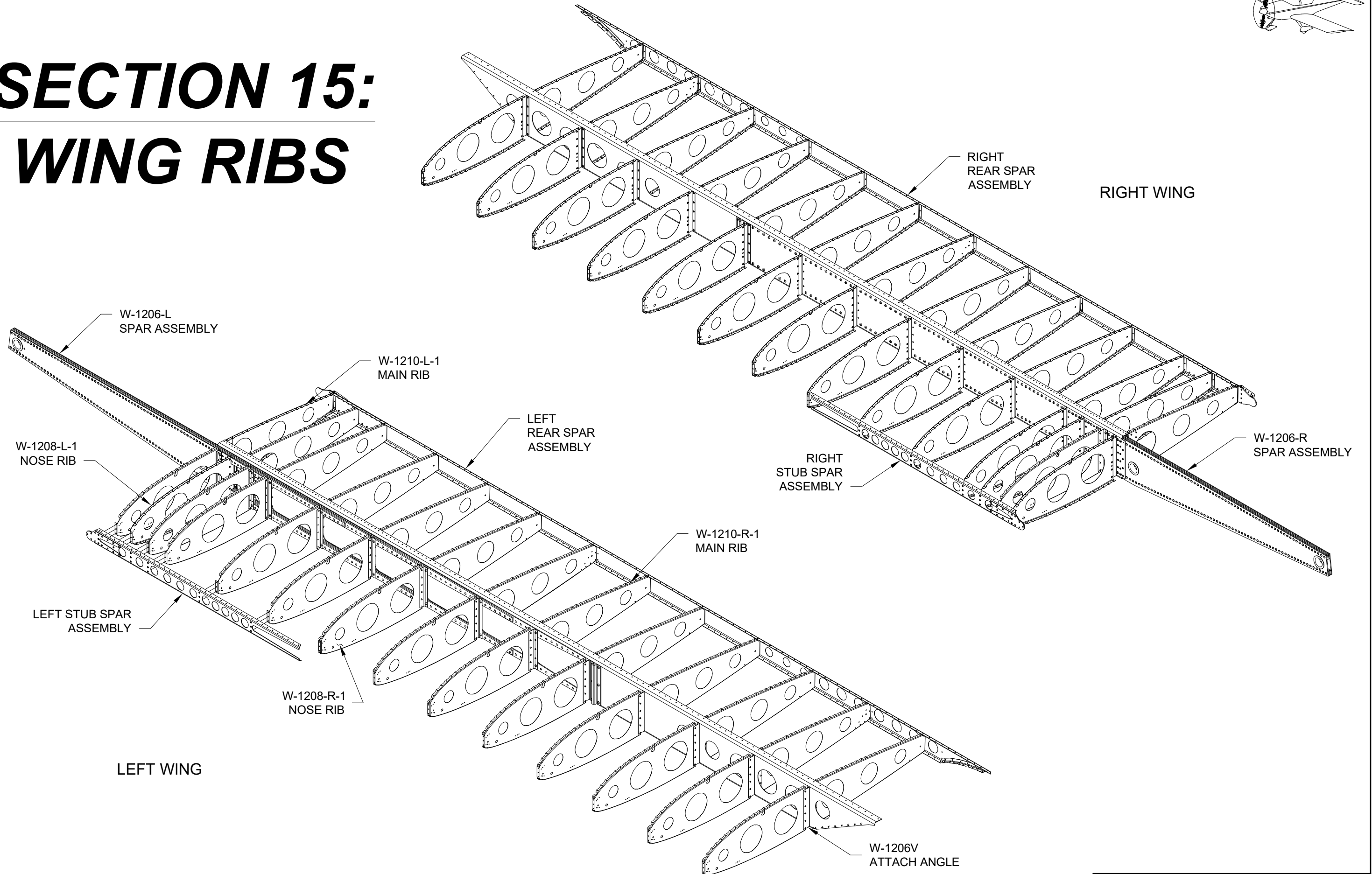
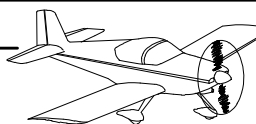


SECTION 15: WING RIBS





Step 1: Flute and straighten all of the W-1208-1 Nose Rib flanges.

Step 2: Select 13 of the 14 W-1208-L-1 Nose Ribs and trim the aft flange as shown in Figure 1.

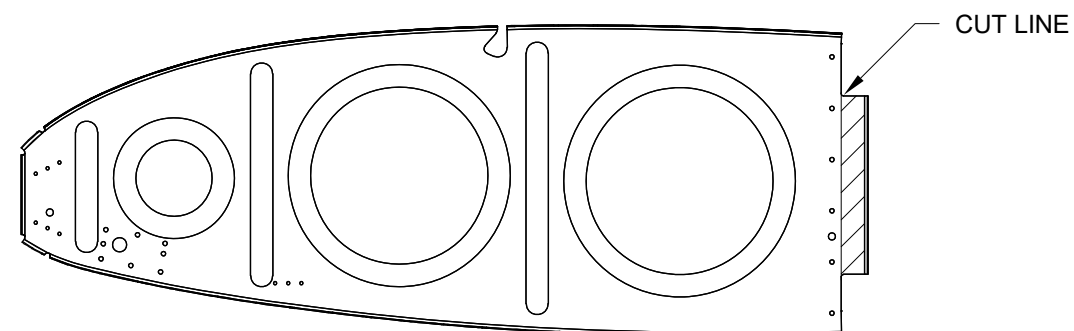


FIGURE 1: W-1208-1 NOSE RIB AFT FLANGE TRIM

Step 3: Take five of the 13 W-1208-L-1 Nose Ribs that you just trimmed and trim off the upper and lower forward flanges as shown in Figure 2.

Step 4: Select the one W-1208-L-1 Nose Rib that is untrimmed and trim the forward upper and lower flanges as shown in Figure 2.

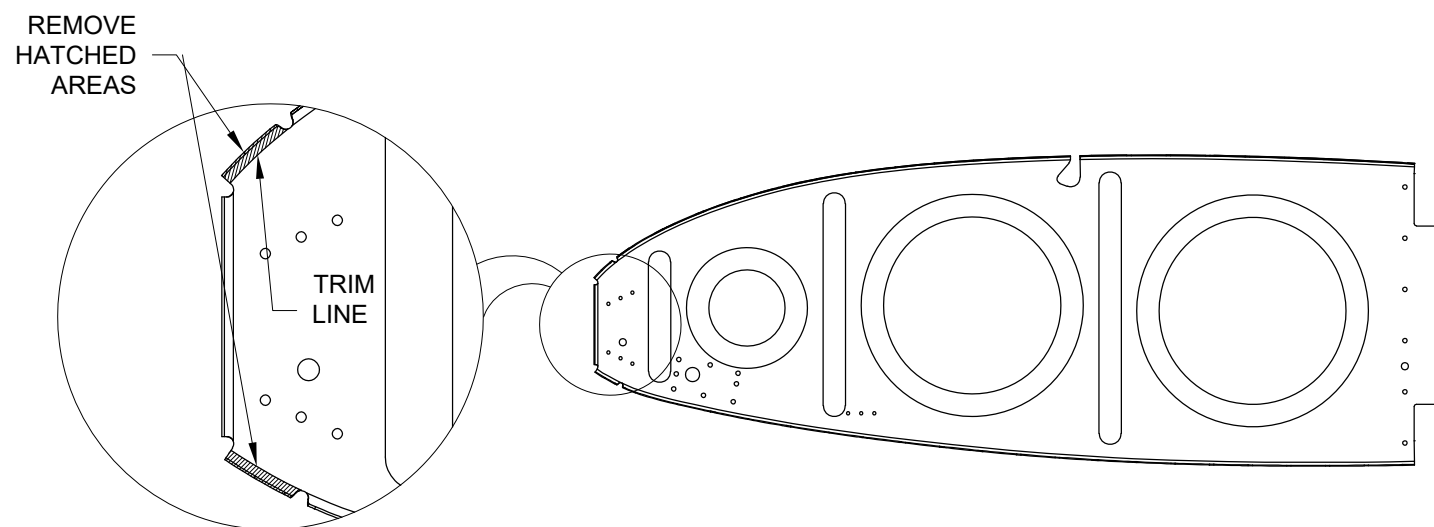


FIGURE 2: W-1208-1 NOSE RIB FWD FLANGE TRIM

Step 5: Take seven of the 14 W-1208-R-1 Nose Ribs and trim off the aft flange as shown in Figure 1.

Step 6: Select two of the seven W-1208-R-1 Nose Ribs with the aft flange trimmed and trim the forward upper and lower flanges as shown in Figure 2.

Step 7: Select four of the seven W-1208-R-1 Nose Ribs that are untrimmed and trim the forward upper and lower flanges as shown in Figure 2.

Step 8: Cut apart the two W-1216B Hinge Ribs into W-1216B-L and W-1216B-R Hinge Ribs as shown in Figure 3.

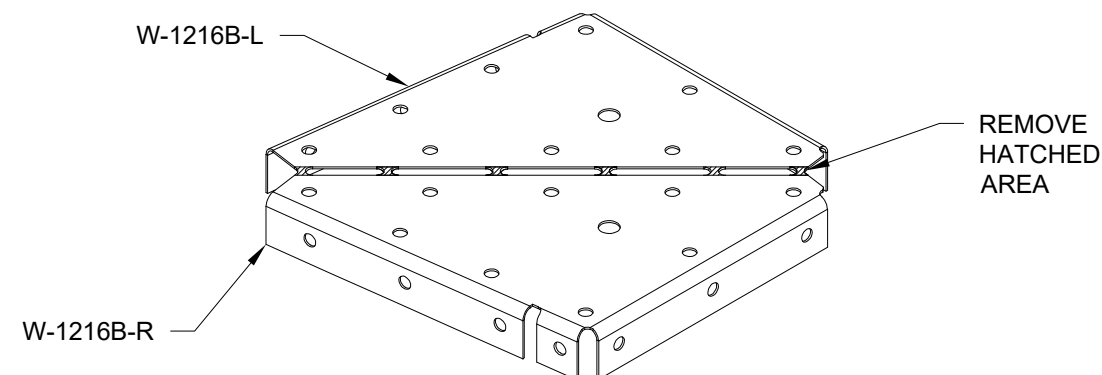


FIGURE 3: SEPARATING HINGE RIBS

Step 9: Select one each of the W-1208-L-1 Nose Ribs and W-1208-R-1 Nose Ribs with the aft and forward trimmed flanges. Dimple the rivet hole locations as shown in Figure 4. Final drill #19 the center nutplate hole as shown in Figure 4. Dimple then install the nutplate on each nose rib as shown in Figure 4.

Cleco and rivet the W-00028 Doubler Plate to the W-1208-L-1 Nose Rib and W-1208-R-1 Nose Rib with the hardware called out in Figure 4.

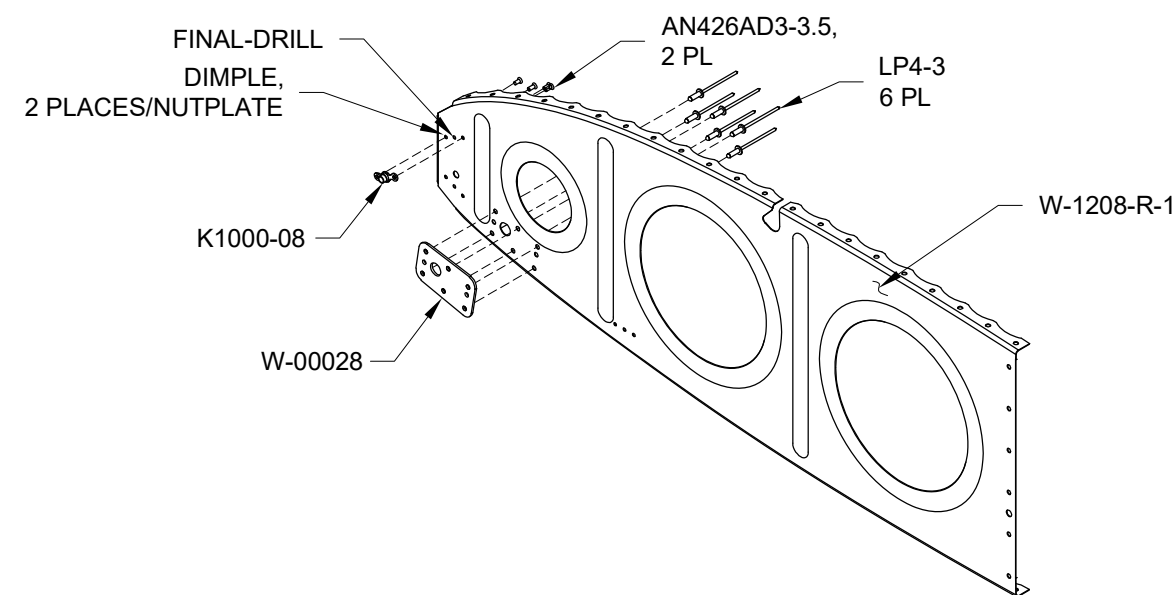


FIGURE 4: ADDING THE NUTPLATE TO FWD AND AFT TRIMMED NOSE RIBS

Step 10: Select one of the three untrimmed W-1208-R-1 Nose Ribs and dimple the rivet hole locations for the forward nutplates as shown in Figure 5. Final-Drill #19 the center nutplate holes. Dimple then install the nutplates on the nose rib as shown in Figure 5.

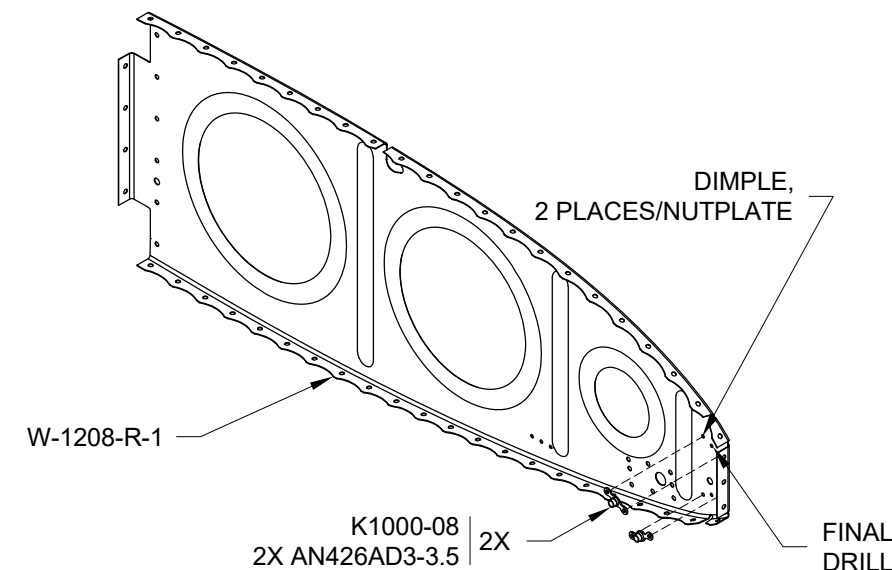
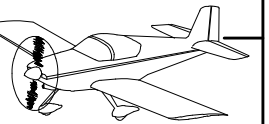


FIGURE 5: ADDING THE NUTPLATE TO UNTRIMMED NOSE RIB



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

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

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

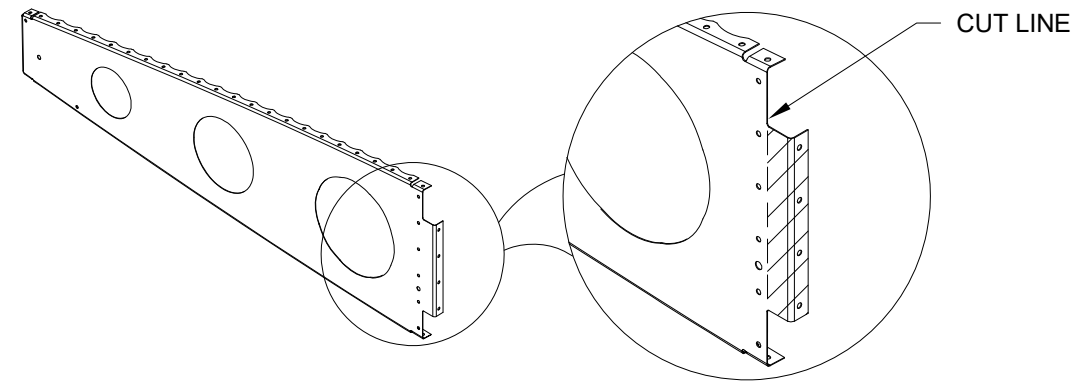


FIGURE 1: W-1210-1 MAIN RIB FWD FLANGE TRIM (LEFT SHOWN)

Step 4: Cleco the W-1210B-L Rib Doubler to one of the six trimmed W-1210-L-1 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-1 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.

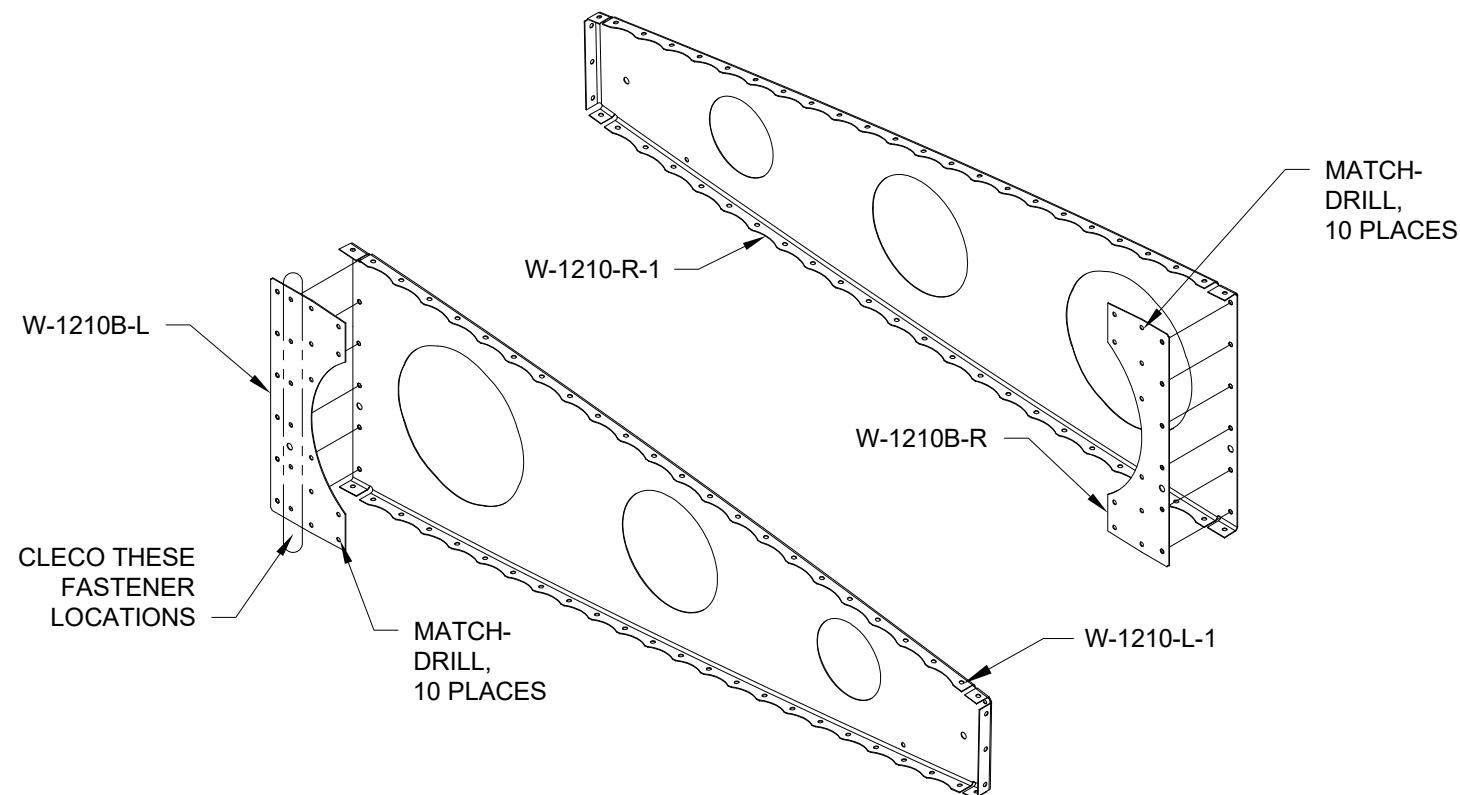


FIGURE 2: MATCH-DRILLING THE RIB DOUBLERS AND MAIN RIBS

Step 6: Select two of the W-1210-R-1 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-1 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.

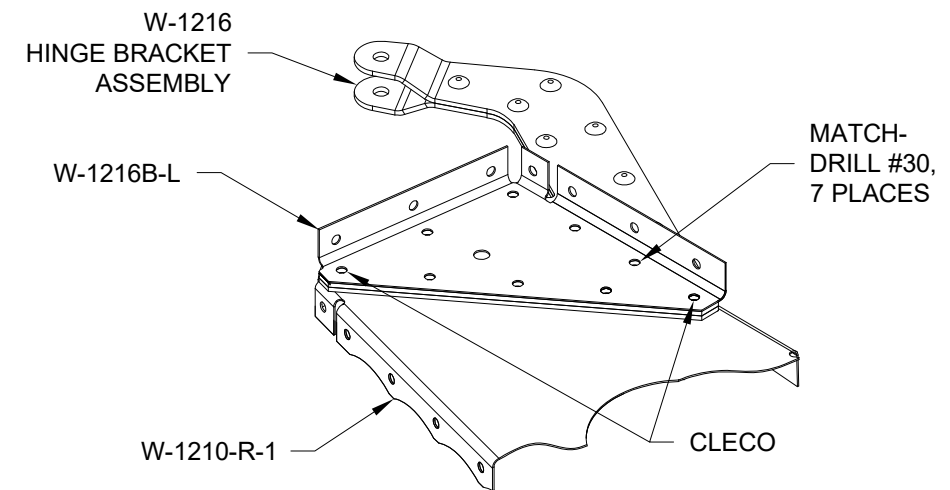


FIGURE 3: MATCH-DRILLING THE FLAPERON HINGE BRACKETS AND MAIN RIBS

NOTE: Take care not to rivet the row of holes that are needed to attach the W-1210-L-1 and W-1210-R-1 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-1 Main Rib as shown in Figure 4.

Step 9: Rivet the W-1210B-R Rib Doubler to the match-drilled W-1210-R-1 Main Rib as shown in Figure 4.

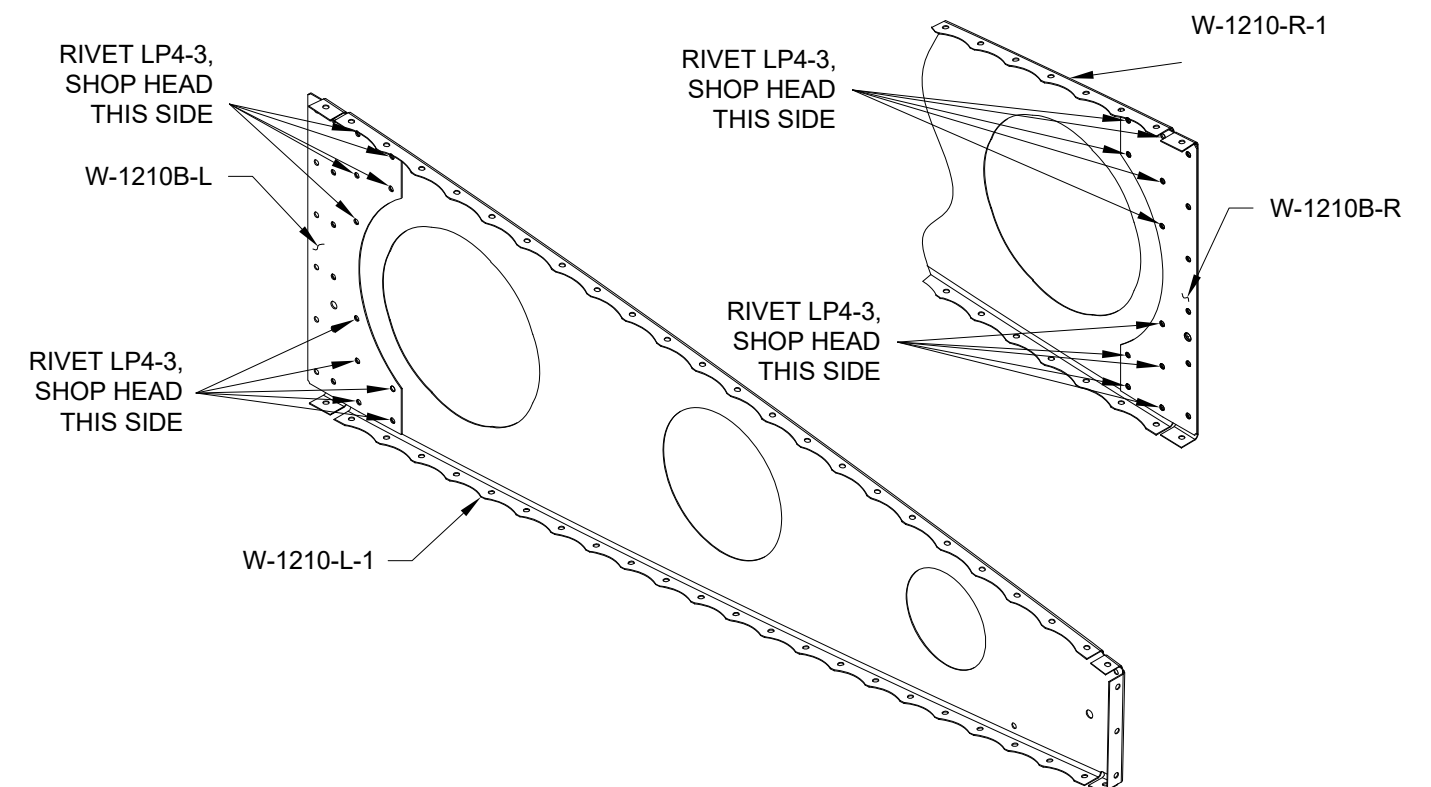


FIGURE 4: RIVETING THE RIB DOUBLERS TO THE MAIN RIBS

Step 1: Lay the W-1206-L Spar Assembly on the work surface with the flanges facing up. Select one of the W-1210-R-1 Main Ribs and cleco then rivet to the furthest outboard attach angle on the spar assembly as shown in Figure 1.

Step 2: Take one W-1210-R-1 Main Rib which was match-drilled to the W-1216B-L Hinge Rib and cleco then rivet to the next inboard attach angle on the W-1206-L Spar Assembly as shown in Figure 1.

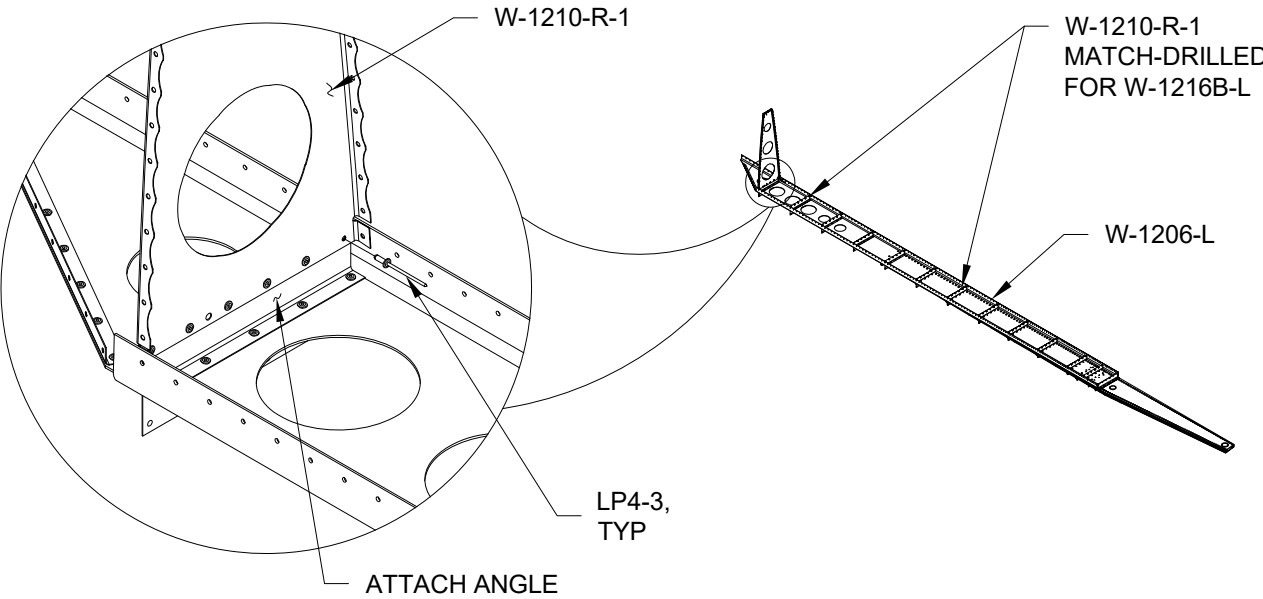


FIGURE 1: ATTACHING THE MAIN RIBS

Step 3: Select four more of the W-1210-R-1 Main Ribs and cleco then rivet to the next inboard attach angles on the W-1206-L Spar Assembly.

Step 4: Cleco then rivet the remaining W-1210-R-1 Main Rib which was match-drilled to the W-1216B-L Hinge Rib to the next inboard attach angle on the W-1206-L Spar Assembly as shown Figure 1.

Step 5: Select five more of the W-1210-R-1 Main Ribs and cleco then rivet to the next inboard attach angles on the W-1206-L Spar Assembly.

Step 6: Cleco then rivet the W-1210-L-1 Main Rib with the attached W-1210B-L Rib Doubler to the remaining attach angle on the W-1206-L Spar Assembly. See Figure 2.

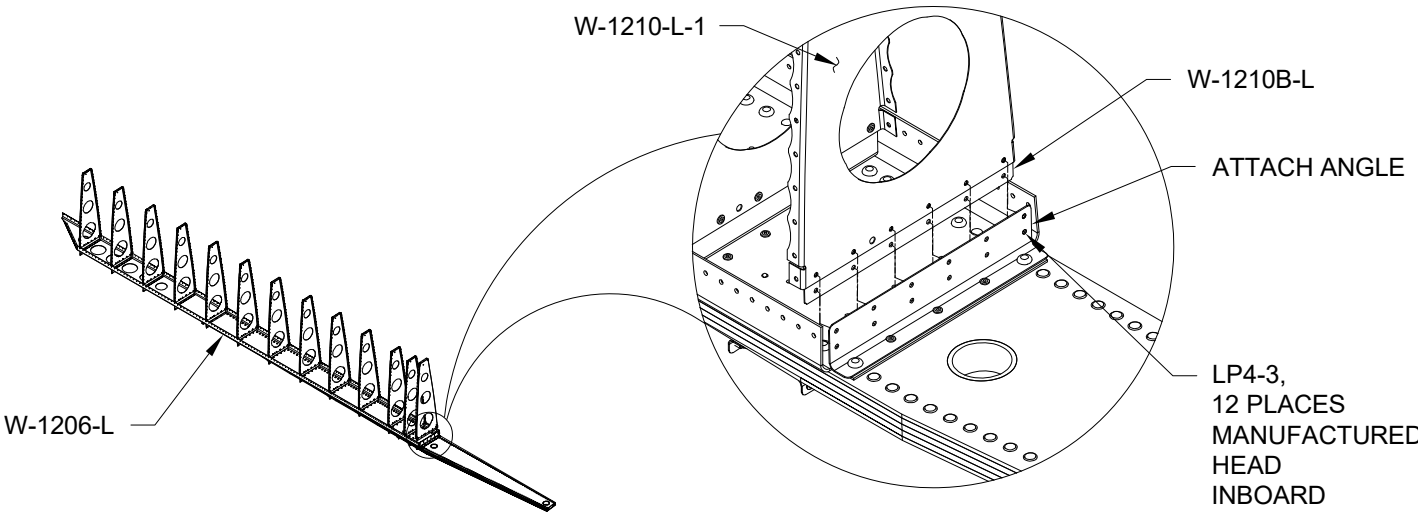


FIGURE 2: ATTACHING THE MAIN RIB AND DOUBLER

Step 7: Cleco the Left Rear Spar Assembly to the aft flanges of the W-1210-1 Main Ribs as shown in Figure 3.

Step 8: Match-drill #30 the hole locations in the aft flange of the main rib as shown in Figure 3. Remove the clecos and the Left Rear Spar Assembly and deburr match-drilled holes as required.

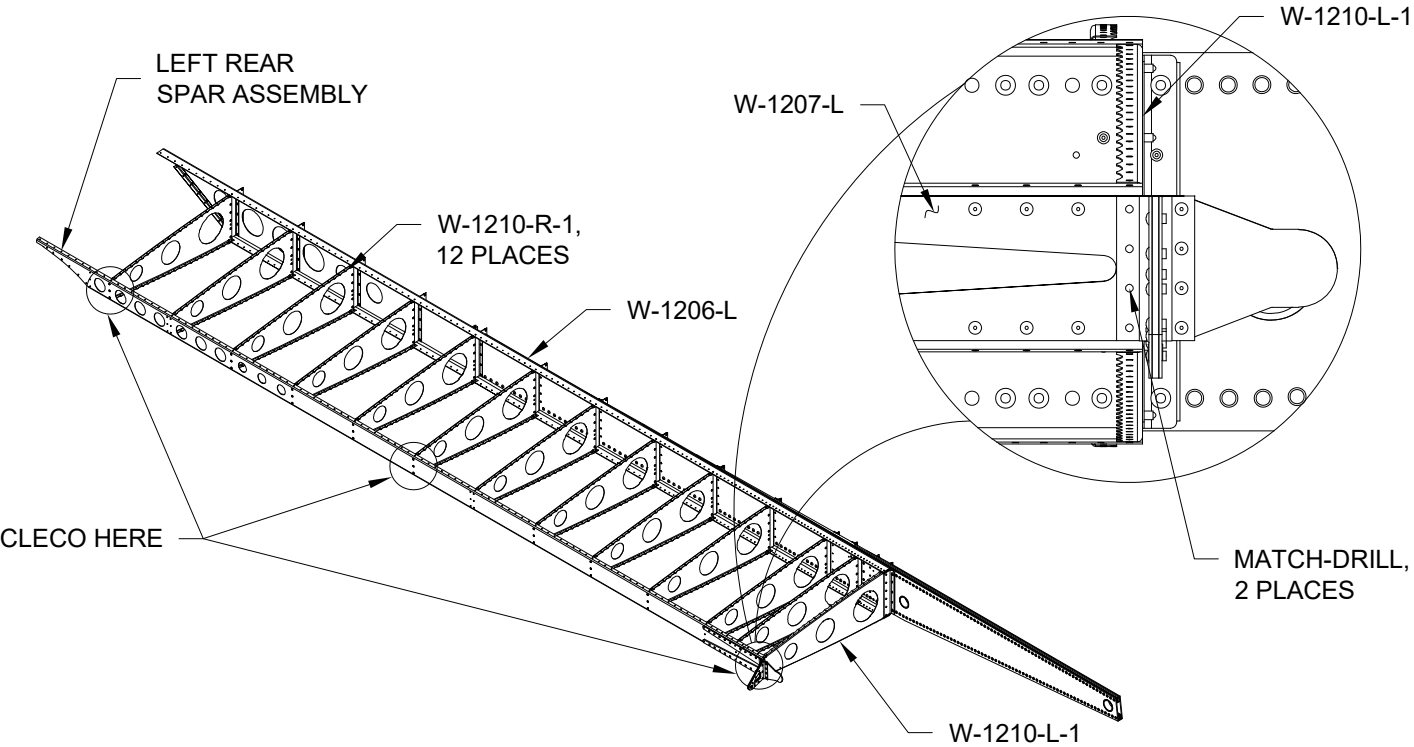


FIGURE 3: MATCH-DRILLING MAIN RIB AFT FLANGE

Step 9: Cleco then rivet the Left Rear Spar Assembly to the aft flanges of the W-1210-1 Main Ribs as shown in Figure 4.

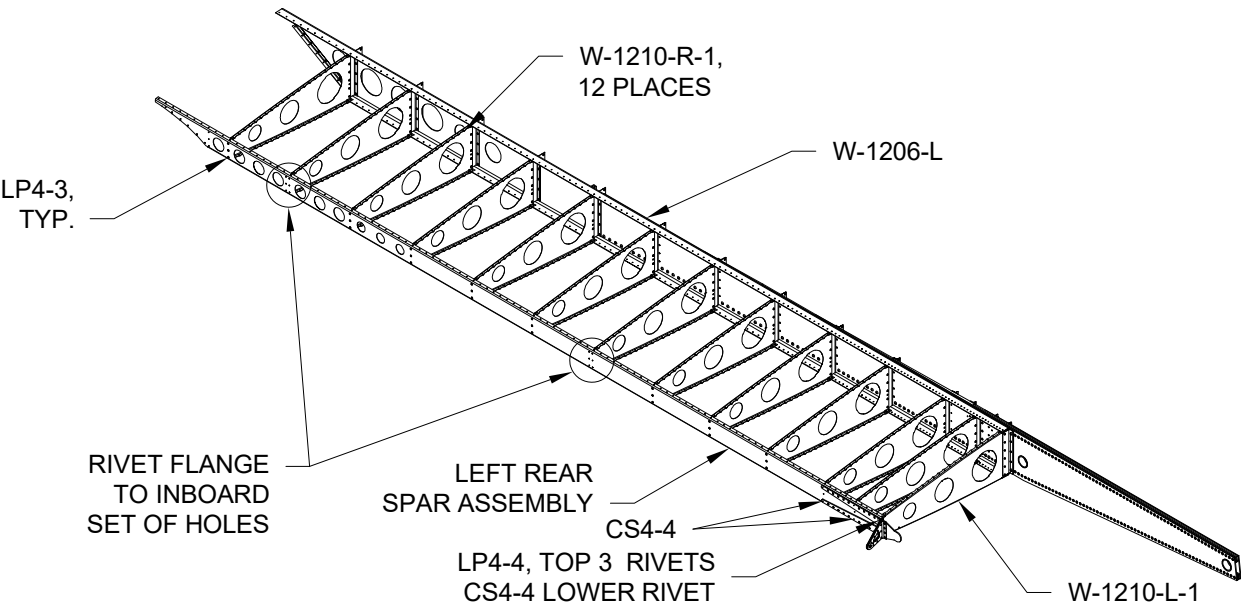


FIGURE 4: ATTACHING THE REAR SPAR



NOTE: With the bottom of the W-1210-1 Main Ribs resting on the work surface, a weight or clamp may be applied to the aft portion of the wing assembly to hold it in position for attaching the W-1208-1 Nose Ribs. Take care not to bend the flanges of the W-1210-1 Main Ribs.

Step 1: Select five of the aft trimmed W-1208-R-1 Nose Ribs and cleco then rivet to the W-1206-L Spar Assembly attach angles starting outboard and working inboard. Rivets should be installed with the manufactured head on the nose rib. See Figure 1.

Step 2: Select two unmodified W-1208-R-1 Nose Ribs, as well as the untrimmed nose rib that has the two nutplates attached. Cleco then rivet the first unmodified nose rib to the W-1206-L spar assembly and attach angle. Cleco then rivet the nose rib with the nutplates to the spar assembly and attach angle. Cleco then rivet the last of the unmodified nose ribs to the spar assembly and attach angle.

Step 3: Select four of the forward trimmed W-1208-R-1 Nose Ribs and cleco then rivet to the W-1206-L Spar Assembly and attach angles.

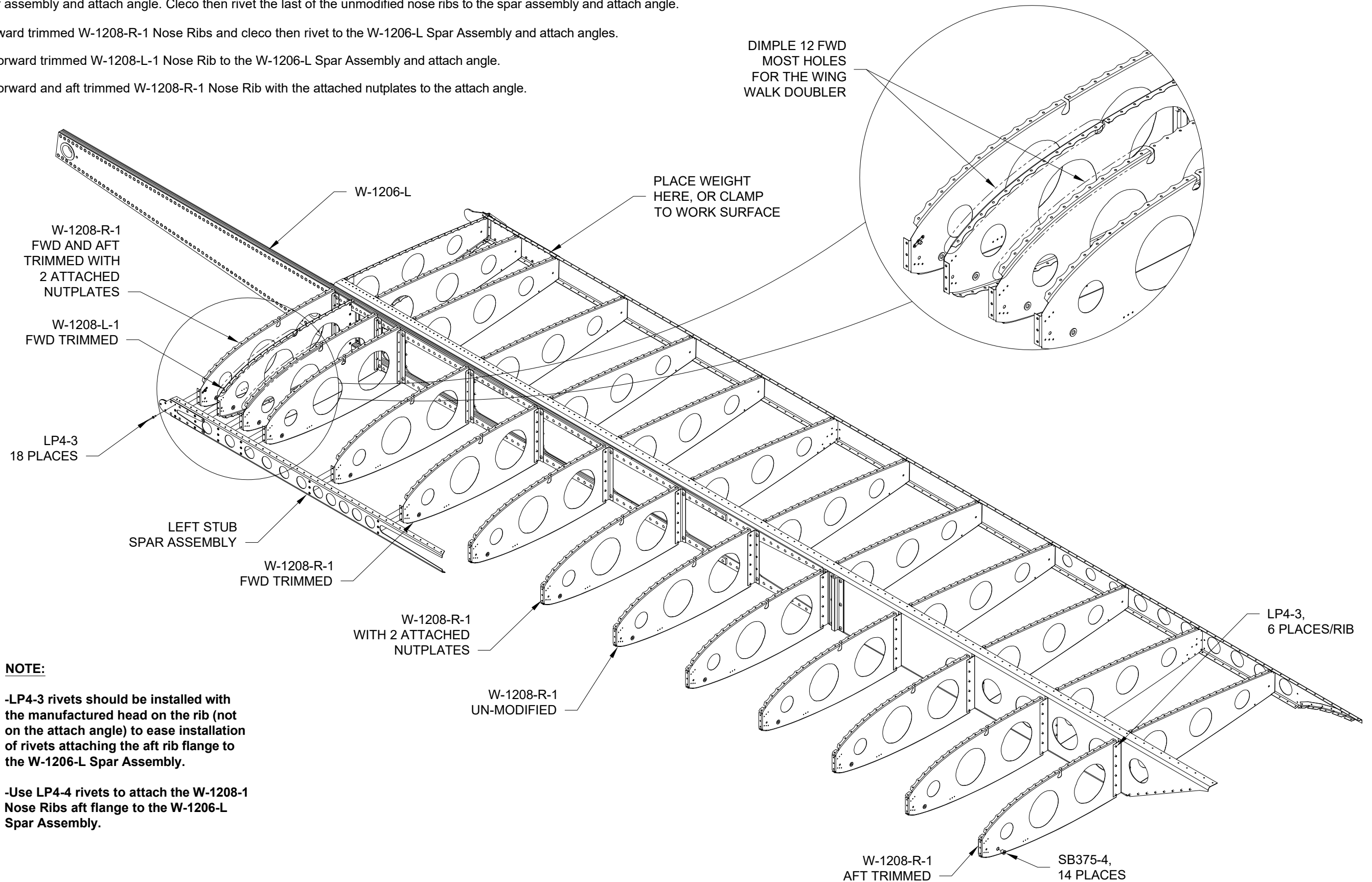
Step 4: Cleco then rivet the forward trimmed W-1208-L-1 Nose Rib to the W-1206-L Spar Assembly and attach angle.

Step 5: Cleco then rivet the forward and aft trimmed W-1208-R-1 Nose Rib with the attached nutplates to the attach angle.

Step 6: Cleco then rivet the Left Stub Spar Assembly to the forward flanges of the W-1208-L-1 and W-1208-R-1 Nose Ribs as shown in Figure 1.

Step 7: Insert the snap bushings into the W-1208-1 Nose Ribs as shown in Figure 1.

Step 8: Dimple the holes in the upper fwd flanges of the nose ribs as indicated in Figure 1 for the wing walk doubler.



NOTE:

-LP4-3 rivets should be installed with the manufactured head on the rib (not on the attach angle) to ease installation of rivets attaching the aft rib flange to the W-1206-L Spar Assembly.

-Use LP4-4 rivets to attach the W-1208-1 Nose Ribs aft flange to the W-1206-L Spar Assembly.

FIGURE 1: ATTACHING THE NOSE RIBS

Step 1: Lay the W-1206-R Spar Assembly on the work surface with the flange facing up. Select one of the forward trimmed W-1210-L-1 Main Ribs and cleco then rivet to the furthest outboard attach angle on the spar assembly as shown in Figure 1.

Step 2: Cleco then rivet the forward trimmed W-1210-L-1 Main Rib which was match-drilled to the W-1216B-R Hinge Rib to the next inboard attach angle on the W-1206-R Spar Assembly as shown in Figure 1.

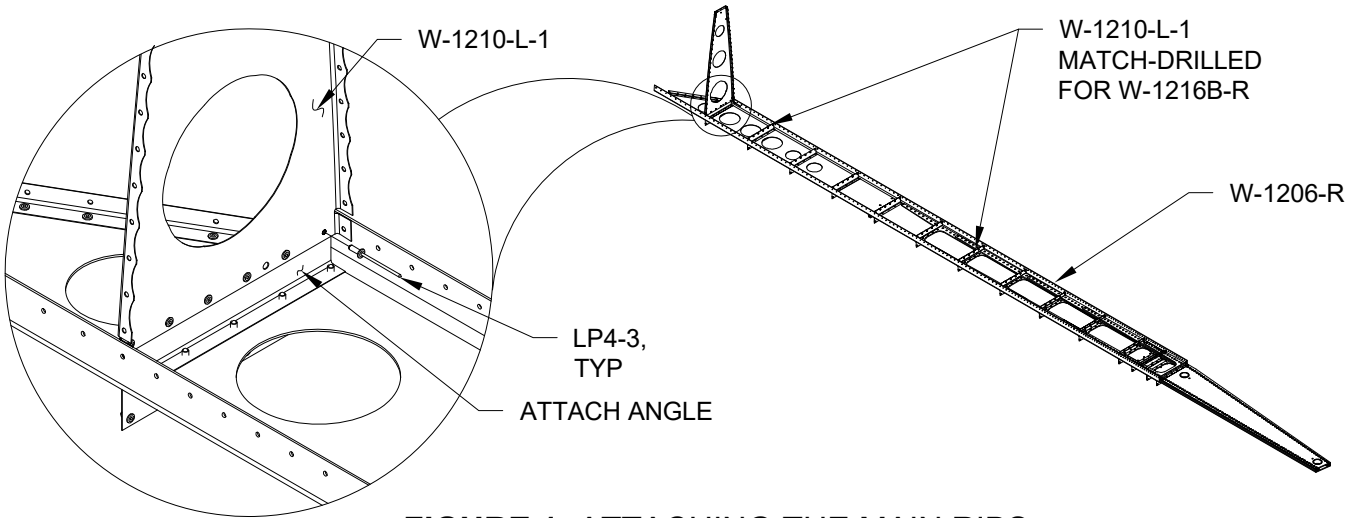


FIGURE 1: ATTACHING THE MAIN RIBS

Step 3: Select three of the forward trimmed W-1210-L-1 Main Ribs and cleco then rivet to the next inboard attach angles on the W-1206-R Spar Assembly.

Step 4: Select one unmodified W-1210-L-1 Main Rib and cleco then rivet to the next inboard attach angle and to the W-1206-L Spar Assembly.

Step 5: Cleco then rivet the W-1210-L-1 Main Rib which was match-drilled to the W-1216B-R to the next inboard attach angle and to the W-1206-R Spar Assembly.

Step 6: Cleco then rivet the remaining five W-1210-L-1 Main Ribs to the next inboard attach angles and to the W-1206-R Spar Assembly as shown in Figure 2.

Step 7: Cleco then rivet the forward trimmed W-1210-R-1 Main Rib with the attached W-1210B-R Rib Doubler to the most inboard attach angle on the W-1206-R Spar Assembly as shown in Figure 2.

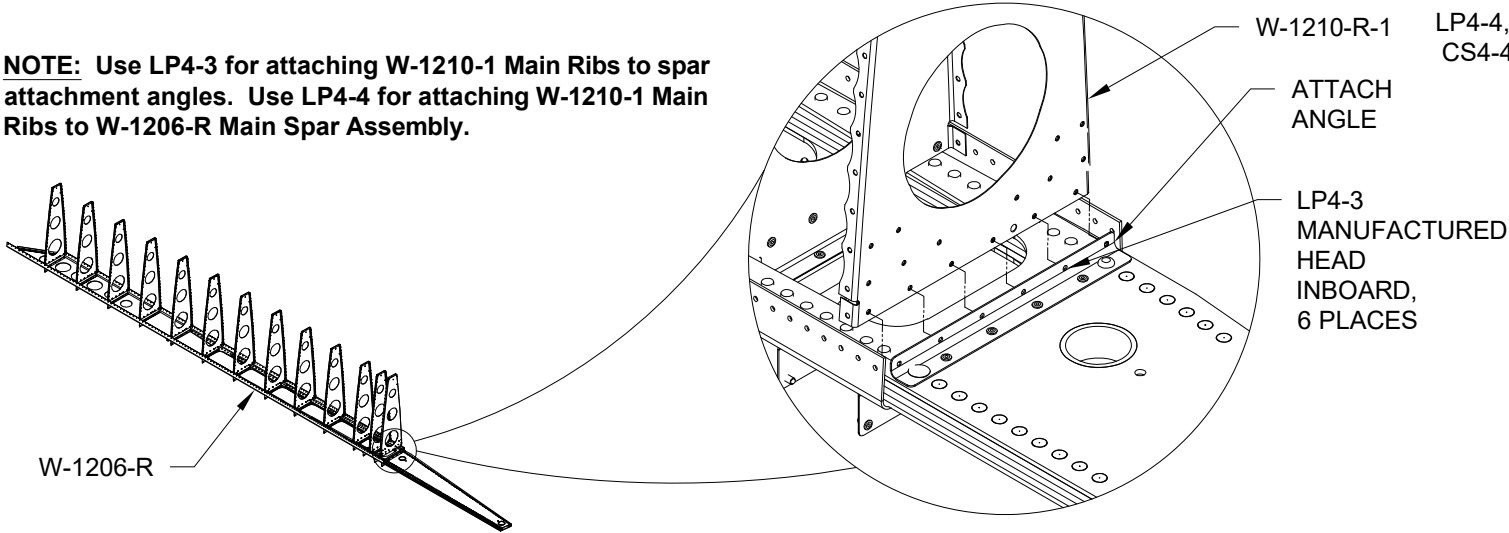


FIGURE 2: ATTACHING THE MAIN RIB AND DOUBLER

Step 8: Cleco the Right Rear Spar Assembly to the aft flanges of the W-1210-1 Main Ribs as shown in Figure 3.

Step 9: Match-drill #30 the hole locations in the aft flange of the main rib as shown in Figure 3. Remove clecos and Rear Spar Assembly and deburr match-drilled holes as required.

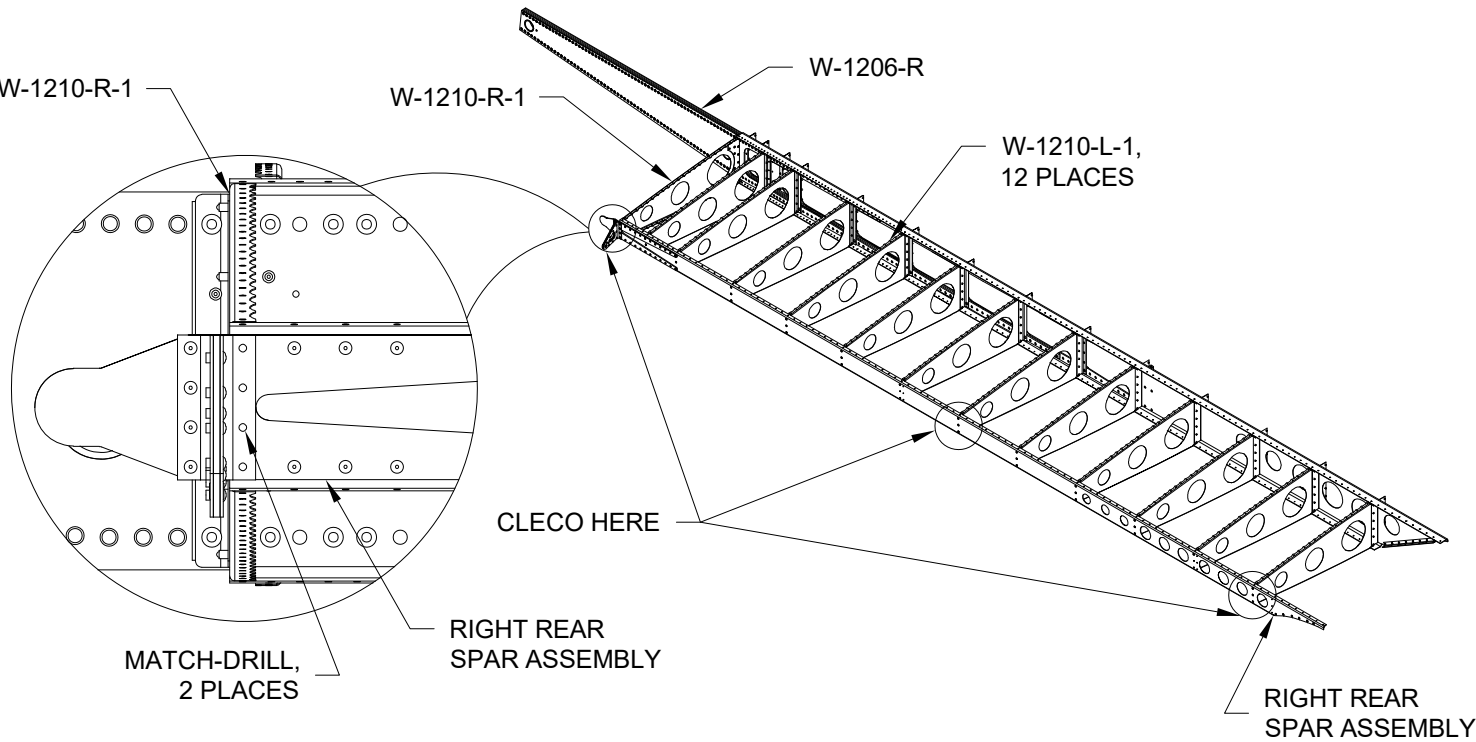


FIGURE 3: MATCH-DRILLING MAIN RIB AFT FLANGE

Step 10: Take the Right Rear Spar Assembly and cleco then rivet to the aft flanges of the W-1210-1 Main Ribs as shown in Figure 4.

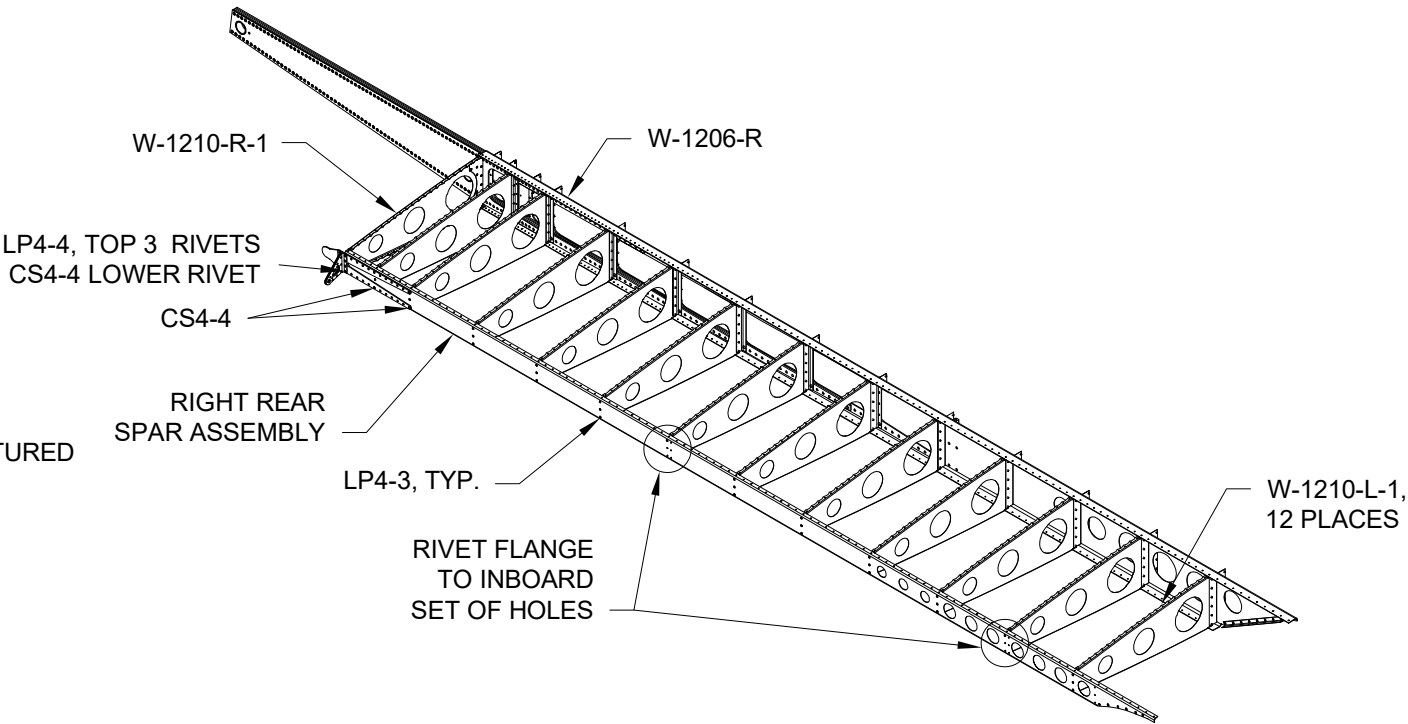


FIGURE 4: ATTACHING THE REAR SPAR



NOTE: With the bottom of the W-1210-1 Main Ribs resting on the work surface, a weight or clamp may be applied to the aft portion of the wing assembly to hold it in position for attaching the W-1208-1 Nose Ribs. Take care not to bend the flanges of the W-1210-1 Main Ribs. See Figure 1.

Step 1: Cleco then rivet the eight remaining aft trimmed W-1208-L-1 Nose Ribs to the W-1206-R Spar Assembly attach angles, starting outboard and working inboard. See Figure 1.

Step 2: Select the four forward and aft trimmed W-1208-L-1 Nose Ribs (no attached nutplates) and cleco then rivet to the W-1206-R Spar Assembly attach angles.

Step 3: Cleco then rivet the forward and aft trimmed W-1208-R-1 Nose Rib to the W-1206-R Spar Assembly attach angles.

Step 4: Select the forward and aft trimmed W-1208-L-1 Nose Rib with attached nutplates and cleco then rivet to the W-1206-R Spar Assembly attach angles.

Step 5: Cleco then rivet the Right Stub Spar Assembly to the forward flanges of the W-1208-L-1 and W-1208-R-1 Nose Ribs as shown in Figure 1.

Step 6: Insert the snap bushings in the W-1208-1 Nose Ribs as shown in Figure 1.

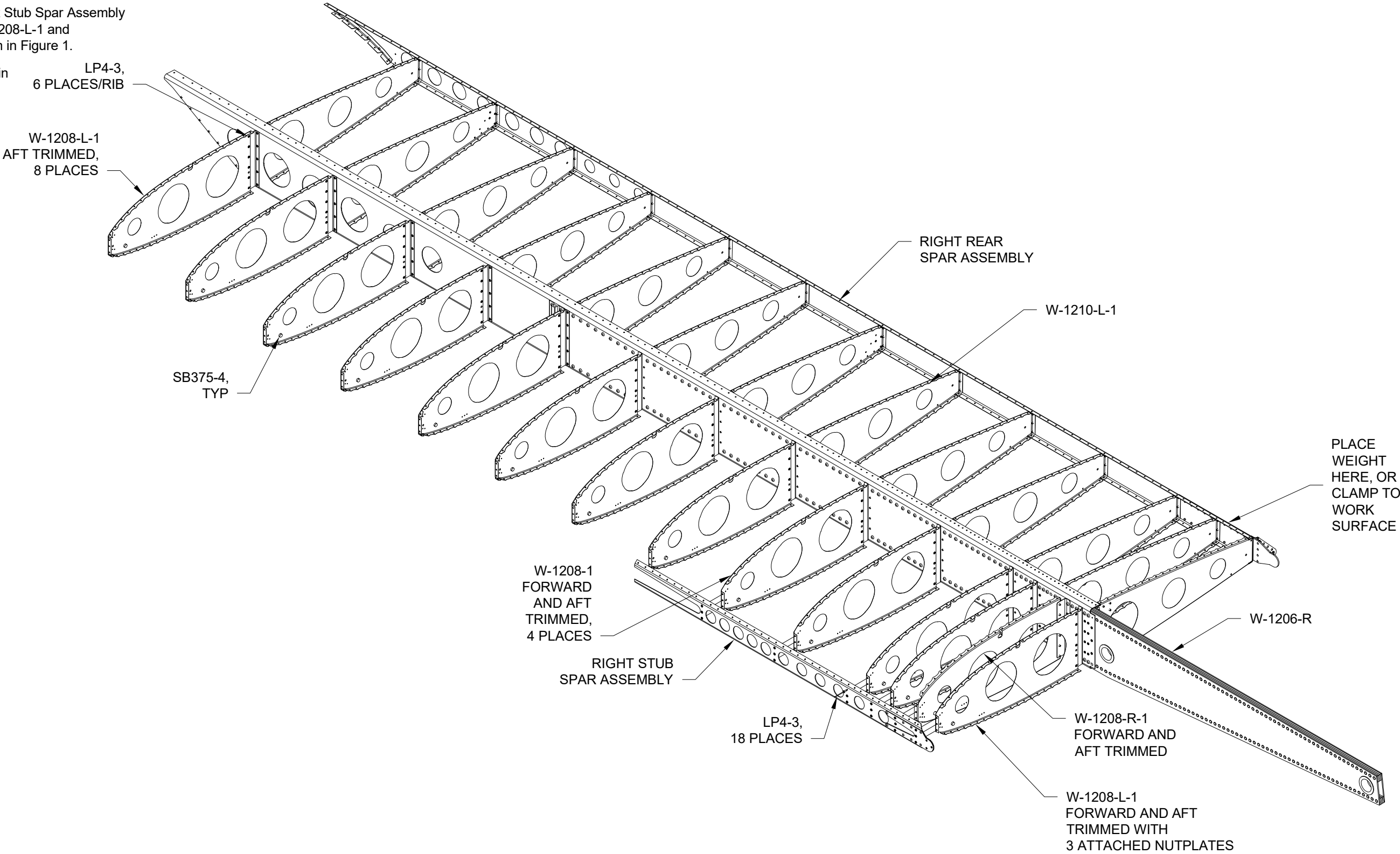
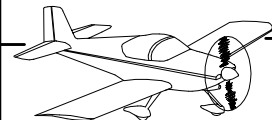


FIGURE 1: ATTACHING THE NOSE RIBS



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