

NOTE: Refer to Figure 1 for Step 1 through Step 4.

Step 1: Final-Drill #12 the 3/16 holes in the web of the VS-1202 Front Spar.

Step 2: Machine countersink (Section 5E) the six #40 holes in the web of the VS-1203 Rear Spar flush for 3/32 rivets.

Step 3: Machine countersink the four #40 holes in the VS-1212B-R & -L Upper Spar Caps flush for 3/32 rivets.

Step 4: Machine countersink the #40 holes in the web of the VS-1202 Front Spar flush for 3/32 rivets .

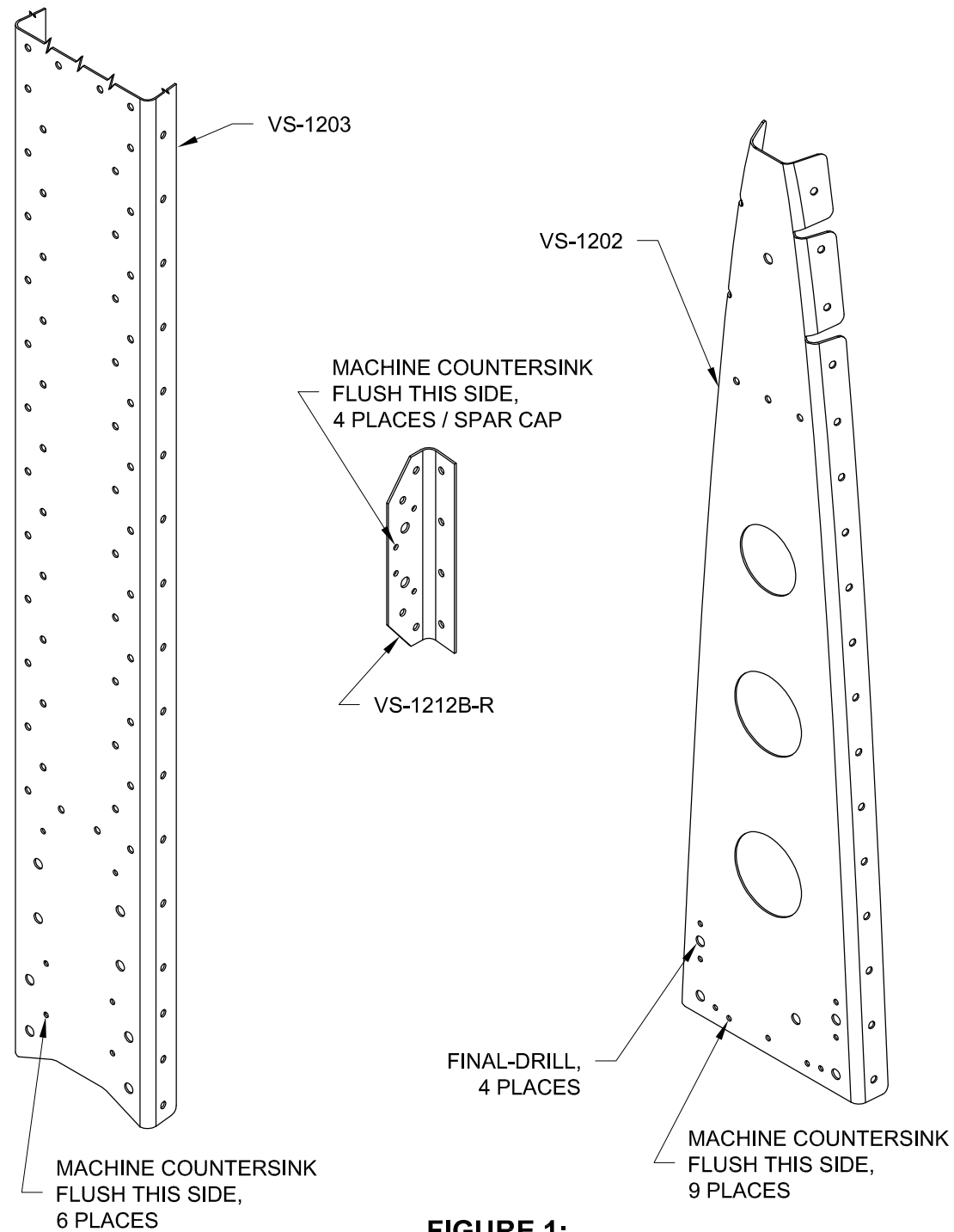


FIGURE 1:
PART PREPARATION

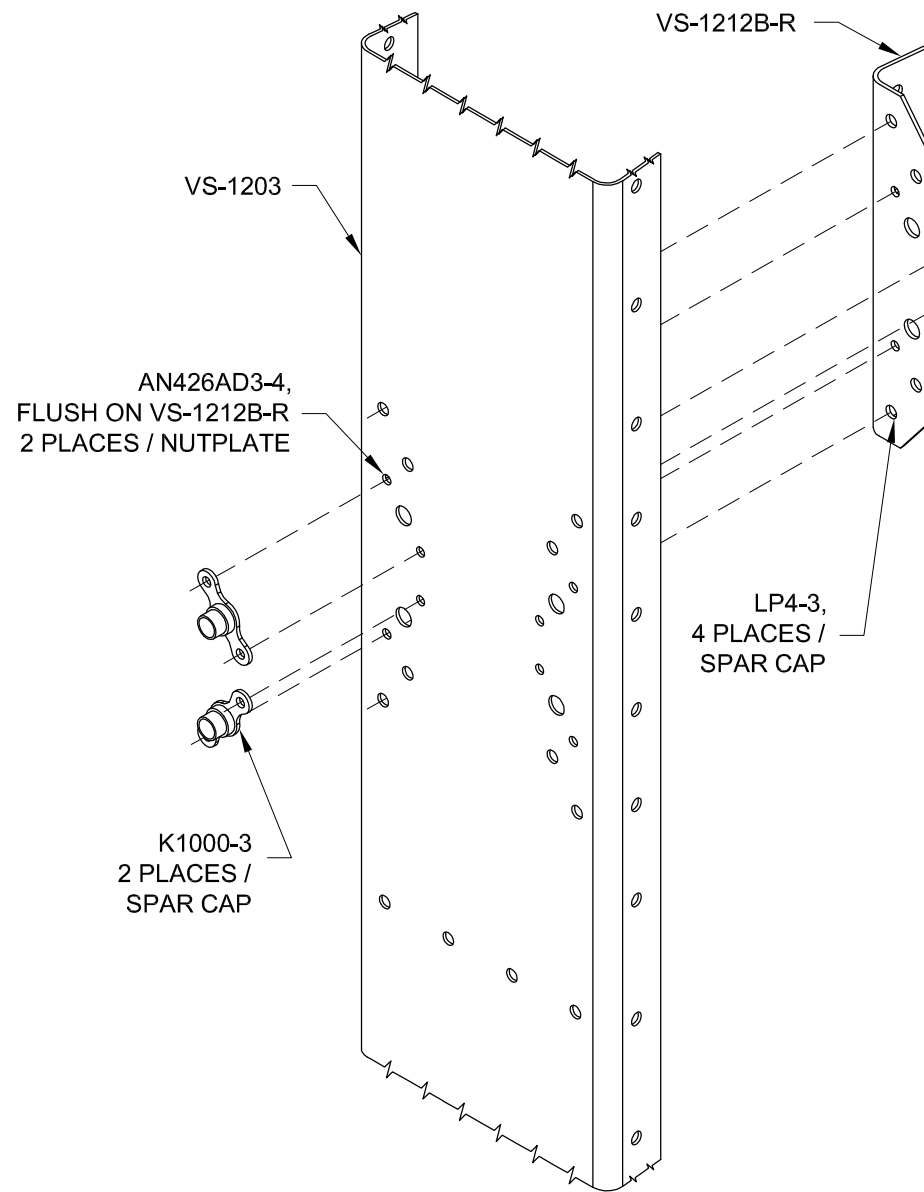


FIGURE 2:
SPAR CAP INSTALLATION

Step 7: Rivet the nutplates to the VS-1202 Front Spar per call-out in Figure 3.

NOTE: The blind rivets for the VS-1203 Rear Spar should be set with the manufactured head on the spar cap side of the rear spar web since they will be visible on the finished assembly.

Step 5: Rivet the VS-1212B-R Upper Spar Cap to the VS-1203 Rear Spar as shown in Figure 2. Leave open the spar flange rivets for this step. Install the VS-1212B-L Upper Spar Cap as a mirror of the right. (The rivet wedge tool fabricated at the beginning of this section may be useful here for the rivets closest to the rear spar flange.)

Step 6: Rivet the nutplates to the VS-1203 Rear Spar and VS-1212B-R & -L Upper Spar Caps as shown in Figure 2.

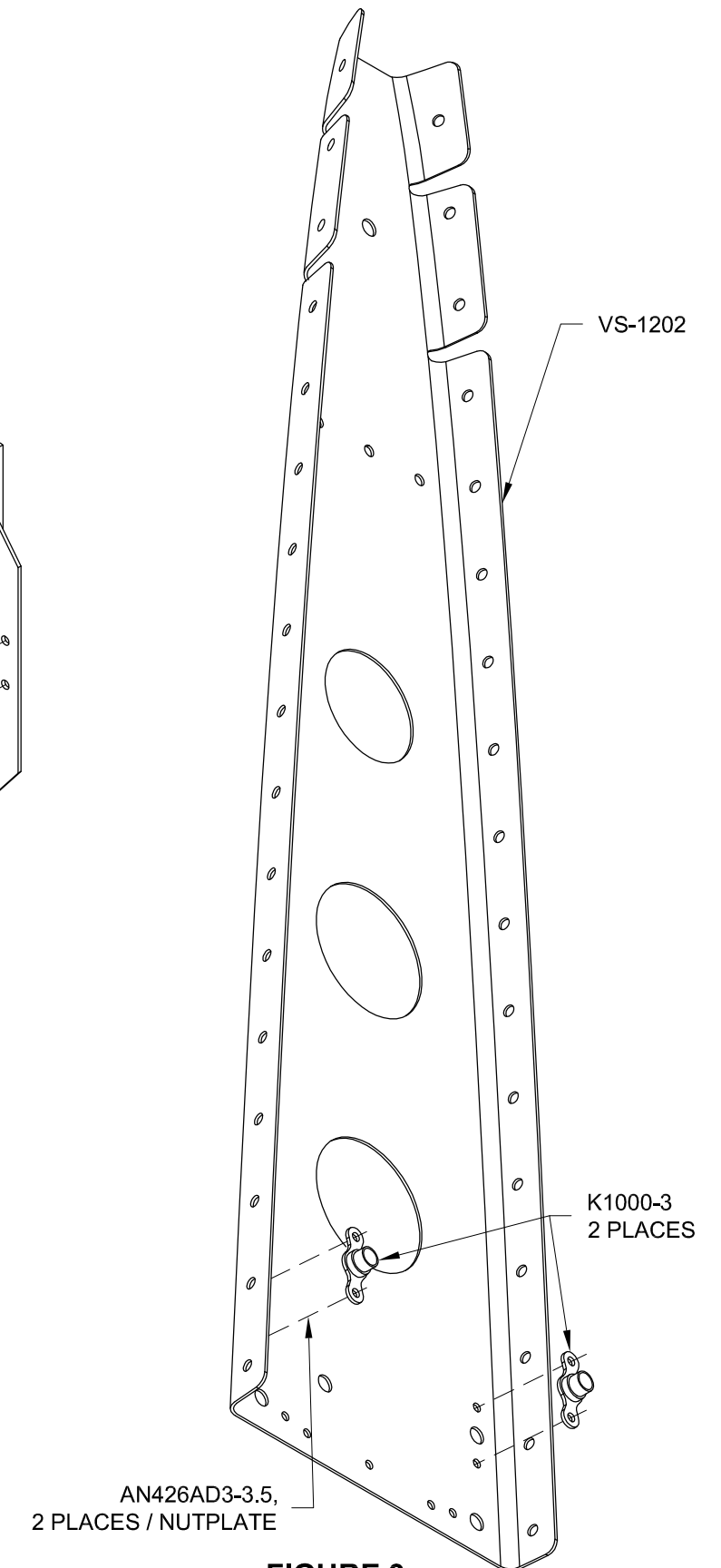


FIGURE 3:
NUTPLATE INSTALLATION