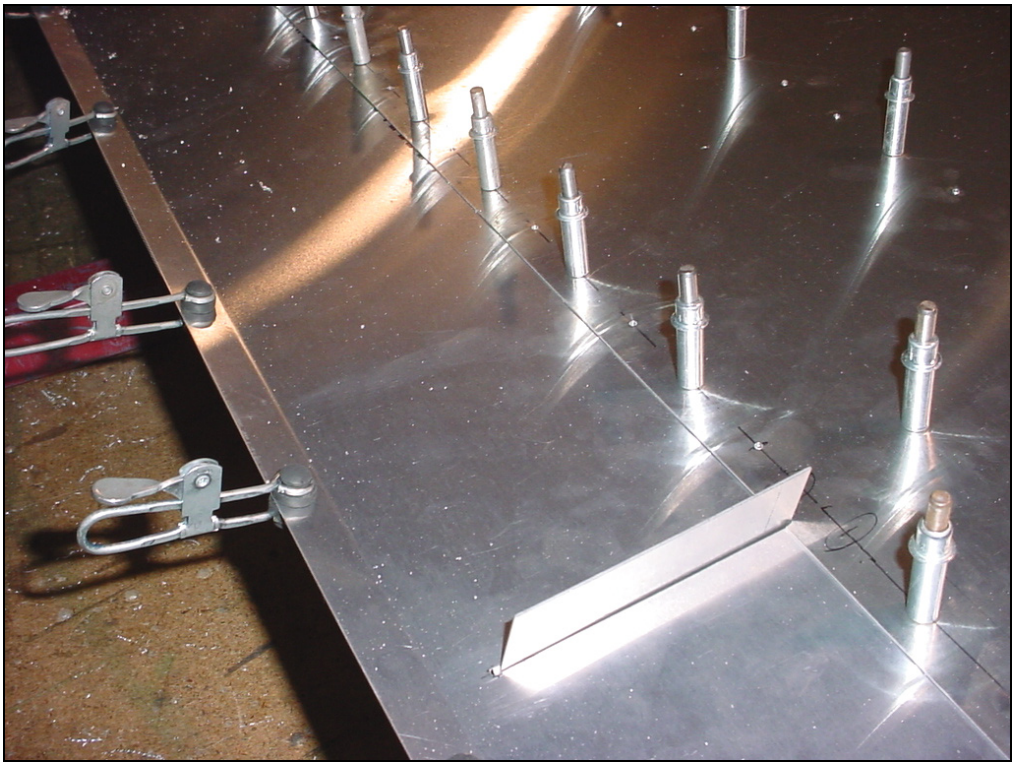
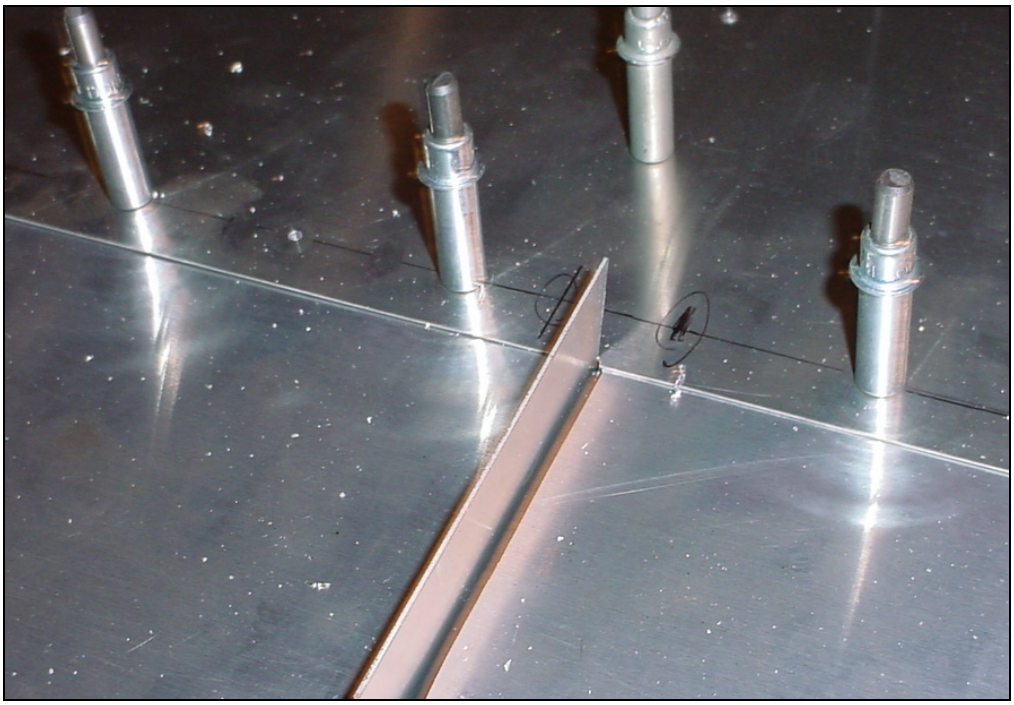


Layout the rivet line with proper edge distance on the channels 7V6-1 and 7V6-2SP

NOTE: Edge distance from the aft end of the lower rear skin may be more than 10mm to have proper edge distance on the channels underneath the skin.



Layout the rivet spacing. On The O/B side of the bracket 7V4-6, the first hole is 10mm from the end of the channel. Use a piece of L angle to mark the holes through the L angle Ref. 7-V-5 section A-A

Detail of the holes for the L angles (on one each side of the Flaperon bracket).

IMPORTANT: “No Rivet Zone” Circle the holes to indicate they are not to be drilled at this time.

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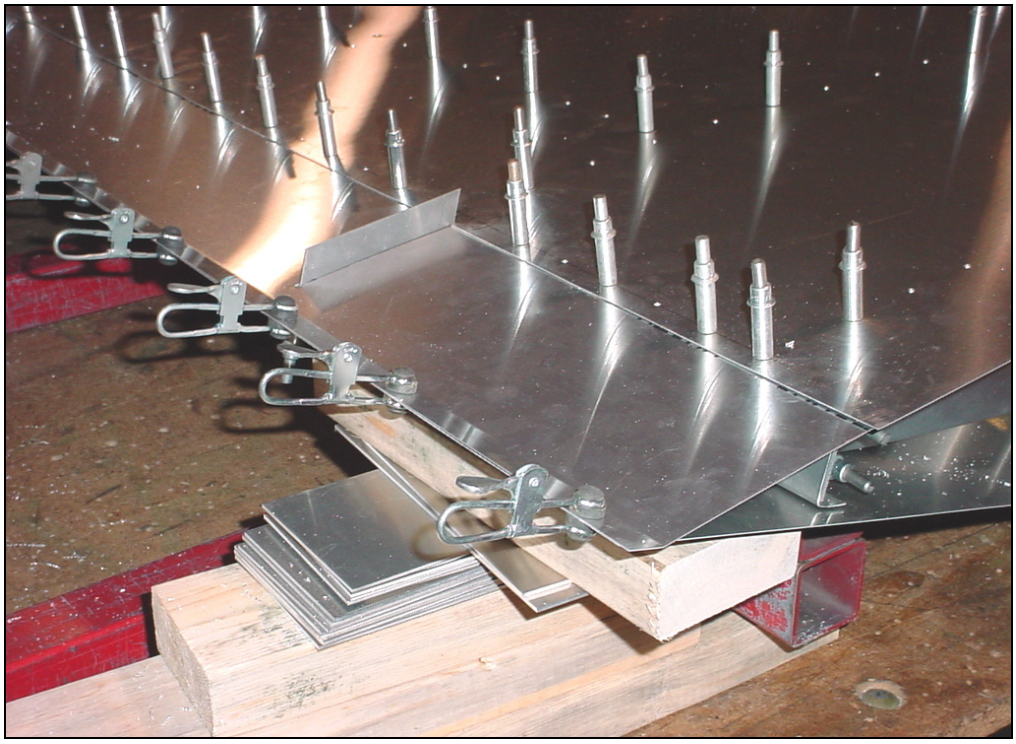
A4 PITCH 40
Ref. top right diagram on drawing 7-V-8

Drill and Cleco every second hole with #40 pilot holes.



Last hole on the inboard end is the intersection hole with the root rib 7V4-2 rivet line.

Finish drilling between the Clecoes.

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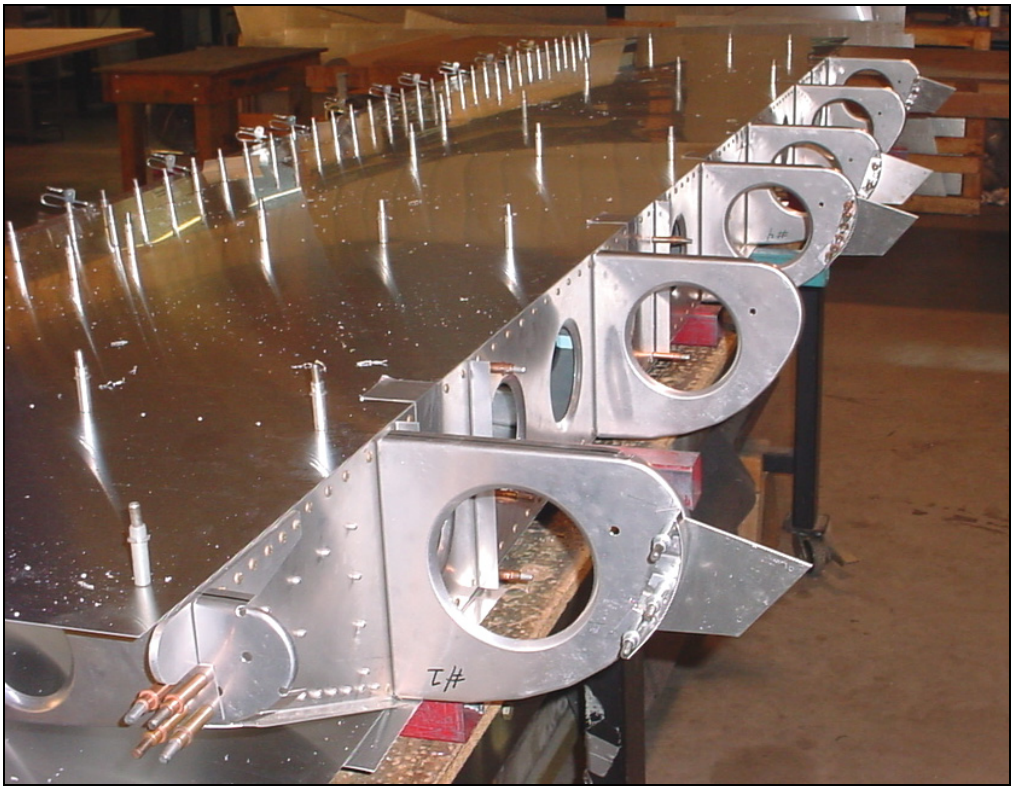

CHECK make sure that the slat brackets are at the correct distance from each other (drawing 7-V-6).

Wing before the nose skin 7V7-1 is positioned.

Re-install the nose ribs.

Use an adjustable square to set the depth of the spar web and extrusion.

Mark the aft edge of the spar extrusion on the top side of the skin.

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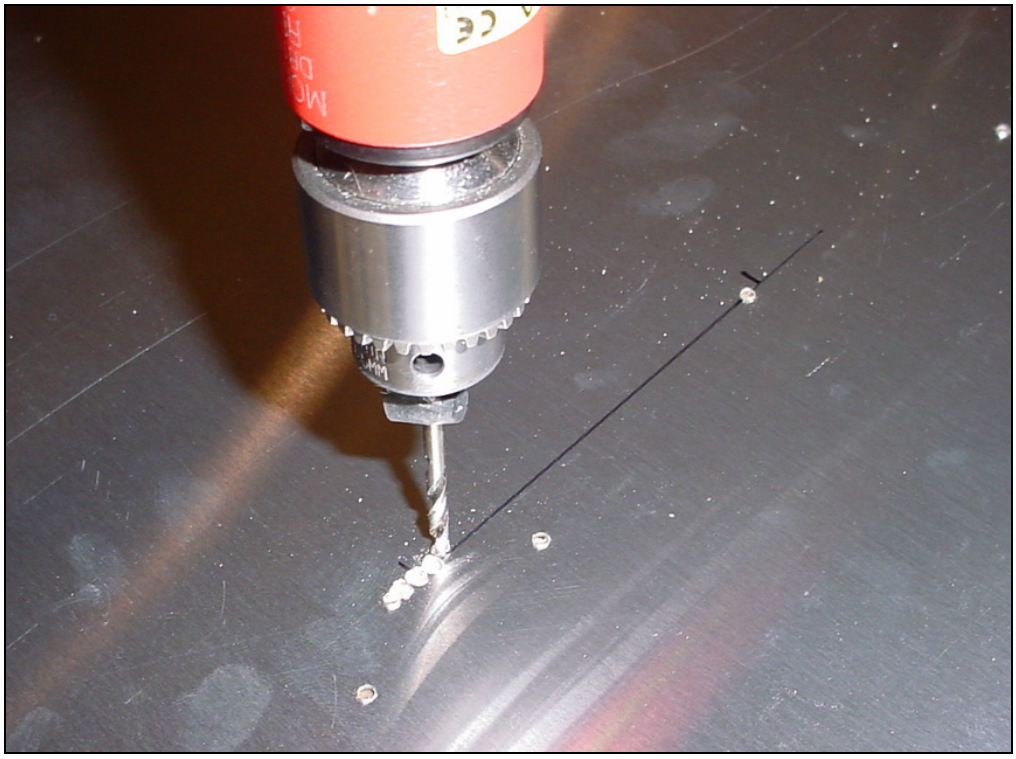
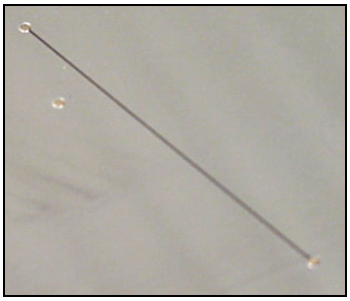


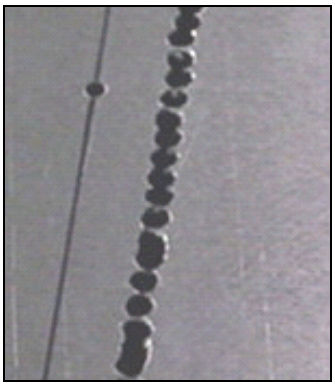


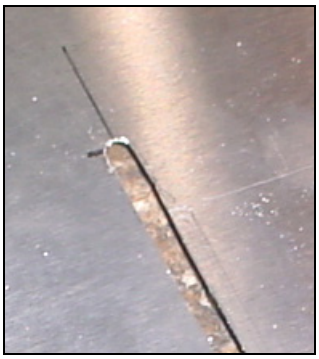
7V7-1 Nose Skin
The slots for 7V4-5 have two predrilled holes. Locate them and connect them with a line. These will be at rib #1,#3,#4,#6.

LAYOUT: Connect the two with a straight line.

The best way to cut the slot is by drilling a series of holes using a #30 drill bit. Then finish with a small round file leaving a nice smooth slot.

This is the finished slot after drilled and filed.





NOTE: The slot is centered on the line.

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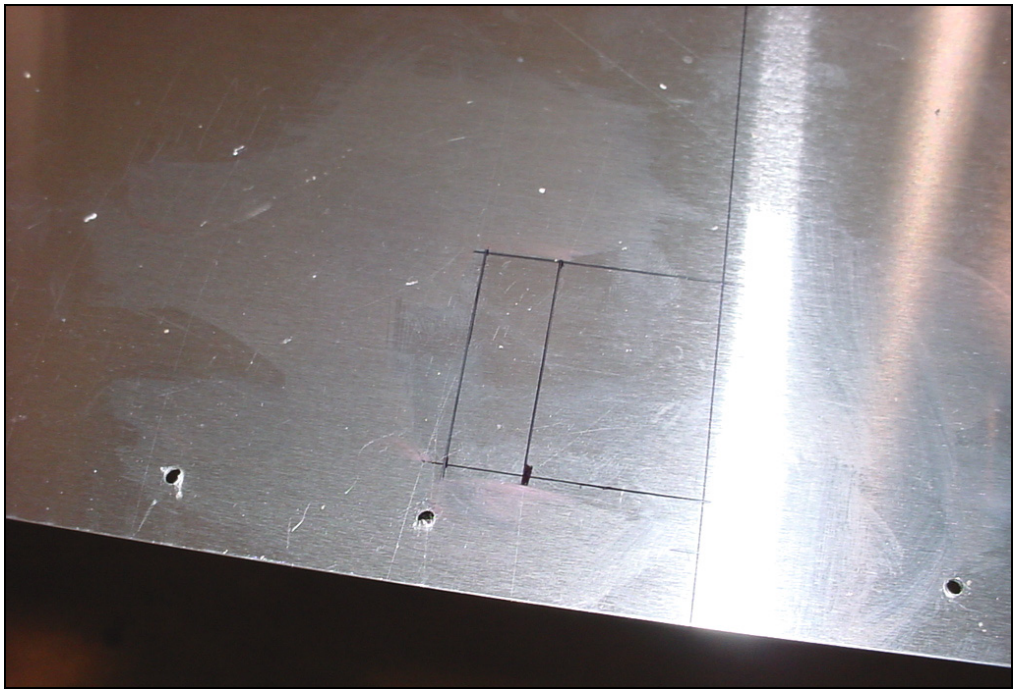
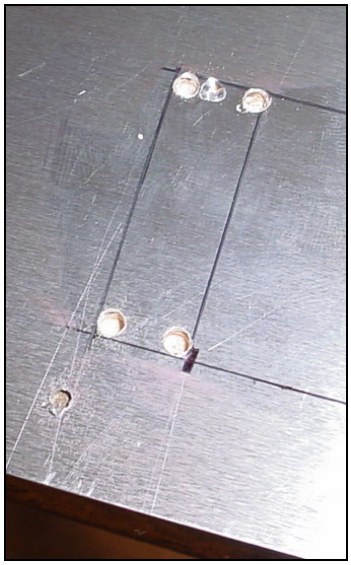
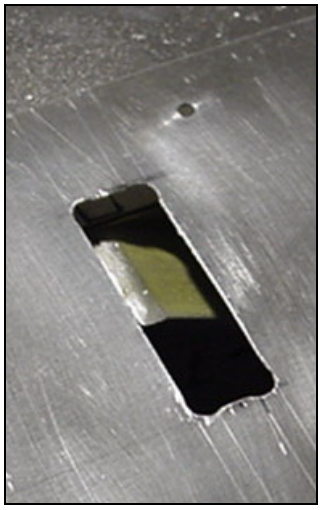




Drill out the corners of the hole, cut and file to size.

ORIENTATION: Bottom side is up.
Connect the pre-drilled holes through nose rib #4 with a straight line to the bottom edge of the sheet.
Layout the cutout for the front upper strut fitting 7V2-5. The cut out is made in front of the spar; it is 12mm wide and 40mm long.



File the side smooth.

NOTE: 20mm from the aft edge of the sheet to the edge of the cutout. Ref. top diagram on drawing 7-V-7

Drill a series of holes. Use the drill bit to cut between the holes.

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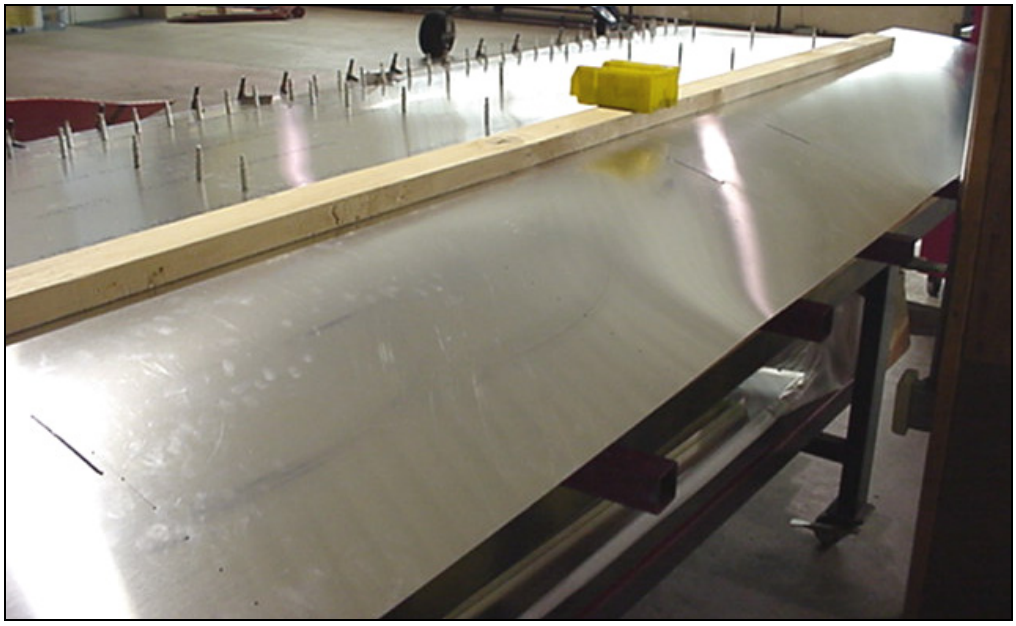
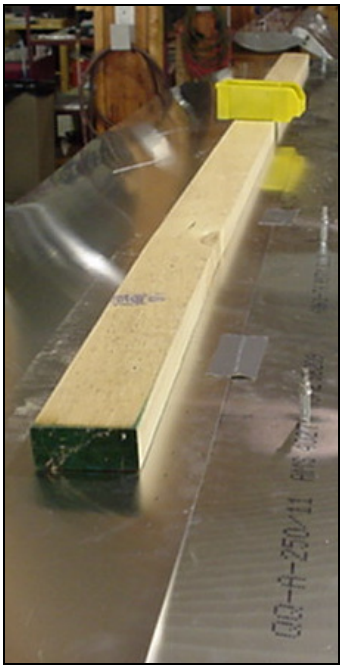


Position the skin on the wing.

CHECK: The aft edge of the skin is in line with the aft edge of the spar extrusion 7V2-3



Uses pieces of duct tape to hole the skin in place. A 2x4 board across the bottom of the nose rib will also help keep the skin down.

CHECK: The line through the nose rib rivet holes lines ups with the rear rib rivet line.

Detail of rivet line at rib #4

Lateral position is established by aligning the predrilled holes with the rib centerline.

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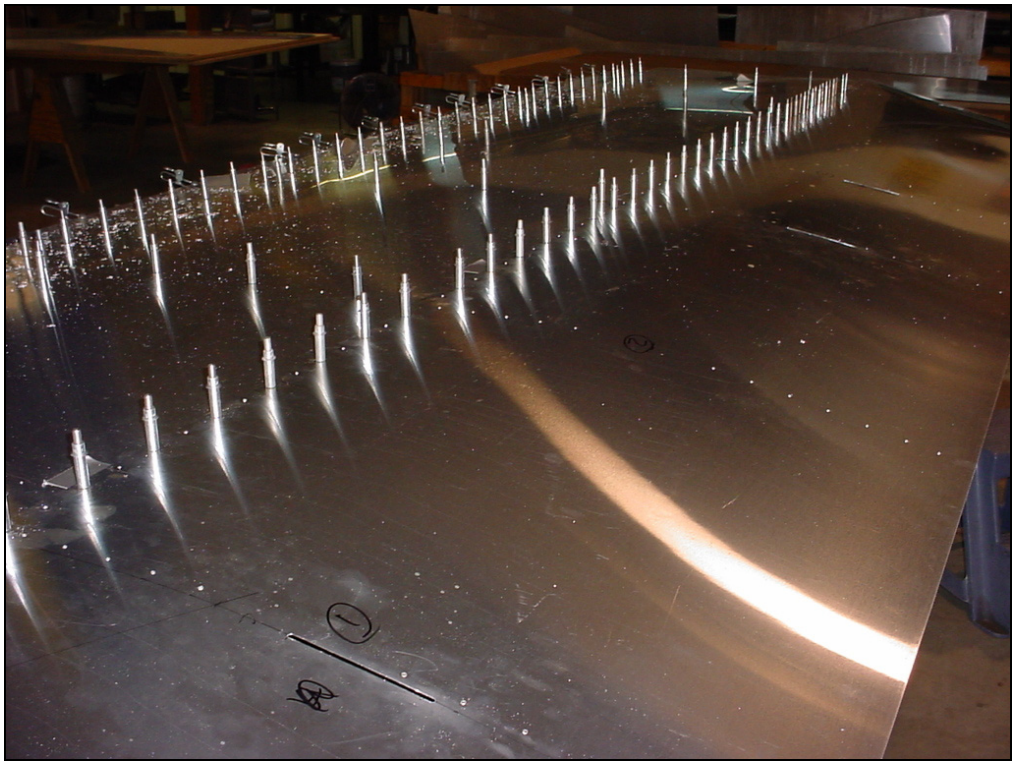
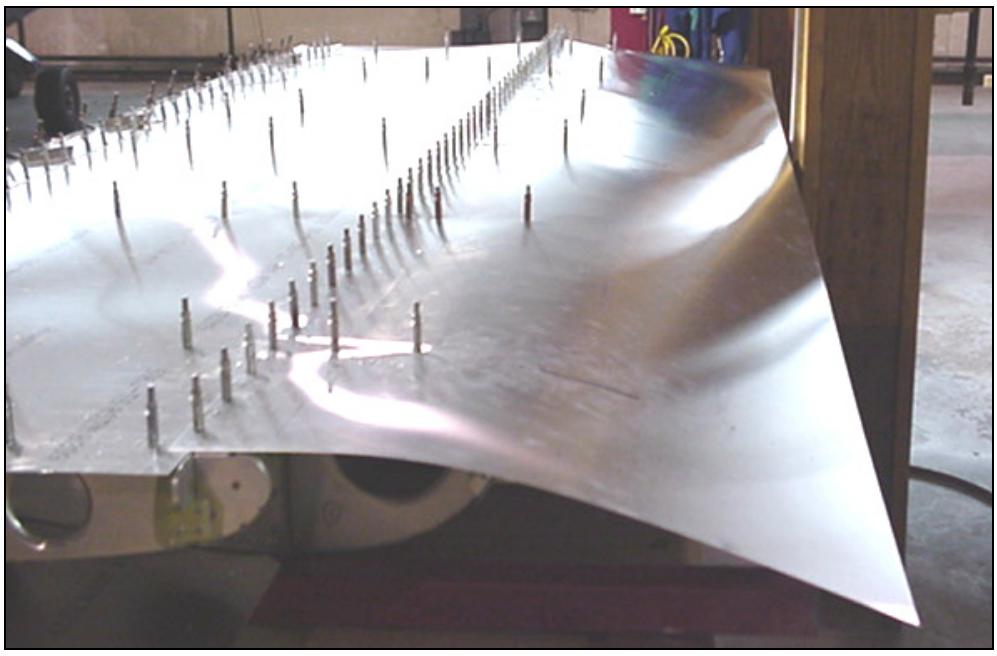


Drill and Cleco the skin to the spar.

Edge distance: Detail of the rivet line on the extrusion with 10mm edge distance from the aft edge of the skin.



Proceed to drill the rib rivet holes.

7V7-1 Nose Skin

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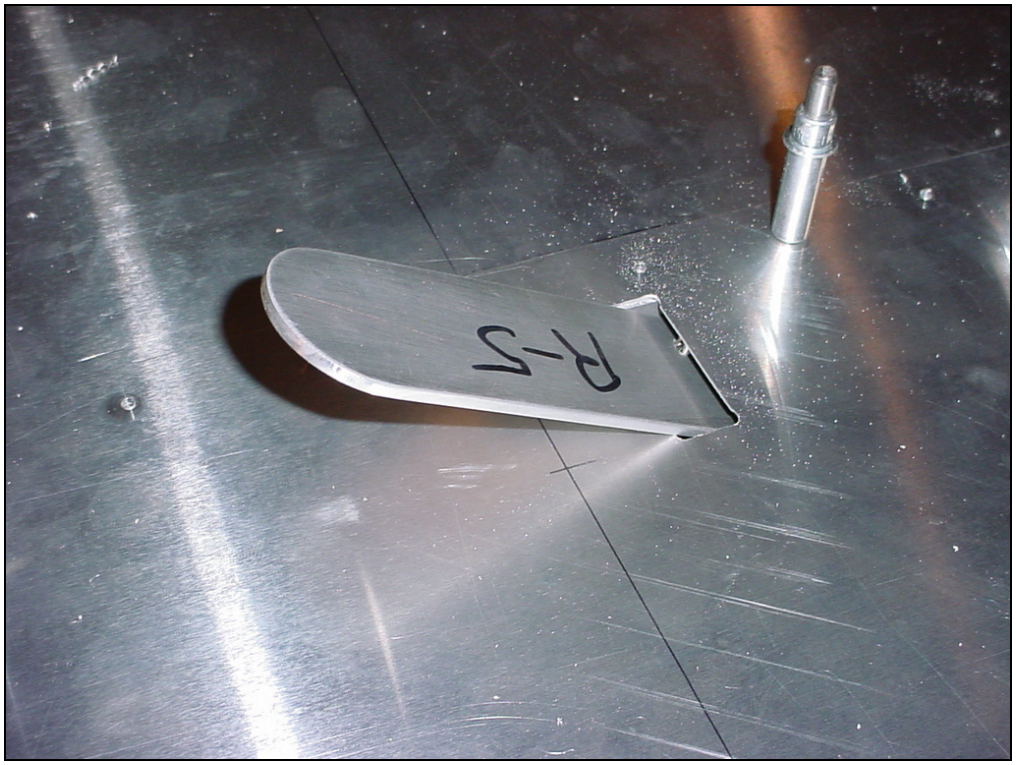
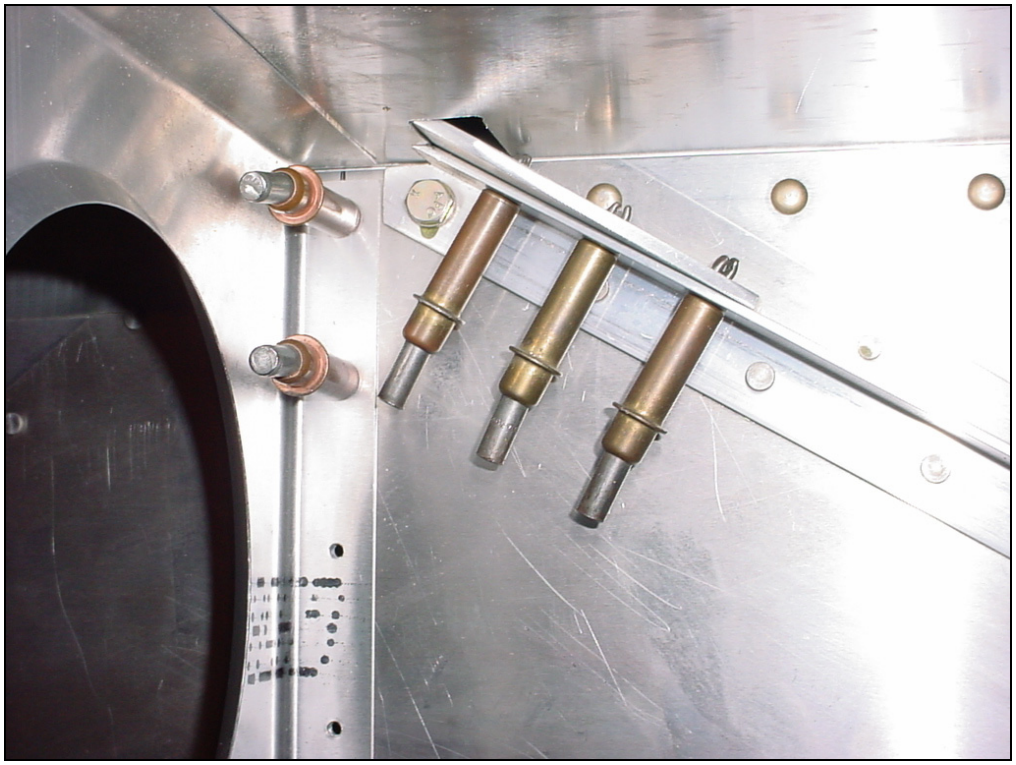
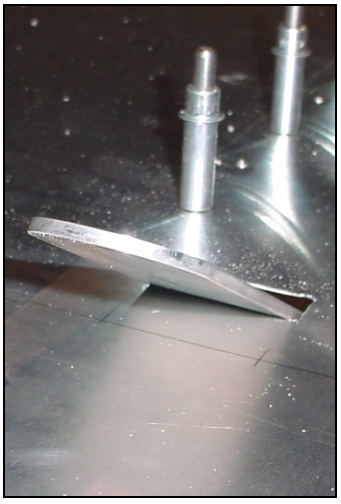


Position the front upper strut fitting 7V2-5 through the cutout in the skin.

REMARK: The number on the front upper strut fitting 7V2-5 “R-5” is a serial number to indicate it is for the right wing production series 5





7V2-5 Front Upper Strut Fitting

CHECK: The cutout in the skin is large enough, the skin does not touch the fitting.

At this time it is best to Cleco the strut fitting if you have a 3/16” Cleco, or you can bolt it together.

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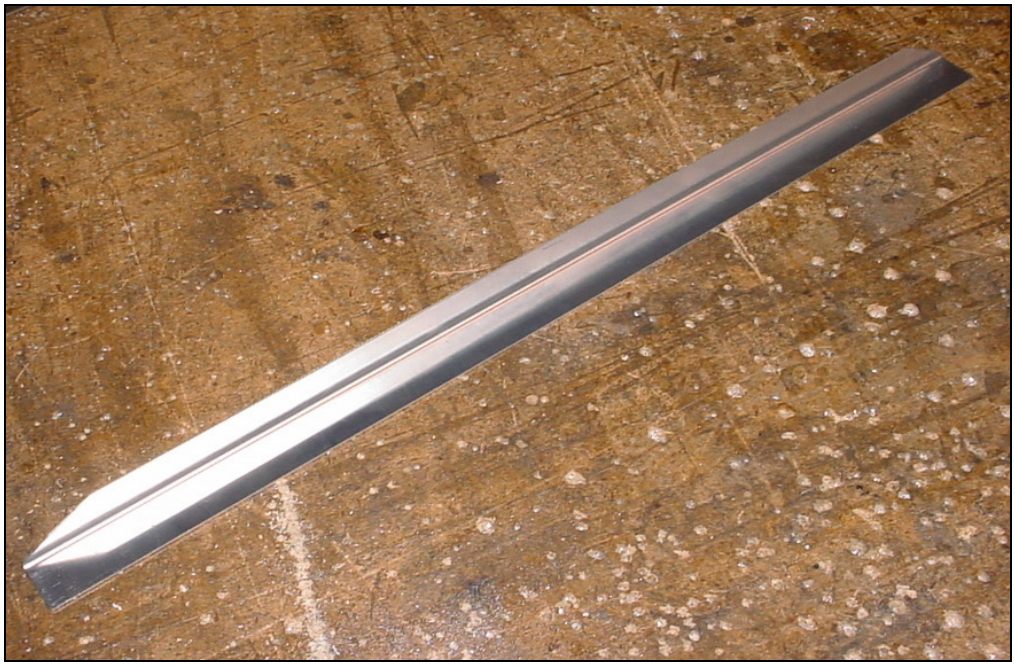
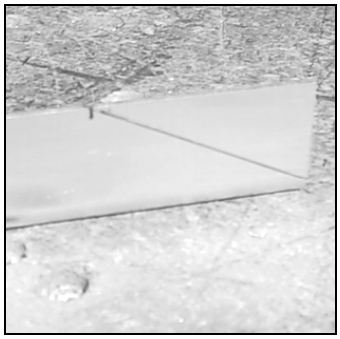
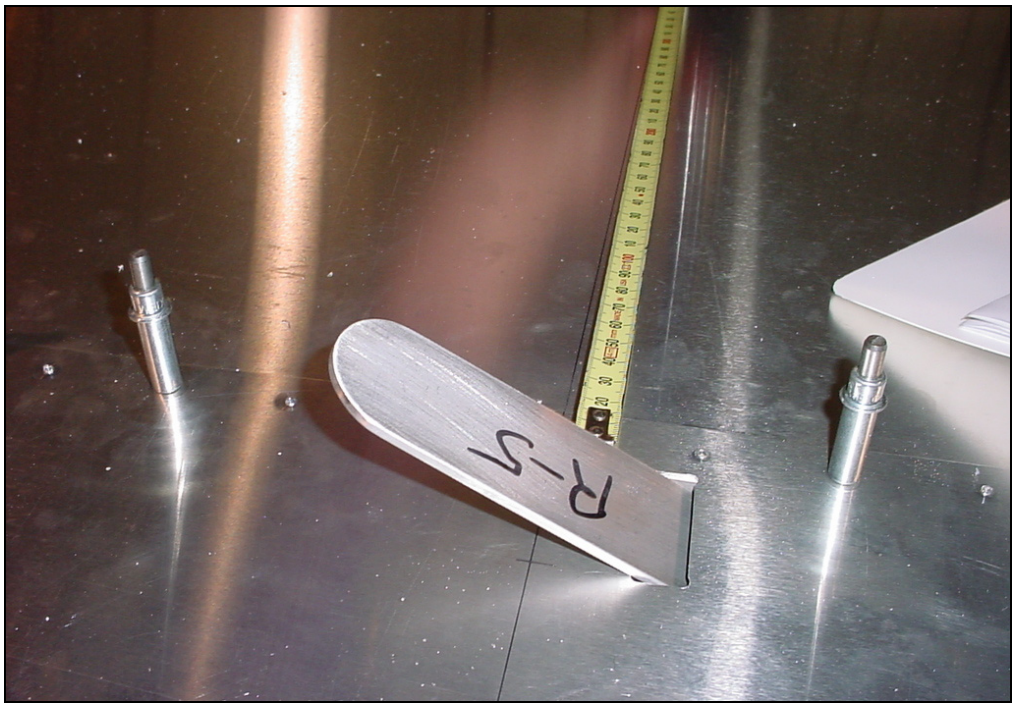


STRUT ANGLE 7V8-3SP

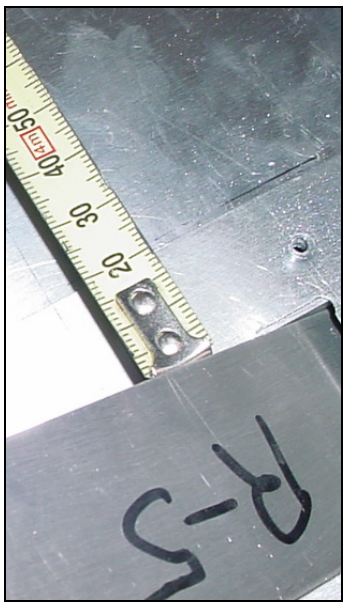


Layout the diagonal cut line on the vertical flange.

Trim the ends (vertical flange only).



LAYOUT: From the aft edge of the strut fitting, layout 355mm to mark the aft end of the angle 7V8-4SP



Zero reference: aft edge of the strut fitting. Ref. middle diagram on drawing 7-V-8

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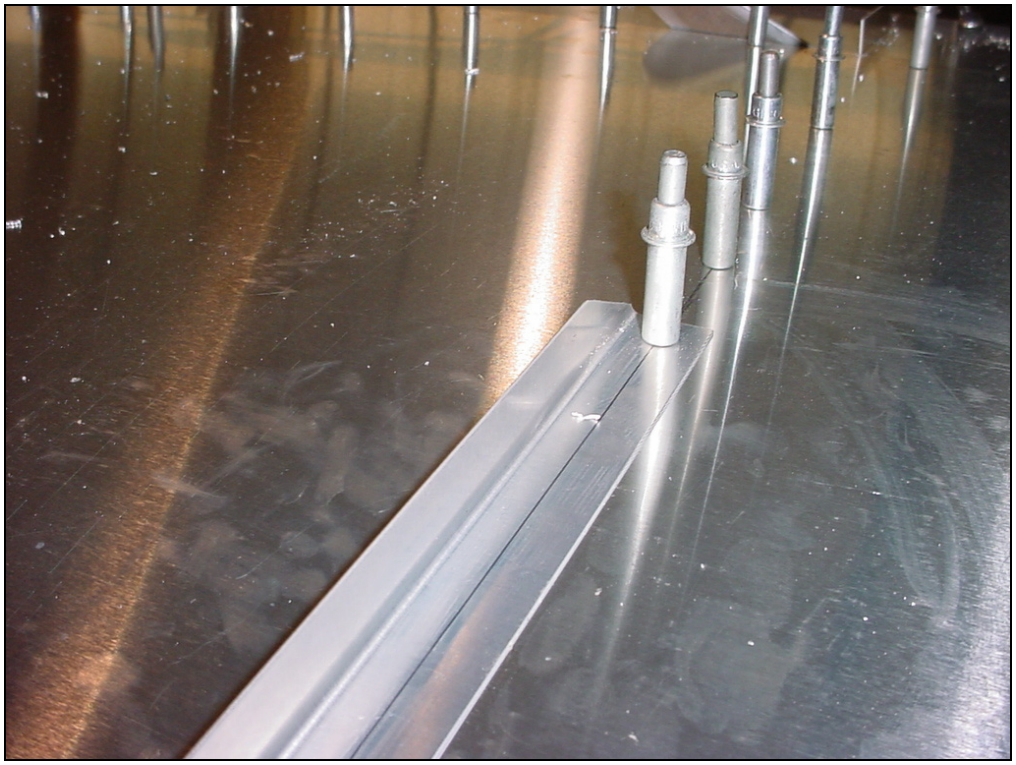
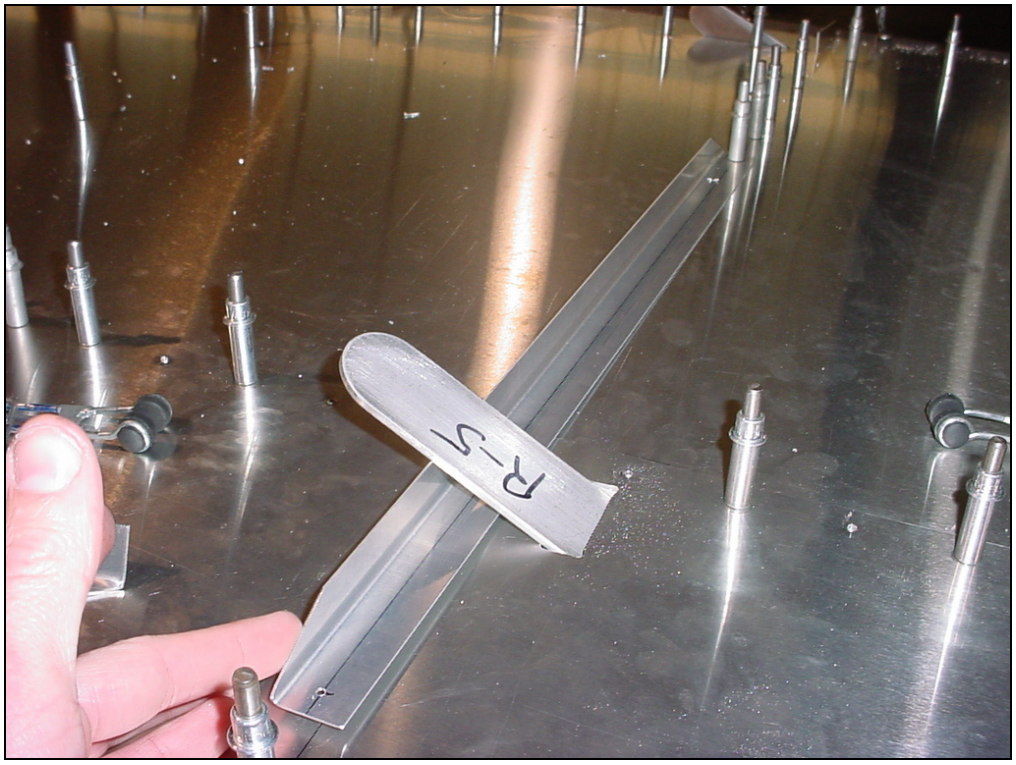


LAYOUT: Mark the rivet line on the bottom flange of the strut angle 7V8-4SP

Pre-drill the 2 end holes in the strut angle 7V8-2SP 10mm from the ends. Position the strut angle on the bottom of the wing, line up the rivet line with the rivet line for the rear rib #4



Line up the aft end of the angle on the 355 mark. Drill and Cleco the end hole.

CHECK: The vertical flange of the strut angle fits underneath the strut fitting 7V2-5

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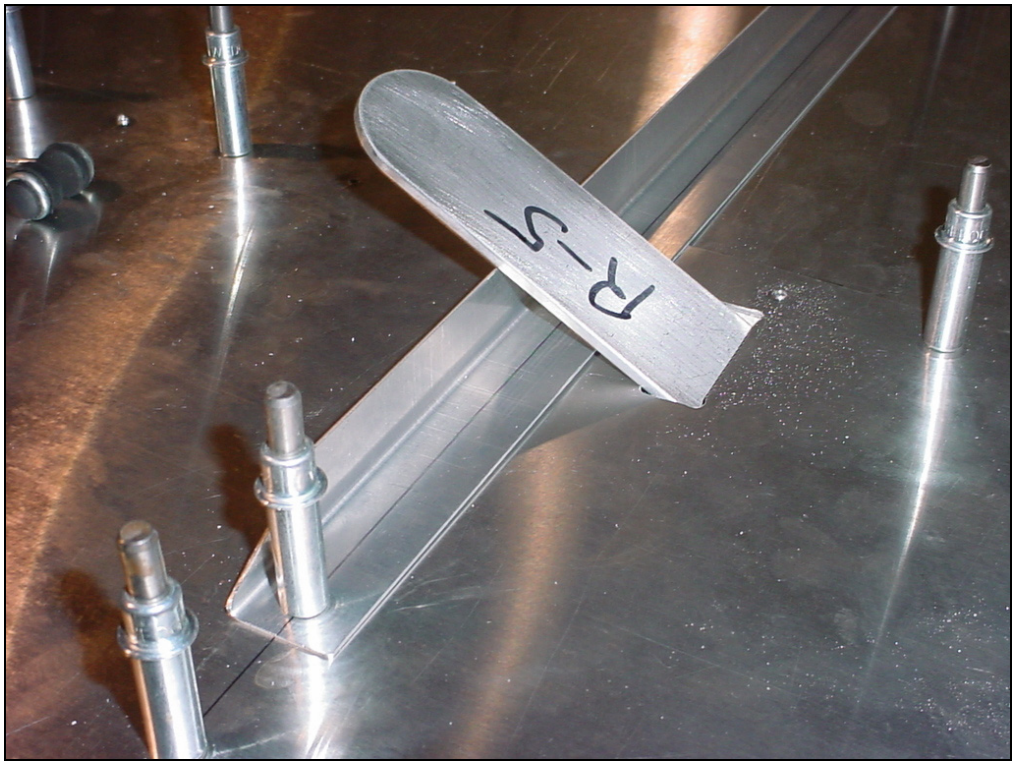

Drill and Cleco the front end hole.

Detail to show the alignment of the rivet lines.

Mark the spar rivet line on the angle.

7V8-4SP Strut Angle

Drill and Cleco intersection hole with spar rivet line.

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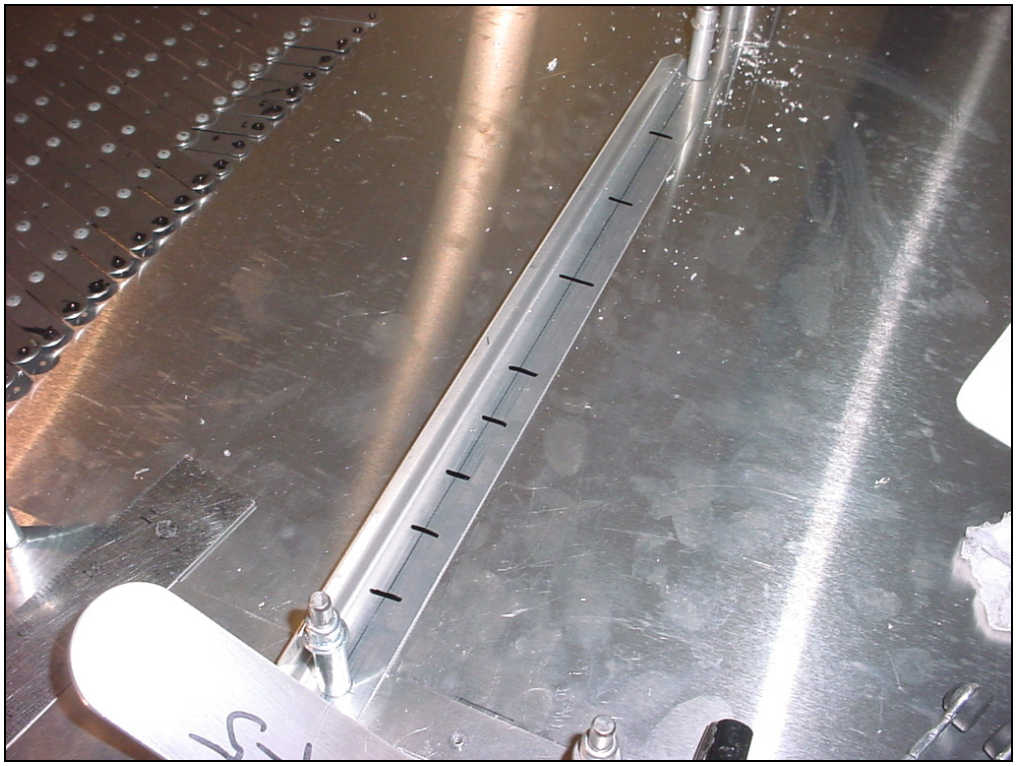
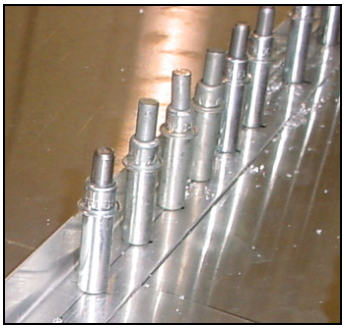
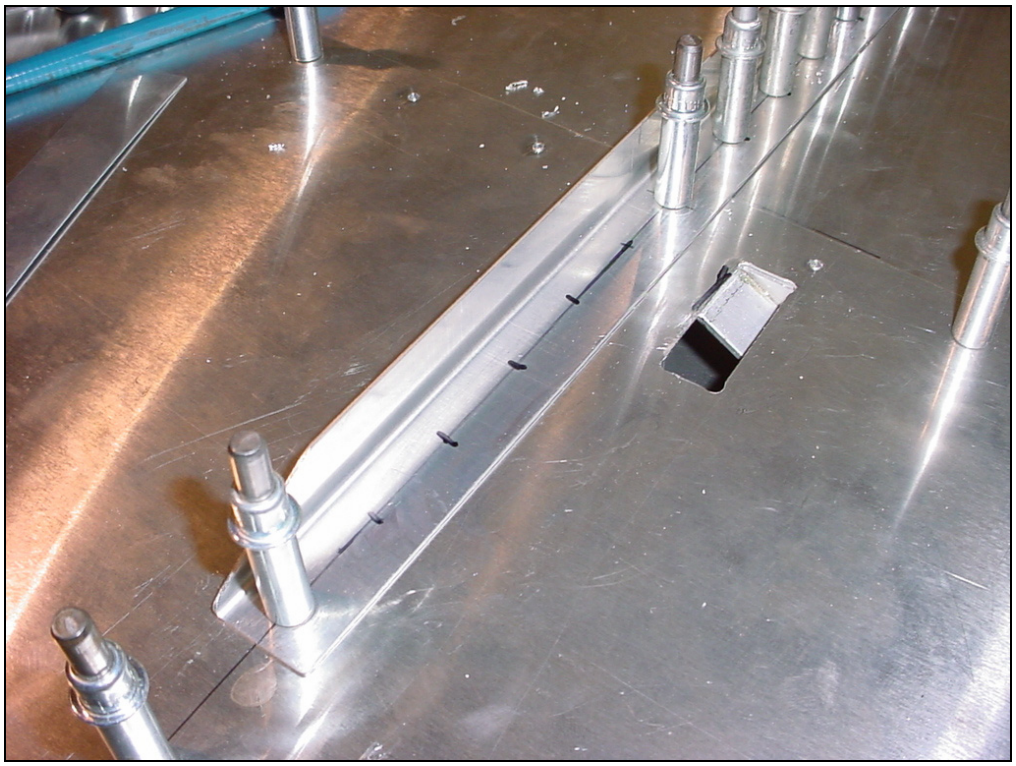
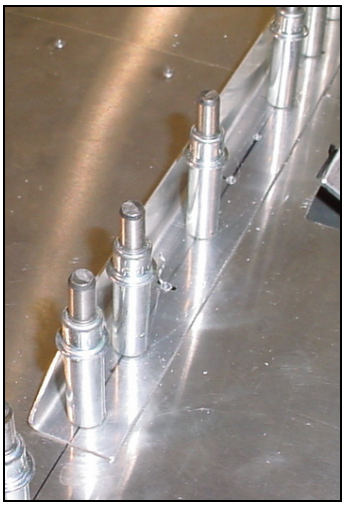




Drill and Cleco.

The first hole behind the spar intersection hole is at 35mm
The next 4 holes are set at pitch 25
Remaining 3 holes have pitch 40





Drill and Cleco

Remove the strut fitting to layout the rivets on the angle.

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