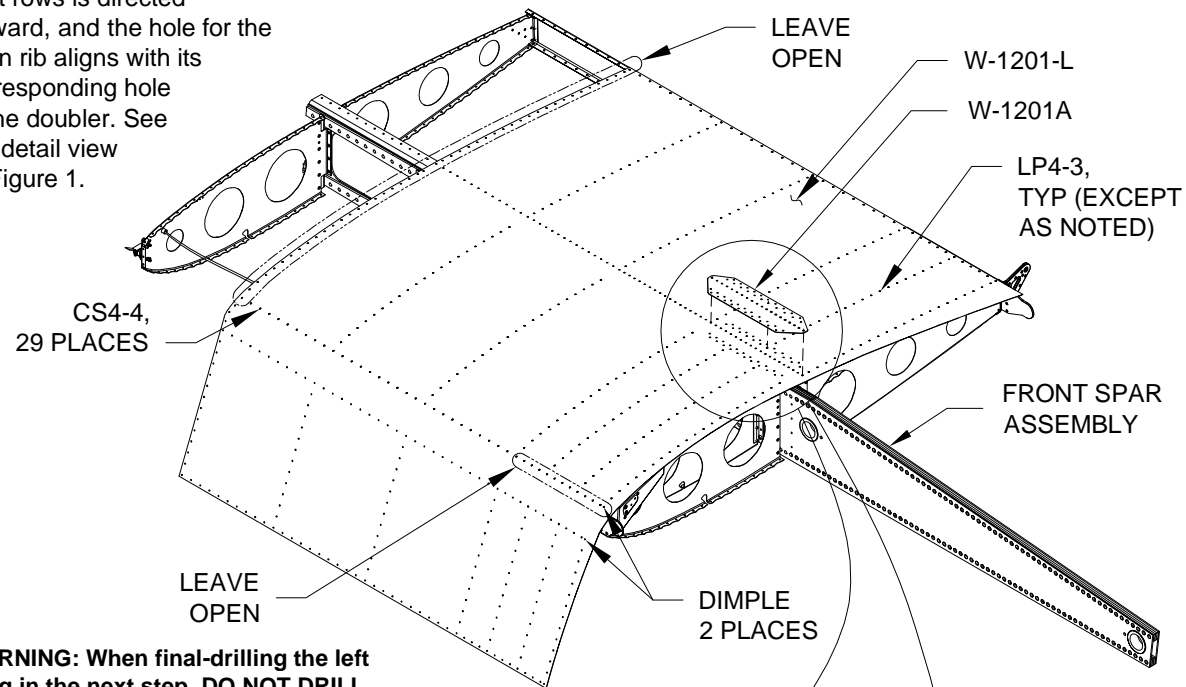


NOTE: If installing the optional lighting system it will be easier at this time.

Step 1: Place a layer of carpet or an old blanket on the work table. Place the wing skeleton upside-down on the table with the leading edge overhanging the edge by two to four inches.

Step 2: Dimple the W-1201-L Inbd Wing Skin in two places as shown in Figure 1.

Step 3: Cleco the W-1201A Doubler to the inbd wing skin and to the bottom flange of the Front Spar Assembly. The doubler is almost symmetrical; proper orientation is achieved when the larger gap between rivet rows is directed forward, and the hole for the main rib aligns with its corresponding hole in the doubler. See the detail view of Figure 1.



WARNING: When final-drilling the left wing in the next step, DO NOT DRILL THE SPAR CAPS of the spar assembly. Protect the spar caps from being inadvertently drilled by temporarily inserting a thin strip (.040 max. thickness) of steel between the skin and the spar caps.

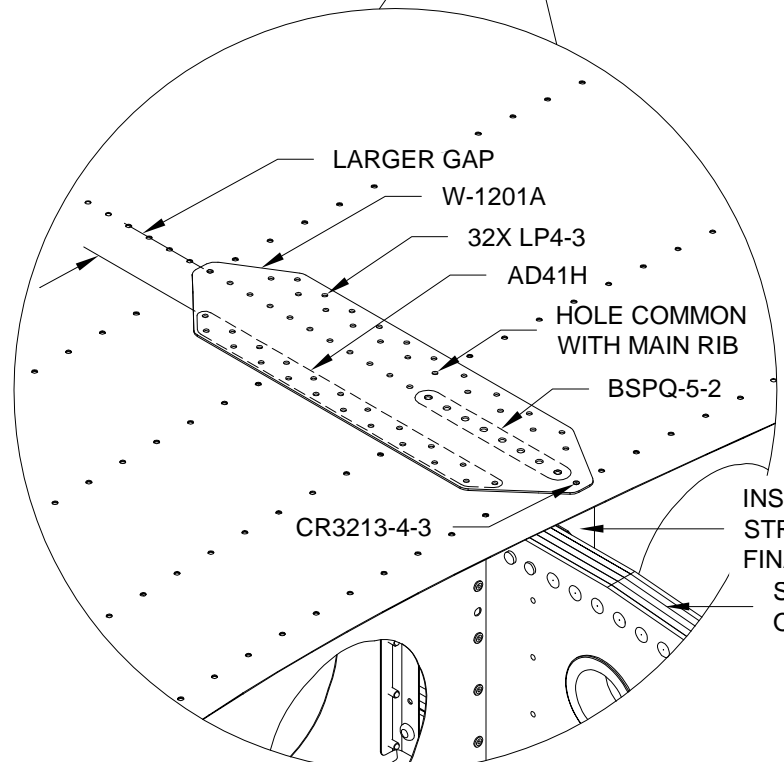
Step 4: Final-Drill #20 the holes in the doubler, inbd wing skin, and flange of the Front Spar Assembly for the eight BSPQ rivets. Be sure not to final-drill the inboard most hole for the CR3213 rivet. See the detail view of Figure 1.

Step 5: Disassemble, then deburr the holes that were final-drilled in the previous step.

Step 6: Cleco the inbd wing skin to the entire bottom of the wing and cleco the doubler back in place.

Step 7: Rivet the inbd wing skin and the doubler to the bottom of the wing. Leave all holes on the outboard edge open as well as the holes called out in Figure 1.

FIGURE 1: ATTACHING INBD WING SKIN (LEFT WING SHOWN)



Step 8: Final-Drill 3/8 the #30 hole in the W-1203-L Outbd Wing Skin for the tie down ring. See Figure 2.

Step 9: Cleco the W-1203-L Outbd Wing Skin to the wing skeleton as shown in Figure 2. Rivet the outbd wing skin to the skeleton leaving open all holes on the inboard and outboard edges, the leading edge holes, and the holes for the W-1216B-L Hinge Rib (Page 17-03 Figure 2) as shown in Figure 2.

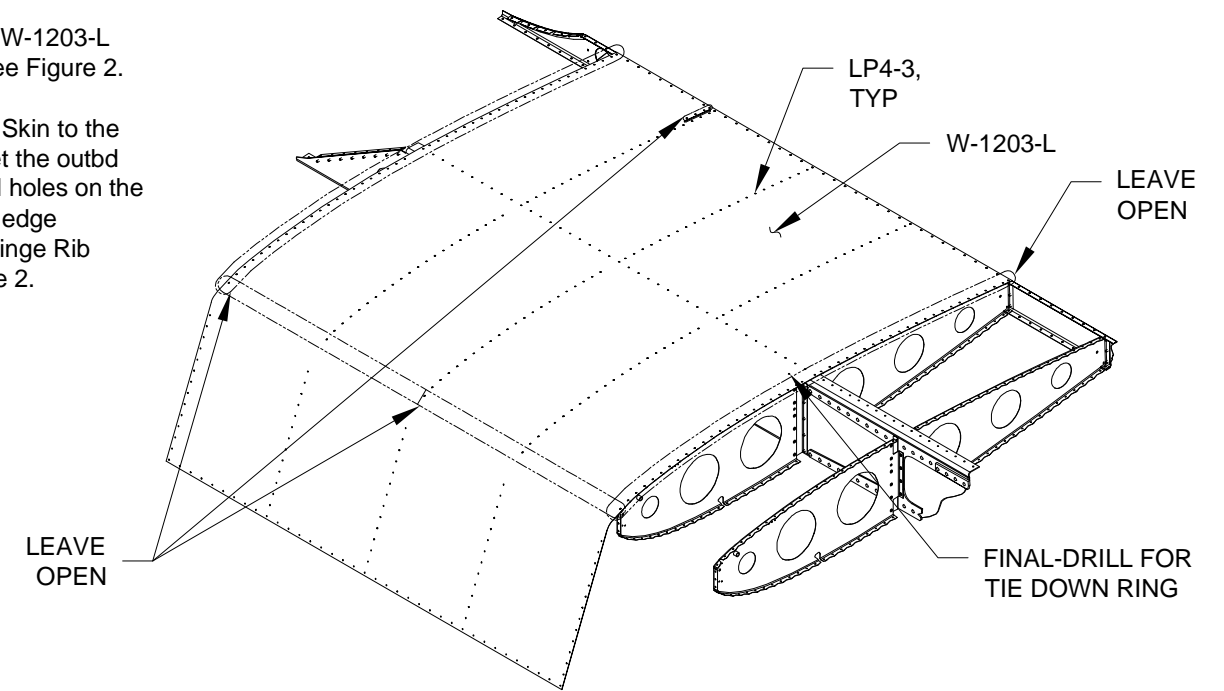


FIGURE 2: ATTACHING OUTBD WING SKIN (LEFT WING SHOWN)

Step 10: Cleco the W-1202-L Mid Wing Skin to the wing skeleton as shown in Figure 3. Rivet the mid wing skin to the wing skeleton leaving open the 1st holes aft of the leading edge and the holes for the W-1216B-L (Page 17-03 Figure 2) as shown in Figure 3.

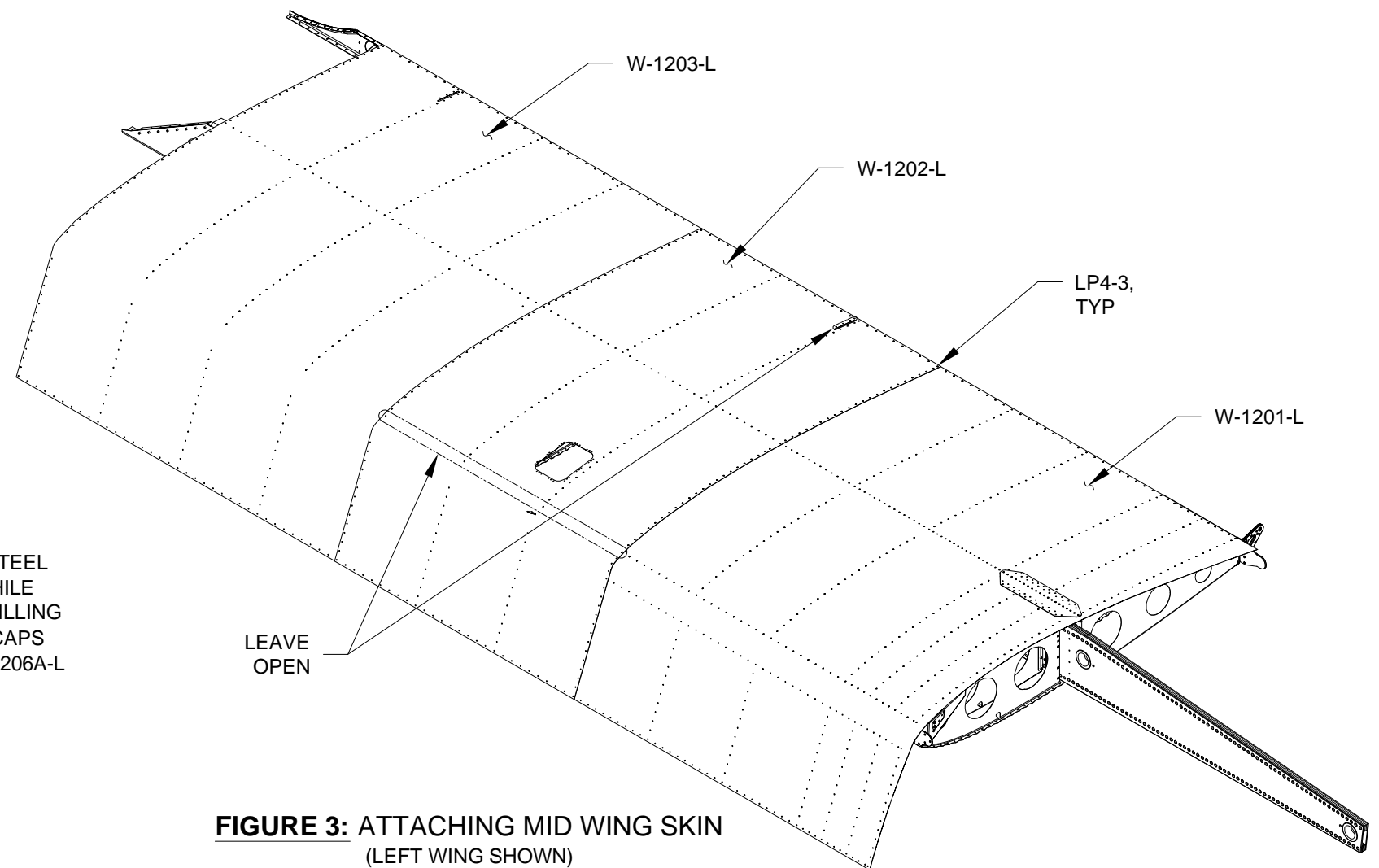


FIGURE 3: ATTACHING MID WING SKIN (LEFT WING SHOWN)