



Step 1: Cleco one of the W-1202B Mid Upper Wing Skins to the wing skeleton as shown in Figure 1. Rivet the mid upper wing skin to the skeleton leaving holes open as shown in Figure 1.

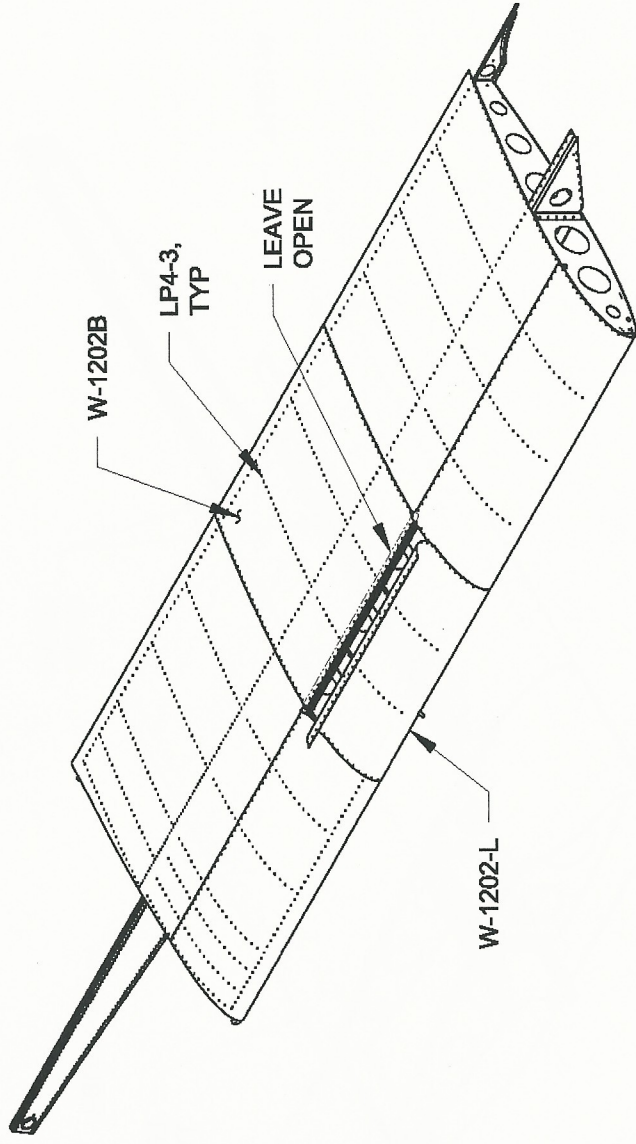


FIGURE 1: ATTACHING MID UPPER WING SKIN

Step 2: Dimple the three inboard holes in the W-1201C-L Wing Walk Doubler which are in line with the two rows of holes in the leading edge which are already dimpled.

NOTE: It may be necessary to make a slight edge bend to the forward edge of the W-1201C-L Wing Walk Doubler. See Section 5K for details on how to make the bend.

Step 3: Cleco the W-1201C-L Wing Walk Doubler to the wing as shown in Figure 2. Begin clecoing at the forward/lower edge of the wing walk doubler and progress up and aft. Cleco the remaining portion of the W-1201 Inbd Wing Skin to the wing skeleton. Rivet the wing walk doubler and inbd wing skin to the wing. Be sure to use flush-head rivets in the dimpled holes as called-out in Figure 2.

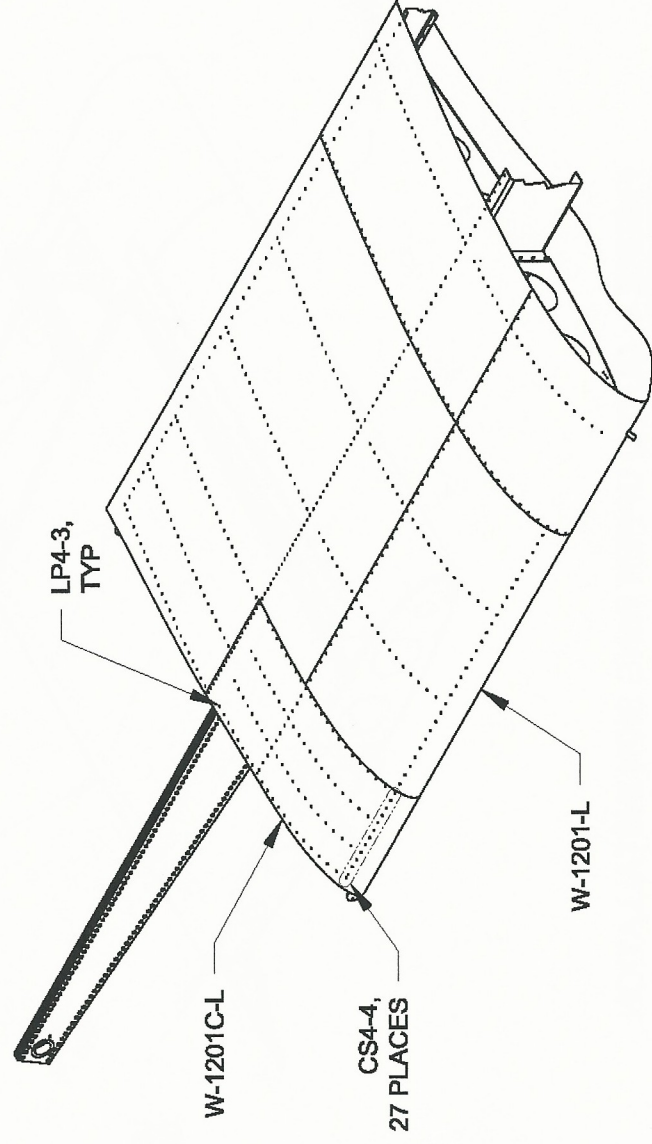


FIGURE 2: ATTACHING WING WALK DOUBLER

Step 4: Cleco the remaining portion of the W-1203-L Outbd Wing Skin and W-1202-L Mid Wing Skin to the wing. Rivet the outbd and mid wing skins to the wing leaving open holes as shown in Figure 3.

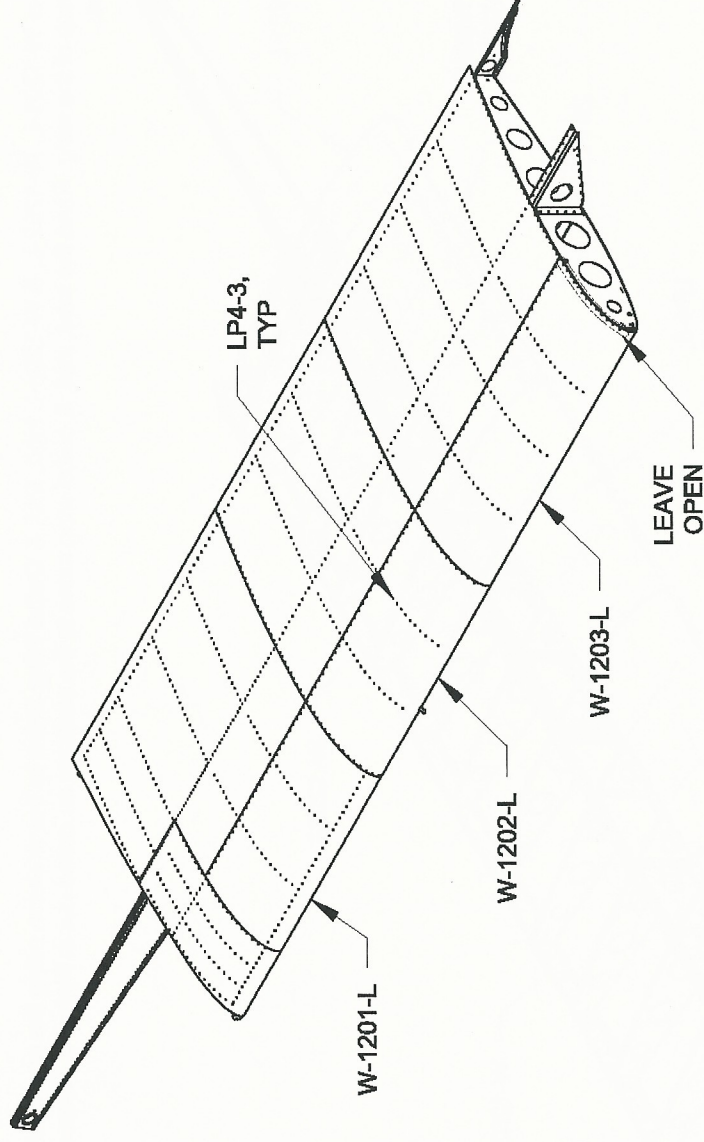


FIGURE 3: RIVETING MID AND OUTBOARD WING SKINS

Step 5: Flip-over the wing placing it upside-down on the table. Dimple the screw holes in the W-1202-L Mid Wing Skin and in the VA-195H Access Hatch as shown in Figure 4. Dimple the rivet holes in both the nutplates and in the mid wing skin for the access hatch as shown in Figure 4. Install nutplates on the mid wing skin as shown in Figure 4. Install the access hatch.

Step 6: Repeat all steps from page 17-02 Step 2 through Step 4 on this page for the right wing.

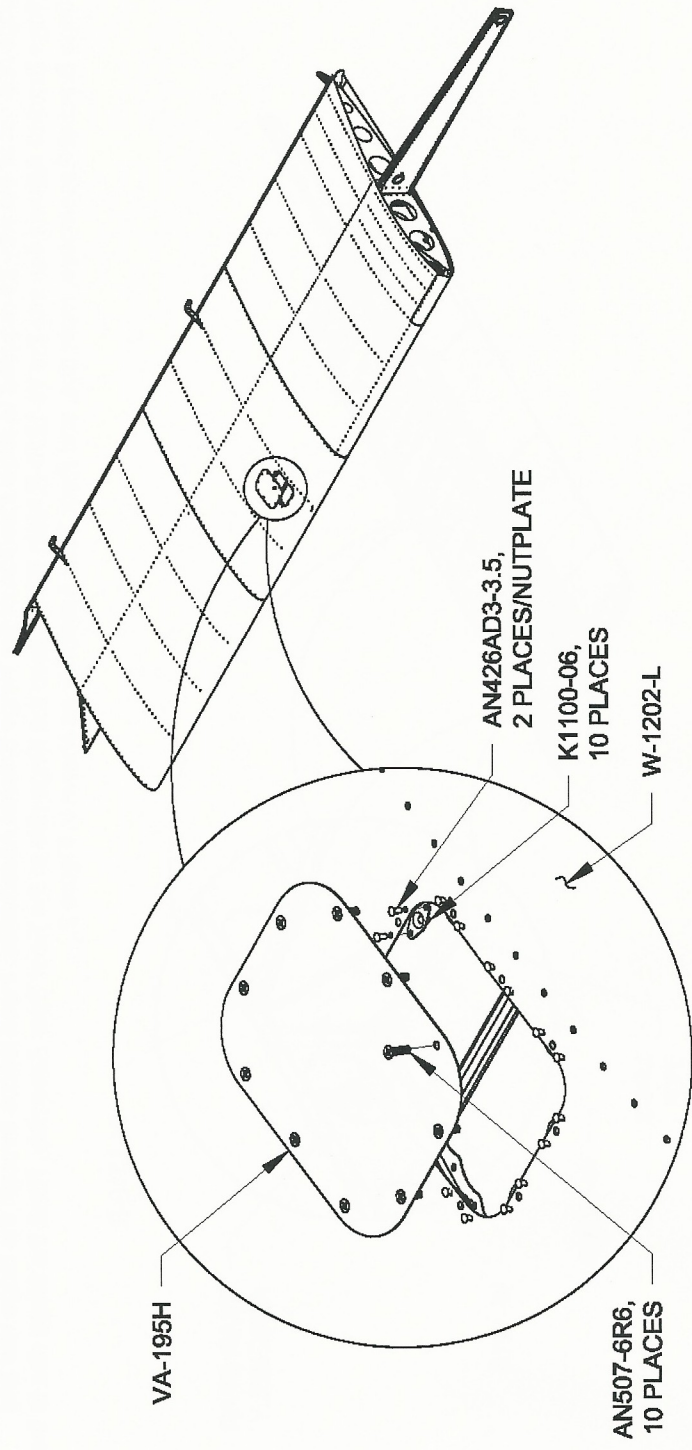


FIGURE 4: INSTALLING ACCESS HATCH