



Step 1: Cut the 5/16 aluminum tube to make four HS-1210 Hinge Stops per dimensions in Figure 1.

Deburr the hinge stops.

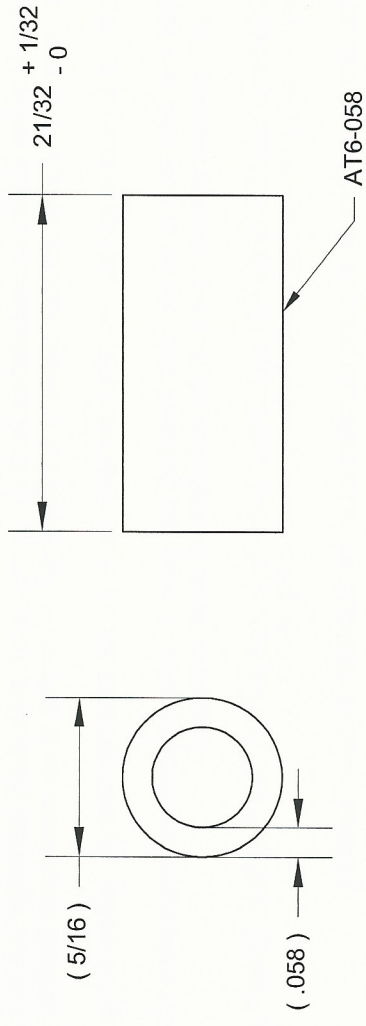


FIGURE 1:
HS-1210 HINGE STOP FABRICATION

Step 2: Separate the HS-1214 Rib Clips by removing the material shown hatched in Figure 2.

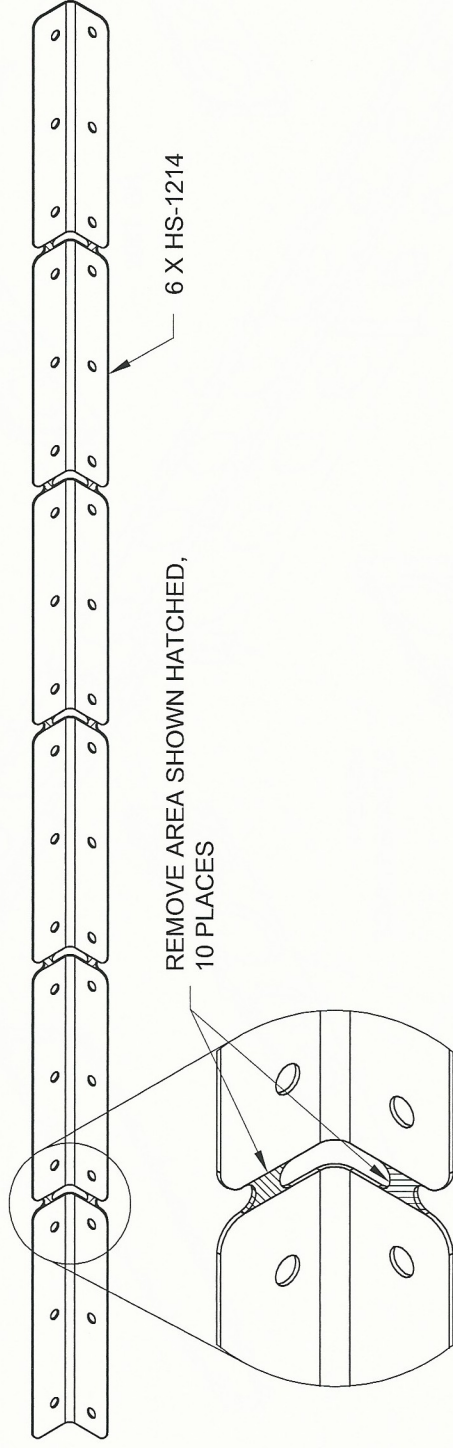


FIGURE 2:
RIB CLIP SEPARATION

Step 3: Cleco the Spar Box Assembly back together. Check alignment of HS-1202 Fwd and HS-1203 Aft Spar flange holes to the corresponding holes in both HS-1211 Spar Caps. All spar flange holes must align with spar cap holes.

Step 4: Rivet the previously countersunk holes in both flanges of the HS-1202 Fwd and HS-1203 Aft Spar to the HS-1211 Spar Caps per call-out in Figure 3.

Step 5: Rivet the HS-1202 Fwd and HS-1203 Aft Spar to the inboard HS-1212 Inspar Ribs using rivets called out in Figure 3.

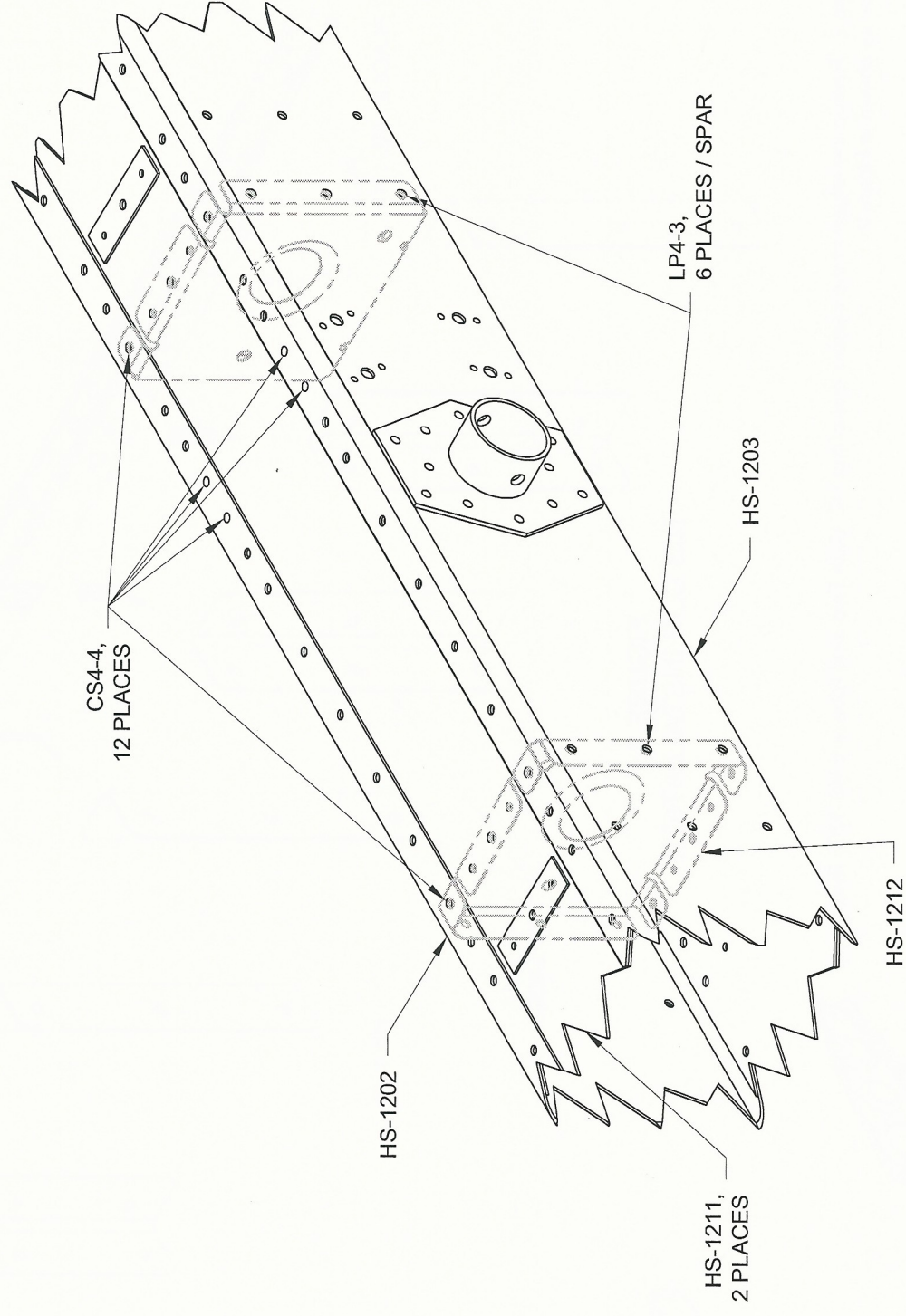


FIGURE 3:
SPAR BOX ASSEMBLY