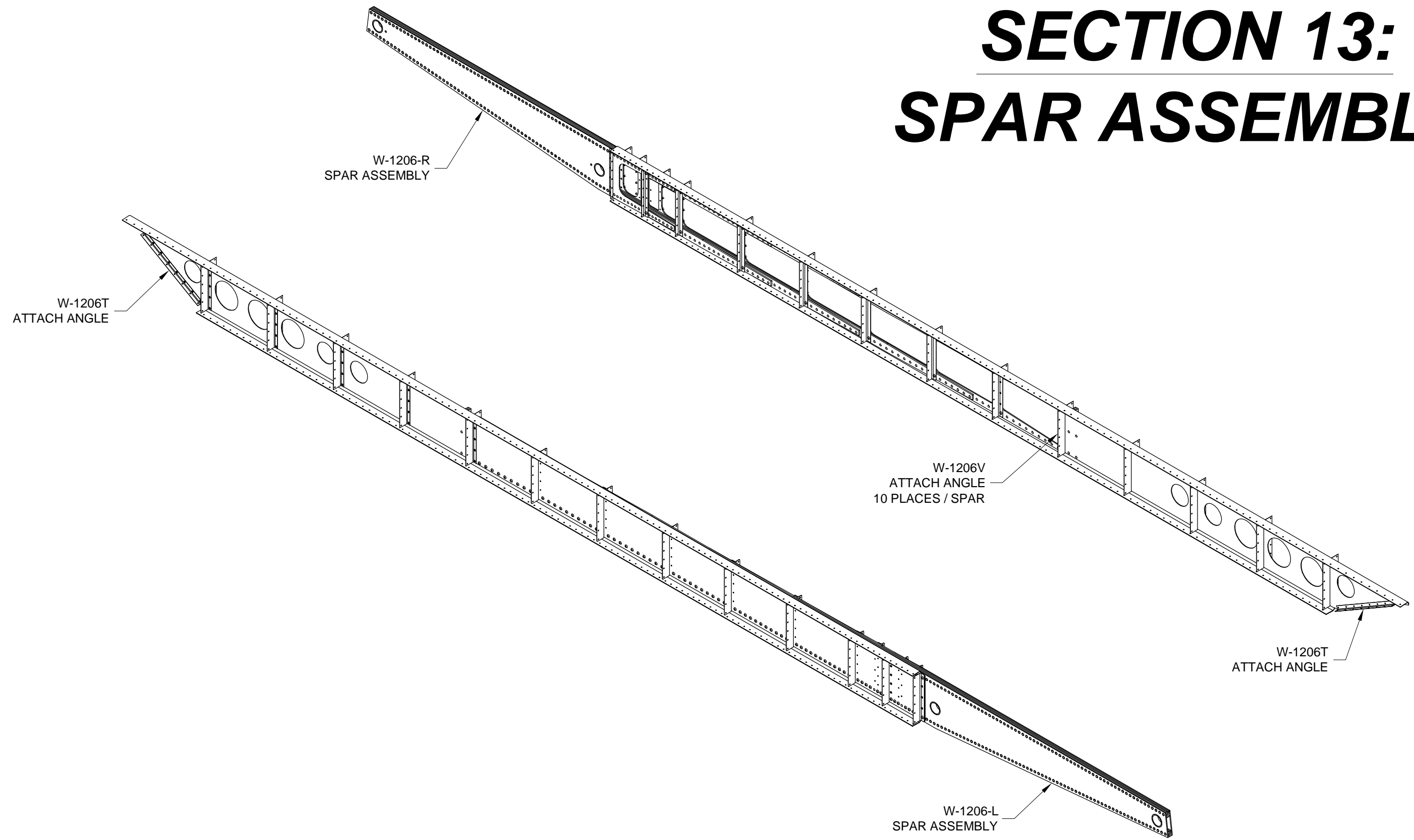


SECTION 13: SPAR ASSEMBLY



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

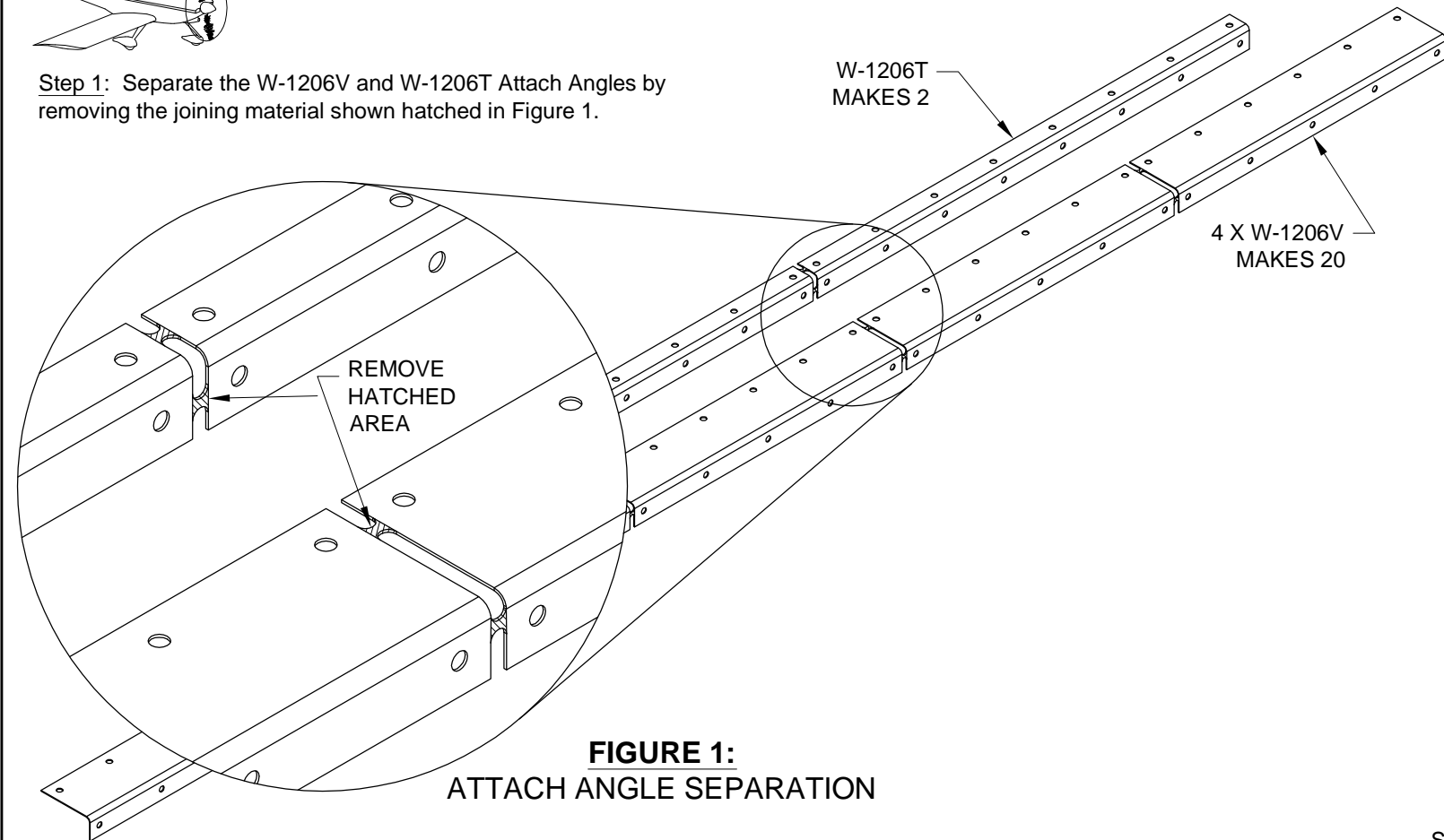


FIGURE 1:
ATTACH ANGLE SEPARATION

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

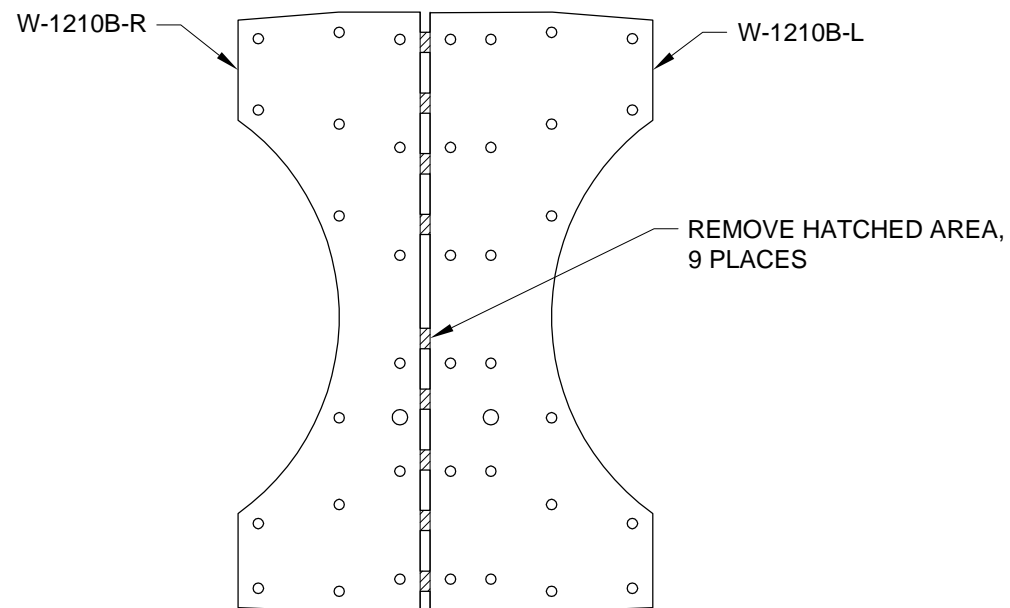


FIGURE 2:
W-1210B RIB DOUBLER SEPARATION

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.

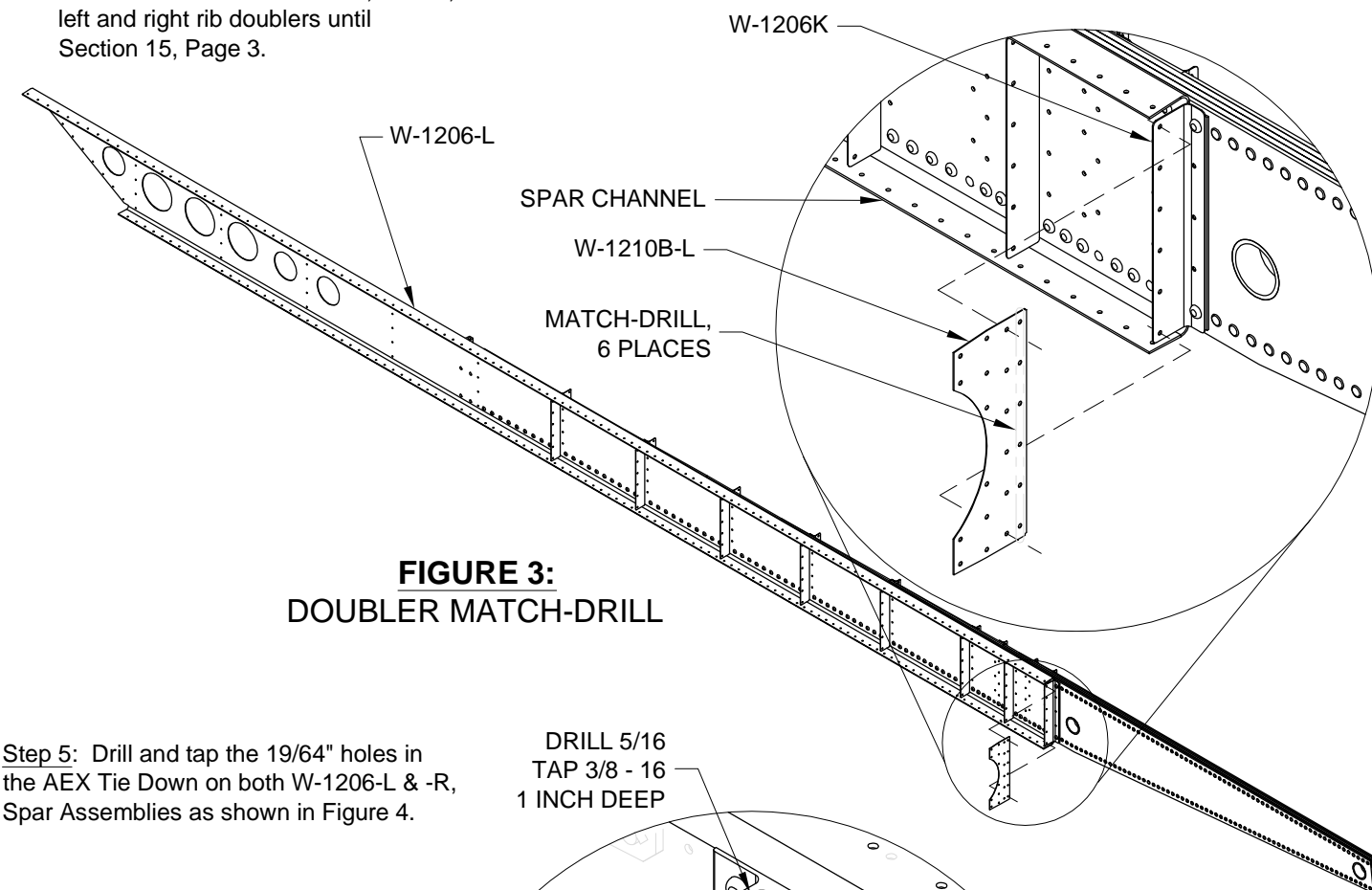


FIGURE 3:
DOUBLER MATCH-DRILL

Step 5: Drill and tap the 19/64" holes in the AEX Tie Down on both W-1206-L & -R, Spar Assemblies as shown in Figure 4.

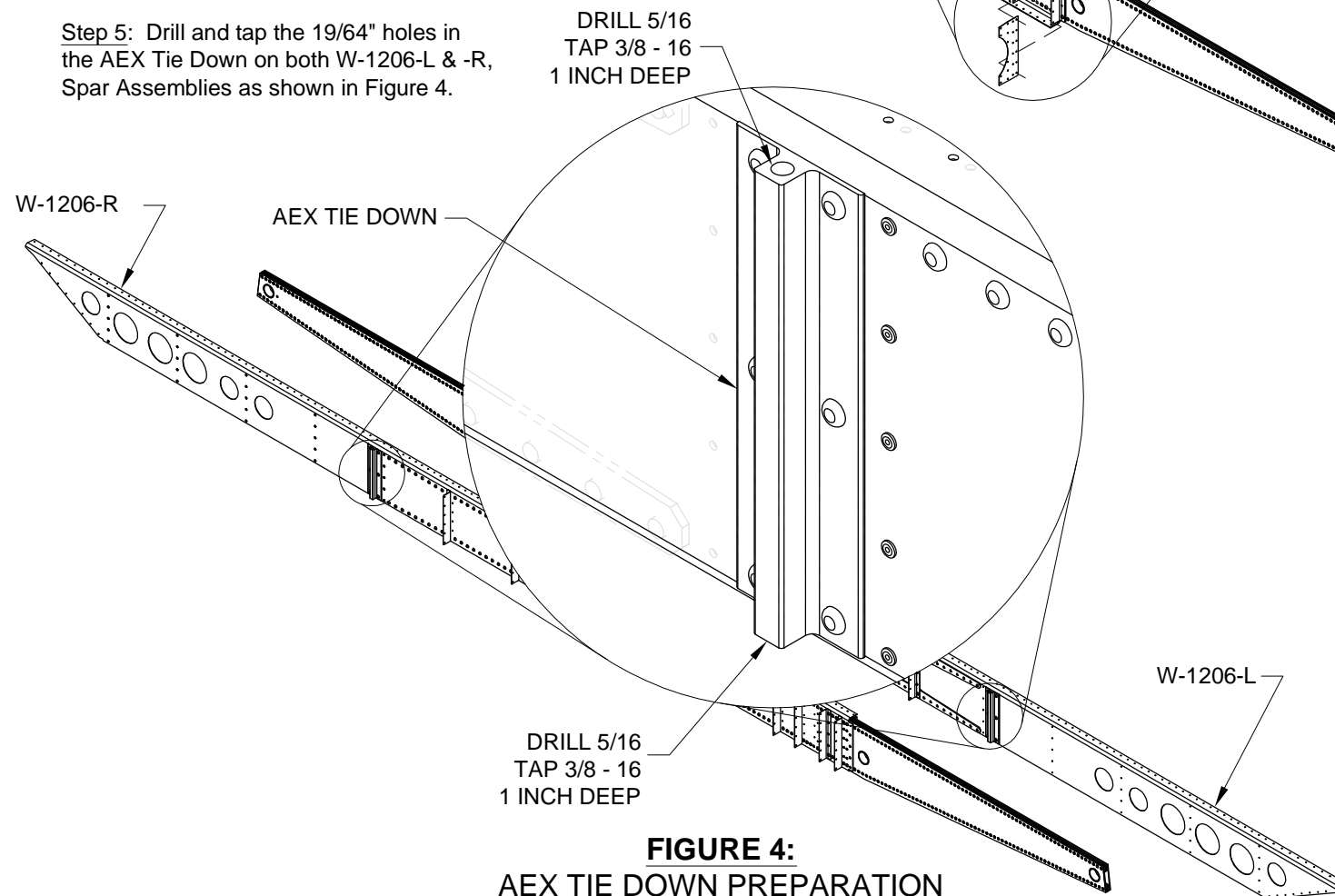
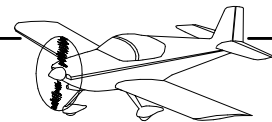


FIGURE 4:
AEX TIE DOWN PREPARATION



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.

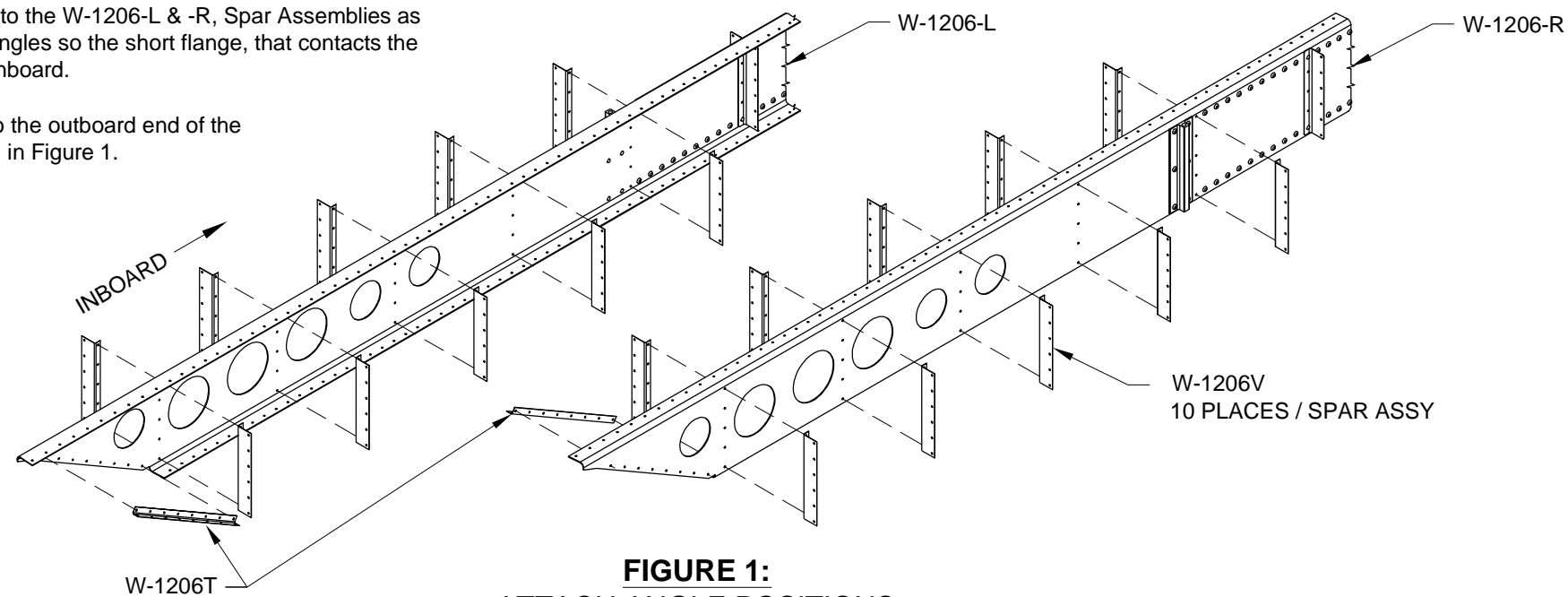


FIGURE 1:
ATTACH ANGLE POSITIONS

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.

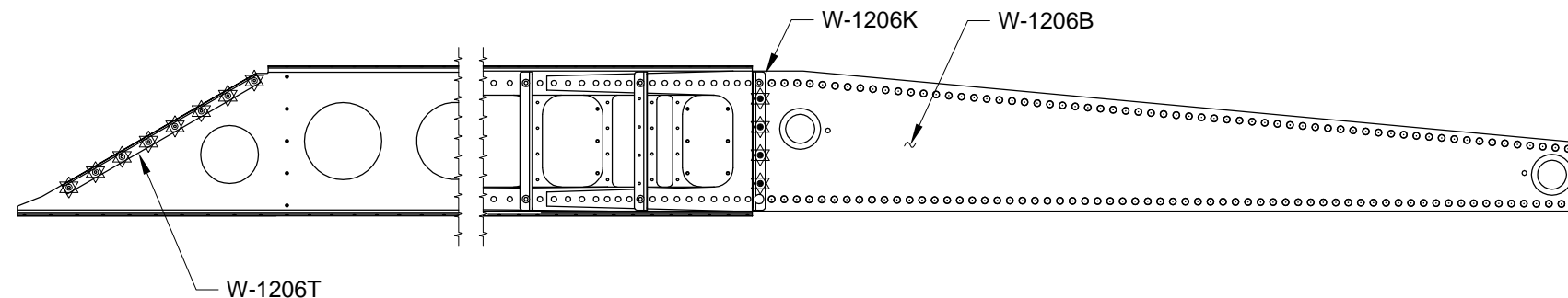



FIGURE 2:
W-1206-R SPAR ASSEMBLY RIVETS 

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.

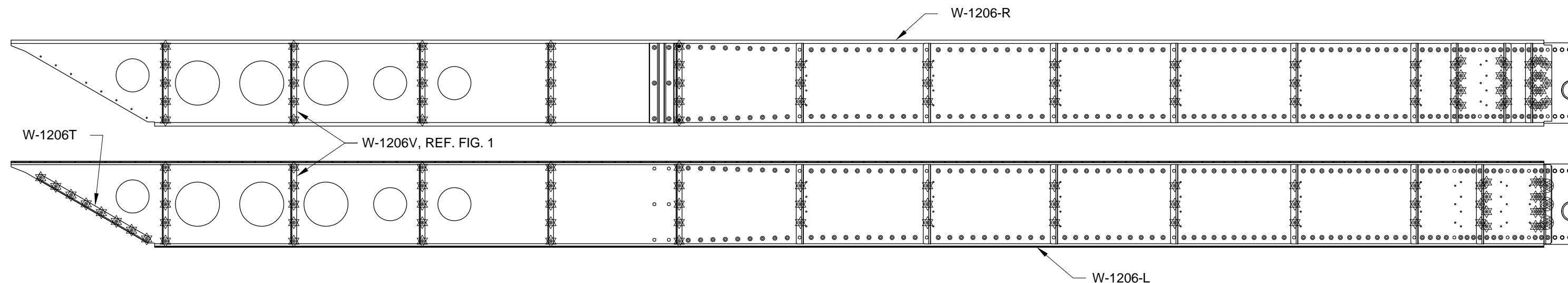




FIGURE 3:
SPAR ASSEMBLY RIVETS  LP4-3  LP4-4



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