

FIGURE 1:
ATTACH ANGLE POSITIONS

Step 1: Cleco the W-1206V Attach Angles to the W-1206-L & -R, Spar Assemblies as shown in Figure 1. Orient all of the attach angles so the short flange, that contacts the web of the spar assembly channel, points inboard.

Step 2: Cleco the W-1206T Attach Angle to the outboard end of the W-1206-L & -R, Spar Assemblies as shown in Figure 1.

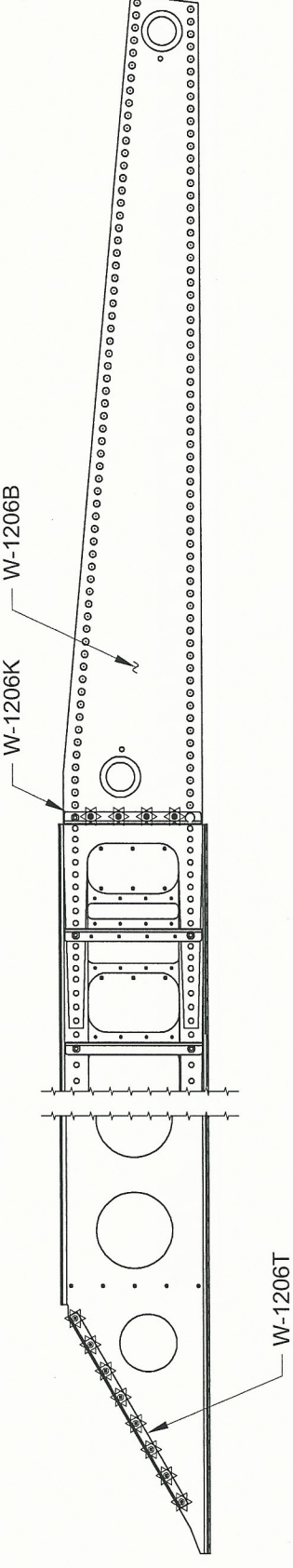


FIGURE 2:
W-1206-R SPAR ASSEMBLY RIVETS

Step 3: Rivet the W-1206T Attach Angle to the W-1206-R Spar Assembly channel. Rivet the inboard most W-1206K Attach Angle, which comes attached to the right spar assembly, to the W-1206B Spar Stub Doubler as shown in Figure 2.

Step 4: Rivet all of the W-1206V Attach Angles to the W-1206-L & -R, Spar Assemblies. Rivet the W-1206T Attach Angle to the left spar assembly as shown in Figure 3.

Step 5: Rivet the W-1206-L & -R, Spar Assemblies at the remaining holes marked with the symbol in Figure 3.

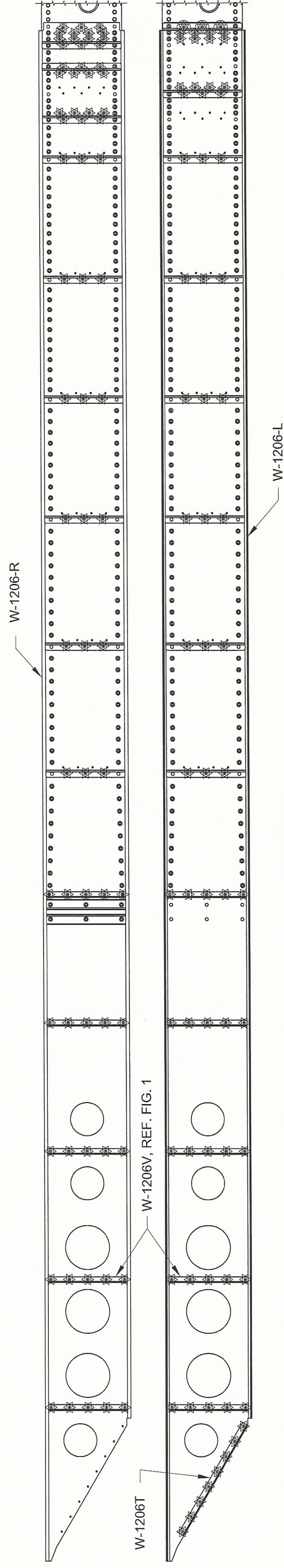


FIGURE 3:
SPAR ASSEMBLY RIVETS