

NOTE: With the bottom of the W-1210 Main Ribs resting on the work surface, a weight or clamp may be applied to the aft portion of the wing assembly to hold it in position for attaching the W-1208 Nose Ribs. Take care not to bend the flanges of the W-1210 Main Ribs.

Step 1: Select five of the aft trimmed W-1208-R Nose Ribs and cleco then rivet to the W-1206-L Spar Assembly attach angles starting outboard and working inboard. Rivets should be installed with the manufactured head on the nose rib. See Figure 1.

Step 2: Select two unmodified W-1208-R Nose Ribs, as well as the untrimmed nose rib that has the two nutplates attached. Cleco then rivet the first unmodified nose rib to the W-1206-L spar assembly and attach angle. Cleco then rivet the nose rib with the nutplates to the spar assembly and attach angle. Cleco then rivet the last of the unmodified nose ribs to the spar assembly and attach angle.

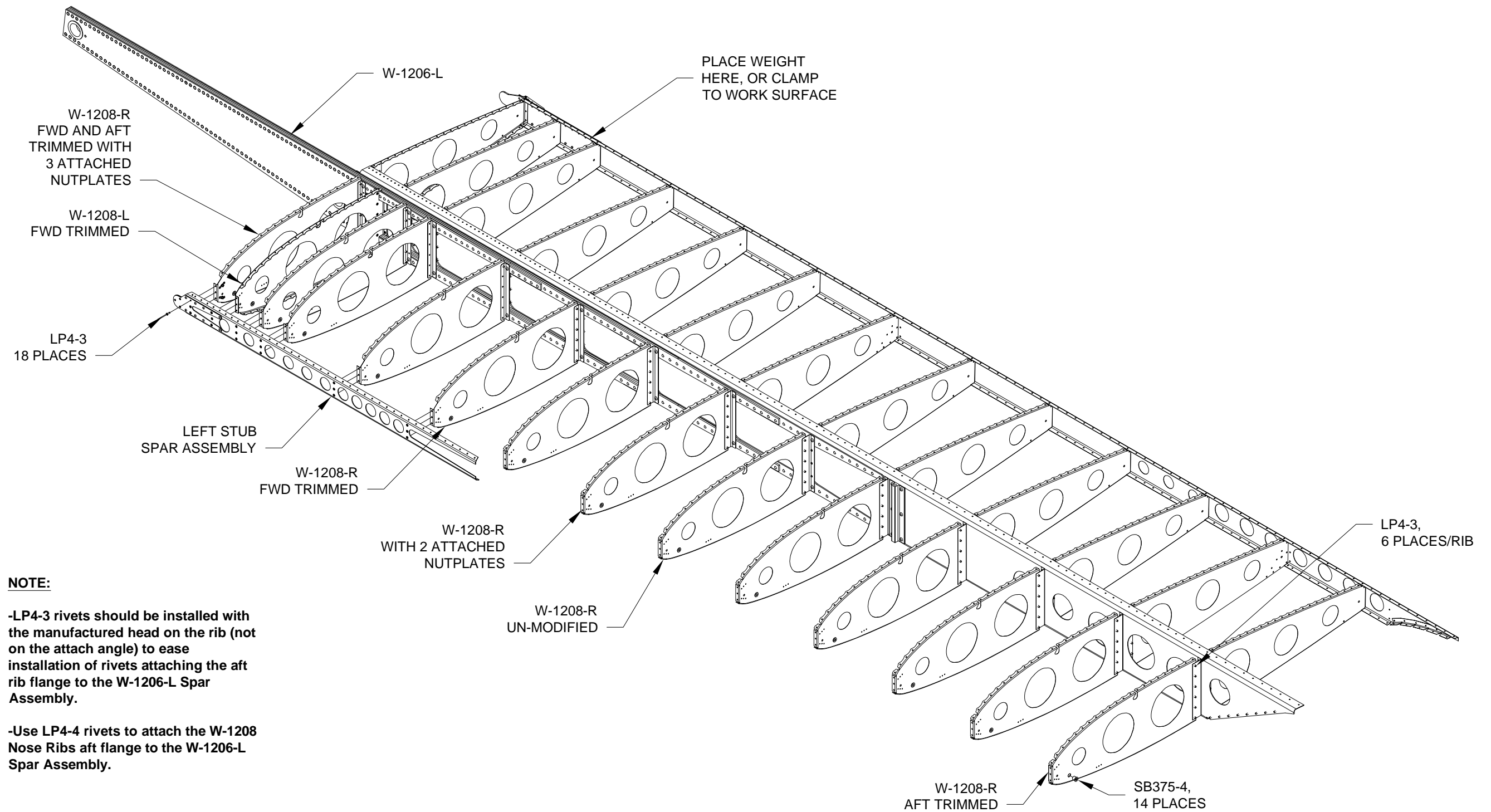
Step 3: Select four of the forward trimmed W-1208-R Nose Ribs and cleco then rivet to the W-1206-L Spar Assembly and attach angles.

Step 4: Cleco then rivet the forward trimmed W-1208-L Nose Rib to the W-1206-L Spar Assembly and attach angle.

Step 5: Cleco then rivet the forward and aft trimmed W-1208-R Nose Rib with the attached nutplates to the attach angle.

Step 6: Cleco then rivet the Left Stub Spar Assembly to the forward flanges of the W-1208-L and W-1208-R Nose Ribs as shown in Figure 1.

Step 7: Insert the snap bushings into the W-1208 Nose Ribs as shown in Figure 1.



NOTE:

-LP4-3 rivets should be installed with the manufactured head on the rib (not on the attach angle) to ease installation of rivets attaching the aft rib flange to the W-1206-L Spar Assembly.

-Use LP4-4 rivets to attach the W-1208 Nose Ribs aft flange to the W-1206-L Spar Assembly.

FIGURE 1: ATTACHING THE NOSE RIBS