REV:	ENGINEERING DATA REQUIREMENTS (ATTACHMENT "A")

NOTE: MILITARY SPECIFICATIONS / STANDARDS WILL NOT BE FURNISHED IN THE BID SET.

1. THE FOLLOWING INSTRUCTIONS ARE FURNISHED FOR THE MANUFACTURE OF:
HORIZONTAL STABILIZER ASSEMBLY F-16

2. PART NUMBER:	3. NATIONAL STOCK NUMBER:
16T7461-835	1560-01-619-8981WF

4. THE FOLLOWING SPECIFICATIONS/STANDARDS, ETC., WILL BE USED IN LIEU OF THE DATA INDICATED. THE SUPERSEDED DATA WILL NOT BE FURNISHED UNLESS SO INDICATED.

5. THE SOURCES/MATERIALS IF LISTED ON THE STANDARDS, SPECIFICATION AND DRAWINGS ARE THE ONLY SOURCES/MATERIALS FOR THOSE ITEMS. SUBSTITUTIONS SHALL HAVE PRIOR APPROVAL BY THE COGNIZANT ENGINEERING ACTIVITY.

6. DEVIATIONS FROM SPECIFICATIONS IDENTIFIED IN CONTROL DRAWINGS ARE NOT AUTHORIZED WITHOUT PRIOR APPROVAL BY THE COGNIZANT ENGINEERING ACTIVITY.

7. MARKING PER MIL-STD-130 IN LIEU OF FPS-3008.

8. USE MATERIAL PER SAE AMS-QQ-A-250/4 IN LIEU OF QQ-A-250/4.

9. 16PR100 IS NOT REQUIRED TO MANUFACTURE THIS ITEM AND WILL NOT BE PROVIDED.

10. 16PR006 IS NOT FURNISHED. USE IGES LOFT DATA 16T7465-3, 16T7465-3, 16T7465-4, 16T7469-9, 16T7482-11, 16T7482-13, 16T7470-7 AND 16T7479-9 FOR MANUFACTURING.

11. THIS ITEM HAS BEEN IDENTIFIED AS A CRITICAL SAFETY ITEM (CSI). SEE EO 14C5251-H FOR DETAILS.

12. THE TRAILING EDGE OF NEWLY MANUFACTURED HORIZONTAL STABILIZER ASSEMBLYS SHALL INCLUDE THE HORIZONTAL STABILIZER TRAILING EDGE REINFORCEMENT REPAIR (55-12-02-11) IAW TO 1F-16C-3-4 SECTION 2.1.1.5.13. THE INSTRUCTIONS INCLUDED IN SECTION 2.1.1.5.13 ARE AS FOLLOWS:
REINFORCEMENT REPAIR (55-12-02-11). REPAIR HORIZONTAL STABILIZER TRAILING EDGE AS FOLLOWS. (SEE FIGURE 1).
WARNING:
• DRILLING, MILLING, AND COUNTERSINKING OPERATIONS CREATE CHIPS WHICH MAY CAUSE SERIOUS INJURY. PROTECTIVE EQUIPMENT CONSISTING OF INDUSTRIAL GOGGLES IS REQUIRED. FAILURE TO OBSERVE THIS WARNING MAY RESULT IN SERIOUS INJURY TO PERSONNEL.
• HANDLING OF SPLINTERED OR DELAMINATED GRAPHITE-EPOXY SKINS ON DAMAGED PARTS MAY BE HAZARDOUS. WEAR PROTECTIVE GLOVES WHEN HANDLING GRAPHITE-EPOXY PARTS. FAILURE TO OBSERVE THIS WARNING MAY RESULT IN SERIOUS INJURY TO PERSONNEL.
NOTE:
• WHEN WORKING GRAPHITE-EPOXY SKINS, IT IS RECOMMENDED THAT TUNGSTEN CARBIDE DRILL BITS BE USED. STANDARD HIGH SPEED DRILL BITS MAY BE USED BUT DULL RAPIDLY AND SHALL BE SHARPENED FREQUENTLY OR REPLACED.
• IF NECESSARY, APPROPRIATE BACKUP DEVICES SHALL ALSO BE USED TO PREVENT SPLINTERING AND DELAMINATION OF GRAPHITE-EPOXY COMPOSITE MATERIAL ON INSIDE SURFACE DURING DRILL PENETRATION.
A. PREPARE HOLES FOR JK5689C05NXXB/C9634 RIVETS ATTACHING THE 16T7483 CLOSURE WEDGE.
B. MANUFACTURE TWO STAINLESS STEEL STRAPS 0.75 X 62.5 X 0.050-INCH THICKNESS OUT OF PASSIVATED 301 STAINLESS STEEL 1/2 HARD. THE STRAPS WILL BE USED ON BOTH UPPER AND LOWER SURFACES OF THE TRAILING EDGE ON THE 16T7483 CLOSURE WEDGE. THE STRAPS WILL NEED TO BE TRIMMED TO FIT EACH INDIVIDUAL STABILIZER. ONE OF THE TWO STRAPS WILL NEED TO BE CUT INTO THREE PIECES TO AVOID THE STATIC DISCHARGERS (SEE FIGURE 1).
C. ALIGN STRAPS AND DRILL TO MATCH EXISTING FASTENER HOLES IN THE STABILIZER.
D. WET INSTALL THE STRAPS ONTO THE STABILIZER WITH AMS-3276 OR AMS-3277 APPLIED TO FAYING SURFACES.
E. INSTALL APPROPRIATE LENGTH JK5689C05NXXB/C9634 SLEEVE RIVETS TO FASTEN THE STRAPS IN PLACE AS FOLLOWS:

PREPARED BY:	OFFICE SYMBOL:	DATE:
DONALD WILLMOTH	416 SCMS/GUEAA	20220217

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HORIZONTAL STABILIZER ASSEMBLY F-16

2. PART NUMBER:	3. NATIONAL STOCK NUMBER:
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1. PLACE SLEEVE RIVET IN HOLE AND ADJUST 5/32 X 100-DEGREE DIMPLE DIES OF CP-0214 PNEUMATIC RIVETEROR EQUIVALENT TO TRAILING EDGE OF HORIZONTAL STABILIZER.
2. REMOVE SLEEVE RIVET AND APPLY AMS 3276 OR AMS 3277 SEALING COMPOUND UNDER THE HEAD AND ON HEAD OF SLEEVE RIVET.
NOTE: OVER-SQUEEZING OF SLEEVE RIVET MAY CAUSE SLEEVE RIVET TO SPLIT.
3. INSTALL SLEEVE RIVET, INSURING NOT TO OVER-SQUEEZE.
4. MILL FLUSH EACH END OF SLEEVE RIVET WITH RIVET SHAVER.
F. APPLY FILLET SEAL TO EDGES OF STRAPS, FILL SLEEVE RIVETS WITH SEALANT, AND OVERCOAT RIVET HEADS TO ELIMINATE THE POSSIBILITY OF MOISTURE INTRUSION AND TO MAINTAIN AERODYNAMIC SMOOTHNESS.

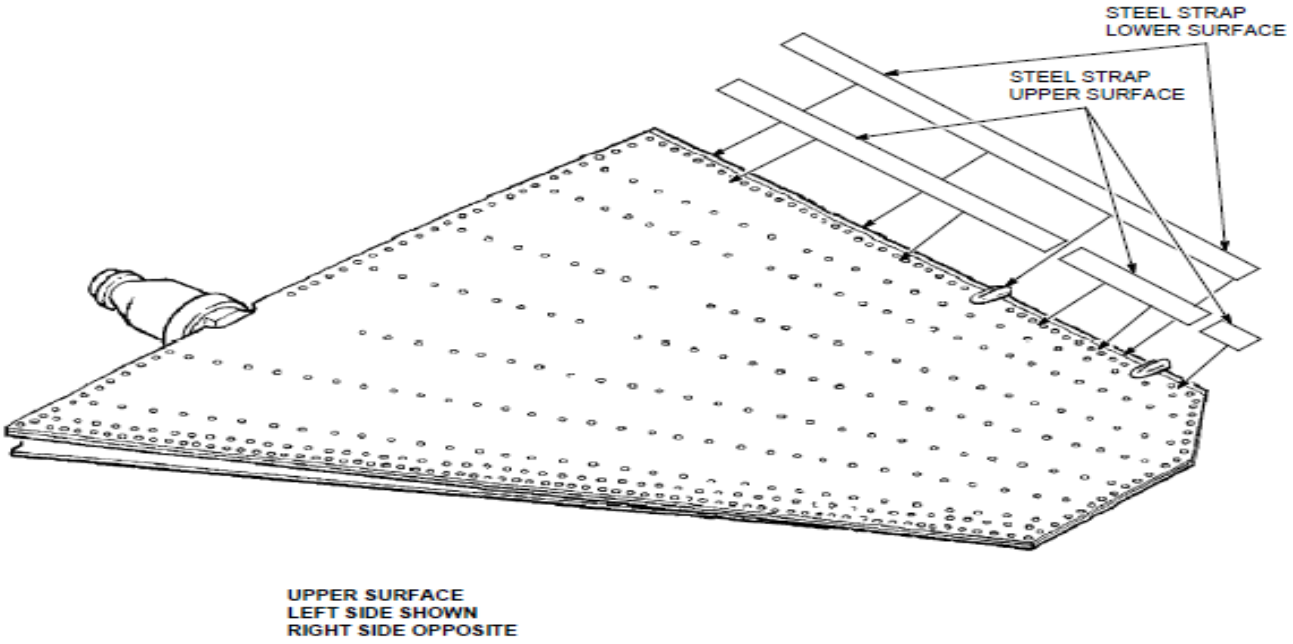

FIGURE 1: HORIZONTAL STABILIZER TRAILING EDGE REINFORCEMENT REPAIR

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