

NOTE: The spars in Figure 1 are shown unbent and oriented as if the flanges bend down. All countersinking done on the spars and spar caps will be done on the outer surfaces.

- Step 1: Machine countersink the HS-1202 Fwd Spar for 1/8 inch rivets in the holes on both of the flanges as called out in Figure 1.
- Step 2: Machine countersink the HS-1203 Aft Spar for 1/8 inch rivets in the holes on both of the flanges as called out in Figure 1.
- Step 3: Machine countersink the HS-1202 Fwd Spar for 3/32 inch rivets in the nutplate attach rivet holes on the web as called out in Figure 1.
- Step 4: Machine countersink both of the HS-1211 Spar Caps for 3/32 inch rivets in the holes called out in Figure 1.

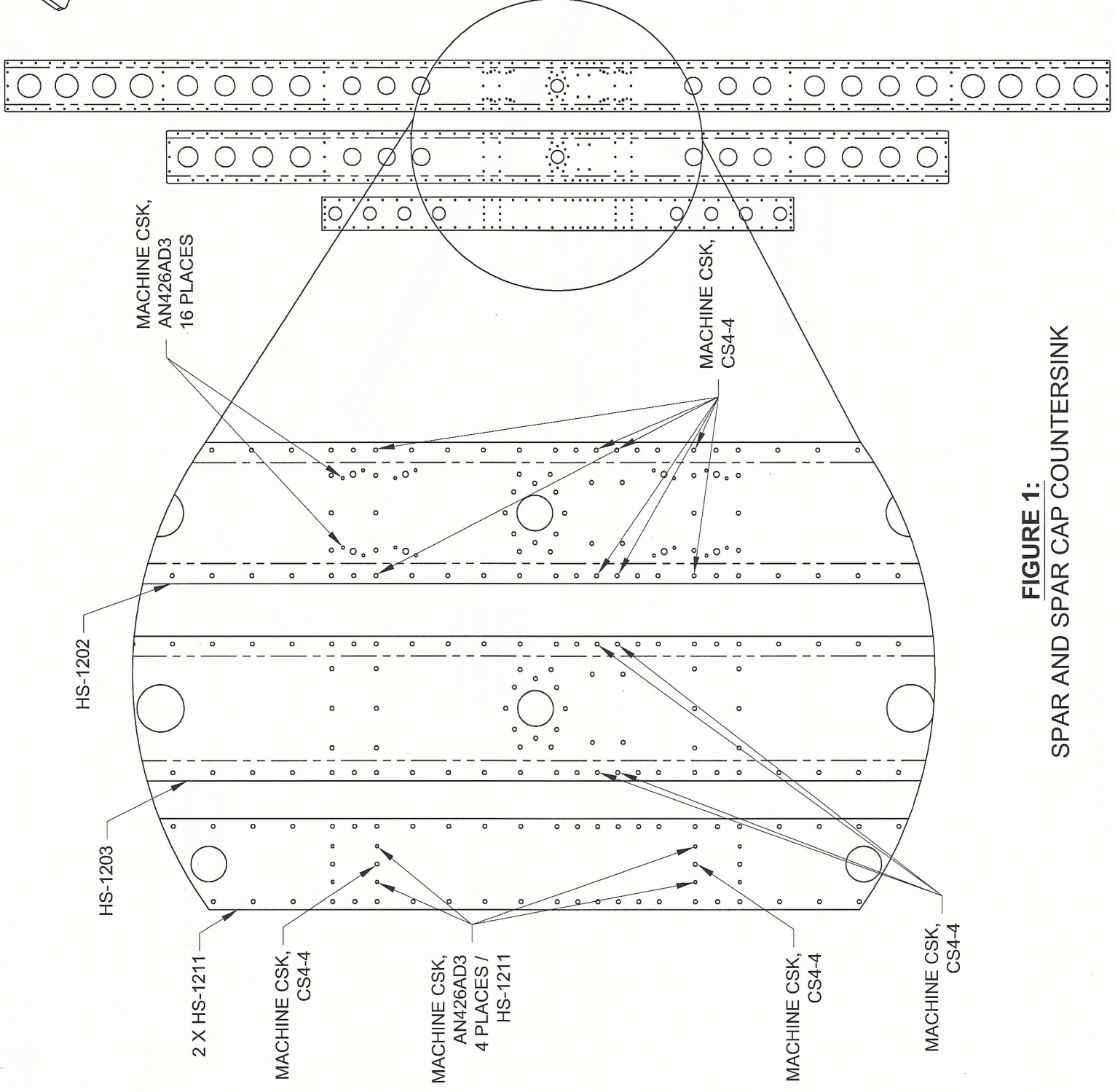
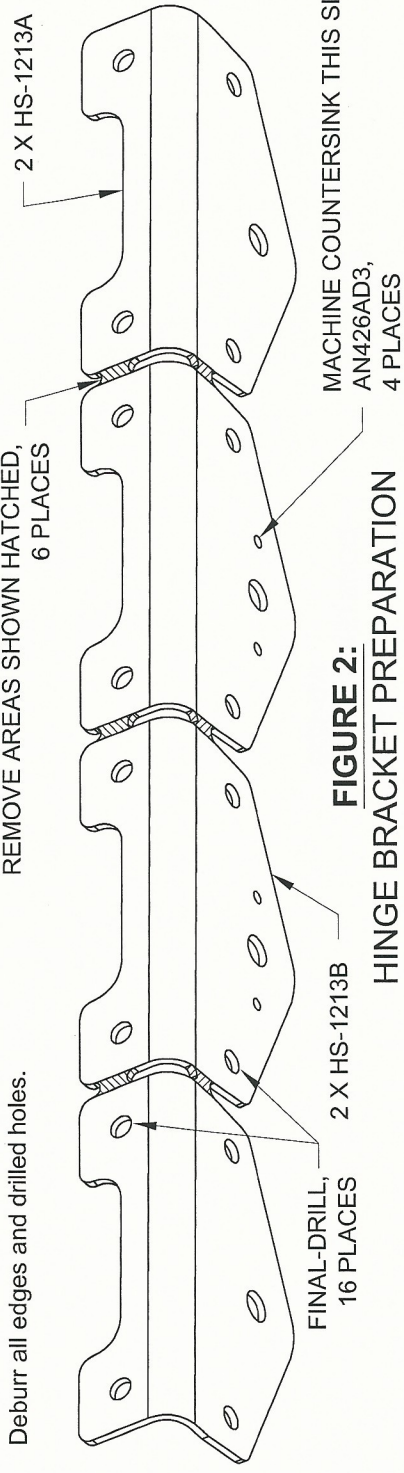
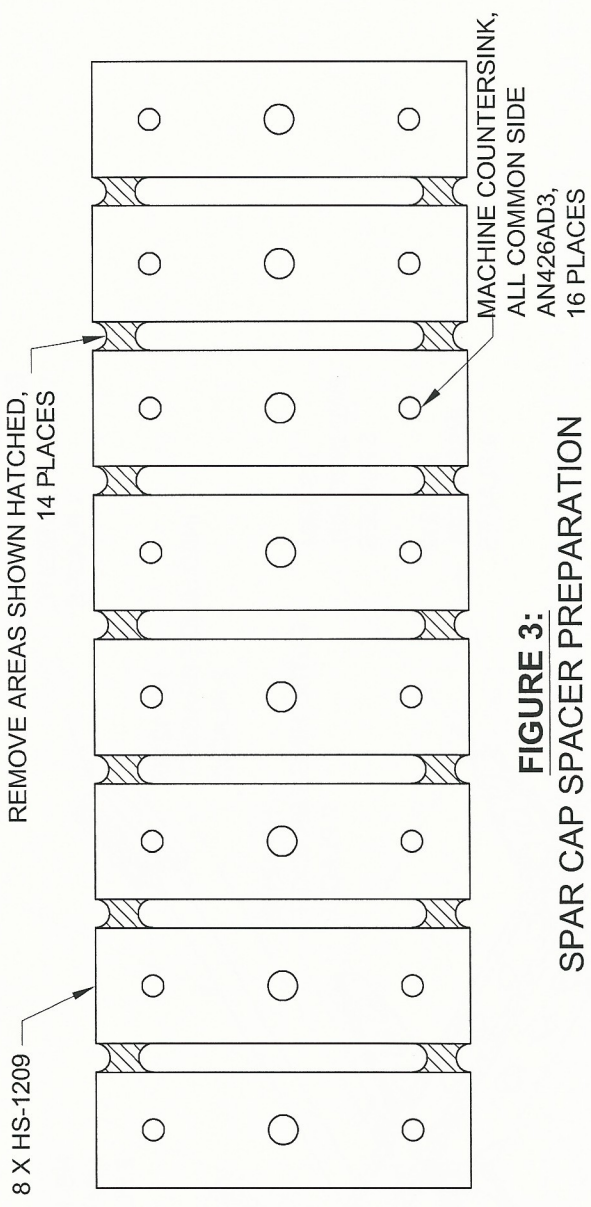


FIGURE 1:
SPAR AND SPAR CAP COUNTERSINK

- Step 5: Machine countersink the HS-1213 Hinge Bracket at the nutplate attach rivet holes for 3/32 inch rivets per call-out in Figure 2.
- Step 6: Final-Drill #12 the HS-1213 Hinge Bracket through all of the 3/16 inch holes as called out in Figure 2.
- Step 7: Trim the HS-1213 Hinge Bracket to make the HS-1213A Inbd and HS-1213B Outbd Hinge Brackets by removing the material shown hatched in Figure 2.



- Step 8: Machine countersink the #40 holes in the HS-1209 Spar Cap Spacers for 3/32 inch rivets per call-out in Figure 3.
- Step 9: Separate the HS-1209 Spar Cap Spacers by removing the material shown hatched in Figure 3.



- Step 10: Separate the HS-1224 Doublers by removing the material shown hatched in Figure 4. Deburr the edges of the separated parts.

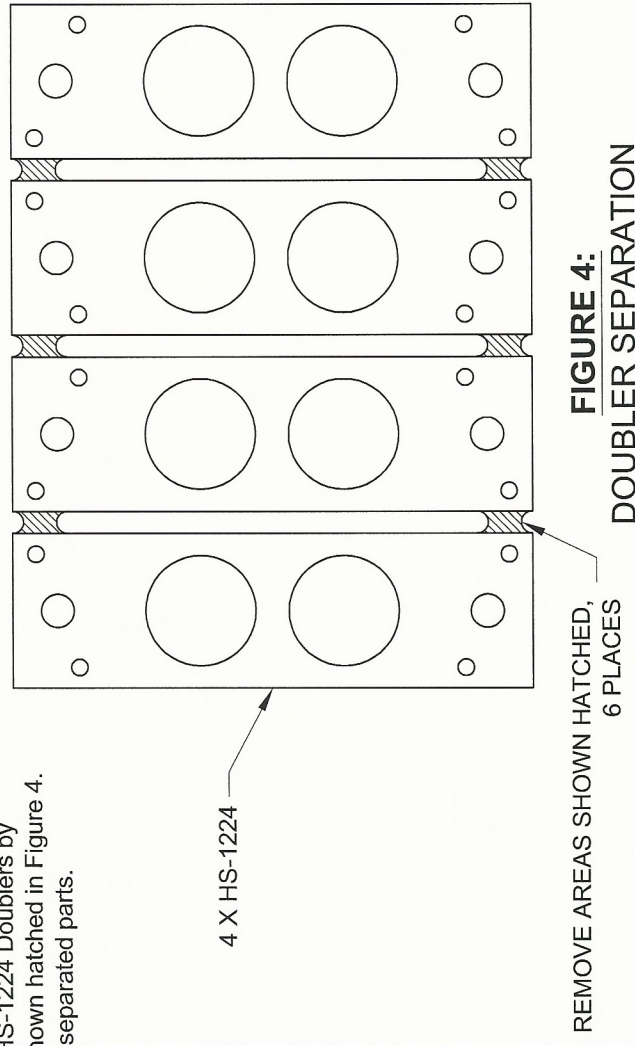


FIGURE 4:
DOUBLER SEPARATION