Step 1: Radius the edges at the narrow end of the VS-1205 Tip Rib, the VS-1206 Mid Rib and the VS-1202 Front Spar as shown in Figure 1.

A great way to cut the radius is with a fine file.

Step 2: Flute (Section 5N) between the holes in the flanges of the VS-1202 Front Spar and any of the other vertical stabilizer ribs as necessary to straighten the flange hole pattern.

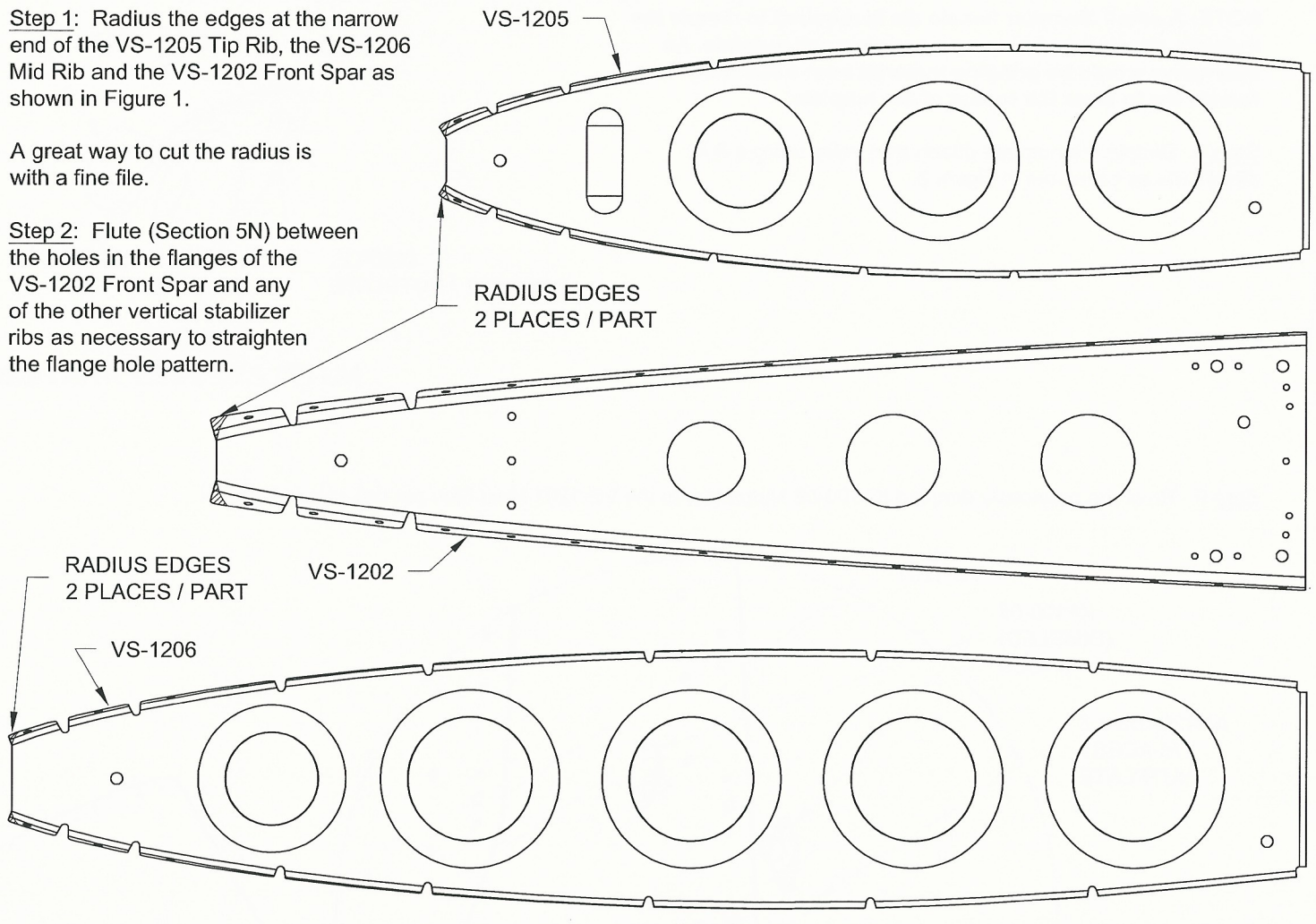

FIGURE 1:
RIB PREPARATION

Step 3: Rivet the VS-1202 Front Spar, the VS-1208 Lower Main Rib, and the nutplates together. Orient rib flanges as shown in Figure 2. Flush rivet on the previously countersunk side of the front spar.

Step 4: Rivet the VS-1207 Upper Main Rib to the VS-1202 Front Spar. Hardware call-out and rib flange orientation shown in Figure 2.

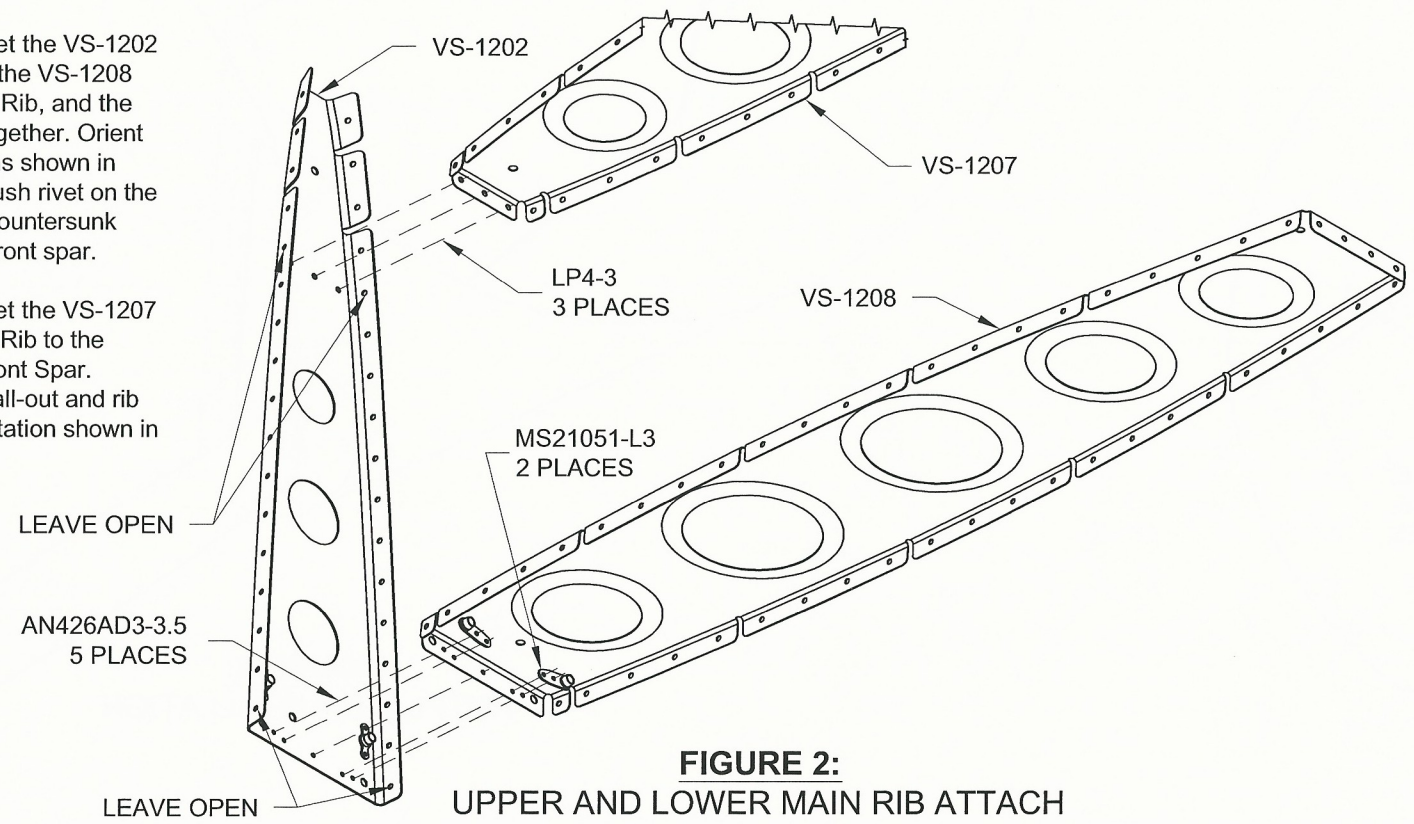

FIGURE 2:
UPPER AND LOWER MAIN RIB ATTACH

NOTE: Rib flange orientation and hardware call-outs for Step 5 through Step 8 are shown in Figure 3.

Step 5: Rivet the VS-1212A-L & -R Lower Spar Cap to the VS-1203 Rear Spar using the rivets called out. Place tape over the holes to be left open. Leave open all rear spar flange holes and the rib attach holes for this step.

Step 6: Rivet the VS-1207 Upper and VS-1208 Lower Main Rib to the VS-1203 Rear Spar and VS-1212A-L & -R Lower Spar Caps.

Step 7: Rivet the VS-1206 Mid Rib to the VS-1203 Rear Spar.

Step 8: Rivet the VS-1205 Tip Rib to the VS-1203 Rear Spar.

Refer to this sub-assembly as the V-Stab Skeleton Assembly.

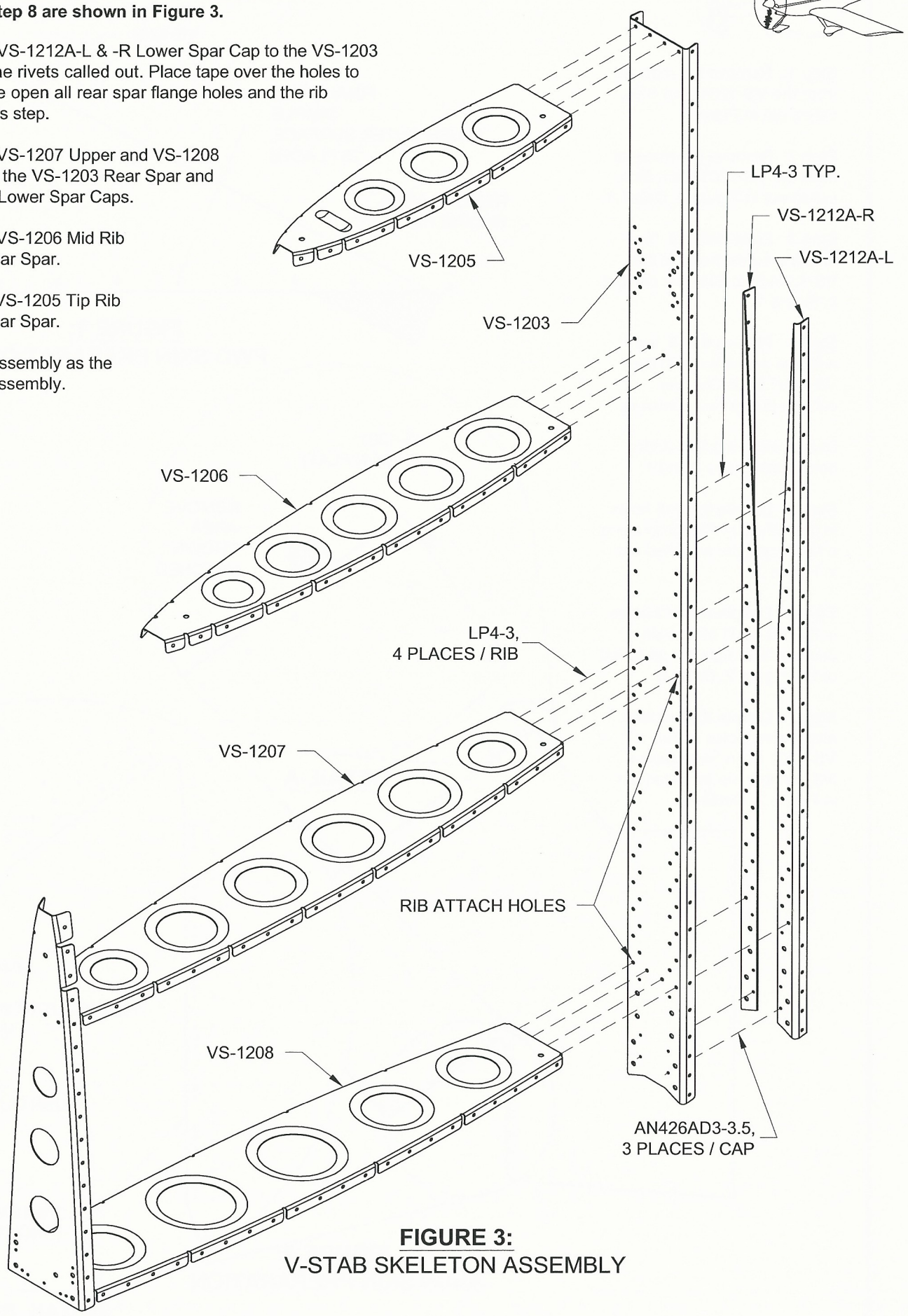

FIGURE 3:
V-STAB SKELETON ASSEMBLY