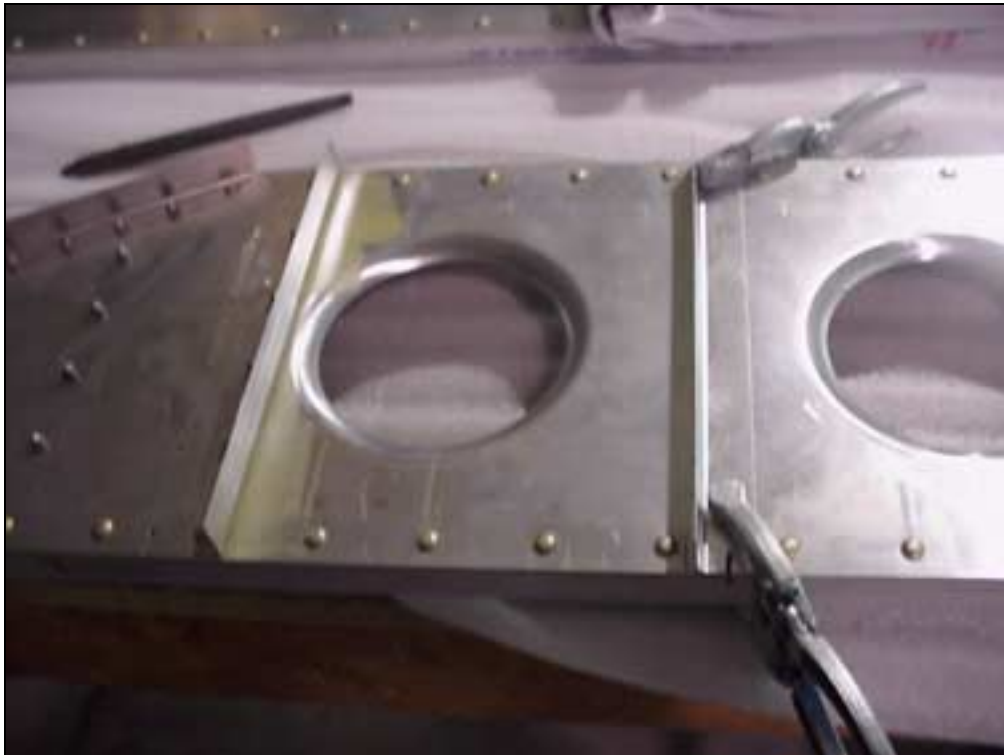




Cut over-sized (left);  
Trim and file (above).

Note: Six needed.

Three vertical 'L' angles must be riveted to each main spar (length = 206mm see boxed diagram on drawing 7-V-2).



Trace line down center of  
'L' angle flanges (above).

Situate first 'L' angle as  
illustrated (left), 480mm  
from spar root (STN 480).

See drawing 7-V-3 for  
positions.

Clamp 'L' angle to spar so that flange center-line is visible from the back through pre-drilled holes. Drill (#30), deburr and rivet.

Note: Rivet-heads are placed on 'L' angle side through spar-caps; but on the spar-web side between the spar caps.



Note: Positions for the three 'L' angles are pre-drilled in the spars with #40 hole.

Situate second 'L' angle at STN 1160 (see drawings: **7-V-3**).  
Clamp, drill, deburr and rivet just like first 'L' angle.



Location of third 'L' angle on the Spar.

Install the third 'L' angle in the same manner as the first two, at STN 2760.

Repeat entire procedure on other main-wing spar.



Building the right wing skeleton.



7V1-1 Nose Rib  
Wing Spar

Mark flange centerline on the nose rib. All ribs are positioned with the flanges pointing towards the outboard wing tip. Clamp the rib to the spar and make sure the rib is square. Align the centerline marked on the rib with the predrilled holes in the spar. Drill and cleco.

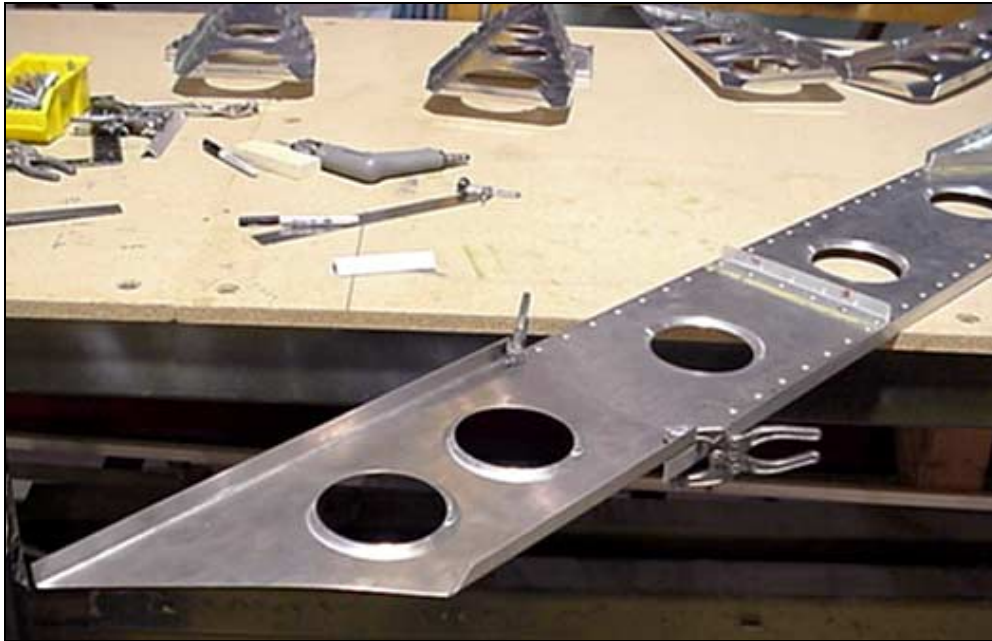


Continued the same process for the rest of the nose ribs.



7V1-2 Rear Rib

The process is the same with the rear rib. A small piece of material clamped to the flat edge will help in aligning the rib flange on the spar flange. The rear ribs 7V1-2K are located at station 280 or RR#1. This is to make room for the wing tank outlet. Drill and cleco the rear ribs to the spar.



7V3-3 Spar Tip

Mark a 10mm line on the spar tip; clamp the tip to the spar. Align the center with the predrilled holes on the spar. Check for proper location on 7V3 drawing.

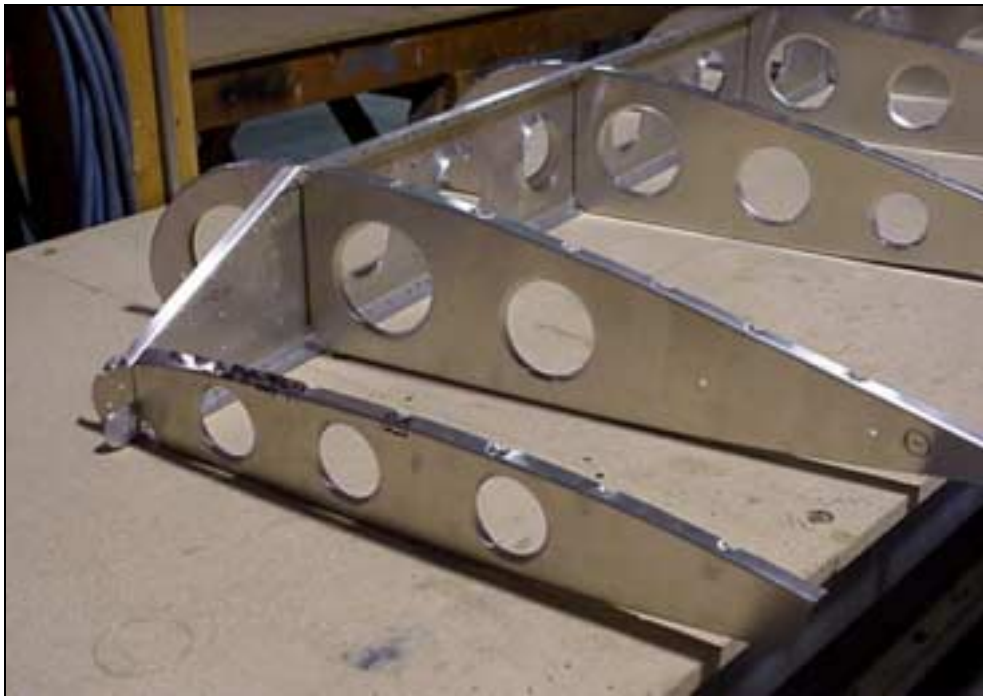


Nose and rear rib are cleco to the main spar. Notice the location of 7V1-2K.



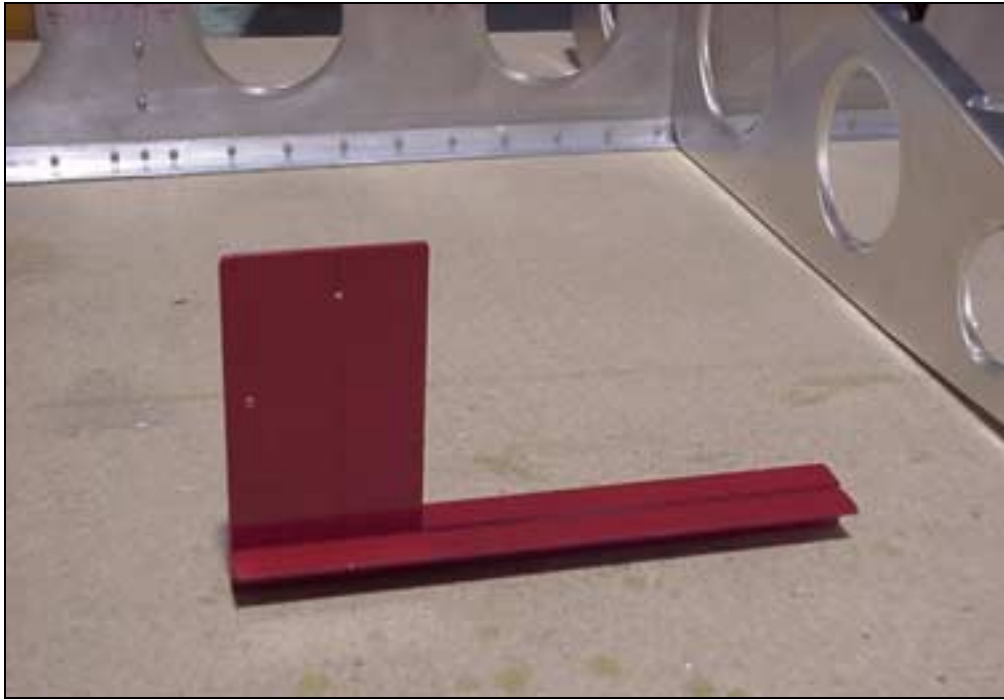
7V4-1 Root Nose Rib

Position the root nose rib at station "0" drill and cleco. The spar root doubler (7V3-2SP) flange may need to be bent down the same as the root nose rib flange for a proper fit.



7V4-2 Rear Root Rib

Position the rear root rib at station "0" drill and cleco.



Slat Support Template

Layout and make the slat support positioning template.



7V4-5 Slat Supports

Layout and predrill the slat position holes with number 40.



7V4-5 Slat Supports

Cleco the predrilled holes to the slat pos. template.



'L' angle

Cut eight pieces of std 'L' 120 mm long. Layout the corner relief holes in the radius. Cut all five notches.





7V4-7 Slat Supports  
7V1-1 Nose Rib

Position the slat template on nose rib #1, #3, #4, #6 and trace the bracket on the nose rib.



7V1-1 Nose Rib

Start at the top and drill the first hole. Bend the 'L' around the nose and drill to the rib to establish the shape of the leading edge of the nose rib. Wrap a piece of .016" material around the nose to check for proper fit of the 'L'. The strip represents the fitting of the leading edge skin.



7V1-1 Nose Rib  
7V4-5 Slat Supports

Take the 'L' off and clamp the rib to the template. Back drill through the rib to the slat bracket (7V4-5).



Disassembly the parts, deburr and apply corrosion protection.