



Step 1: Flip-over the wing placing it right-side-up on the table with the leading edge overhanging the edge by four inches. A helper will definitely be required to flip the wing over and a second helper might be useful to stabilize the overhanging portion of the skins and prevent them from becoming creased across the most forward row of rivets as the wing is being re-positioned.

Step 2: Cleco the W-1201-L, W-1202-L, & W-1203-L Inbd, Mid, & Outbd Wing Skins to the skeleton using the open holes on the bottom and the top of the wing. Rivet the inbd, mid, & outbd wing skins to the skeleton as called-out in Figure 1. Remove any remaining clecos.

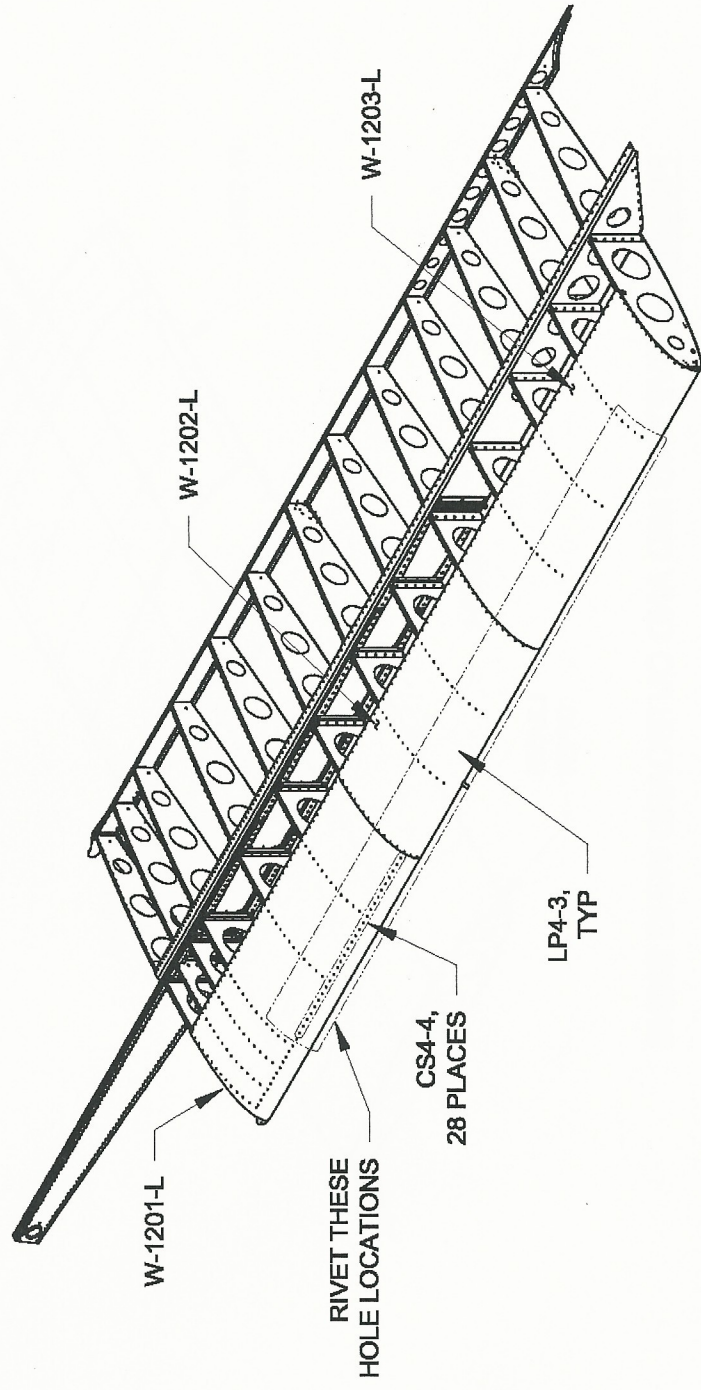


FIGURE 1: RIVETING THE LEADING EDGE

Step 3: Cleco the bottom flange of the two W-1216B-L Hinge Ribs to the W-1202-L & W-1203-L Mid & Outbd Wing Skins. Rivet the bottom flange of the hinge ribs to the mid & outbd wing skins. See Figure 2. Insert two W-1216 Hinge Bracket Assemblies through the openings in the W-1202-L & W-1203-L Mid & Outbd Wing Skins. Flex the hinge ribs out of the way as required to allow insertion of the Hinge Bracket Assemblies. Insert clecos through the hinge ribs and Hinge Bracket Assemblies into the W-1210-R Main Ribs. Cleco the hinge ribs to the Rear Spar Assembly. Rivet the hinge ribs to the Hinge Bracket Assemblies, main ribs, and Rear Spar Assembly as shown in Figure 2.

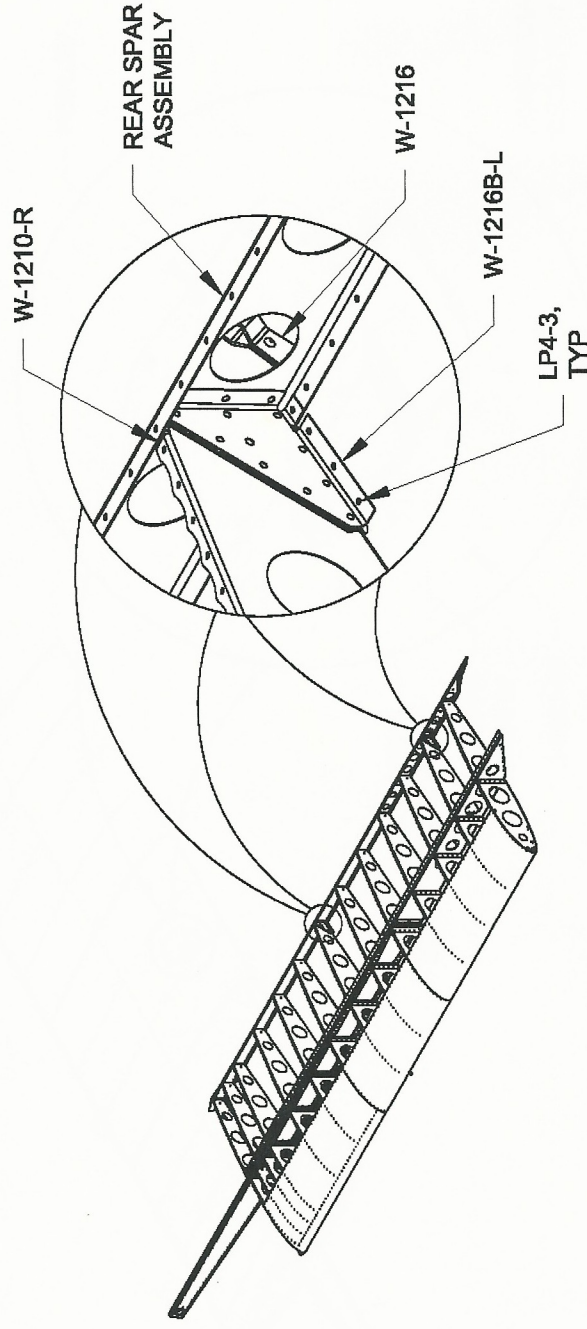


FIGURE 2: ATTACHING HINGE RIBS

Step 4: Position the W-1201B-L Inbd Upper Wing Skin

on the wing skeleton as shown in Figure 3. The stiffening flange along the leading edge of the inbd upper wing skin should drop into the cut-outs in the W-1208 Nose Ribs when you lift the trailing edge of the inbd upper wing skin. Cleco then rivet the inbd upper wing skin to the skeleton leaving holes open as shown in Figure 3.

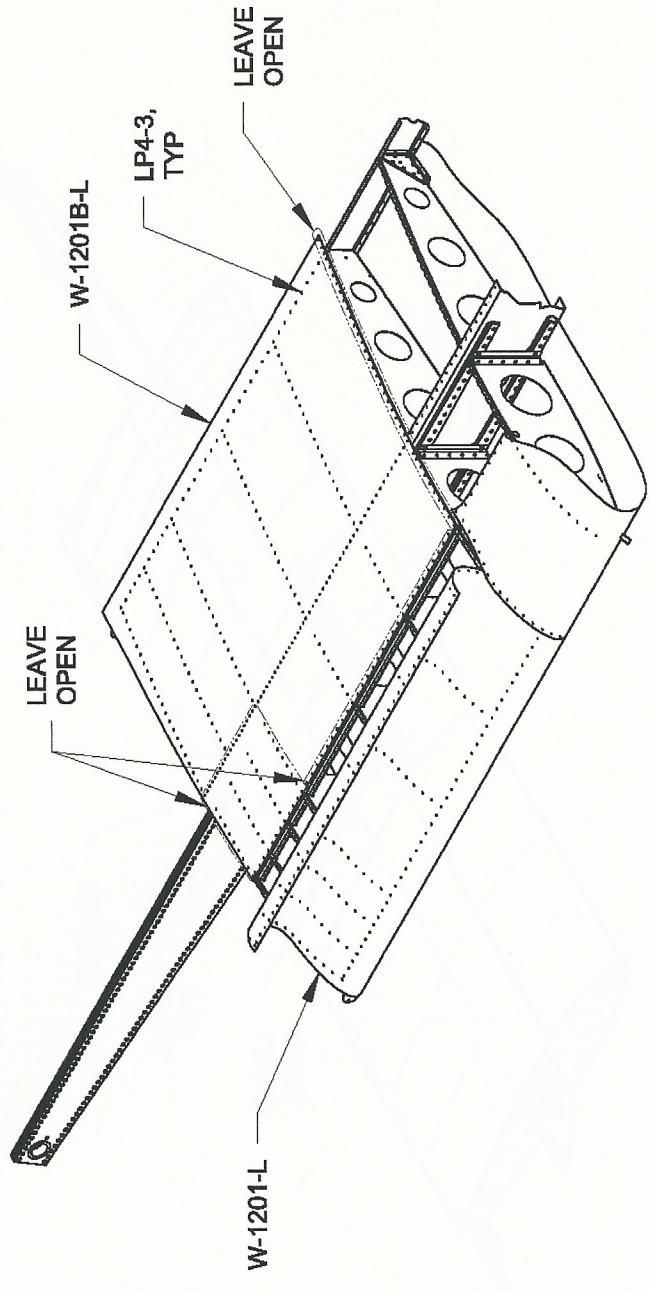


FIGURE 3: INBD UPPER WING SKIN INSTALLATION

Step 5: Cleco the W-1203B-L Outbd Upper Wing Skin to the wing skeleton as shown in Figure 4. Rivet the outbd upper wing skin to the skeleton leaving holes open as shown in Figure 4.

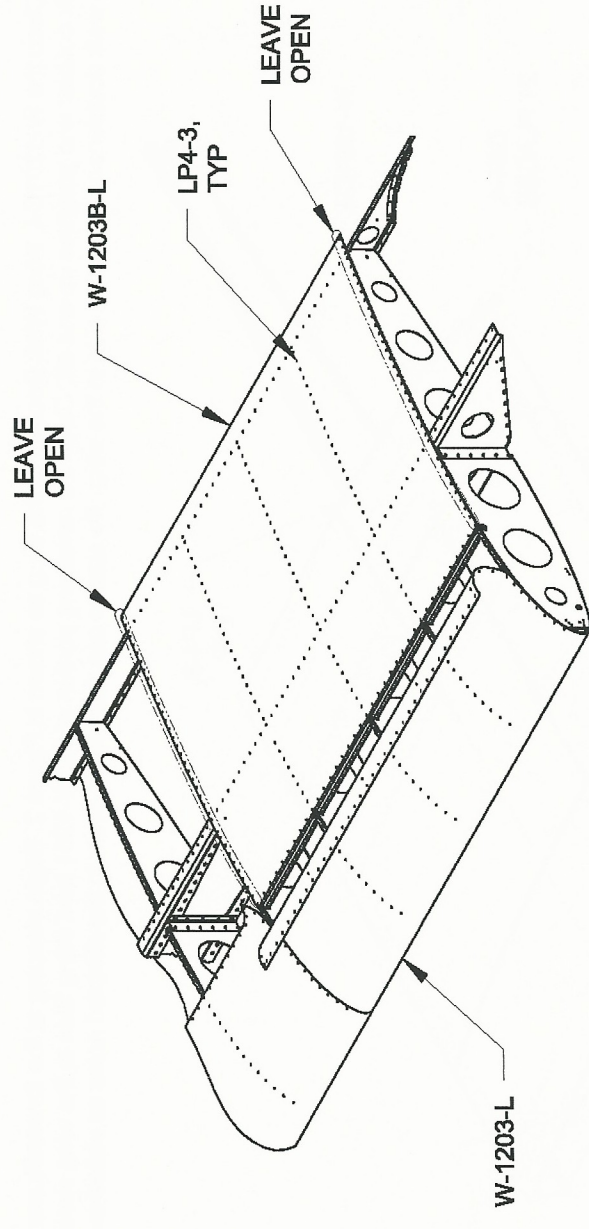


FIGURE 4: OUTBD UPPER WING SKIN INSTALLATION