIN) down on it to align the series of holes with the line on the rib lips. Stretch the skin towards the spar to guarantee it adheres with the ribs.	fig 3						
	4	Redrill the holes of the skin on the ribs (lips and petals at the head) and spar to Ø3,2. Cleco and stretch the skin to the advancement. Trim the surplus parts of the skin and the spar.	fig 3						
	5	Redrill the holes to Ø3,2 from the spar to the feet of the ribs substituting each time the Ø2,4 clecos with the Ø3,2 ones	fig 3						
	6	Dismantle everything and deburr.	-						
	7	Countersink the holes of the skin (of size Ø2,4) from the outside to the inside to permit the connection of the flanges (T-FS), (T-CC) and (T-P).	fig 1, 4						
	8	Dimple the most inner holes of the flanges (T-FS), (T-CC) e (T-P), (hole size: Ø2,4) and check the adherence with the countersinking of the skin.	fig 5						
	9	Clean the various part with acetone/thinner to guarantee the correct adhesion of the mastic	fig 1						
	10	Prepare the mastic mixing the two products to obtain a mixture with a uniform colour. [NOTE 1]	-						
	11	Pass the mastic on the flanges (T-FS), (T-CC) and (T-P) on the side of the dimpling.	fig 5, photo 1						
	12	Position the flanges (T-FS), (T-CC) and (T-P) on the inside part of the skin and block with cleco. Rivet with Ø2,4x6 dimpled rivets drenching with mastic. Check that the notch of the flange (T-FS) is turned towards the long side of the skin (edge of assembly of the spar (T-CAPS)).	fig 4, 5, 6, 7, photo 1, 2, 3						
	13	Spread the mastic carefully following the edges of each flange and the central hole. Pass a gloved finger to ensure adherence. Don't leave out the head and foot of each rivet as they are not watertight.	fig 6, 7, photo 1						
	14	Free the thread of the flanges of surplus mastic with the aid of an M5 bolt.	dis 7						
	15	Pass the mastic on the ventilation bushing (S-FS), block with cleco on the rib (T-RB6) and rivet with Ø3,2x8 watertight rivets and drench with mastic. Spread the mastic sufficiently on the inside edge of the rib (T-RB6) close to the bushing (S-FS).	fig 8, photo 4						

NOTE 1

ATTENTION: the next steps must be carried out quickly as the mastic has a working time beyond which it is undavisable to continue. Read the technical characteristics on the label of the mastic used and check the expiry date.

M	Step	Description	table	V		hours of work		Operator	
				R	L	R	L	R	L
	16	Pass the mastic on the lip and on the petal at the top of the rib (T-RB6). Exclude the foot in contact with the spar.	fig 9, photo 5						
	17	Insert the above-mentioned rib in the relative position inside the skin. Block with cleco at alternate holes and rivet the remaining holes with Ø3,2x6,5 watertight rivets after having drenched them with mastic. Rivet the remaining holes after having removed the cleco.	fig 9, photo 5, 6						
	18	Spread some mastic on the head of the just positioned rivets	fig 9, photo 6						
	19	Repeat steps 14,15 and 16 with all the other ribs	fig 9, photo 5, 6						
	20	Cover the interstices of the ribs with mastic (T-RB1) and (T-RB6) paying particular attention to the angles of the petals at the head, as there are draining holes of the folds between the lips of the ribs.	fig 9, 11, photo 6						
	21	Spread mastic on the feet of the ribs (T-RB1/2/3/4/5/6) and on the lips of the spar (T-CAPS).	fig 10, photo 7						
	22	Cleco every second hole of the spar on the skin and cleco the feet of the ribs. Rivet the remaining holes with Ø3,2x6,5 watertight rivets after having drenched them with mastic. Remove the cleco and complete the rivetting.	fig 10, photo 7						
	23	Spread mastic on the just positioned rivet heads and along all the edges of the skin, paying attention to the angles of the feet of the ribs (T-RB1) and (T-RB6), as there are draining holes in the folds between	fig 10, 11 photo 6						