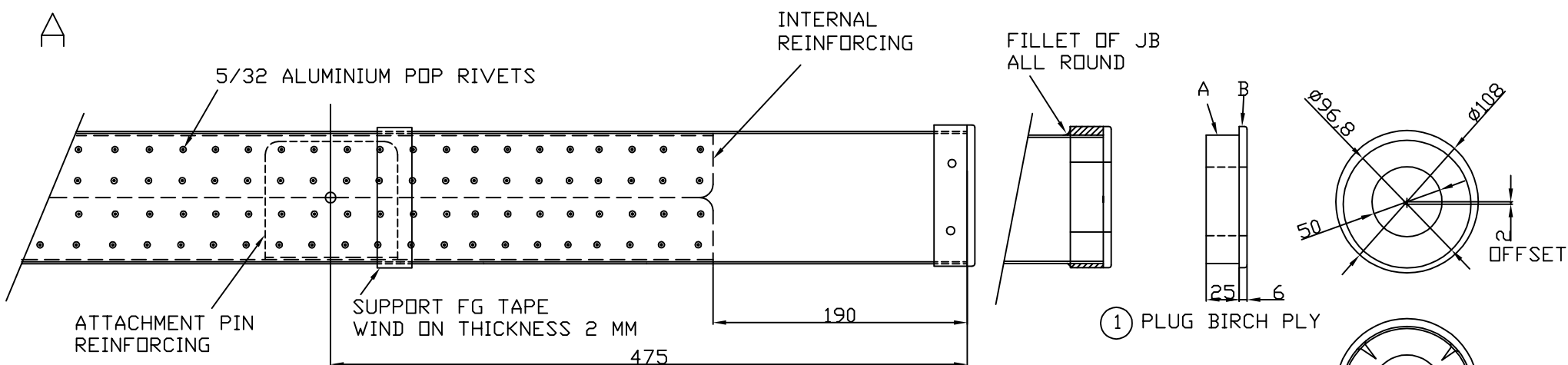
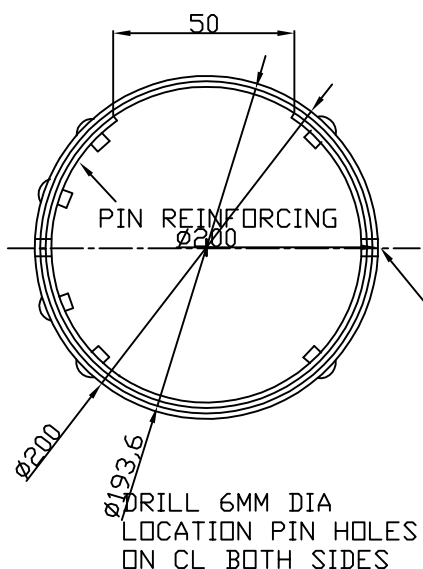


A



SPAR ROOT ABUTMENT

- 1 ITEM 1 TURN DIA A TO GIVE LIGHT PUSH FIT IN SPAR TUBE
- 2 TURN DIA B TO GIVE SLIDE FIT IN 108 DIA CROSS TUBE ITEM 20
- 3 GLUE 1 & 2 TOGETHER WITH 2MM OF ECCENTRICITY AS SHOWN
- 4 POT PLUG INTO SPAR TUBE WITH JB & INSERT 20 MM CSK LOCATION SCREWS
- 5 WIND ON 25 WIDE FG TAPE APPLYING RESIN TO A THICKNESS OF 2 MM AT THE BOTTOM
- 6 BUILD UP REST FROM REDUCING LENGTHS OF TAPE TO FORM AN ECCENTRIC BUSH 4 MM THICK AT THE TOP WIND ON A CONTINUOUS OVERLAPPING TAPE. FIT THE MOULD TOOL AND CLAMP USING A JUBILEE CLIP
- 7 THE FG BUSH OUTSIDE DIA SHOULD BE FLUSH WITH THE 6 MM PLY END PLATE DIA AND BE A LIGHT SLIDE FIT INTO ITEM 20



WING ATTACHMENT PIN ASSEMBLY INSTRUCTIONS

- 1 CUT OUT A 12MM WIDE STRIP IN THE INNER REINFORCING TUBE ALONG ITS LENGTH THE TUBE WILL SPRING SLIGHTLY OPEN CLAMP TOGETHER WITH JUBILE CLIPS
- 2 SLIDE THE REINFORCING INTO THE MAIN SPAR WITH THE SLOT ON THE AFT CL TAP INTO POSITION USING A HARDWOOD DRIFT AND Mallet
- 3 MARK OUT AND GENTLY DRILL 5/32 RIVET HOLES USE SKIN PINS DURING ASSY
- 4 DE BURR THE HOLES CAREFULLY. USE A ROUND STEEL TUBE INSIDE
- 5 COMPRESS THE WING PIN REINFORCING AND INSERT INTO THE SPAR ASSY
- 6 GENTLY DRILL THE ASSY AND DE BURR
- 7 RIVET THE ASSY TOGETHER
- 8 TIP PRIMER PAINT INTO TUBE AND ROTATE TO PAINT INSIDE OF THE SPAR TUBE FULL LENGTH

RIVET PATTERN

RIVET PITCH 25MM

MIN RIVET EDGE LAND 10MM

MAKE REINFORCINGS FROM 100 DIA X 1.6 6082T6 TUBING

MW9B-37

WING SPAR ROOT