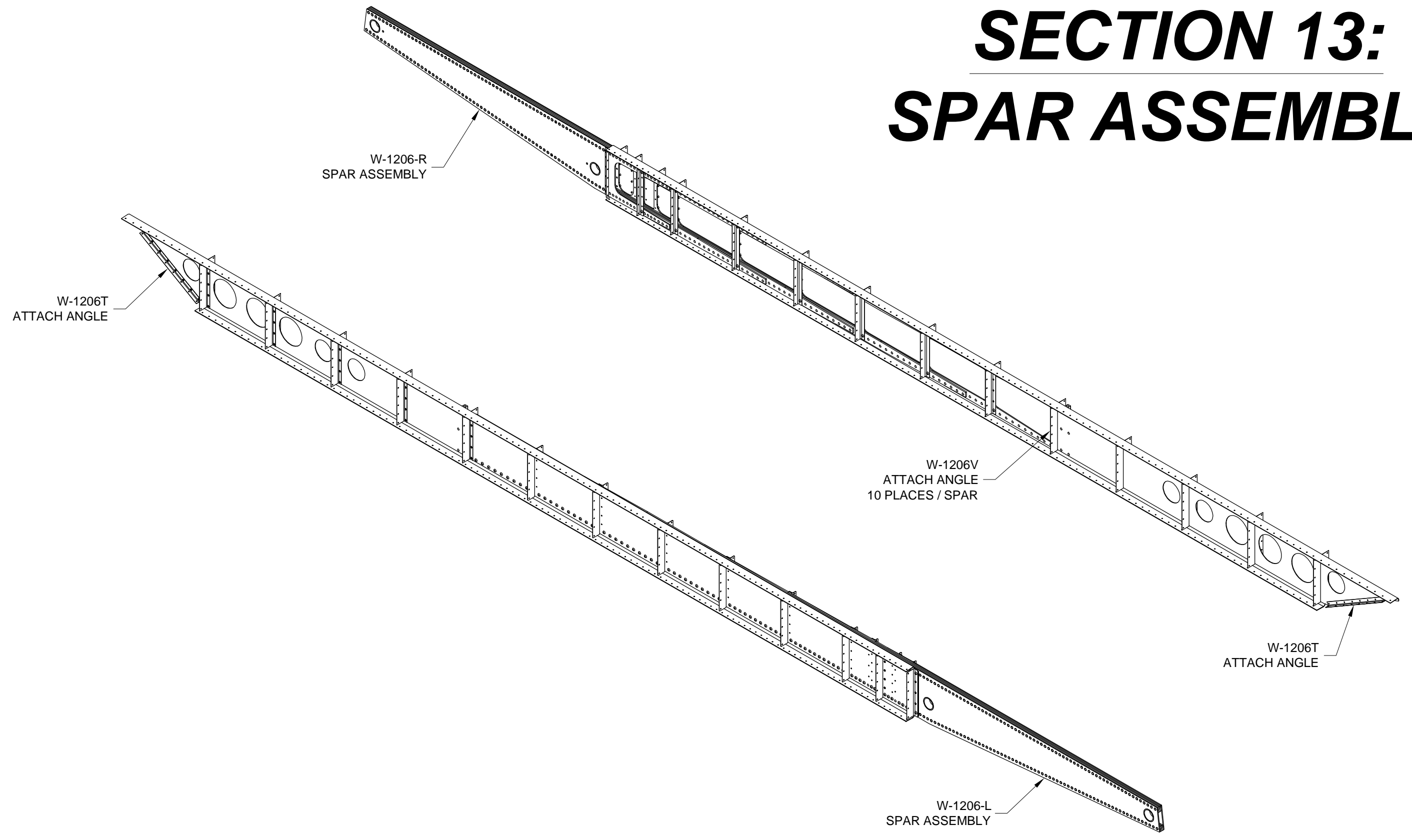
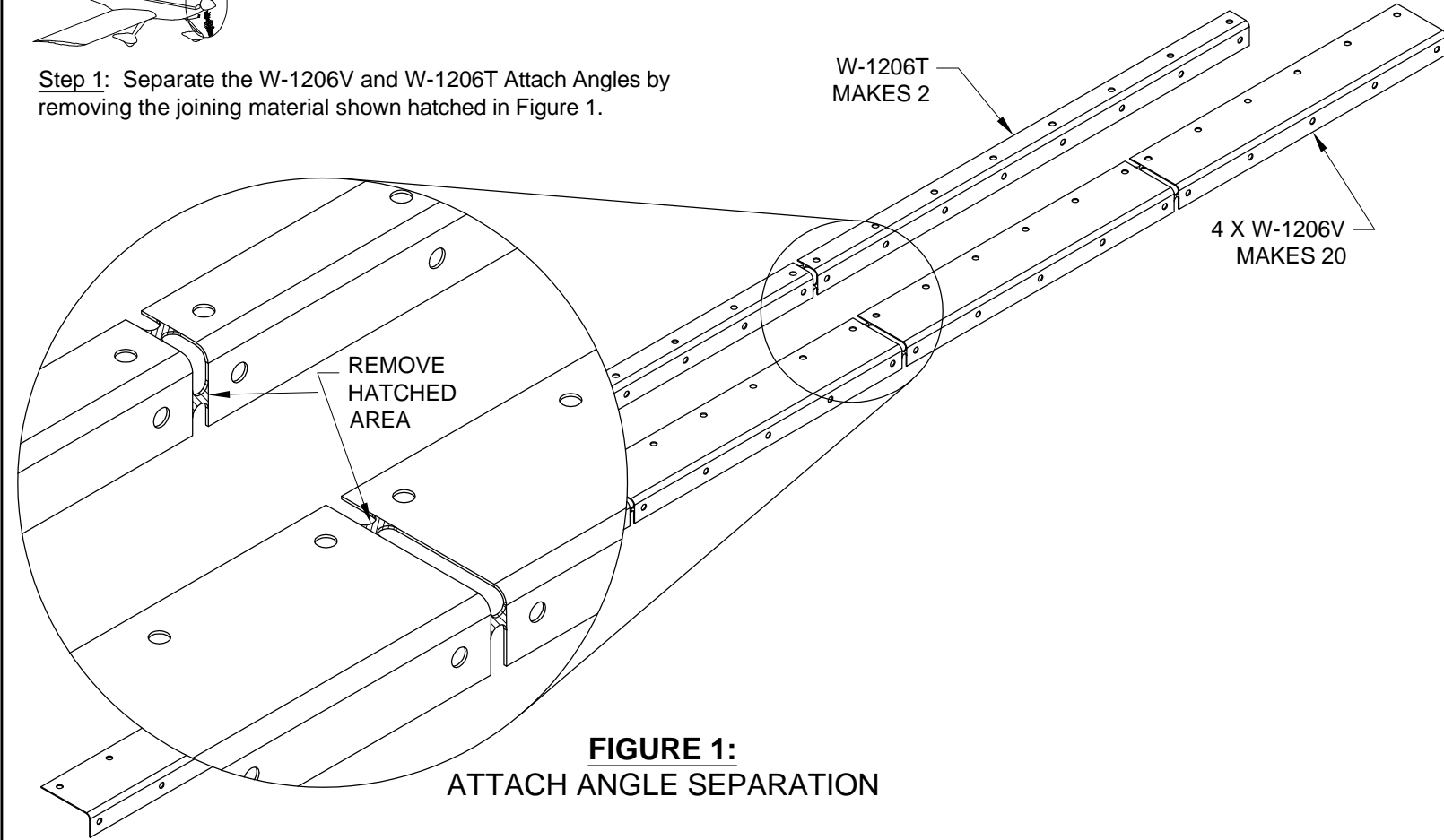


# SECTION 13: SPAR ASSEMBLY

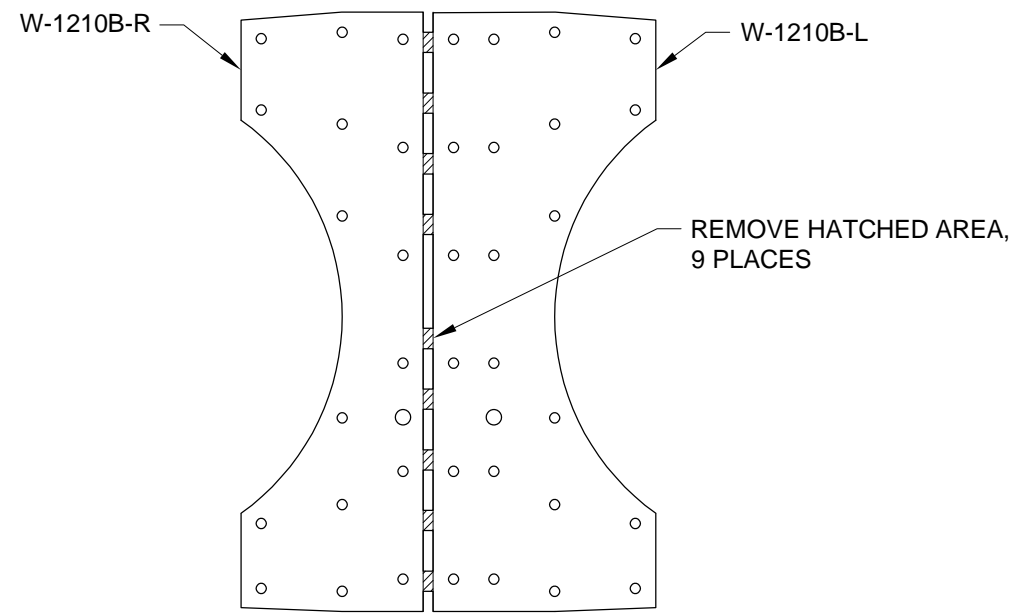


Step 1: Separate the W-1206V and W-1206T Attach Angles by removing the joining material shown hatched in Figure 1.



**FIGURE 1:  
ATTACH ANGLE SEPARATION**

Step 2: Mark, then separate the W-1210B Rib Doublers by removing the joining material as shown in Figure 2.

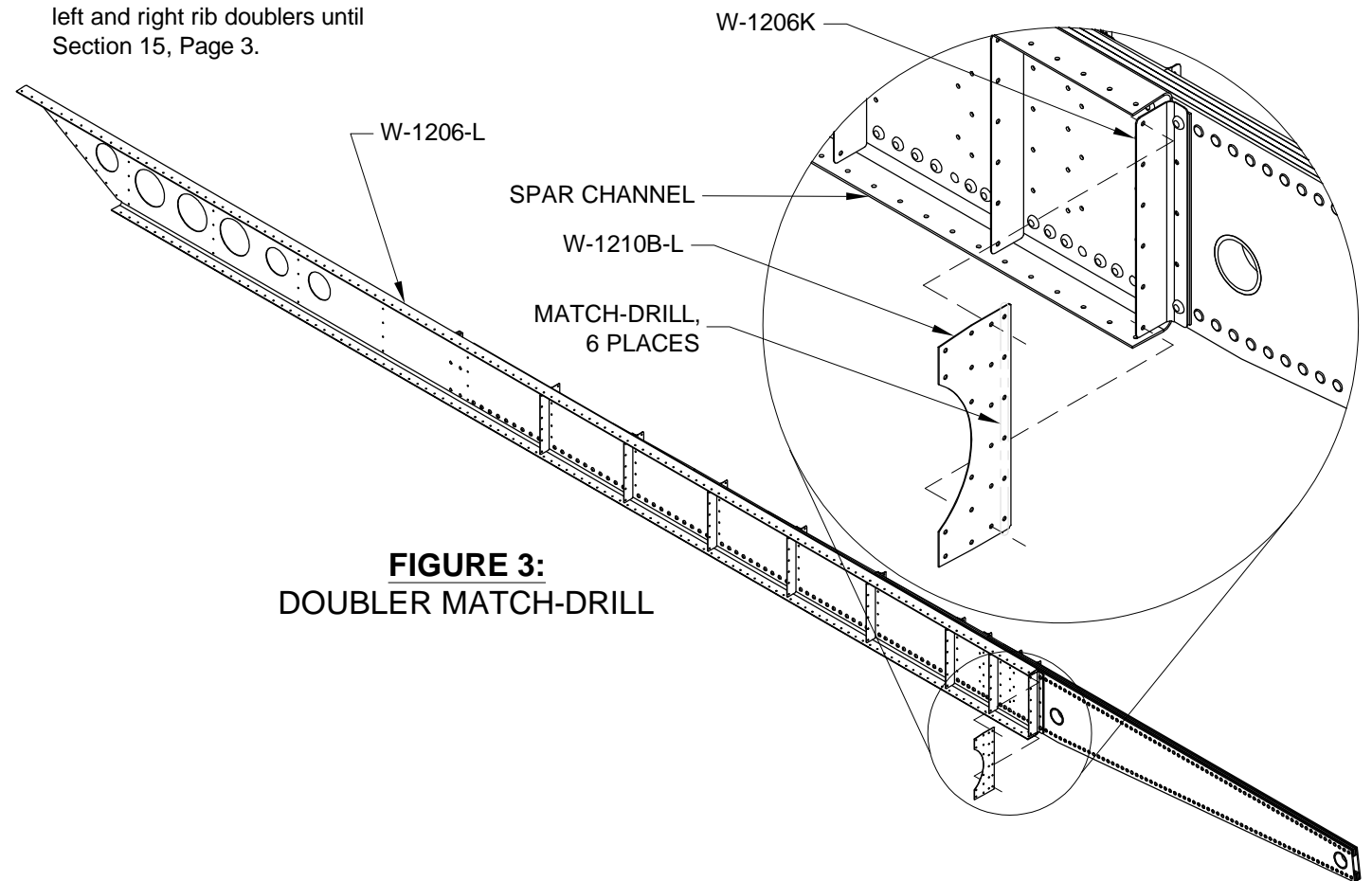


**FIGURE 2:  
W-1210B RIB DOUBLER SEPARATION**

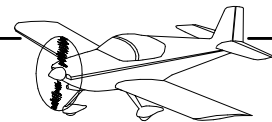
Step 3: Cleco the second row of holes in the W-1210B-L Left Rib Doubler to the W-1206K Attach Angle, which is part of the W-1206-L Spar Assembly, at the inboard end of the spar channel, as shown in Figure 3.

Step 4: Using an extended #30 drill bit, match-drill the first row of holes of the W-1210B-L Left Rib Doubler into the W-1206K Attach Angle as shown in Figure 3.

Remove the Left Rib Doubler, deburr, then set aside the left and right rib doublers until Section 15, Page 3.

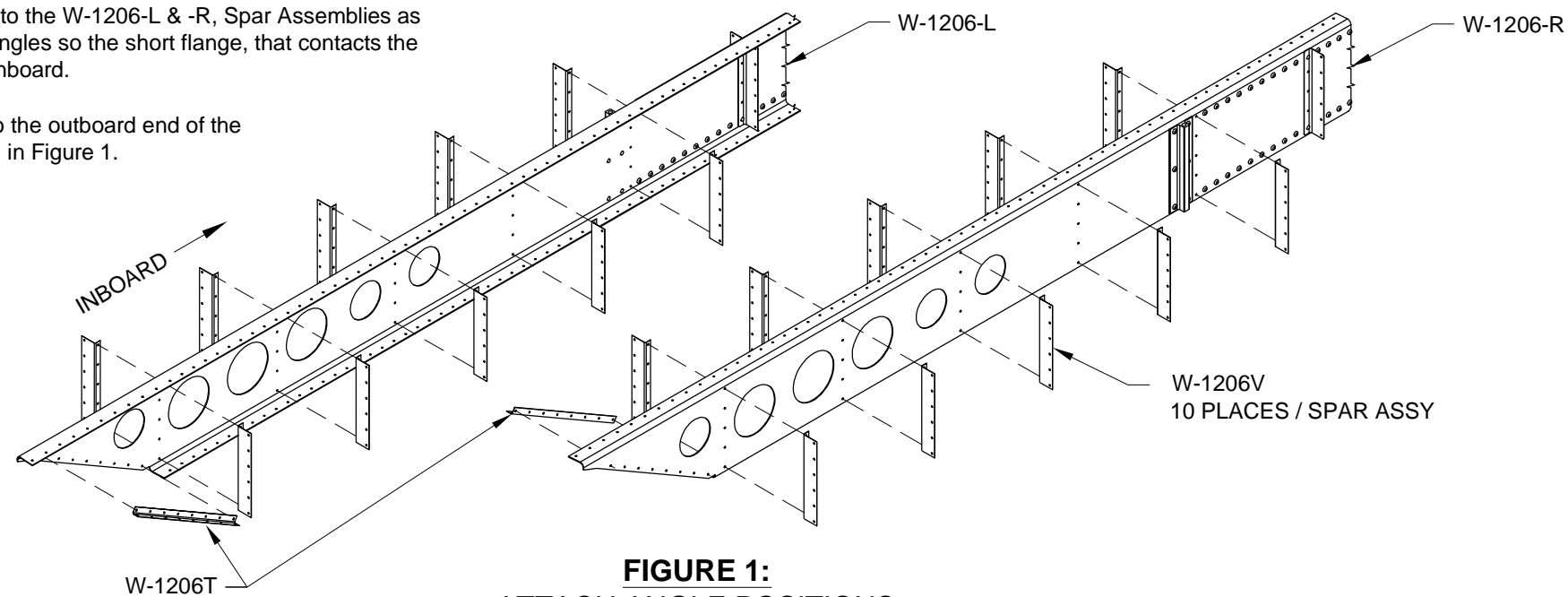


**FIGURE 3:  
DOUBLER MATCH-DRILL**



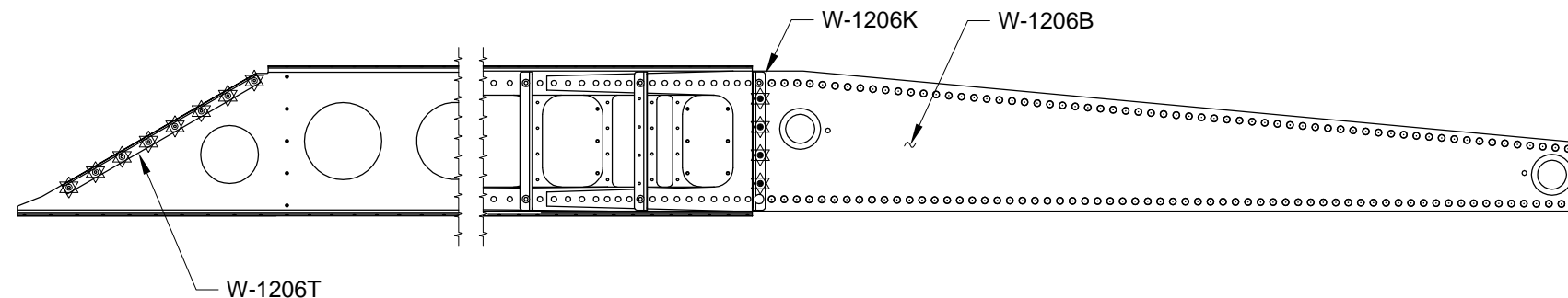
**Step 1:** Cleco the W-1206V Attach Angles to the W-1206-L & -R, Spar Assemblies as shown in Figure 1. Orient all of the attach angles so the short flange, that contacts the web of the spar assembly channel, points inboard.


**Step 2:** Cleco the W-1206T Attach Angle to the outboard end of the W-1206-L & -R, Spar Assemblies as shown in Figure 1.



**FIGURE 1:**  
ATTACH ANGLE POSITIONS

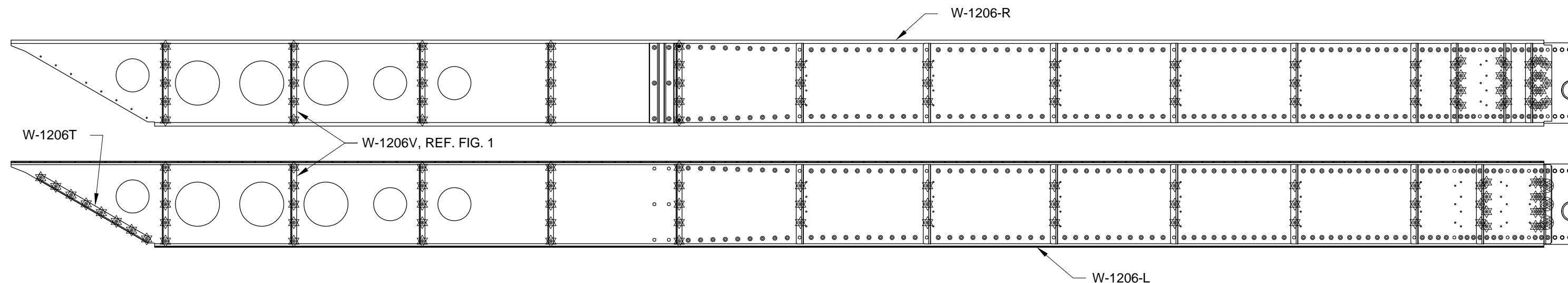
**Step 3:** Rivet the W-1206T Attach Angle to the W-1206-R Spar Assembly channel. Rivet the inboard most W-1206K Attach Angle, which comes attached to the right spar assembly, to the W-1206B Spar Stub Doubler as shown in Figure 2.





**FIGURE 2:**  
W-1206-R SPAR ASSEMBLY RIVETS 

**Step 4:** Rivet all of the W-1206V Attach Angles to the W-1206-L & -R, Spar Assemblies. Rivet the W-1206T Attach Angle to the left spar assembly as shown in Figure 3.

**Step 5:** Rivet the W-1206-L & -R, Spar Assemblies at the remaining holes marked with the symbol in Figure 3.



**FIGURE 3:**  
SPAR ASSEMBLY RIVETS  LP4-3  
 LP4-4



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