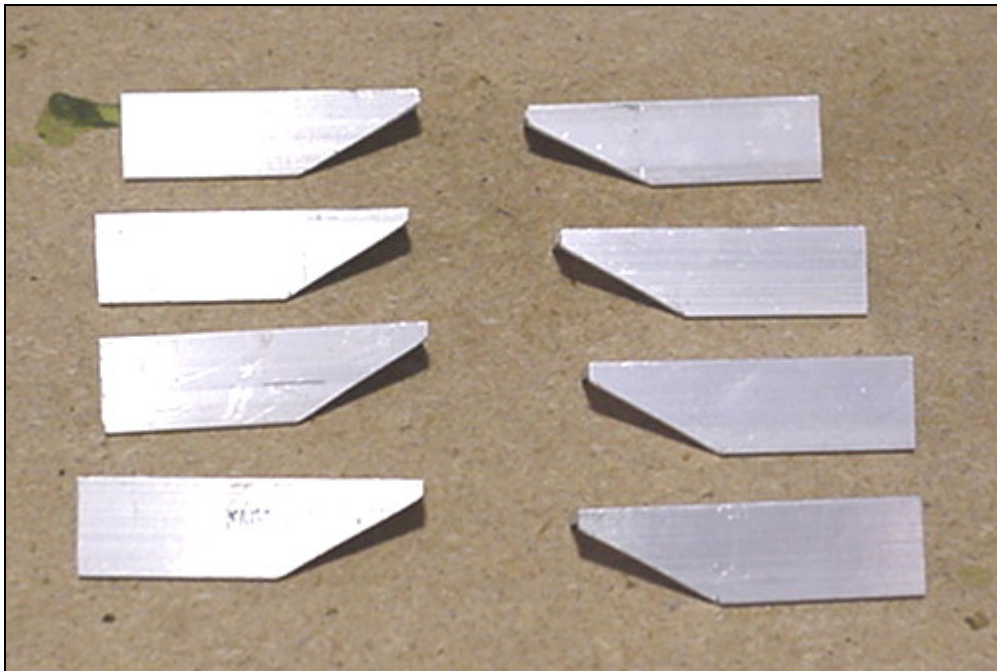




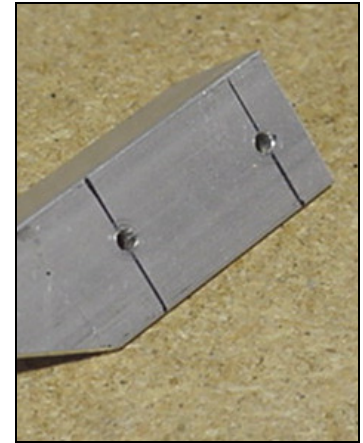
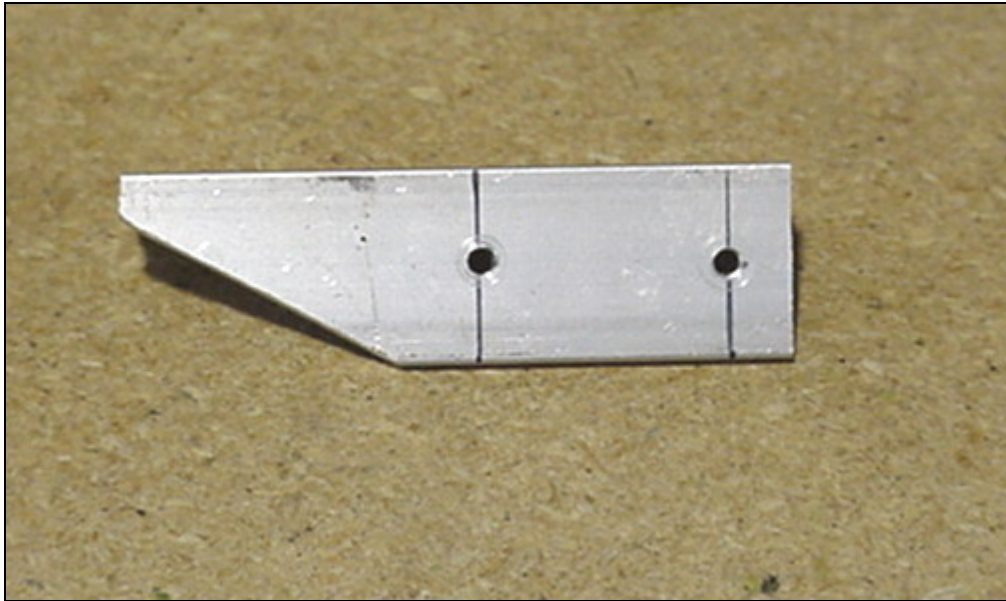
Flaperon Parts

Ribs packaged with left and right in one bundle. Separate the left and right ribs.



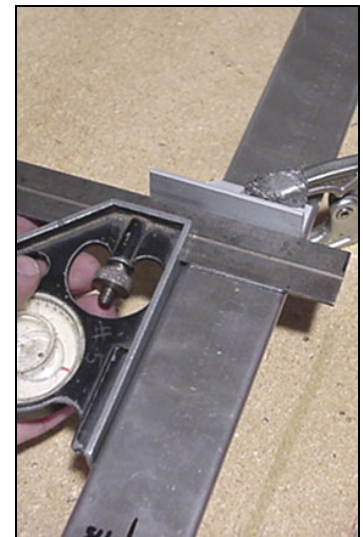
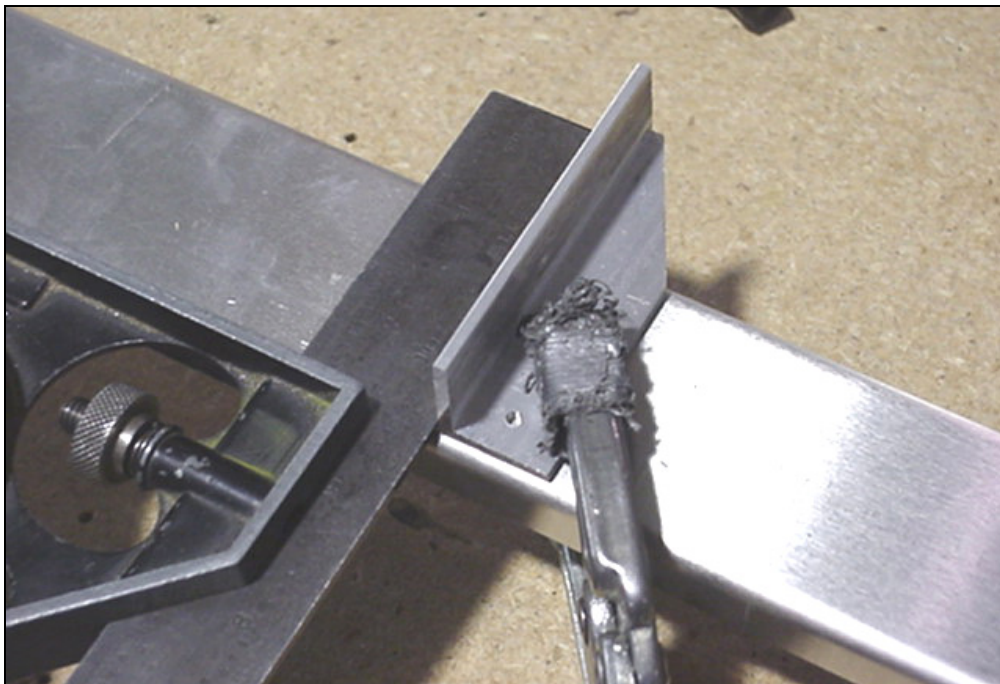
7A1-5 Hinge Bracket

There are four right and four left brackets. Layout and cut the 26mm angle on the brackets. File off the saw marks; they can lead to cracks.



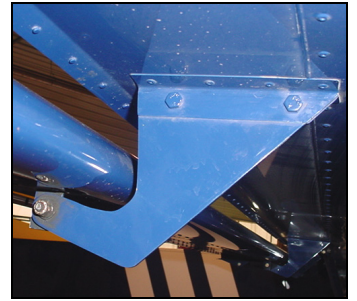
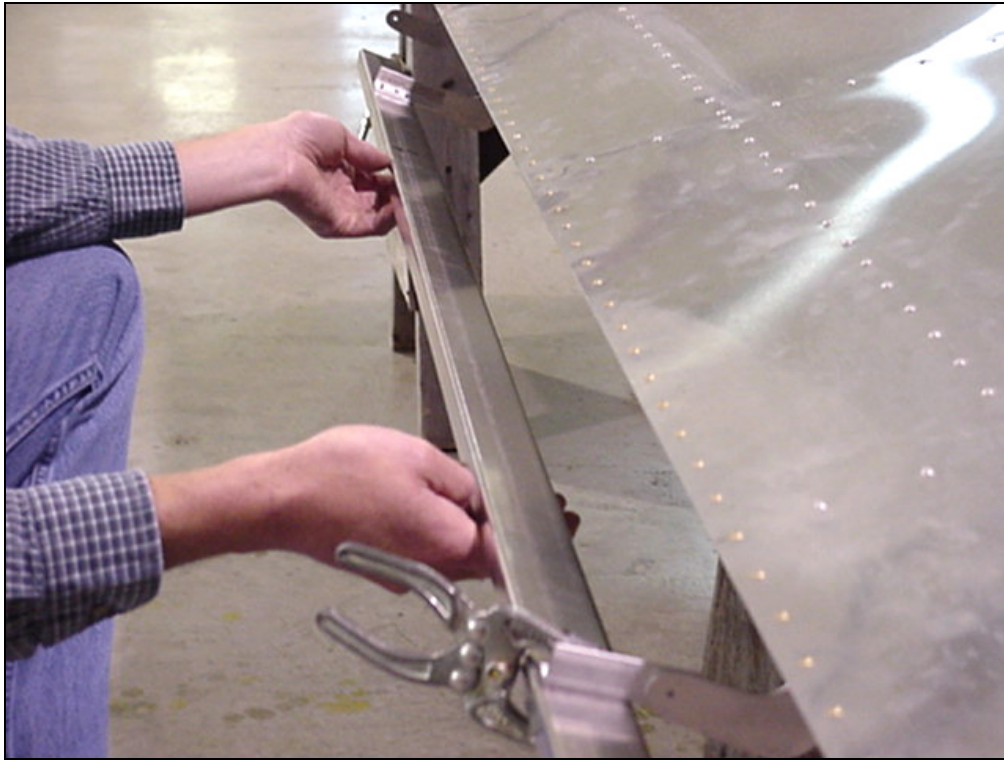
**7A1-5 Hinge Bracket**

Layout and Predrill the mounting holes. Drill the two holes with #40 drill.



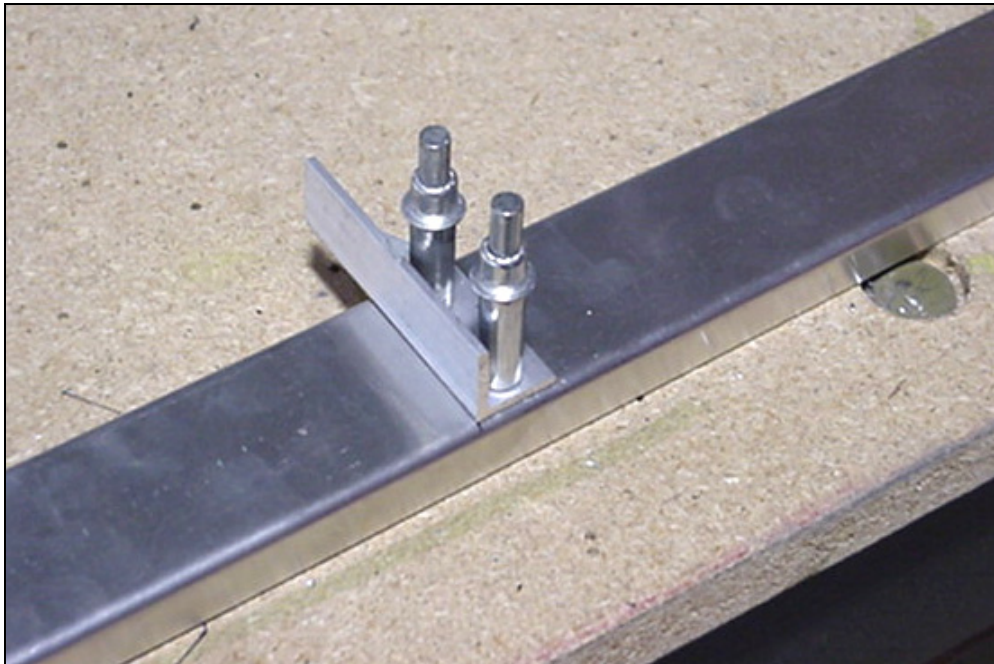
**7A1-5 Hinge Bracket  
7A1-4 Flaperon Spar**

Start with the right outboard flaperon first. Mark the top and bottom on the flaperon spar; the top has the 12 deg bend where the bottom is 90 deg. The bracket on the outboard end is 410mm from the end of the spar, and 180mm for the inboard end. This is on the outboard flaperon. The spar will be 20mm shorter than the skin on each side. Once the bracket is correctly position clamp to the spar.



Before drilling the brackets to the spar, check to make sure that the distance is the same as the flaperon arms 7V4-7 DWG 7-V-6. From outside to outside on the Hinge Bracket 7A1-5 the distance is 1200mm, which will fit between the flaperon arms 7V4-7.

**7A1-4 Flaperon Spar  
7A1-5 Hinge Bracket**



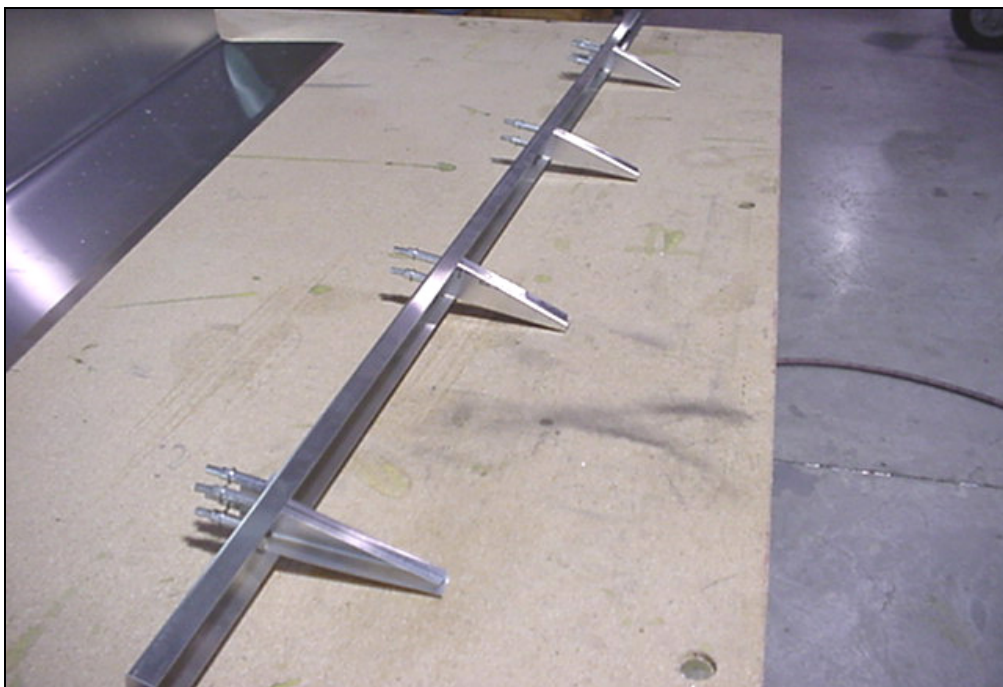
**7A1-4 Flaperon Spar  
7A1-5 Hinge Bracket**

The hinge bracket will extend 24mm past the flaperon spar. Drill two A5 and cleco to the spar.



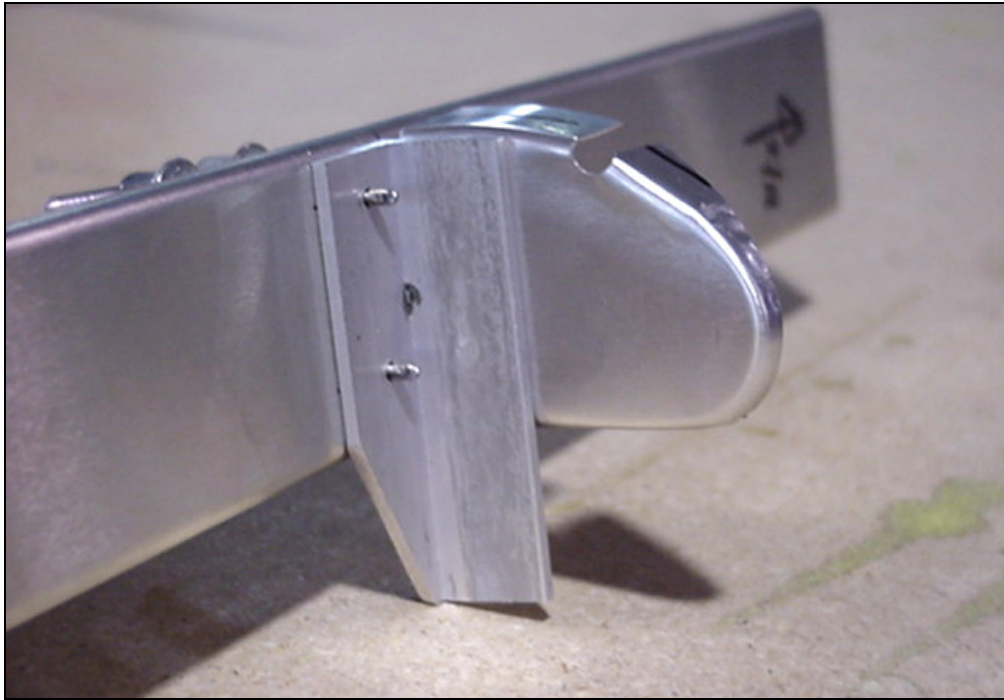
**7A1-4 Flaperon Spar**

Locating the position for the rear rib 7A1-3. This is done by measuring and laying the spar and references it from the predrilled flaperon skin 7A2-1.



**7A1-4 Flaperon Spar  
7A1-3 Flaperon Rear  
Ribs**

Drill and cleco the rear ribs to the spar A4.



Drill two A5 holes through the hinge brackets and into the ribs.

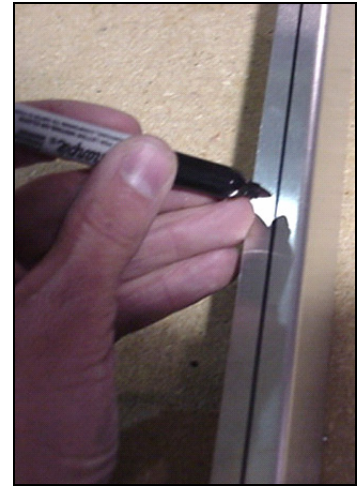
**7A1-2 Flaperon Nose Ribs**  
**7A1-5 Hinge Bracket**

Back drill the nose rib to the spar using the rear rib drill holes.



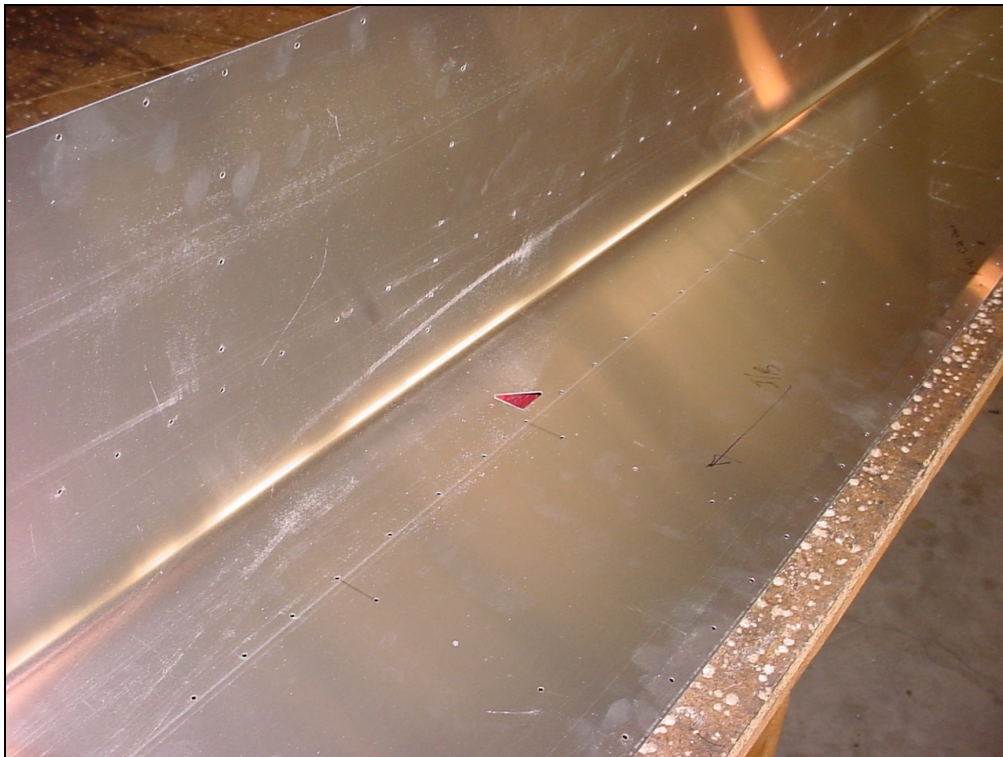
**7A1-2 Flaperon Nose Ribs**  
**7A1-5 Hinge Bracket**

Rivet skeleton.



**7A1-4 Flaperon Spar**

Layout the rivet line on the flaperon spar flange.



Pre-drilled skin with holes along the trailing edge and cutout for the brackets.



**ORIENTATION:** The 15 deg. bent trailing edge on the flaperon skin is the bottom.

Position the skeleton inside the skin.  
Photo of right inboard section.



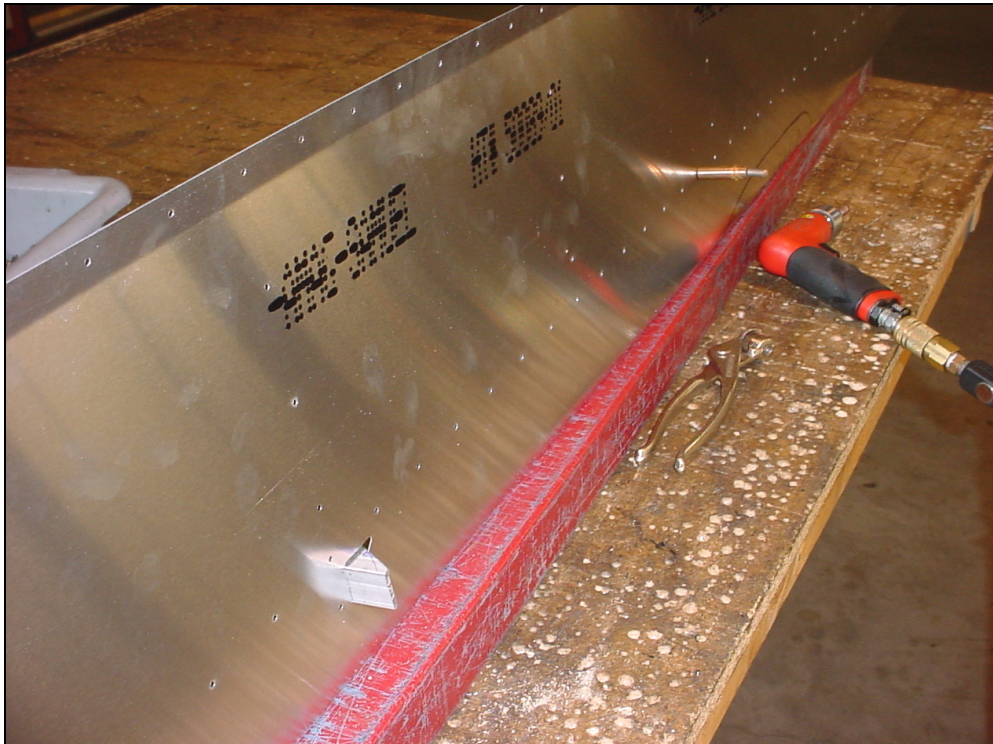
**CLAMP:** Clamp the ends of the spar to the skin (inboard and outboard).

**COMMENT:** Lay the skin across 2 steel beam to make room for the protrude brackets 7A1-5



Rivet line visible through the pilot holes.

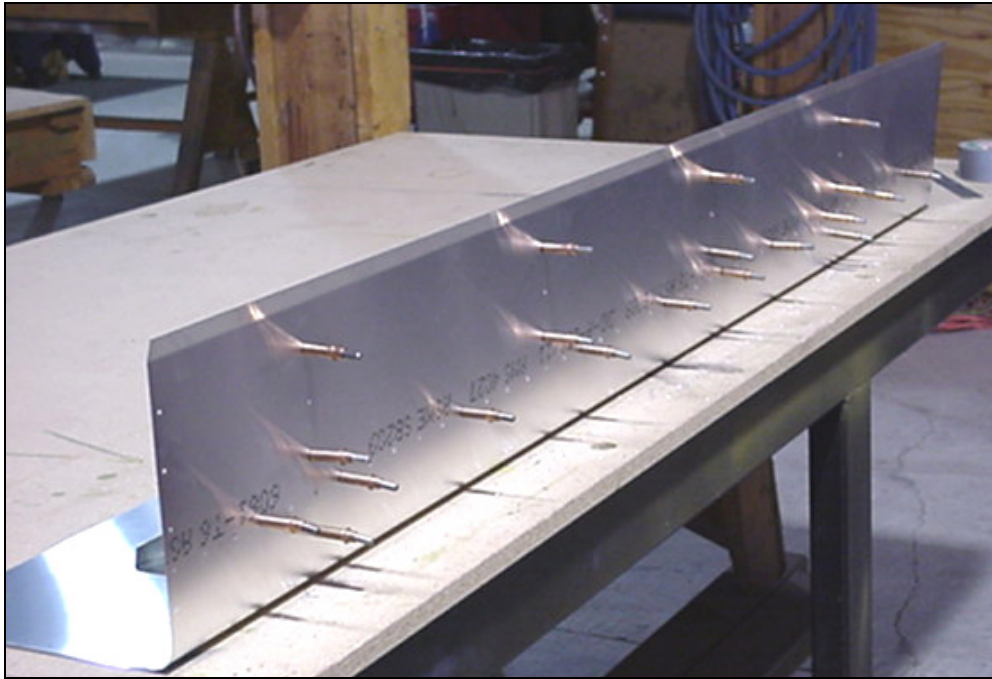
Line up the spar rivet line through the pre-drilled holes in the skin.



**7A2-1 Flaperon Skin**

Position the flaperon spar on the skin, when the centerline is visible drill and cleco.

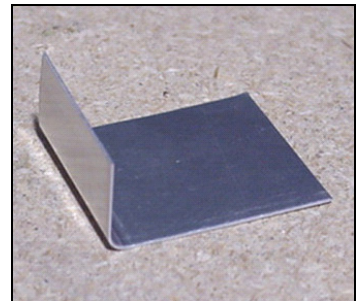




Drill and cleco the spar and the rear ribs to the skin.

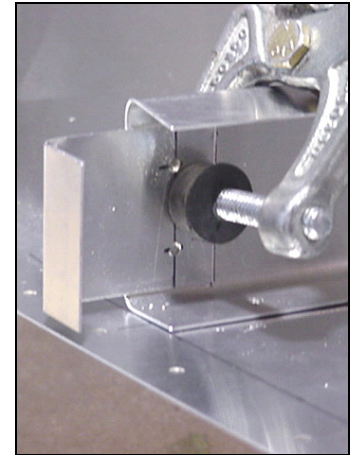


The end of the rib angle is square to the bottom of the spar.



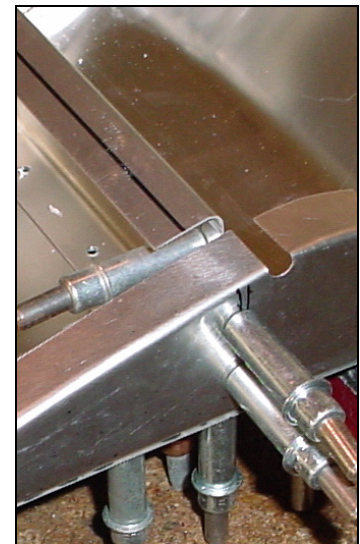
**7V6-3 Rib Angle**

Cut the Rib Angle 35mm long.

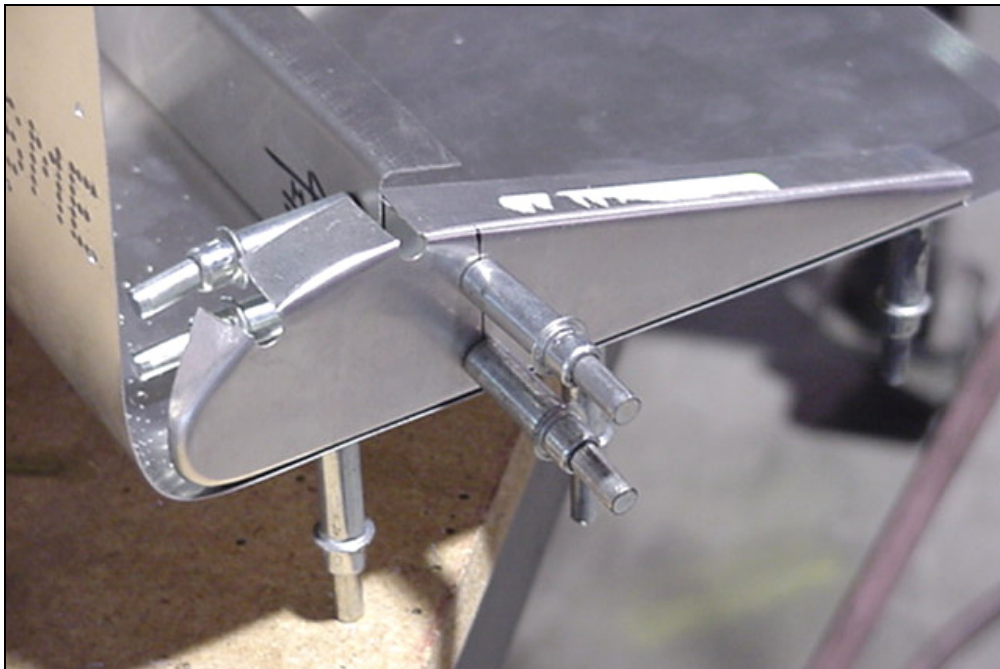
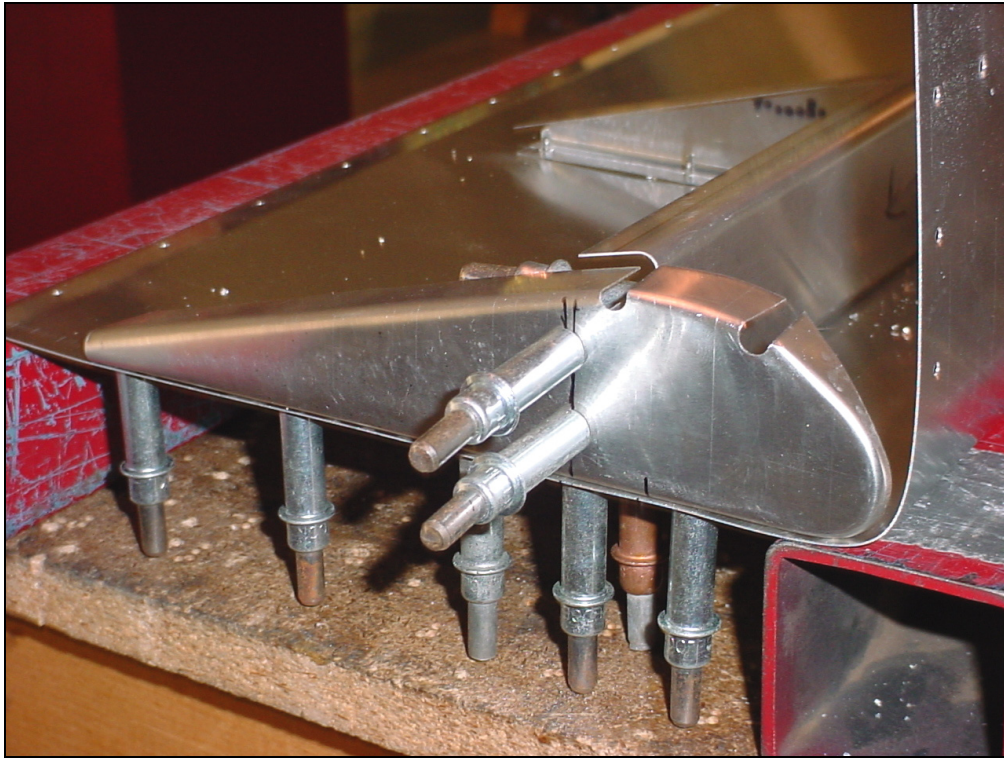


**7V6-3 Rib Angle  
7A1-4 Flaperon Spar**

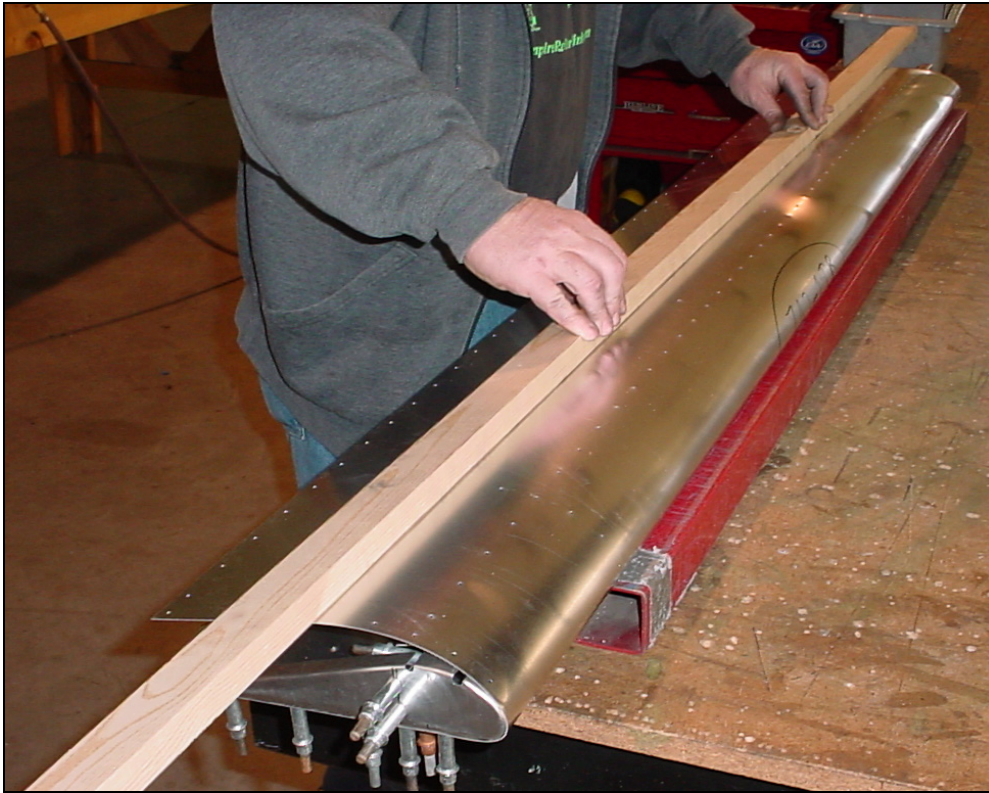
The rib angle will be located at the ends of the spars, but not at the end with fiberglass tip. Line up the bent flange with edge of the skin, clamp and drill two A4 holes.



The Flaperon Splice End Rib is located at the splice of the inboard and outboard section. Position the rib flush with the edge of the skin. Drill and cleco the bottom and drill two A4 holes in the side of 7V6-3.



**7V6-3 Rib Angle  
7A1-1 Flaperon Splice  
End Ribs**



Close the skin, push down on a 2x2 board to prevent damage to the skin.



Cleco the trailing edge with #40 clecos in every 3<sup>rd</sup> hole.



Silver Clecos =#40 pilot holes.