



Step 1: Flute and straighten all of the W-1210 Main Rib flanges.

Step 2: Select six of the 13 W-1210-L Main Ribs and trim the fwd flange as shown in Figure 1.

Step 3: Trim the forward flange of all 13 W-1210-R Main Ribs as shown in Figure 1.

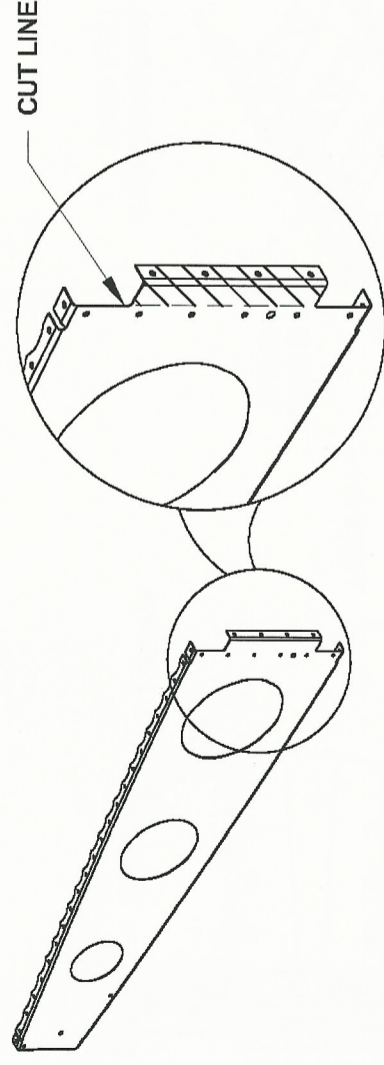


FIGURE 1: W-1210 MAIN RIB FWD FLANGE TRIM (LEFT SHOWN)

Step 4: Cleco the W-1210B-L Rib Doubler to one of the six trimmed W-1210-L Main Ribs as shown in Figure 2. Match-Drill #30 the trimmed main rib using the rib doubler as a drill guide. Uncleco the main rib and rib doubler. Deburr.

Step 5: Select one of the W-1210-R Main Ribs and cleco the W-1210B-R Doubler as shown in Figure 2. Match-Drill #30 the main rib using the rib doubler as a drill guide. Remove the clecos and rib doubler. Deburr.

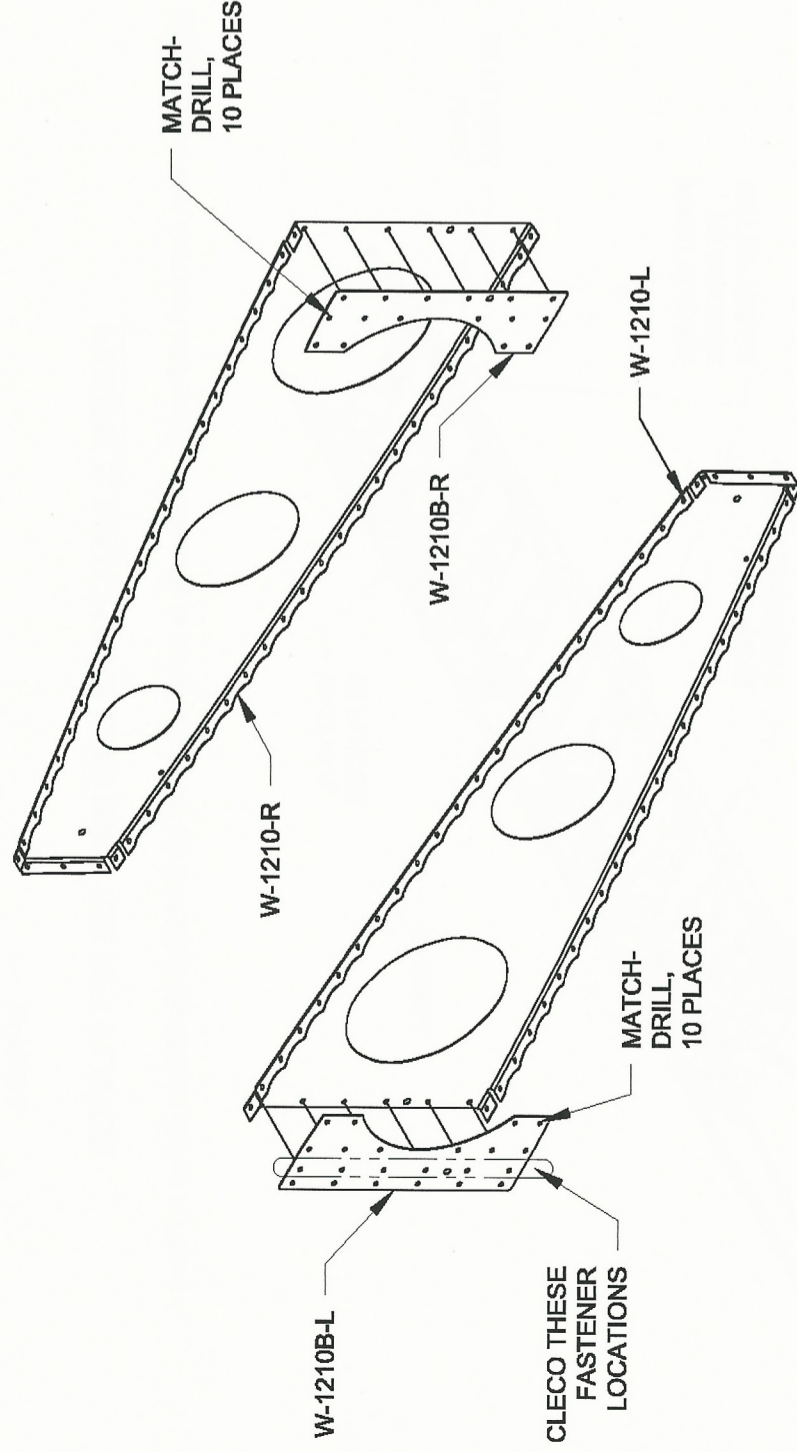


FIGURE 2: MATCH-DRILLING THE RIB DOUBLERS AND MAIN RIBS

Step 6: Select two of the W-1210-R Main Ribs and cleco one of them to the W-1216 Hinge Bracket Assembly and W-1216B-L Hinge Rib. Match-Drill #30 as shown in Figure 3. Repeat for the second main rib. Remove clecos, flaperon hinge brackets, and hinge ribs. Deburr.

Step 7: Select one of the forward flange trimmed W-1210-L Main Ribs and one of the unmodified left main ribs and cleco each to a W-1216 Hinge Bracket Assembly and W-1216B-R Hinge Rib. Match-Drill as shown in Figure 3. Remove clecos and Hinge Bracket Assemblies. Deburr.

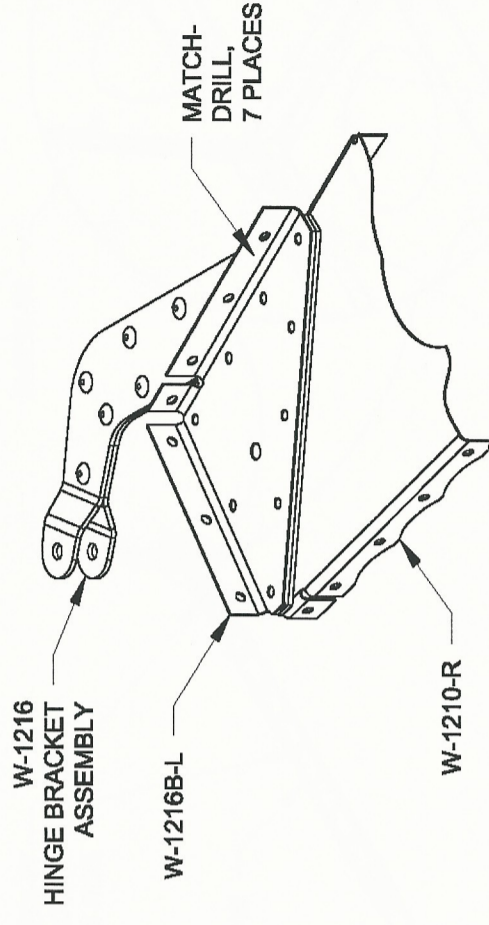


FIGURE 3: MATCH-DRILLING THE FLAPERON HINGE BRACKETS AND MAIN RIBS

NOTE: Take care not to rivet the row of holes that are needed to attach the W-1210-L and W-1210-R Main Ribs and W-1210B-L and W-1210B-R Rib Doublers to the W-1206-L and W-1206-R Spar Assemblies.

Step 8: Rivet the W-1210B-L Rib Doubler to the match-drilled W-1210-L Main Rib as shown in Figure 4.

Step 9: Rivet the W-1210B-R Rib Doubler to the match-drilled W-1210-R Main Rib as shown in Figure 4.

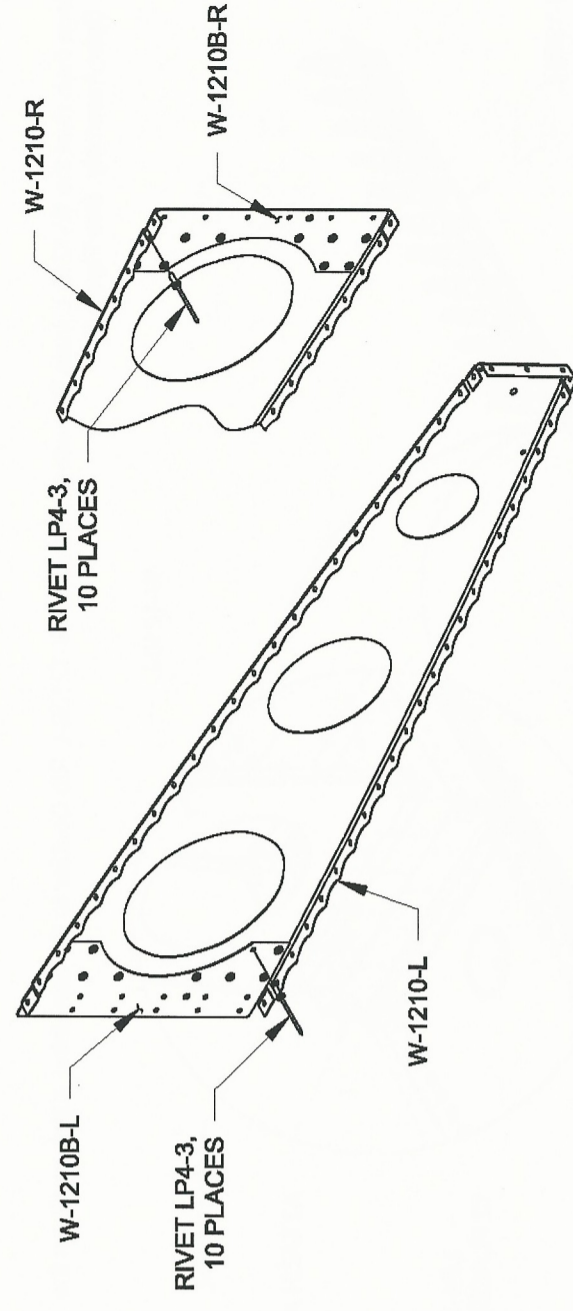


FIGURE 4: RIVETING THE RIB DOUBLERS TO THE MAIN RIBS