



Step 1: Flute and straighten all of the W-1208 Nose Rib flanges.

Step 2: Select 13 of the 14 W-1208-L Nose Ribs and trim the aft flange as shown in Figure 1.

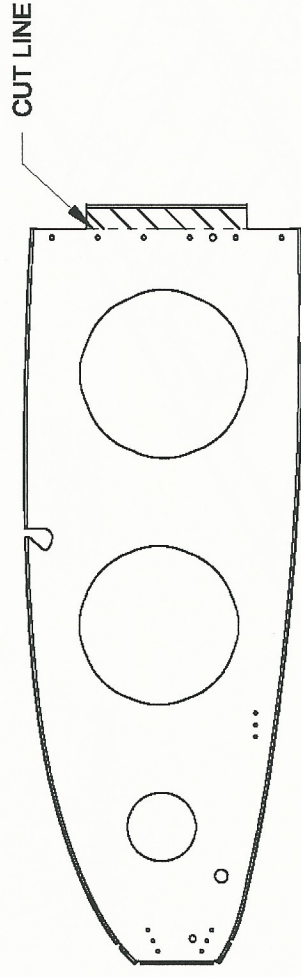


FIGURE 1: W-1208 NOSE RIB AFT FLANGE TRIM

Step 3: Take five of the 13 W-1208-L Nose Ribs that you just trimmed and trim off the upper and lower forward flanges as shown in Figure 2.

Step 4: Select the one W-1208-L Nose Rib that is untrimmed and trim the forward upper and lower flanges as shown in Figure 2.

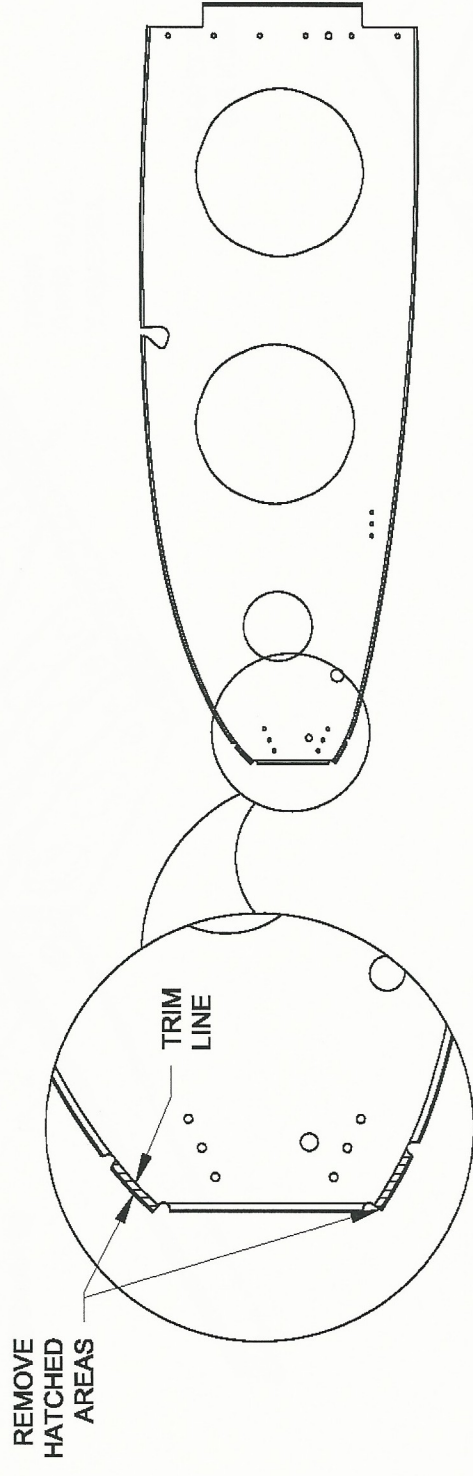


FIGURE 2: W-1208 NOSE RIB FWD FLANGE TRIM

Step 5: Take seven of the 14 W-1208-R Nose Ribs and trim off the aft flange as shown in Figure 1.

Step 6: Select two of the seven W-1208-R Nose Ribs with the aft flange trimmed and trim the forward upper and lower flanges as shown in Figure 2.

Step 7: Select four of the seven W-1208-R Nose Ribs that are untrimmed and trim the forward upper and lower flanges as shown in Figure 2.

Step 8: Cut apart the two W-1216B Hinge Ribs into W-1216B-L and W-1216B-R Hinge Ribs as shown in Figure 3.

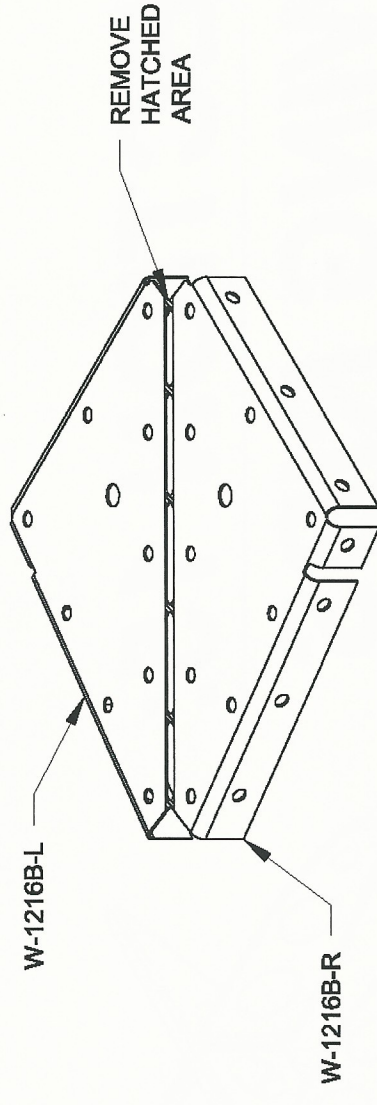


FIGURE 3: SEPARATING HINGE RIBS

Step 9: Select one each of the W-1208-L Nose Ribs and W-1208-R Nose Ribs with the aft and forward trimmed flanges. Dimple the rivet hole locations as shown in Figure 4. Final drill #19 the center nutplate hole as shown in Figure 4. Dimple then install three nutplates on each nose rib as shown in Figure 4.

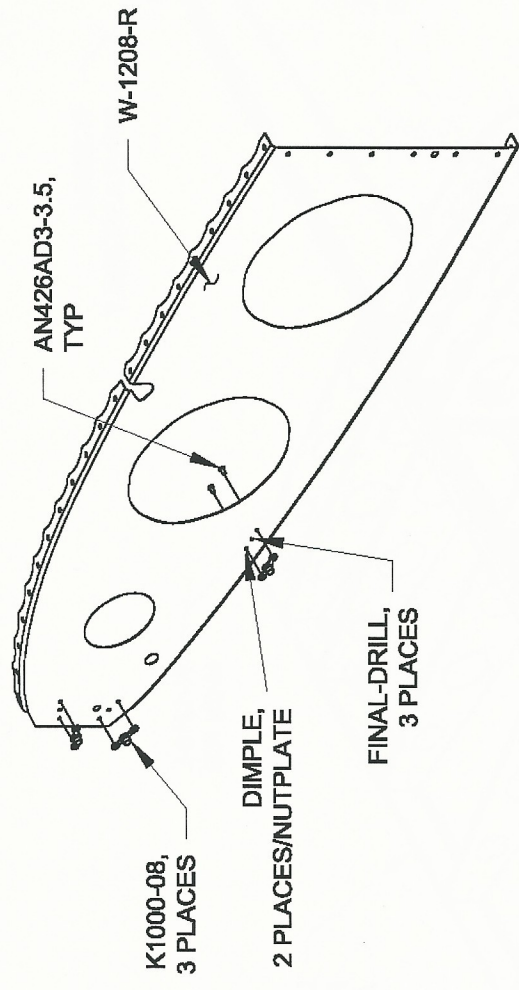


FIGURE 4: ADDING THE NUTPLATES TO FWD AND AFT TRIMMED NOSE RIBS

Step 10: Select one of the three untrimmed W-1208-R Nose Ribs and dimple the rivet hole locations for the two forward nutplates as shown in Figure 5. Final-Drill #19 the center nutplate holes. Dimple then install two nutplates on the nose rib as shown in Figure 5.

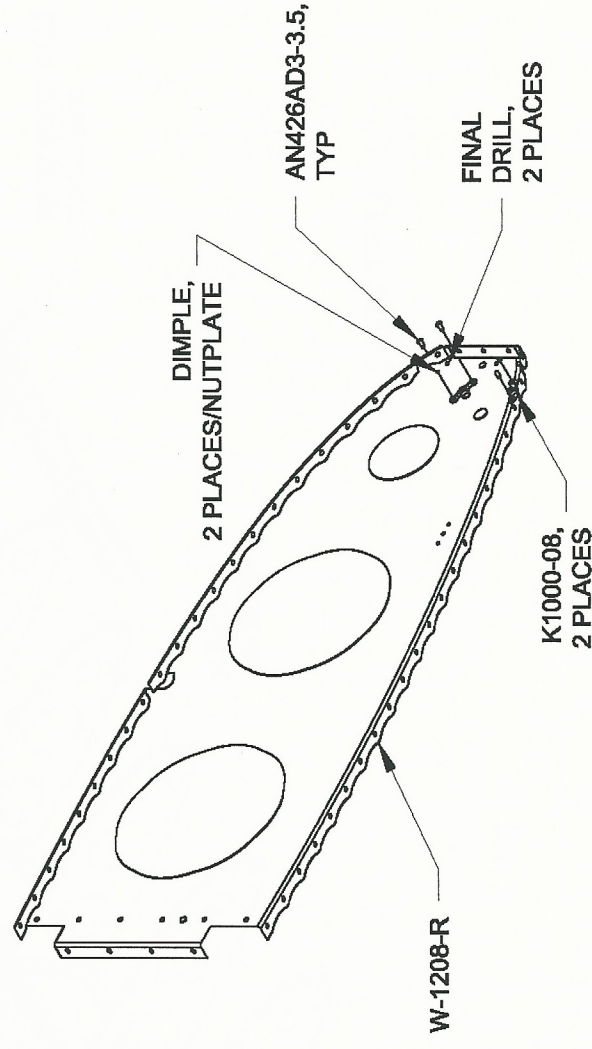


FIGURE 5: ADDING THE NUTPLATES TO UNTRIMMED NOSE RIB