

NOTE: Step 1 through Step 7 describe installing the VS-1212A-R Lower Spar Cap and VS-1212B-R Upper Spar Cap to the right side of the VS-1203 Rear Spar. Installation of the left side is a mirror of the right and is done at the same time.

Step 1: Separate the VS-1212A-R Lower Spar Cap and VS-1212B-R Upper Spar Cap, and trim the lower spar cap by removing the material called out in Figure 1. Mark (Section 5C) the parts with the part numbers shown in Figure 1.

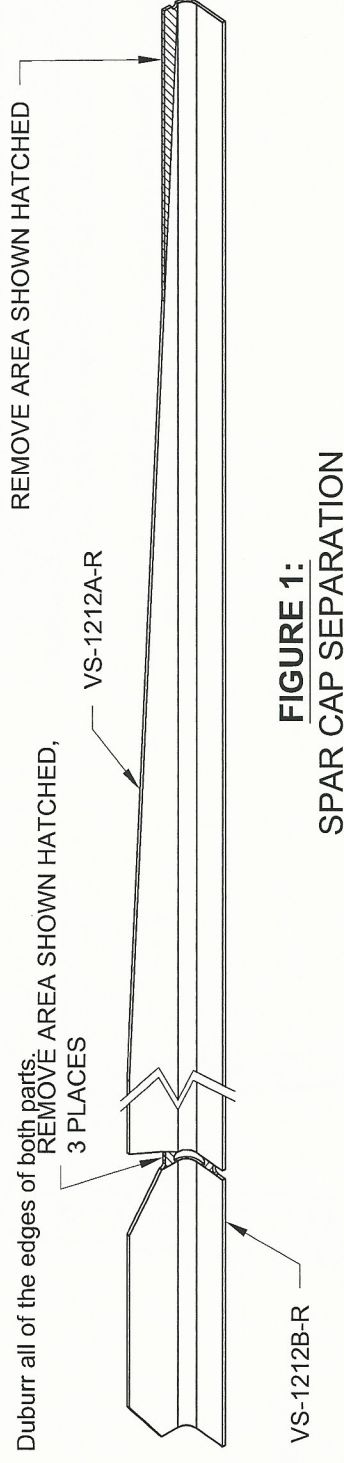


FIGURE 1:
SPAR CAP SEPARATION

Step 2: Mark the VS-1212B-R Upper Spar Cap with a reference line on the surface that nests against the VS-1203 Rear Spar web per the dimension shown in Figure 2.

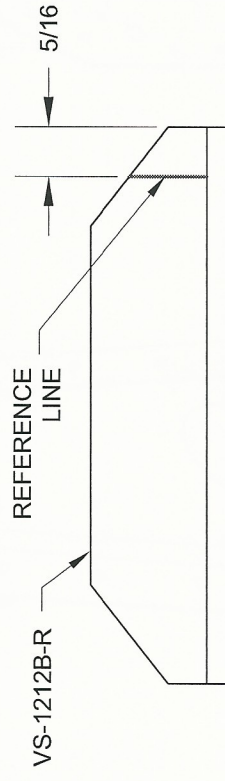


FIGURE 2:
SPAR CAP REFERENCE LINE

Step 3: Nest the VS-1212B-R Upper Spar Cap into the VS-1203 Rear Spar so the reference line shows through the center of the #30 hole in the rear spar web called out in Figure 3.

Clamp the upper spar cap in place.

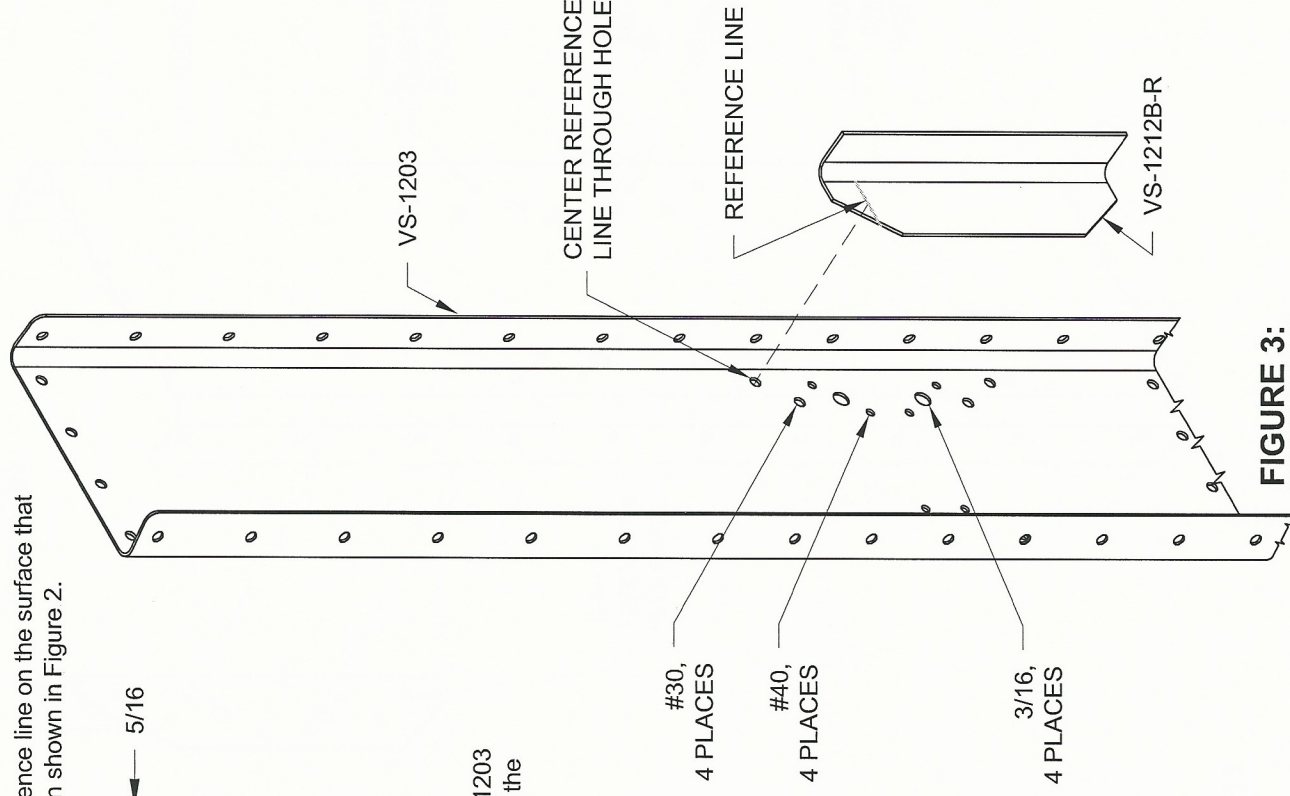


FIGURE 3:
UPPER SPAR CAP MATCH-DRILL

NOTE: For Steps 4 through 7, refer to Figure 3 and 4

Step 4: Nest the VS-1212A-R Lower Spar Cap into the VS-1203 Rear Spar. Align the bottom edge of the lower spar cap flush with the bottom edge of the rear spar web then clamp it in place along the rear spar flange.

Starting from the #30 hole nearest to the bottom of the rear spar web, match-drill #30 about every fourth hole of the rear spar web into the lower spar cap. Cleco each hole as you drill and be sure to drill perpendicular to the rear spar web. After reaching the top of the lower spar cap, move on to the VS-1212B-R Upper Spar Cap. Match-drill #30 the four #30 holes in the rear spar web into the upper spar cap.

Remove the upper and lower spar caps and deburr the match-drilled holes. Clear away any chips, then cleco the upper and lower spar caps back in place. Match-Drill the remaining #30 holes of the rear spar web into the lower spar caps.

Step 5: Match-Drill #30 the VS-1203 Rear Spar flange holes into the VS-1212A-R and VS-1212B-R Upper and Lower Spar Caps. Cleco as you go.

Step 6: Match-Drill #40 the nutplate attach rivet holes from the VS-1203 Rear Spar into the VS-1212B-R Upper Spar Cap. With the same size bit match-drill the #40 holes near the bottom of the rear spar web into the VS-1212A-R Lower Spar Cap.

Step 7: Match-Drill #12 the 3/16 holes of the VS-1203 Rear Spar into the VS-1212A-R and VS-1212B-R Upper and Lower Spar Caps.

Remove the spar caps, deburr the holes and clear away any chips.

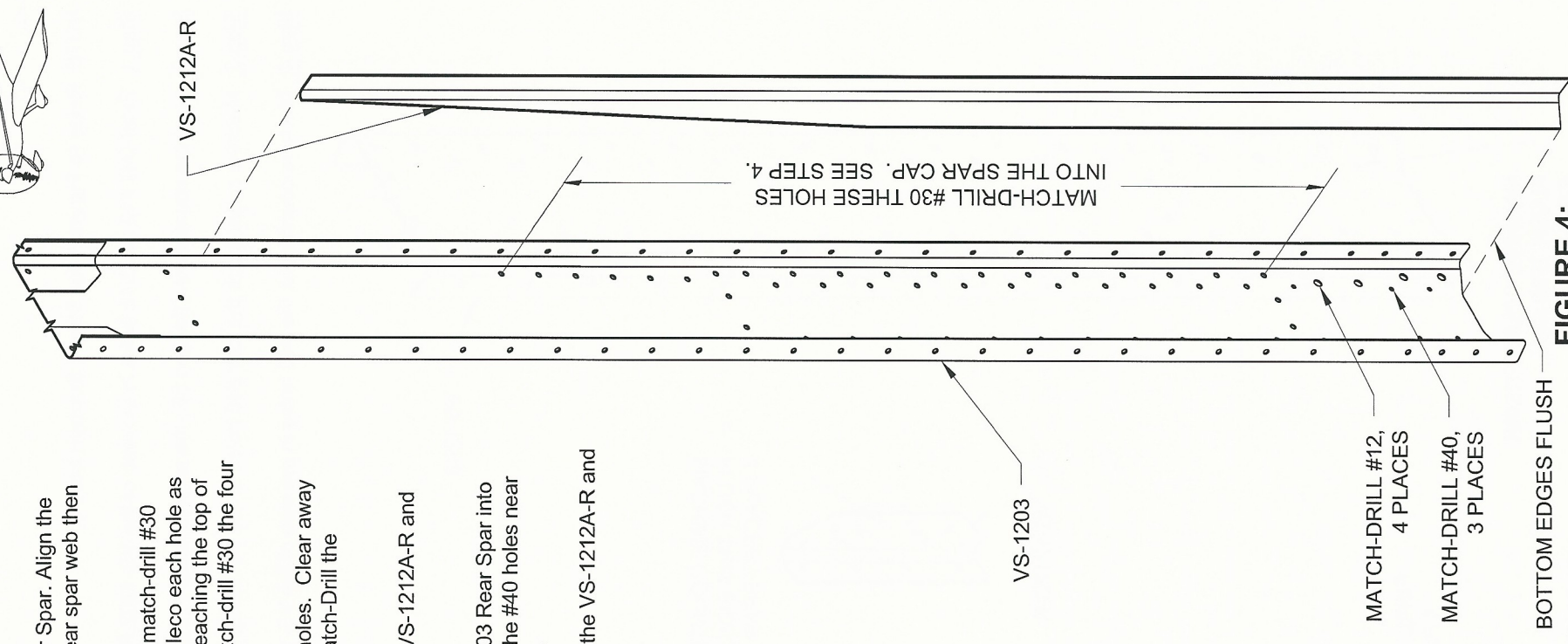


FIGURE 4:
LOWER SPAR CAP MATCH-DRILL