

**Step 1:** On both wings, use a clamp to align the flaperon and wing trailing edges as shown in Figure 1.

**FIGURE 1: CLAMPING THE TRAILING EDGES**

**Step 2:** Flush the ends of the WD-1214-L & -R Flaperon Torque Tubes with the brackets on the WD-1215-L & -R Flaperon Torque Arms as shown in Figure 2. If the A-1207-L & -R Actuation Brackets on the flaperons (see Page 32-09, Figure 3) force the flaperon torque tubes to extend beyond the brackets, trim the actuation brackets until the flaperon torque tubes are flush.

**Step 3:** Insert a temporary 0.063 spacer between the WD-1214-L & -R Flaperon Torque Tubes and the WD-1215-L & -R Flaperon Torque Arms as shown in Figure 2, then clamp the parts together.

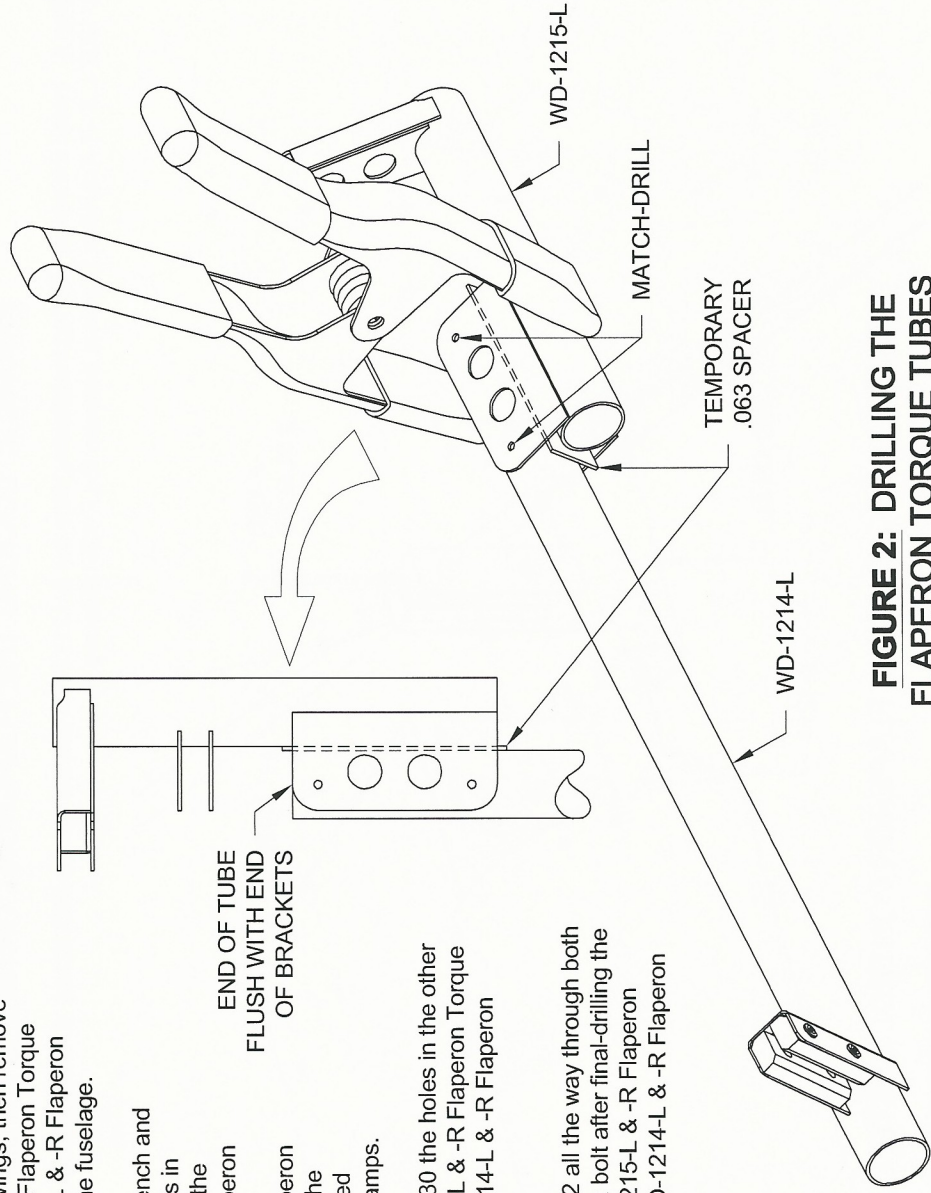
**Step 4:** Match-Drill #30 (use a 12 inch extension drill bit) the two holes of the WD-1215-L & -R Flaperon Torque Arms into the WD-1214-L & -R Flaperon Torque Tubes (one side only, and cleco the first hole before match-drilling the second).

**Step 5:** Remove the wings, then remove the WD-1215-L & -R Flaperon Torque Arms and WD-1214-L & -R Flaperon Torque Tubes from the fuselage.

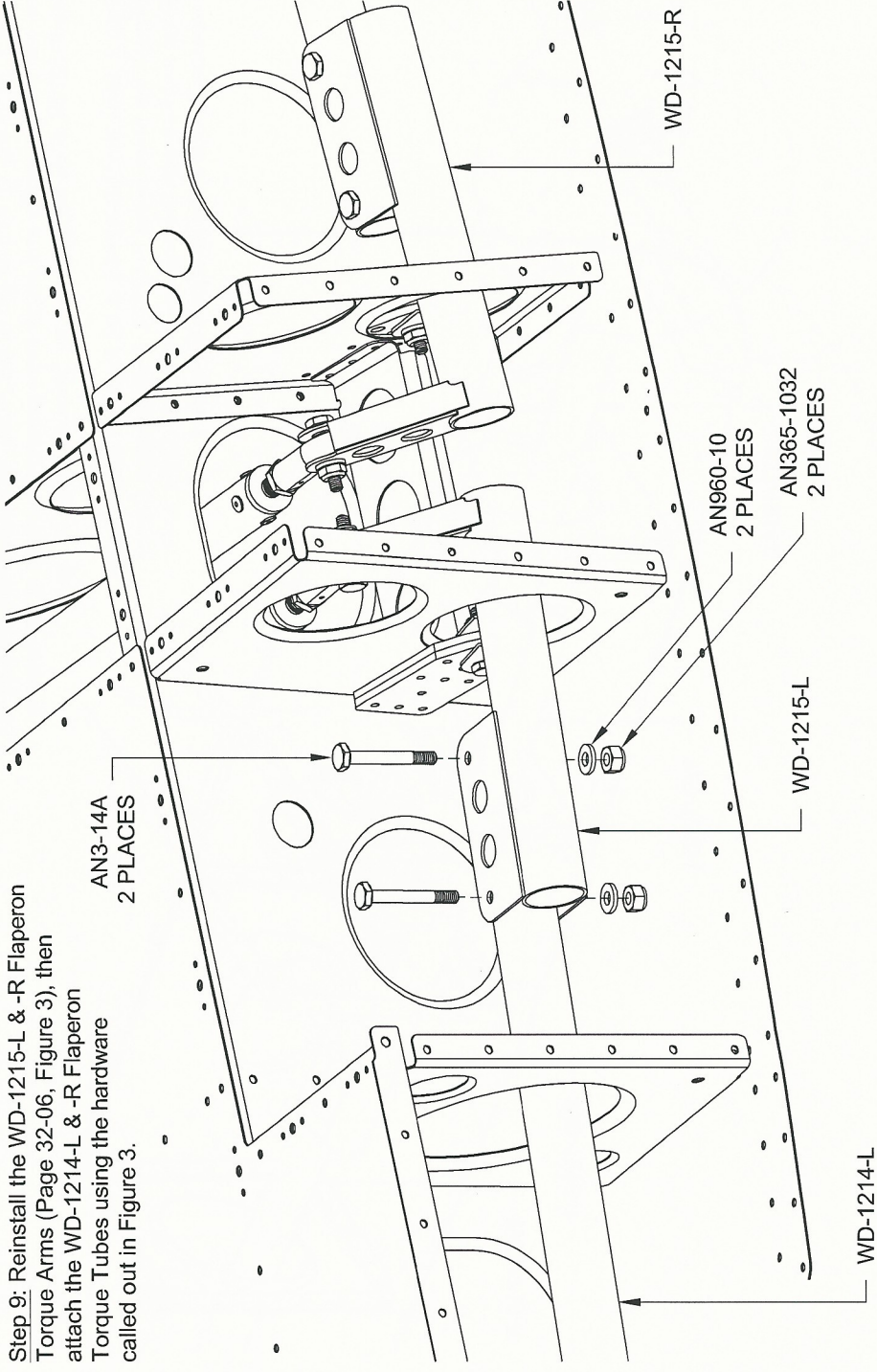
**Step 6:** On a work bench and with the 0.063 spacers in place, cleco together the WD-1215-L & -R Flaperon Torque Arms and WD-1214-L & -R Flaperon Torque Tubes using the previously match-drilled holes. Reapply the clamps.

**Step 7:** Match-Drill #30 the holes in the other side of the WD-1215-L & -R Flaperon Torque Arms into the WD-1214-L & -R Flaperon Torque Tubes.

**Step 8:** Final-Drill #12 all the way through both sets of holes (insert a bolt after final-drilling the first set) in the WD-1215-L & -R Flaperon Torque Arms and WD-1214-L & -R Flaperon Torque Tubes.



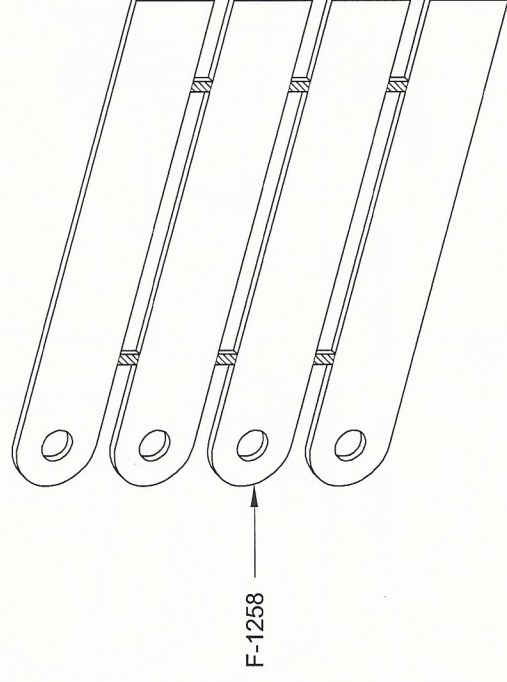
**FIGURE 2: DRILLING THE FLAPERON TORQUE TUBES**



**Step 9:** Reinstall the WD-1215-L & -R Flaperon Torque Arms (Page 32-06, Figure 3), then attach the WD-1214-L & -R Flaperon Torque Tubes using the hardware called out in Figure 3.

**FIGURE 3: SECURING THE FLAPERON TORQUE TUBES**

**Step 10:** Separate the F-1258 Rudder Cable Links by removing the shaded areas shown in Figure 4.



**FIGURE 4: SEPARATING THE RUDDER CABLE LINKS**