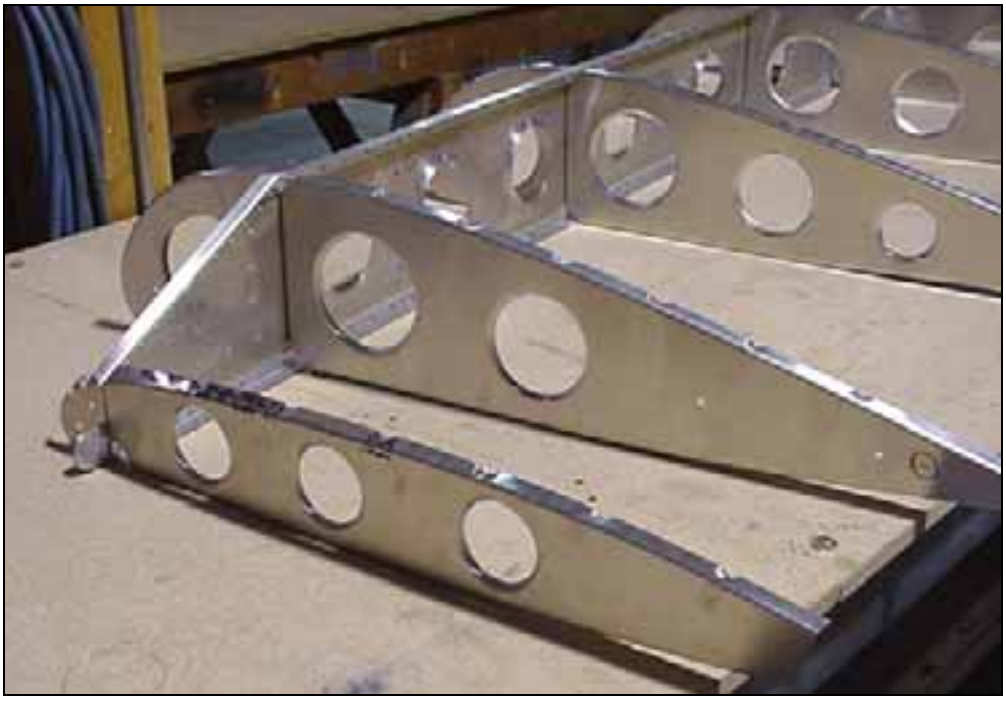
Rear Root Rib 7V4-2

Clamp a reference extrusion on the bottom of the spar. Clamp the bottom flange of the rib to the extrusion.



Position the rear root rib at station “0” drill and cleco.
Ref. top left diagram on drawing 7-V-3

Cleco the root nose rib to the spar

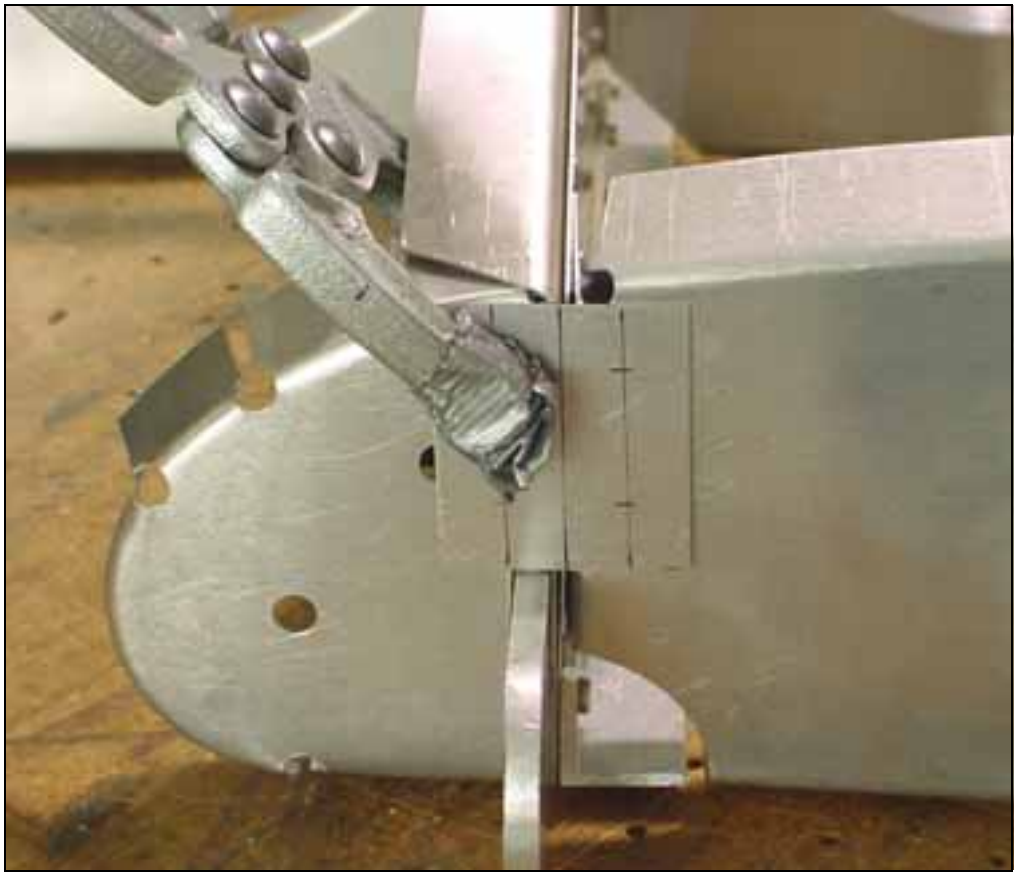
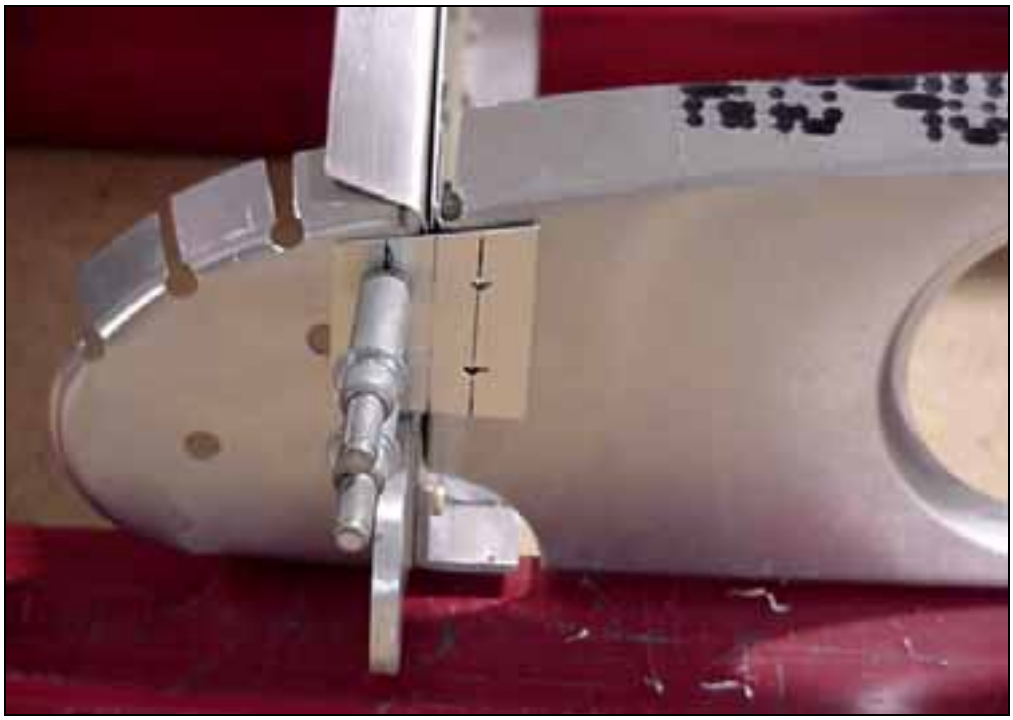


Plate 35 x 40
6061-T6 t=.025”

Note: no part number on drawings for this plate. Use a piece from the rear rib angle 7V6-3, or extra material supplied in kit or cut the front corner on 7F8-7

Layout the center line.
Layout the 4 corner holes.



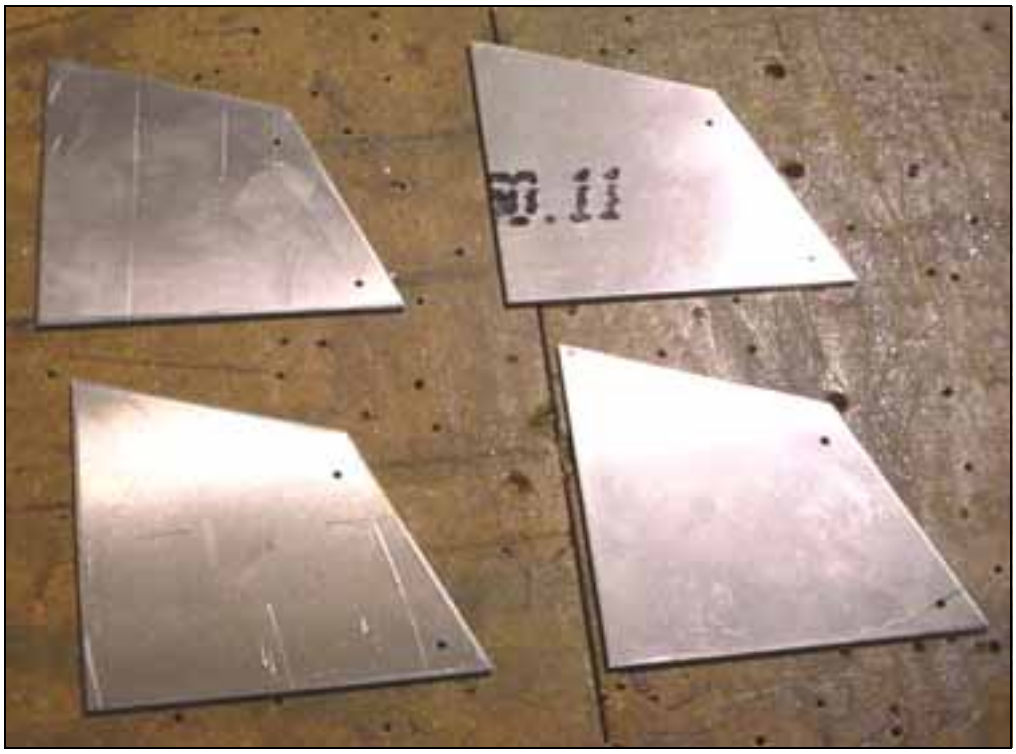
7V4-1 Front Root Rib
7V4-2 Rear Root Rib

Drill and cleco to ribs.

Clamp 2 slat supports together, back drill through the pre-drilled holes.

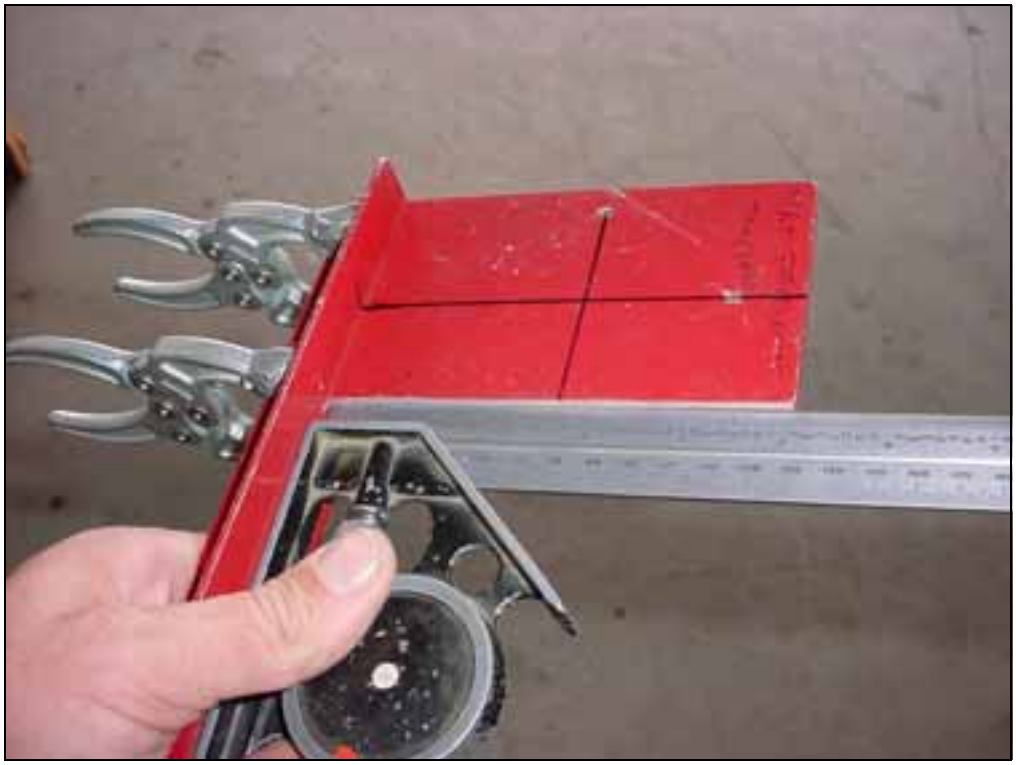
7V4-5 Slat Supports. Layout and drill the two holes with #40 holes.

Use the first slat support to drill the other 4 (4 total per wing).



4 slat supports with the bolt holes drilled.

Ref. **7V4-5**

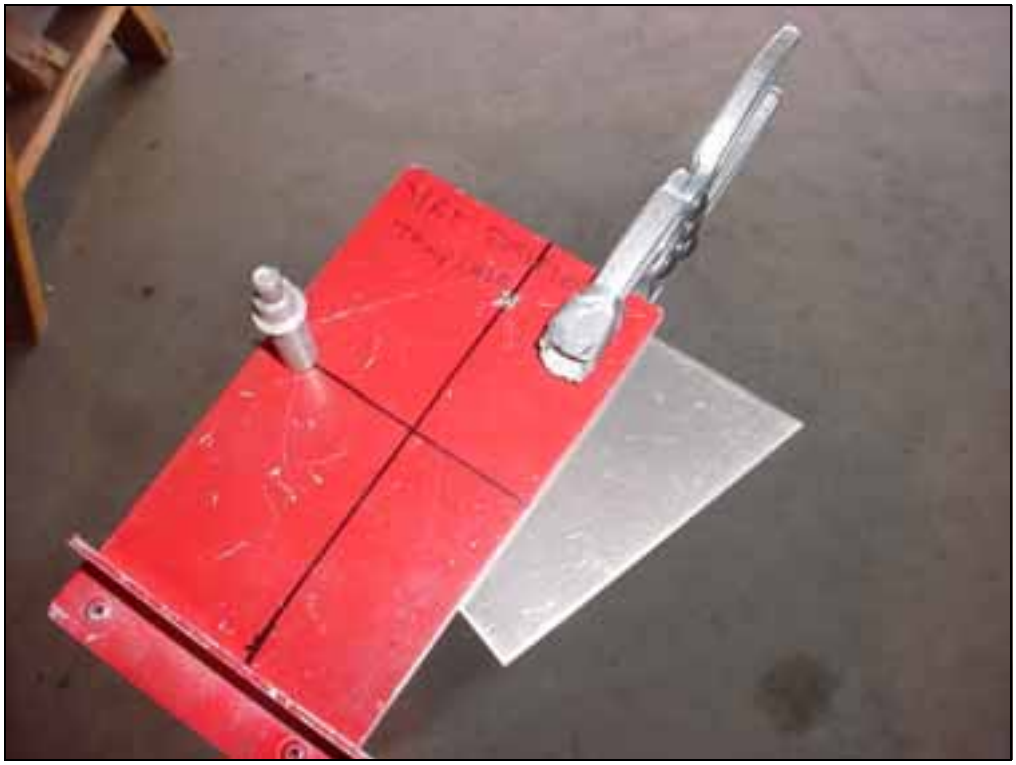


Clamp the plate at 90 degrees to the extrusion.

SLAT SUPPORT POSITIONING TEMPLATE.
Ref., top left diagram on drawing 7-V-5

Instead of making a separate template for the left and right side, two pieces of extrusion are riveted with the plate in the middle.

Drill the front hole: coordinates 70mm across and 68mm up.
Draw a vertical line at 35mm from the aft edge of the plate.



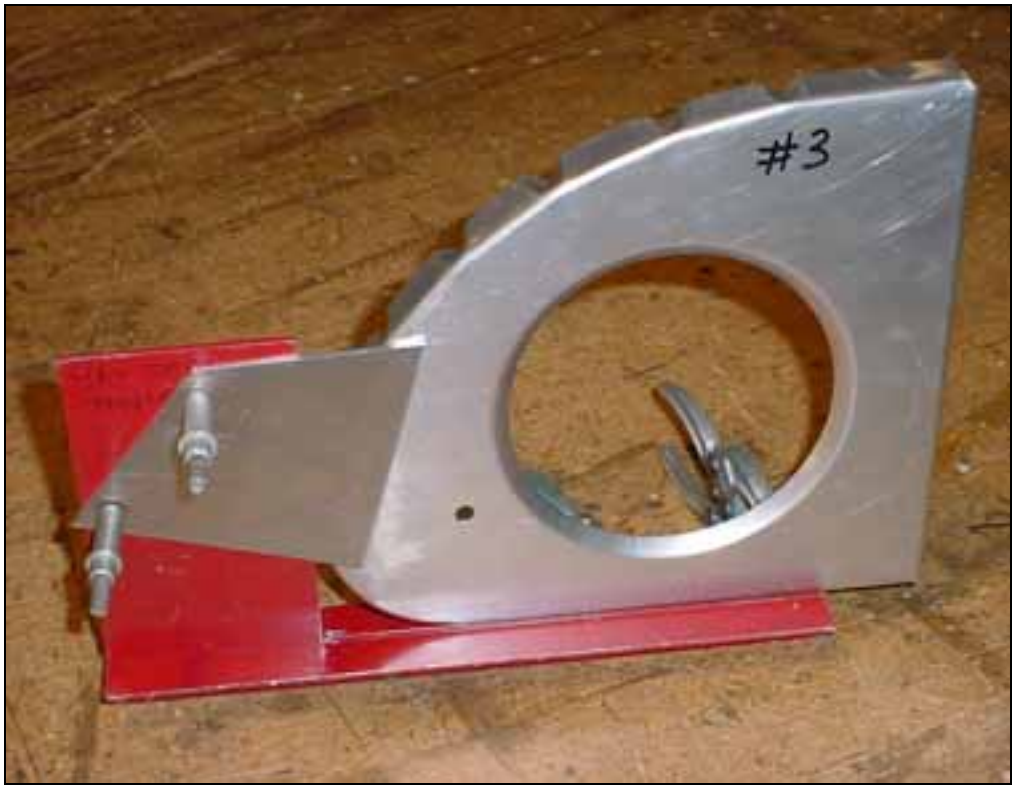
Cleco the slat support 7V4-5 to the template through the front hole.

Slat Support Template.

Adjust the slat support 7V4-5 until the 35mm line is visible through the predrilled hole.
Clamp and back drill into the template.

7V4-5 Slat Supports.

Cleco the slat support to the slat positioning template.



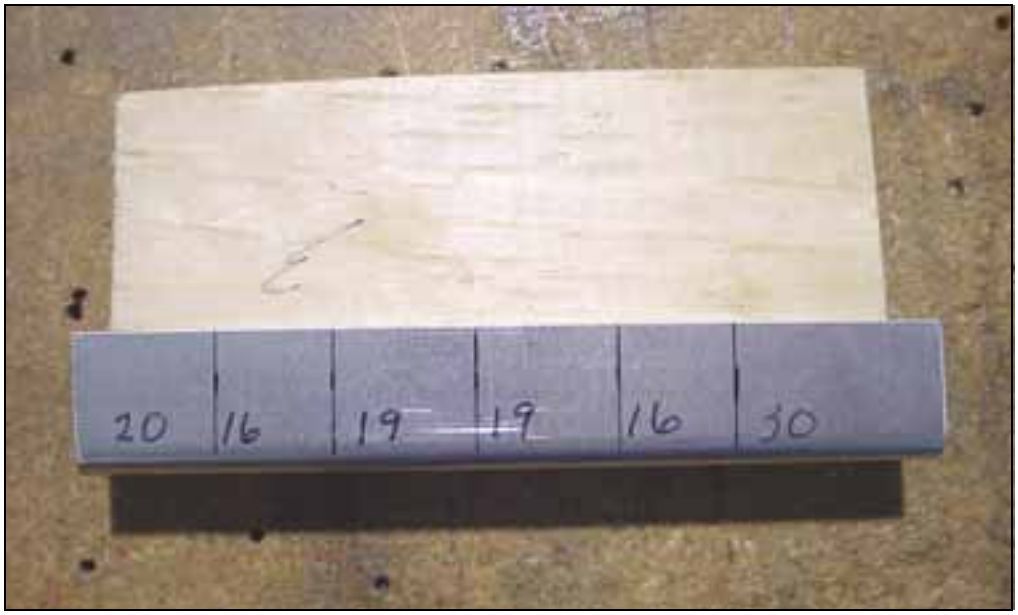
Position a nose rib on the template.

Front detail.

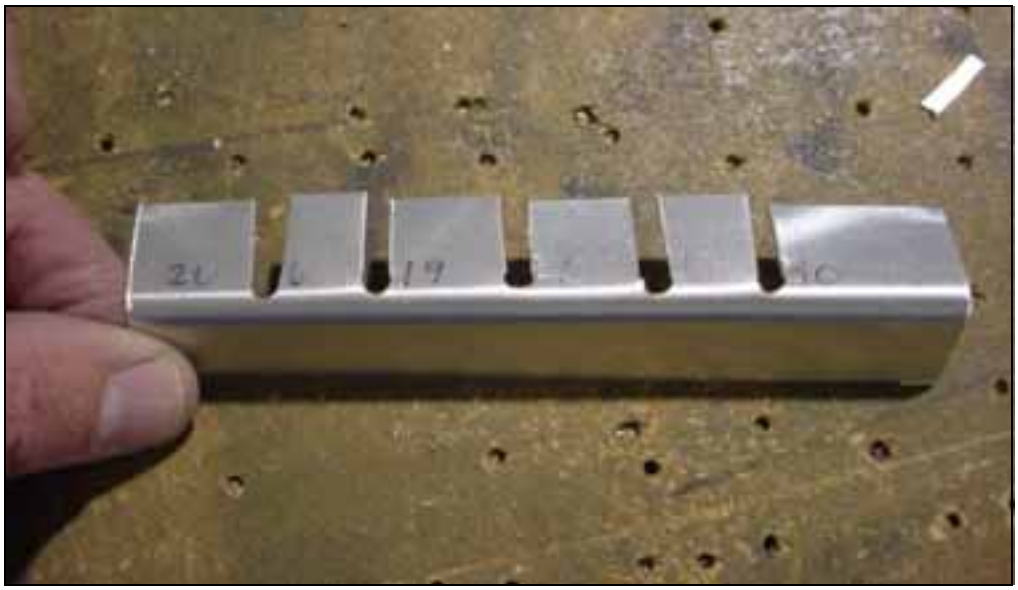
Slide the rib to stop on the aft edge of the template.
Clamp the bottom flange to the template extrusion.

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

Trace the bracket on the nose rib. #1, #3, #4, #6.



Bent L angle. Cut eight pieces 120 mm long
Ref. bottom left diagram on drawing 7-V-5
Layout lines for the corner relief holes.
Drill the corner relief holes in the radius. Drill with #20.



'L' angle.

First cut the five notches. Cut is at 90 degrees to the edge of the hole.

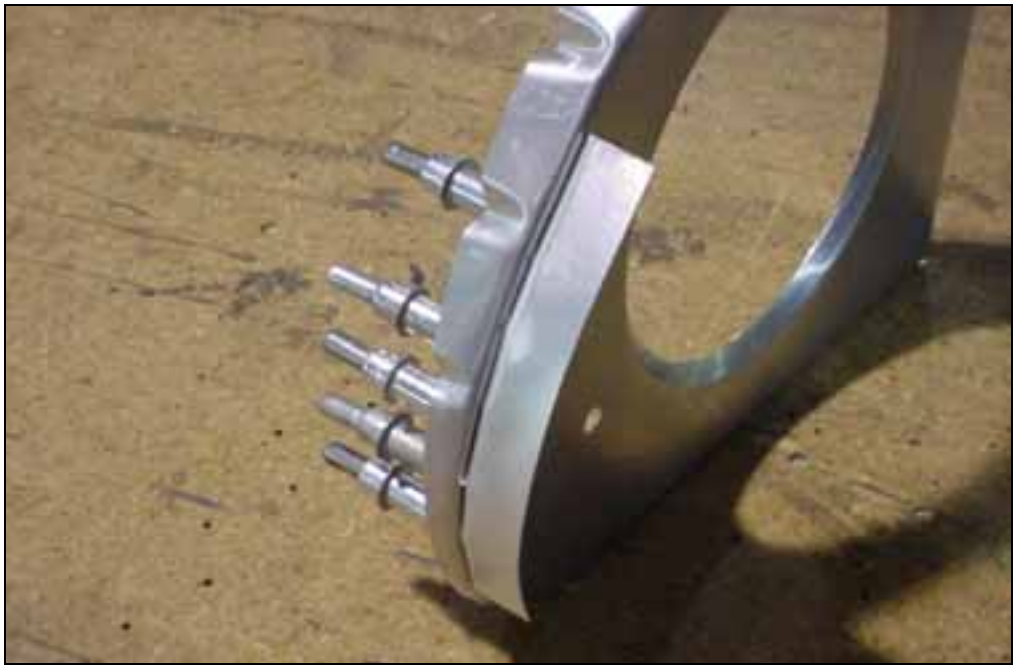
Clamp the bent L angle to the rib.

Bend the L angle to the curvature of the rib. If necessary trim the sides of the notches.

Rivet pattern and stat support trace line.

CHECK: Rivet edge distance for the top and bottom rivets are within the slat support trace lines.

Drill and cleco.



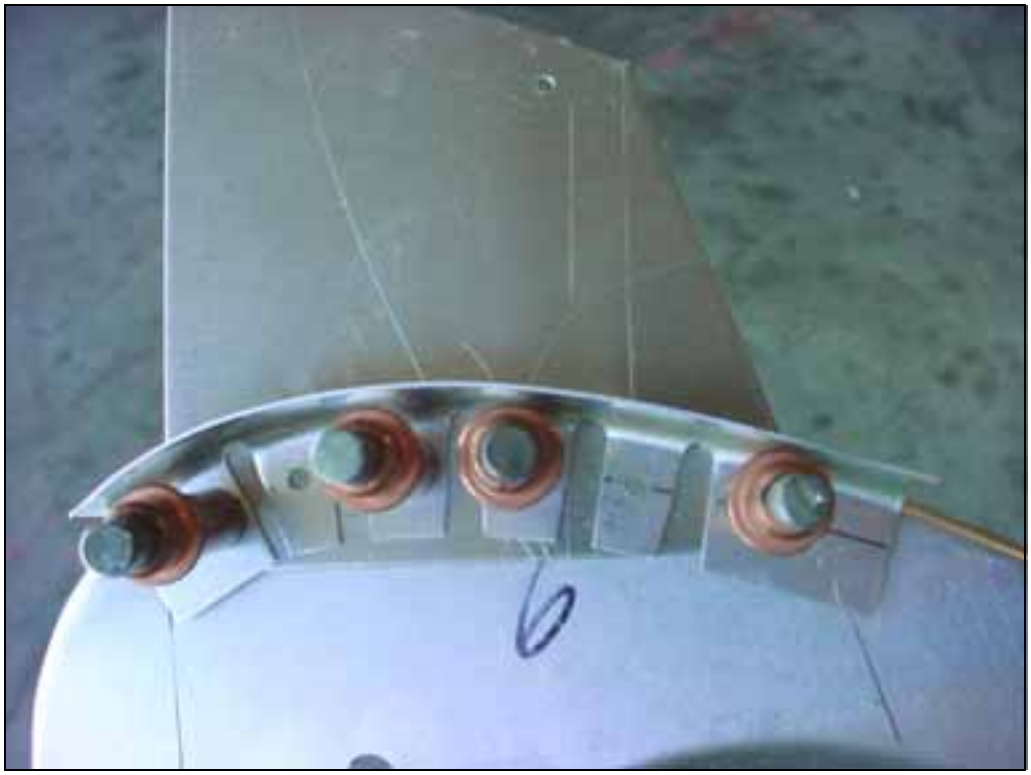
Re-install the clecos from the rib side.

CHECK: Wrap a strip of .016 over the leading edge of the nose rib. The strip represents the fitting of the leading edge skin.

Note: The purpose of the L angle is to support the leading edge skin along the inboard side of the cutout in the skin for the slat support. Ref. text top left on drawing 7-V-8

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

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



Clecoes can be installed from either side.

Re-install the bent L angle.

(view from the front)

Cleco the slat support between the rib and the L angle.

6 RIVETS A4

Disassembly the parts, deburr and apply corrosion protection.
Rivet.