

H. WING MAIN SPAR ATTACH FITTING INSTALLATION

STEP H-1

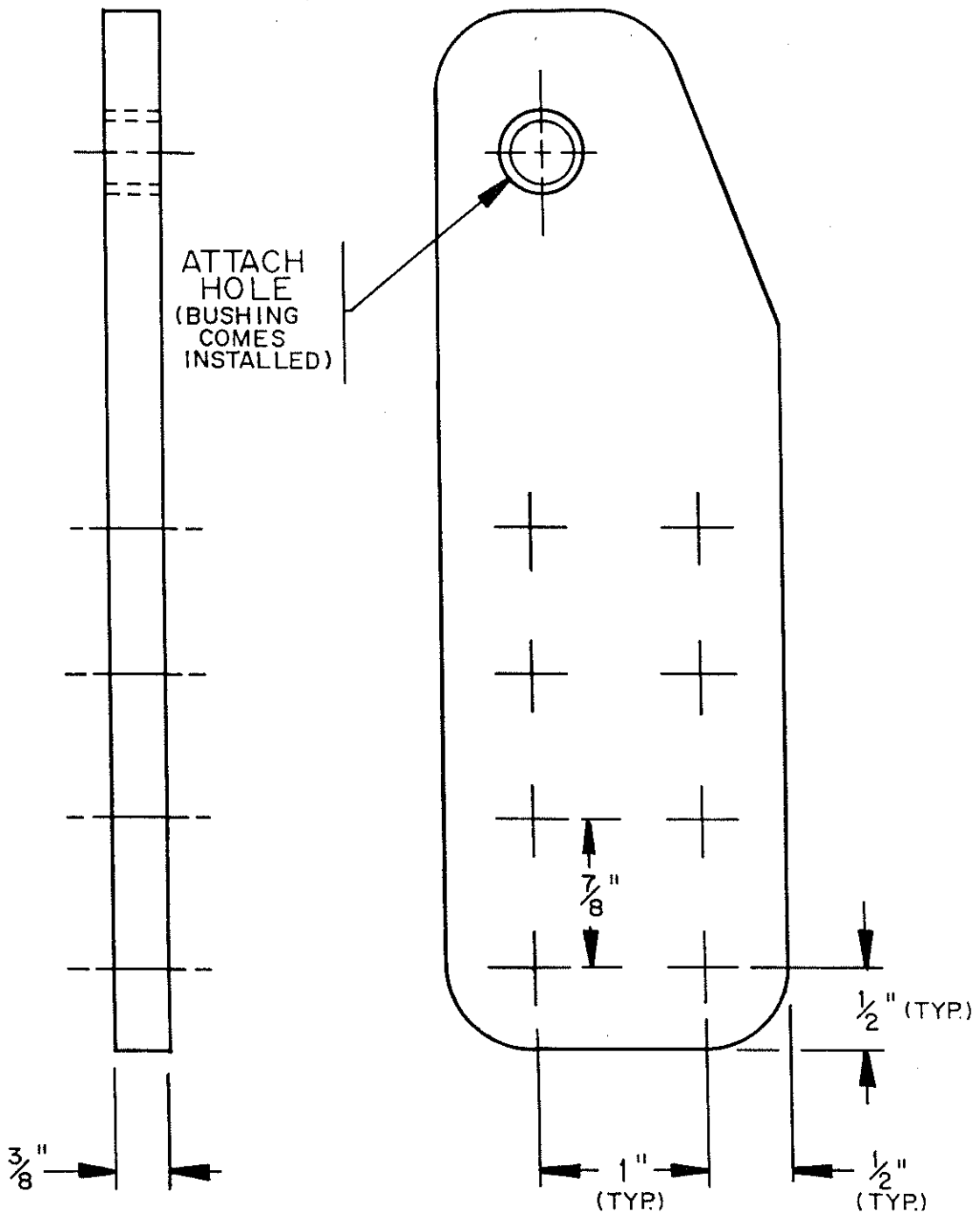



FIGURE (C-27)

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Pictured in FIGURE (C-27) is the wing main spar attach fitting. These fittings are supplied pre-fabricated without the mounting holes drilled.

NOTE: Do not drill any holes at this time.

STEP H-2

To locate the wing attach fitting slots in the upper wing skins, place several strips of masking tape (strips side by side) on the underside of the upper wing panels directly over the wing attach fitting slots. Outline the attach fitting slots in the upper surface of the main spar cap with a heavy coating of ink from a felt tip marker pen. Carefully place the upper panels into position on the lower panel and press down in the location of the wing attach fitting slots. Remove the upper panels and cut out the areas referenced by the slots' ink impressions on the masking tape. These slots do not need to be tight fitting, 1/16" - 3/32" clearance is acceptable.

NOTE: Use acetone to clean away any adhesive residue left from the masking tape and to remove the ink from the top of the spar cap.

STEP H-3

2-20
1-25

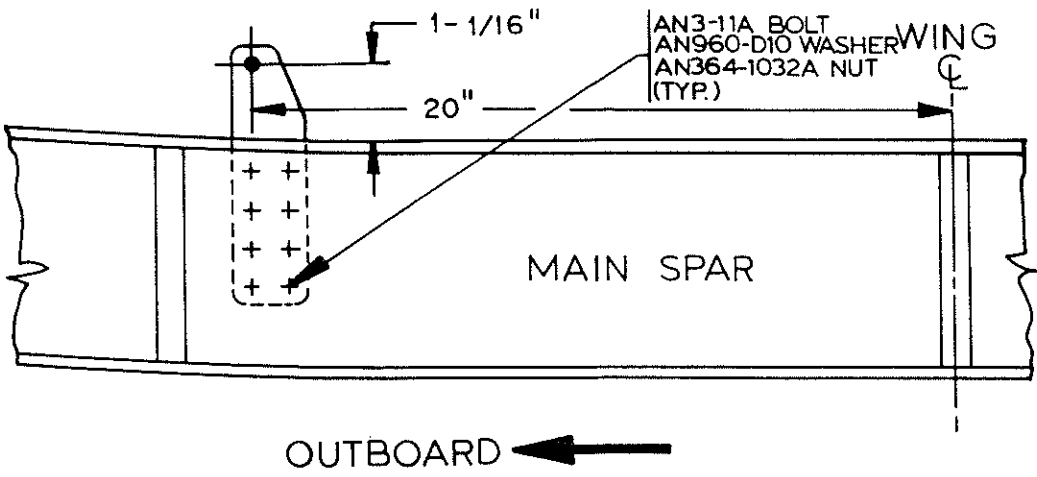


FIGURE (C-28)

Install the wing attach fittings into the wing main spar, as shown in FIGURE (C-28). If they must be tapped into position, be sure to use a wood or plastic hammer.

NOTE: Be sure to install the fittings with the center of the attach holes 20" away from the centerline of the wing, as shown in FIGURE (C-28).



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STEP H-4

1-31 Alodined holes

Shine a flashlight through the main spar around the wing attach fitting and trace the outline of the fitting onto the shear web.

Layout the hole pattern as shown in FIGURE (C-27). Drill the (8) 3/16" diameter holes through the shear web and aluminum fitting.

NOTE: To trace the outline of the fitting onto the shear web, it is helpful to make a copy from the full size pattern given in FIGURE (C-27).

STEP H-5

Remove the fittings and deburr the bolt holes.

Pour a wet mill fiber mixture into the wing attach fitting slots to a level just above the lowest bolt holes and press the fitting into place. Fill all voids around the wing attach fittings with the mill fiber mixture.

With the fitting in place, install the supplied AN3-11A bolts, AN960-D10 washers, and AN364-1032A nuts.

NOTE: Before installing the bolts, spread a small amount of resin on the bolt shanks to seal the front D-section of the wing for the fuel tank. Install the bolts with the head on the forward side and the washers only on the aft side under the nut.

run on torque 10 In/lbs
torque total 30 In/lbs

STEP H-6

After the nuts have been secured, contour around the bolt heads with a mill fiber mixture, and then, while the mill fiber mixture is still wet, cover the entire area with a 3-1/2" x 5" (2) layer bidirectional laminate. This will provide a permanent fuel seal.

2-23
1.5
Completed attach points

COMPLETED [initials]



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2-20
1.5
Drilled and Alodined
Fittings
2-20
Deburred