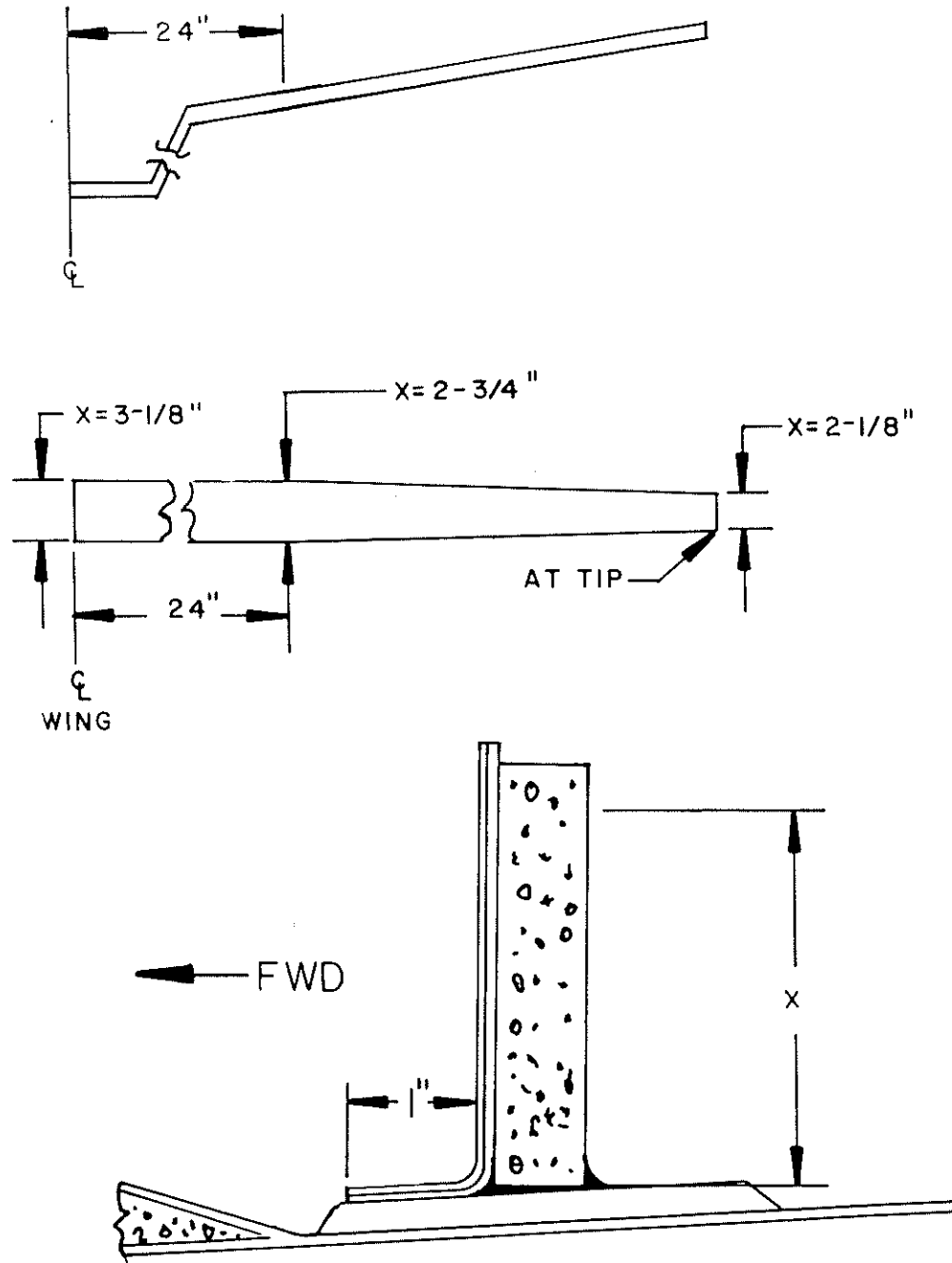


E. REAR SPAR SHEARWEB FIT-UP

STEP E-1 AFT SHEARWEB REFERENCE LINE DIMENSIONS



NOTE: Do NOT trim shearweb to the "X" dimension; use as a reference only.

FIGURE (C-16)

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Using a chalkline, mark a line onto the aft surface of the shear web, to the "X" dimensions shown in FIGURE (C-16). This line provides a straight reference for final fit-up.

CAUTION: Do NOT cut to this line; the shearweb will be trimmed in the next step.

STEP E-2

NOTE: Four layers of duct tape were applied to the upper spar cap in Step B-6 to simulate the thickness of the mat cloth used to bond on the upper wing panels. The tape must be left in place during the rear spar shearweb and rib fitting procedures.

Place the upper wing panels onto the lower wing panel in the jig and hinge the upper panels to the lower panel using (4) short lengths of hardware store piano hinge pop riveted onto the leading edges. Choose piano hinge that has an easily removable hinge pin so the upper panels can be removed completely when necessary. The hinges permit raising and lowering the upper wing panels when fitting the aft spar shearweb and the wing ribs. The pop rivet holes will be laminated over when the upper panels are permanently bonded on.

Check the "Z" dimensions at the trailing edge of the wing panels for agreement with the dimensions shown in FIGURE (C-17).

NOTE: At the outboard ends of the wing, measure the "Z" dimension just inboard of the wing tip attach flange joggle, as shown in Detail A of FIGURE (C-17). In other words, measure the full trailing edge thickness at the ends of the wing rather than the distances between the wing tip attach flanges. At the wing roots, measure the "Z" dimensions 24" outboard of the wing centerline, as shown.

Sand the rear spar shearweb until the "Z" dimensions are achieved. Use the line marked in Step E-1 as a reference for straightness only.

NOTE: This will require several cycles of raising the upper wing panels, sanding the shearweb, lowering the panels, and then checking for agreement with the dimensions in FIGURE (C-17). Be careful; do not sand too much.

When the "Z" dimensions have been achieved, sand the trailing edges of the upper panels straight until they are directly above the lower trailing edge for the entire wing span. Use a carpenter's bubble level or plumb bob to check. See FIGURE (C-17).

After sanding the upper trailing edges, check the "Z" dimensions again at the trailing edge of the wing panels for agreement with the dimensions shown in FIGURE (C-17). Sand the rear spar shearweb some more, if necessary to achieve the "Z" dimensions.

NOTE: Achieving the exact "Z" dimensions is very important. These dimensions must be correct in order for the flaps, ailerons, and seat pans to fit properly.

*Right & Left sanded to "Z" dimension
8-17 2.25*

*2-19
Z
Hinge
RH
7-23
1.25
Hinge
LH
7-23
Sanded
Rear Spar
to "Z"
RH only
3.25*



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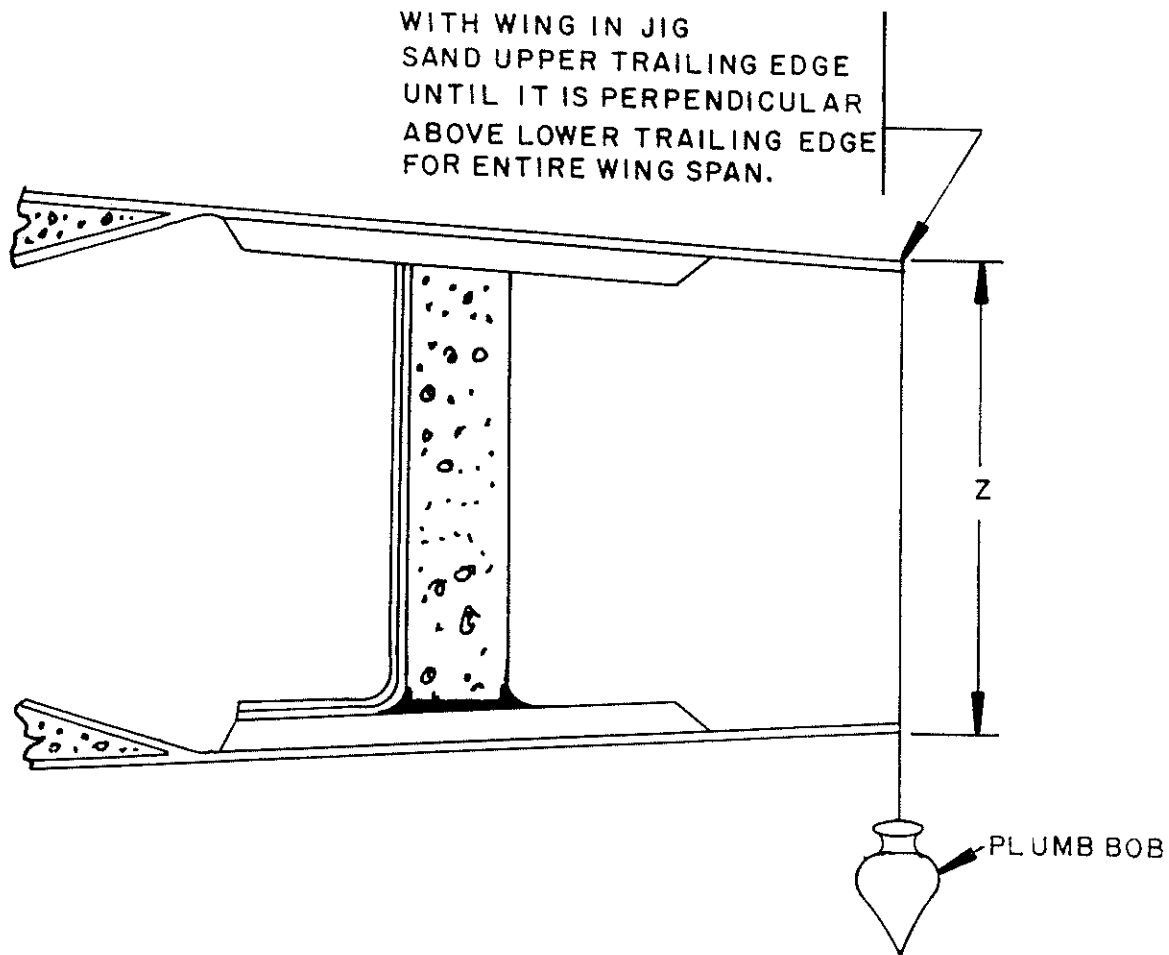
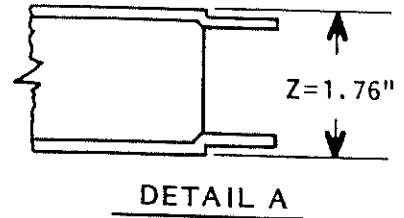
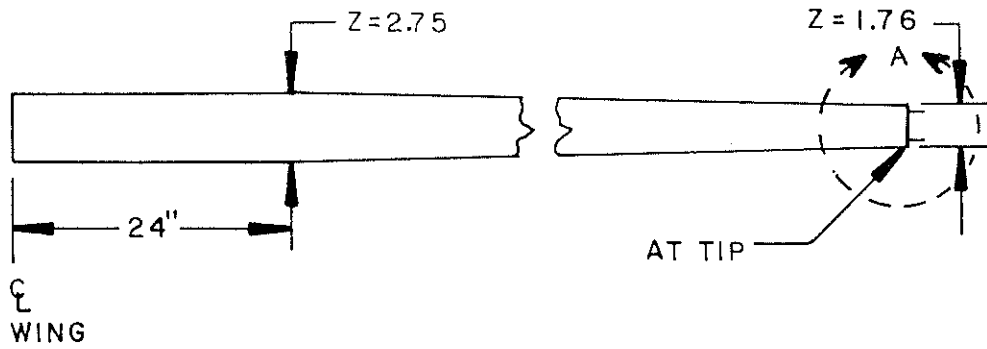


FIGURE (C-17)

COMPLETED []

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