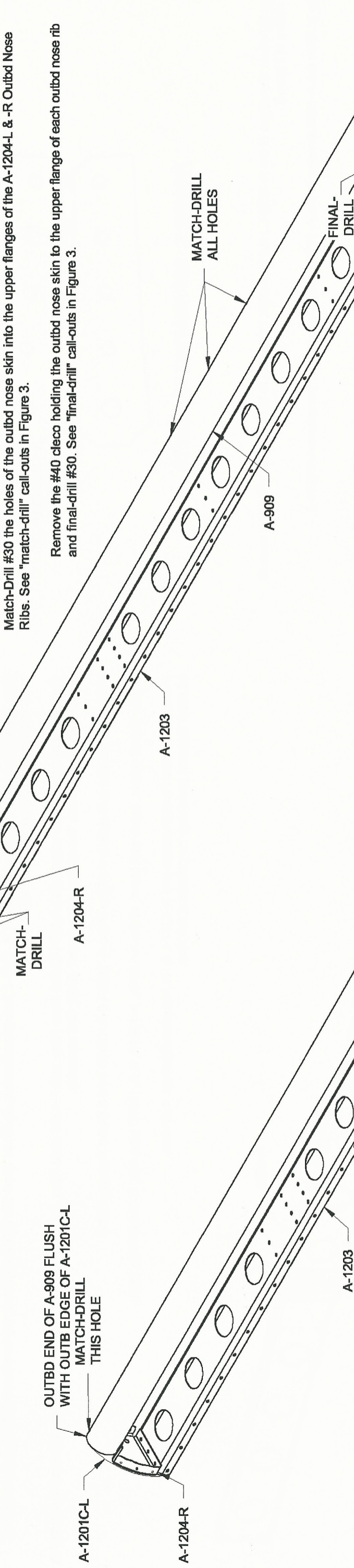




Step 1: Cleco together the A-1203 Spar, A-1204-L & -R Outbd Nose Ribs, A-909 Aileron Counterbalance, and A-1201C-L Outbd Nose Skin as shown in Figure 1.



Step 4: Cleco the A-1204-L & -R Outbd Nose Ribs/A-909 Aileron Counterbalance subassembly to the A-1203 Spar. Cleco the A-1201C-L Outbd Nose Skin to the spar and outbd nose ribs. See Figure 3.

Step 5: Match-Drill #30 the holes of the A-1201C-L Outbd Nose Skin into the A-909 Aileron Counterbalance. See "match-drill" call-outs in Figure 3.

Match-Drill #30 the holes of the outbd nose skin into the upper flanges of the A-1204-L & -R Outbd Nose Ribs. See "match-drill" call-outs in Figure 3.

Remove the #40 cleco holding the outbd nose skin to the upper flange of each outbd nose rib and final-drill #30. See "final-drill" call-outs in Figure 3.

FIGURE 3:
DRILLING THE COUNTERBALANCE

FIGURE 1:
DRILLING THE COUNTERBALANCE

Step 2: Match-Drill #30 the most outboard hole and most inboard hole of the A-1201C-L Outbd Nose Skin into the A-909 Aileron Counterbalance. See "match-drill" call-outs in Figure 1.

Step 3: Un-cleco all the parts. Deburr the two holes just drilled into the A-909 Aileron Counterbalance. Rivet the A-1204-L & -R Outbd Nose Ribs to the aileron counterbalance as shown in Figure 2.

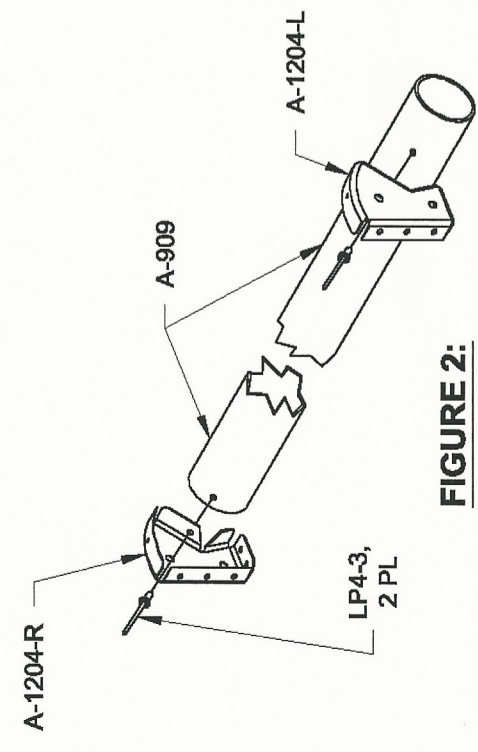


FIGURE 2:
RIVETING THE OUTBD NOSE RIBS TO THE COUNTERBALANCE

Step 6: Un-cleco all parts. Deburr all holes in the A-909 Aileron Counterbalance and all holes in the A-1204-L & -R Outbd Nose Ribs and A-1201C-L Outbd Nose Skin that were either match-drilled or final drilled.