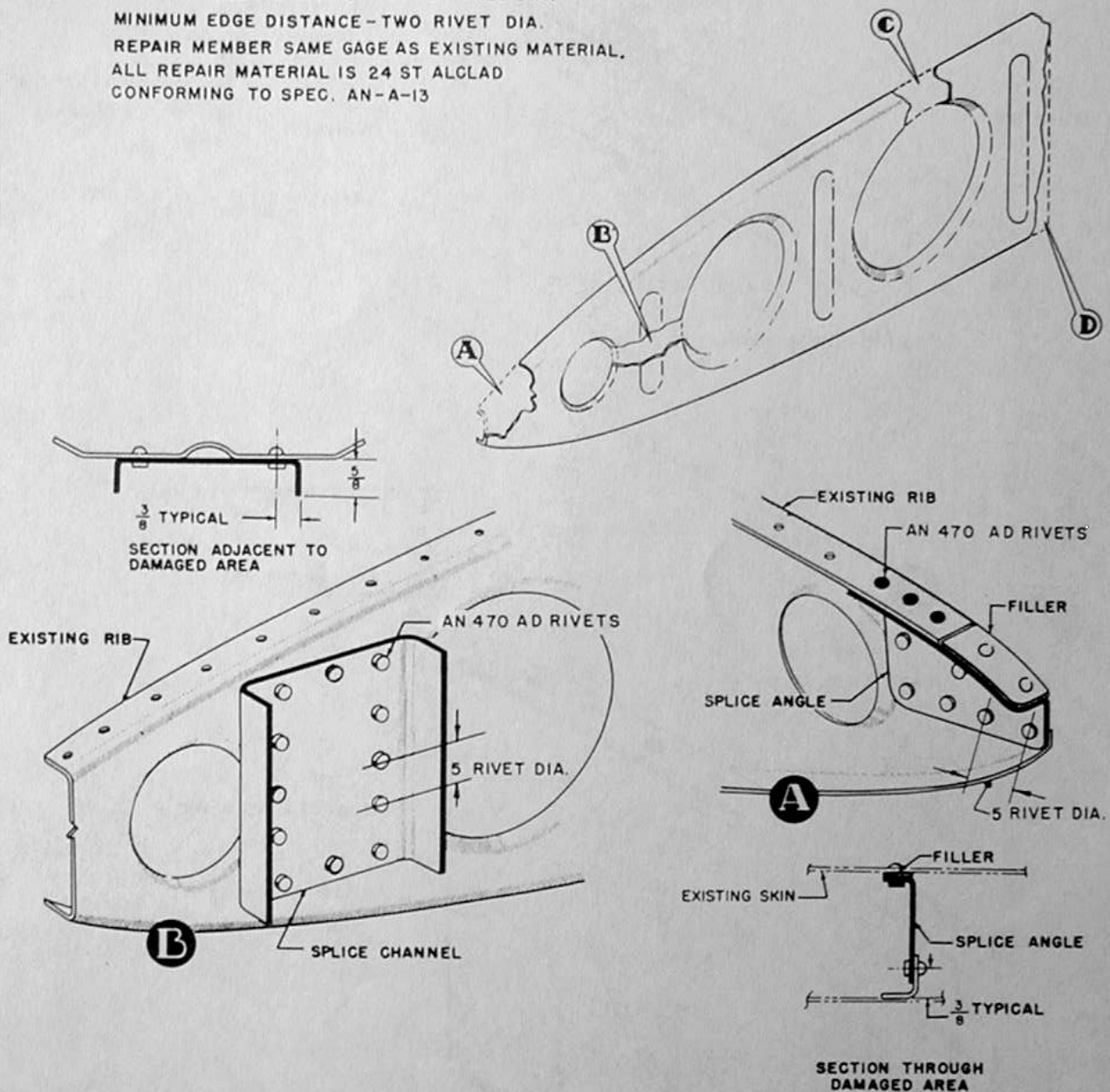


NOTE

MINIMUM RIVET SPACING-THREE RIVET DIA.
 MINIMUM EDGE DISTANCE-TWO RIVET DIA.
 REPAIR MEMBER SAME GAGE AS EXISTING MATERIAL.
 ALL REPAIR MATERIAL IS 24 ST ALCLAD
 CONFORMING TO SPEC. AN-A-13



RIVET SIZES FOR LIGHTENING HOLE REPAIRS

Material Gage (inches)	.016	.020	.025	.032	.040	.051	.064
Rivet Diameter (inches)	3/32	3/32	1/8	5/32	5/32	3/16	3/16

The above values are the preferred AN470AD rivet sizes to be used with various gages of 24ST alclad.

FIGURE B-5. (Sheet 1 of 2 sheets) TYPICAL RIB REPAIRS