



Step 7: Rivet the nutplates to the VS-1202 Front Spar per call-out in Figure 3.

**NOTE:** The blind rivets for the VS-1203 Rear Spar should be set with the manufactured head on the spar cap side of the rear spar web since they will be visible on the finished assembly.

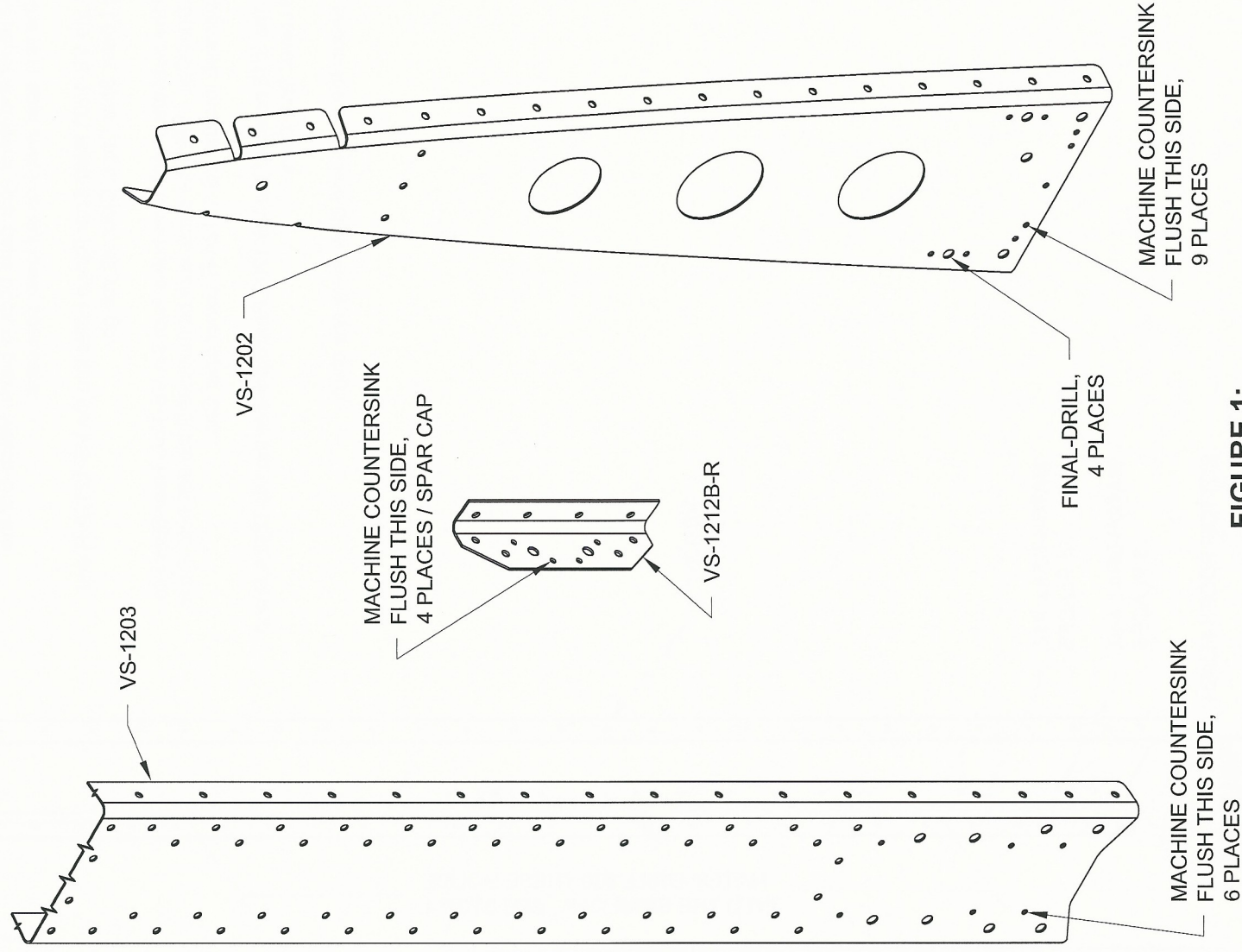
**NOTE:** Refer to Figure 1 for Step 1 through Step 4.

Step 1: Final-Drill #12 the 3/16 holes in the web of the VS-1202 Front Spar.

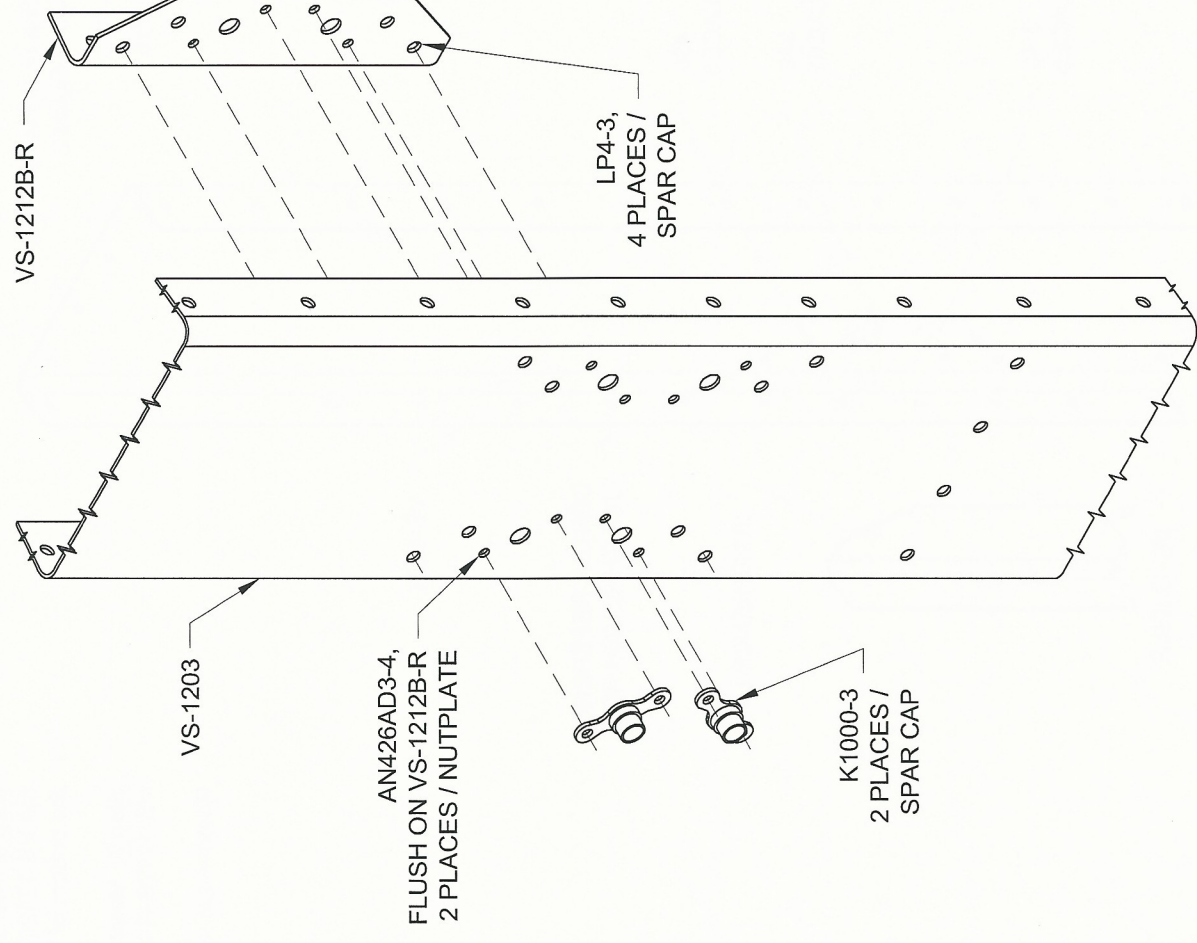
Step 2: Machine countersink (Section 5E) the six #40 holes in the web of the VS-1203 Rear Spar flush for 3/32 rivets.

Step 3: Machine countersink the four #40 holes in the VS-1212B-R & -L Upper Spar Caps flush for 3/32 rivets.

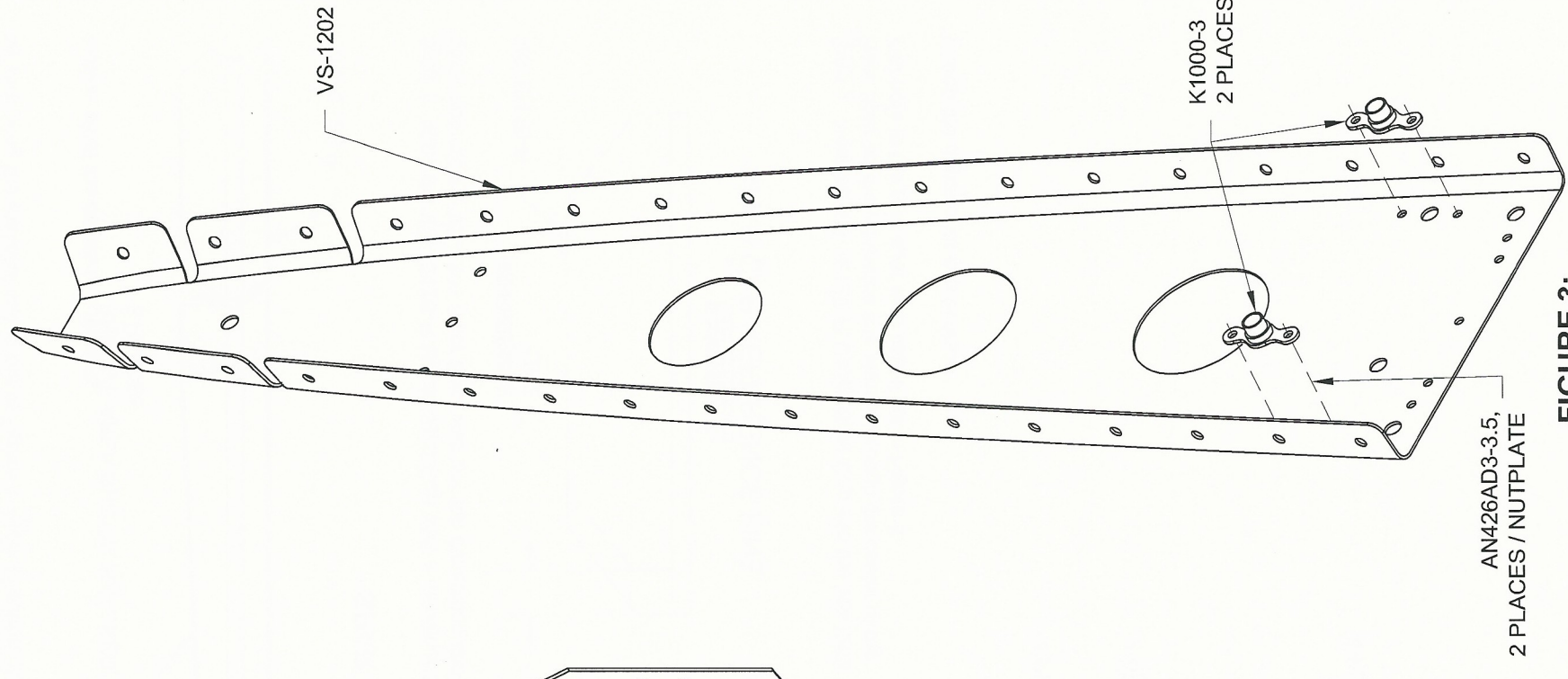
Step 4: Machine countersink the #40 holes in the web of the VS-1202 Front Spar flush for 3/32 rivets.



**FIGURE 1:**  
PART PREPARATION



**FIGURE 2:**  
SPAR CAP INSTALLATION



**FIGURE 3:**  
NUTPLATE INSTALLATION