

NOTE: If you are not experienced in putting in solid rivets, make sure you practice on scrap pieces of material until you can consistently drive good rivets. There are approximately 600 solid rivets total in the two Main Spars. It might be more economical if you do all the drilling and deburring and have someone else who already has the equipment to do the actual riveting.

48) Bolt together the three Wing Strut Fittings (W0716, W0717 and W0718) using 1/4" bolts. These bolts are used only to hold assembly together for drilling. Figure 6.1.21.

49) Drill and ream out the Strut attach hole to 7/16". Figure 6.1.21.

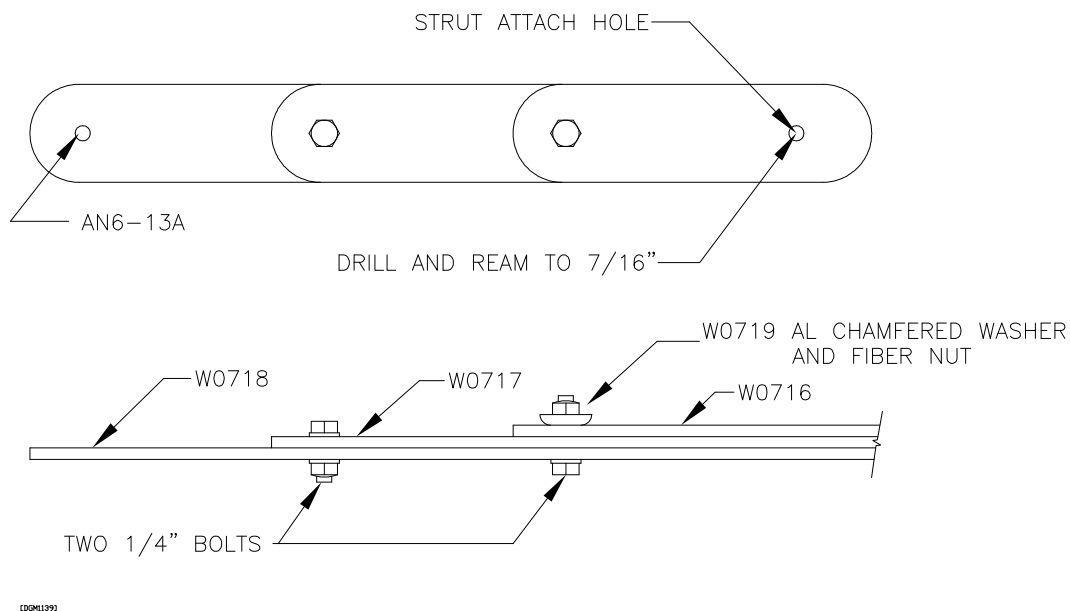


Fig. 6.1.21

50) Bolt the three Wing Strut fittings together with an AN7 bolt. This bolt is positioned through the Strut Attach hole to hold the assembly together for drilling.

51) In the Main Spar assembly, drill out the three Wing Strut fitting attach holes with an "F" drill.

52) Bolt the three Wing Strut fittings to the Main Spar assembly with two AN4 bolts in order to secure assembly for drilling. Figure 6.1.22.

53) Drill and ream the top hole to 9/16". Then bolt securely with the proper AN9 bolt.

54) Remove one of the 1/4" bolts. Then drill and ream to 9/16". Bolt securely with proper AN9 bolt.

55) Repeat for the third hole.

56) Remove the Wing Strut fittings. They will be reinstalled after the wing skins have been installed.

57) Set the Main Spar assembly aside for now.