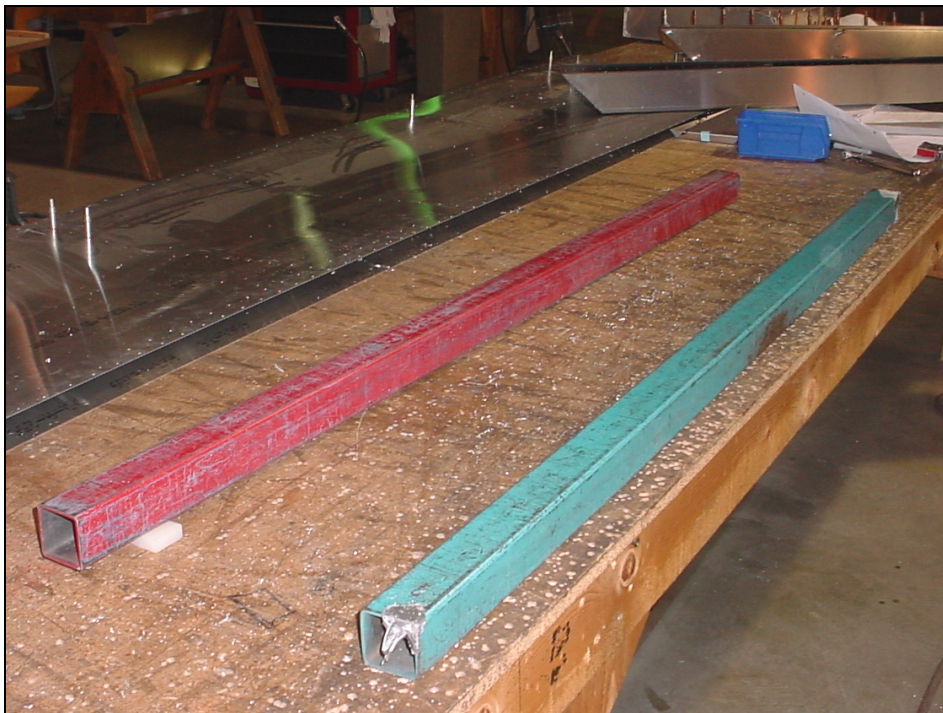


Aileron with "flex" hinge

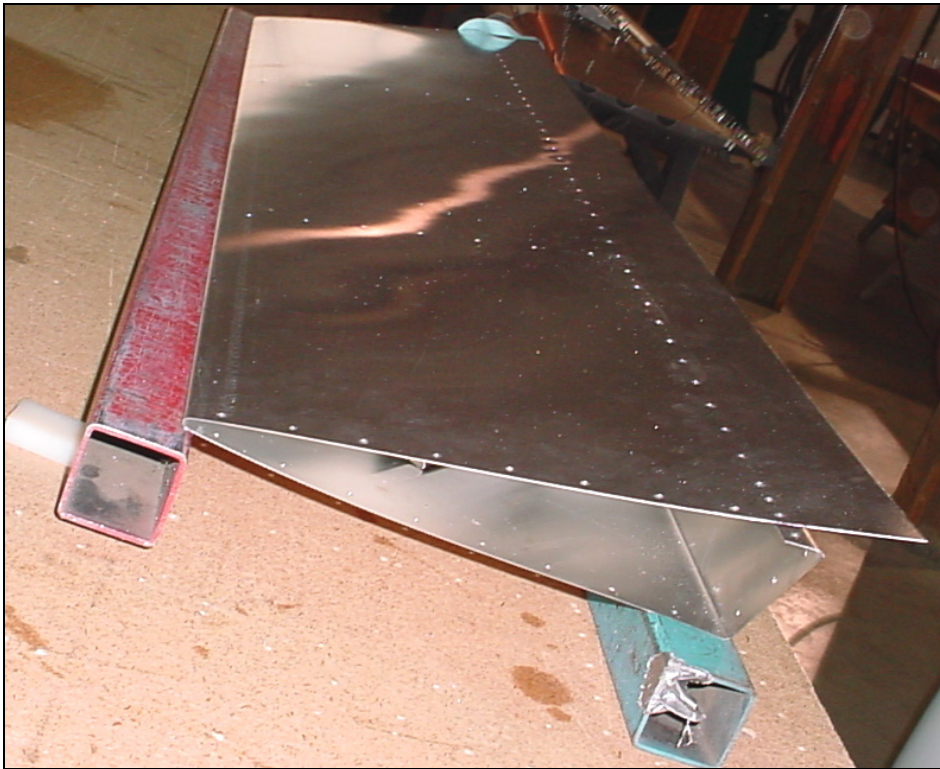
Photo of right aileron.
Note: The aileron extends all the way to the wing tip.



AILERON SKIN
6W2-3

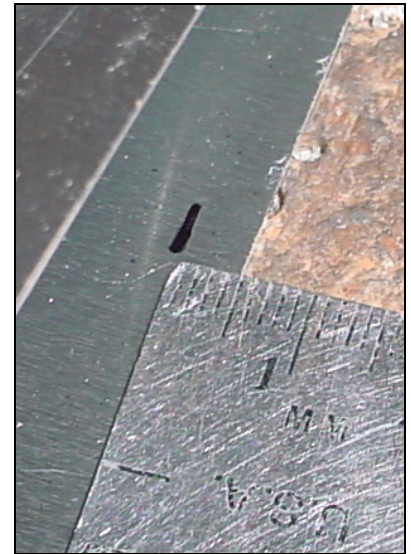
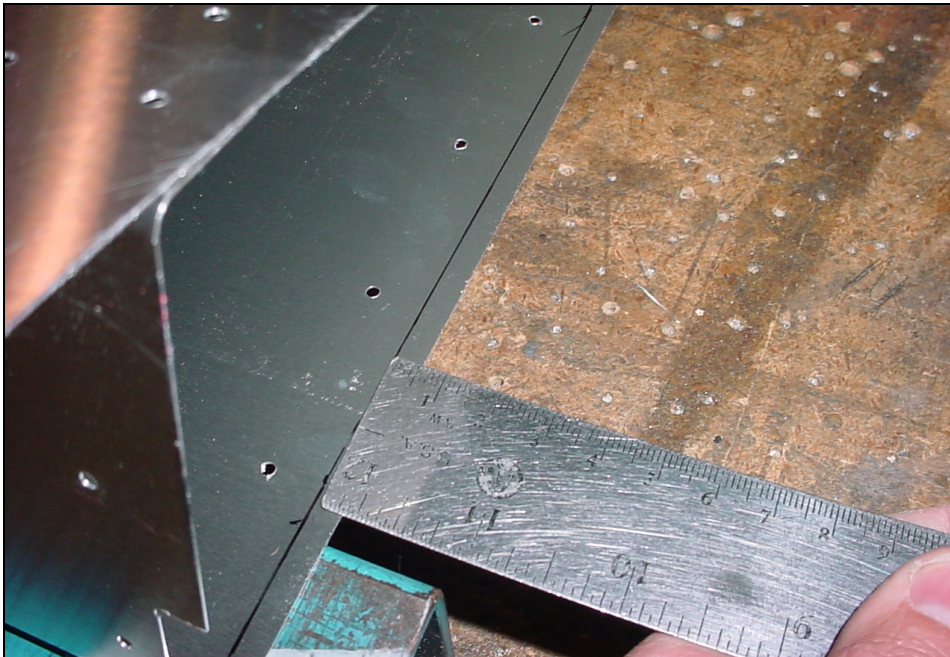
Lay the skin across the
beams.

Straight beams to keep the trailing edge straight.



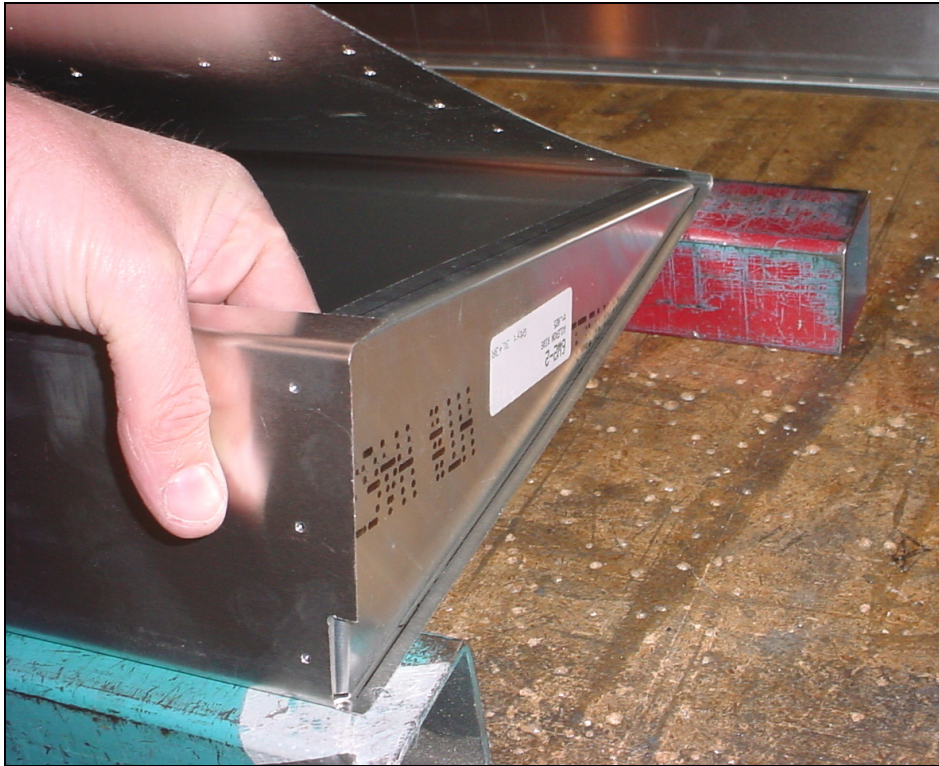
Detail of 13mm spacer block

With the skin right side up on the beams, position the 13mm spacer block between the workbench and the beam (under the outboard end – trailing edge).



Ref. middle diagram on drawing 6-W-2

I/B end of aileron skin 6W2-3
Mark a line 5mm to the edge of the skin (bottom and top side).

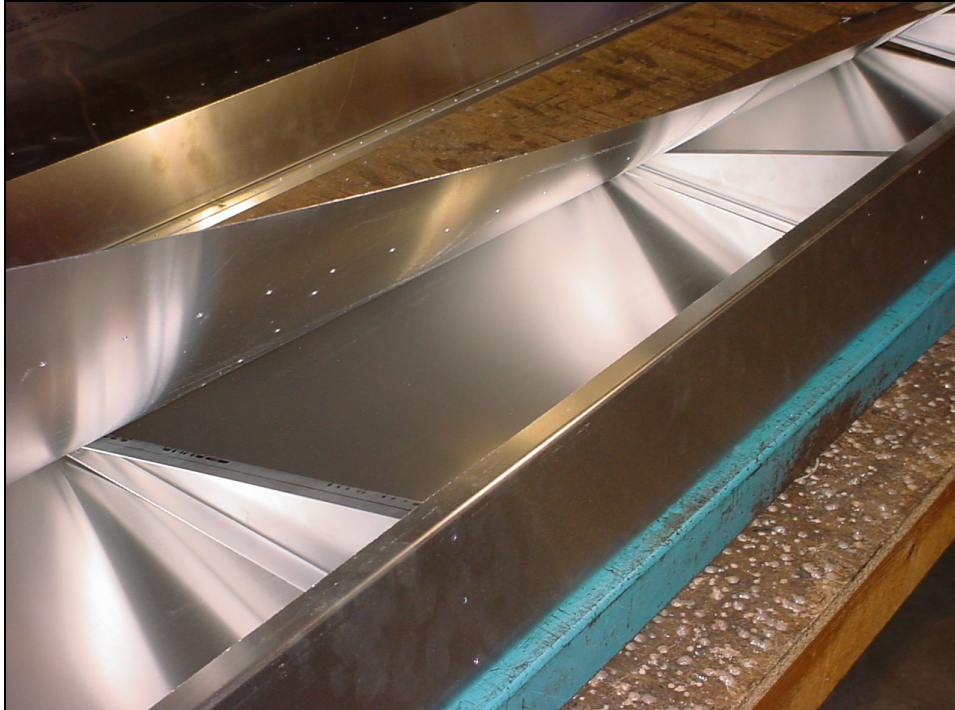


Install the I/B rib 6W2-3 (R) on the line.



**AILERON RIBS
6W2-2**

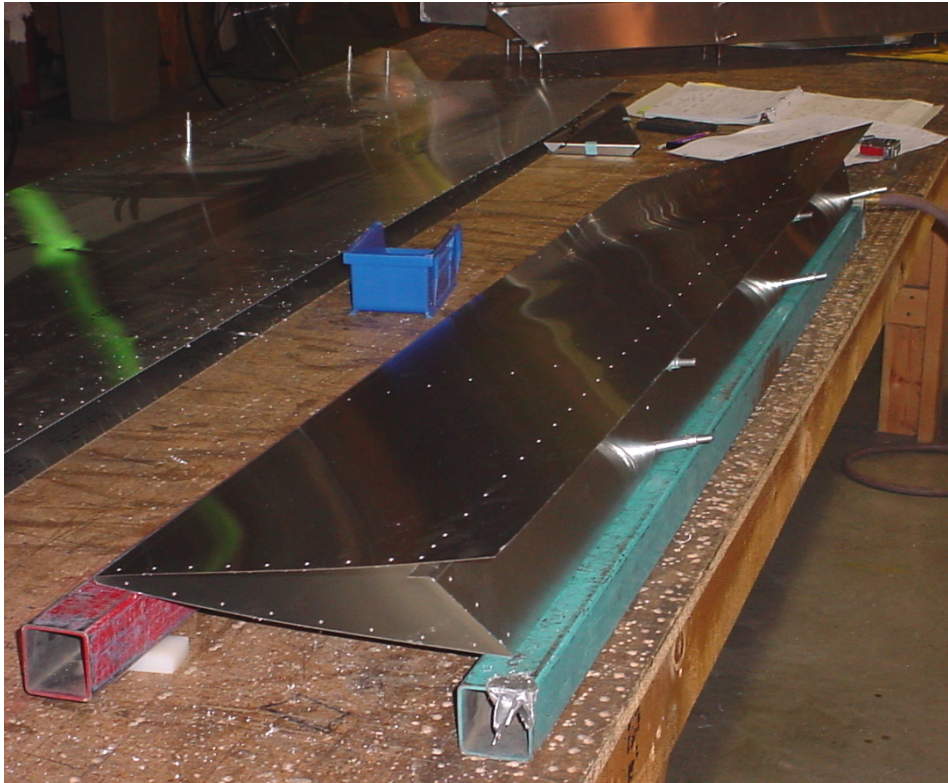
Drill and cleco the top and bottom holes in the front flange.



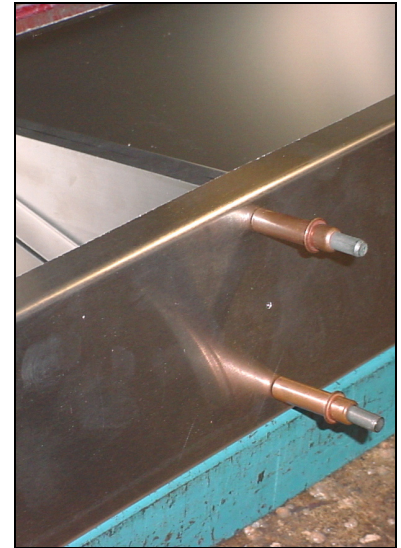
Position the middle ribs 6W2-2 (R) with the flange facing outboard.



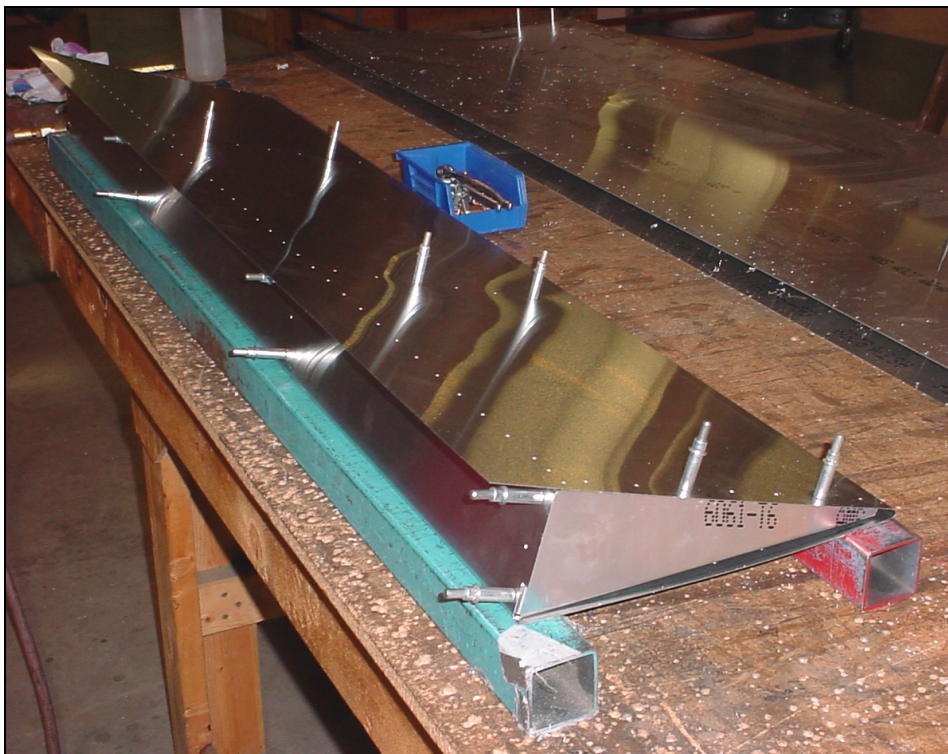
Line up the rib flange rivet line over the pre-drilled holes in the front of the aileron skin.



Ribs 6W2-3 (R) drill to the front side of the aileron skin.



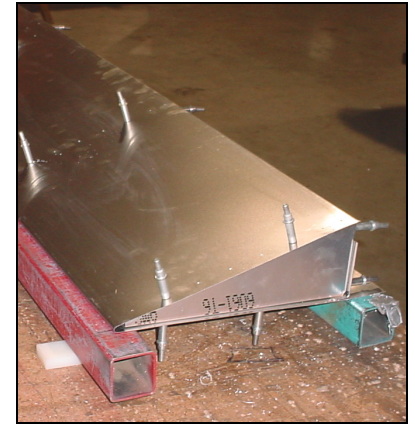
First drill and cleco 2 holes in each rib (front)



Drill and cleco the top side of the skin to the ribs.

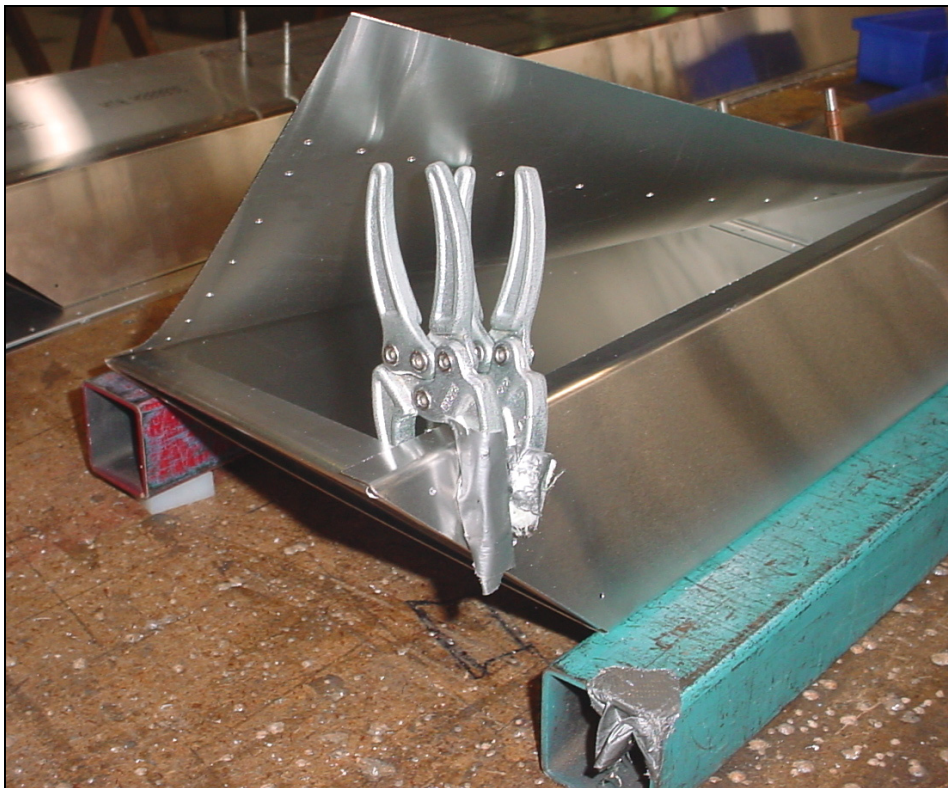


Start at the back and work towards the front.



IMPORTANT: reposition the 13mm spacer block under I/B trailing edge.

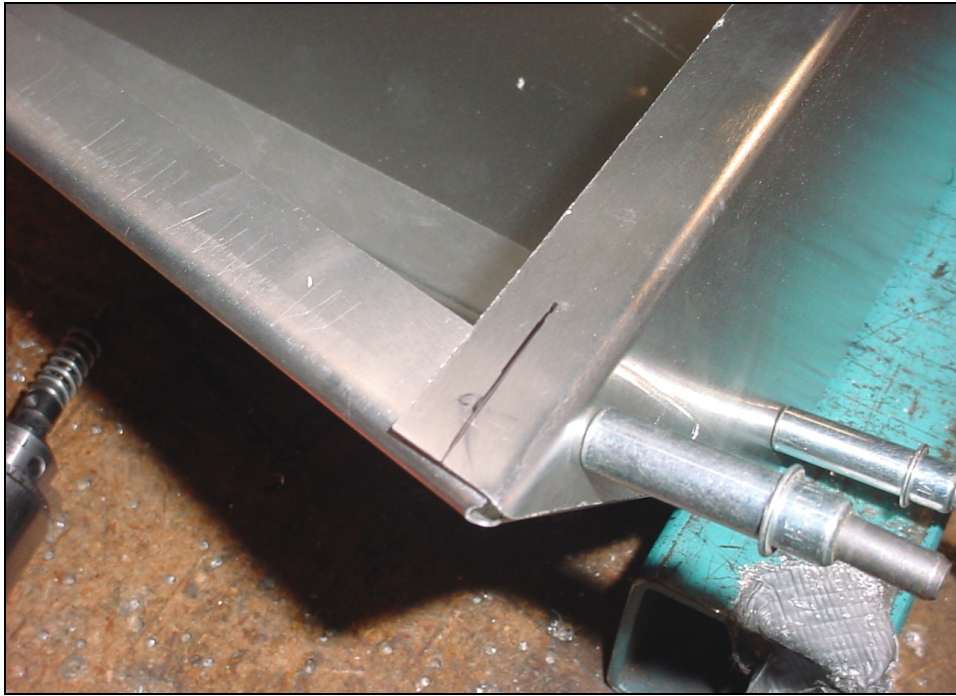
Turn the aileron skin over (upside down).
 Reposition spacer block under I/B trailing edge.
 Drill and Cleco 2 holes in the 3 ribs (bottom side).



**AILERON TIP RIB
 6W2-4**

Drill and Cleco.

Turn skin right side up.
 Reposition the spacer block under O/B trailing edge.
 Clamp the tip rib 6W2-4 to the spar.



O/B tip.
Mark a reference line on the top flange of the aileron skin 9mm from the edge.



Drill and Cleco the last hole when the reference line is visible.



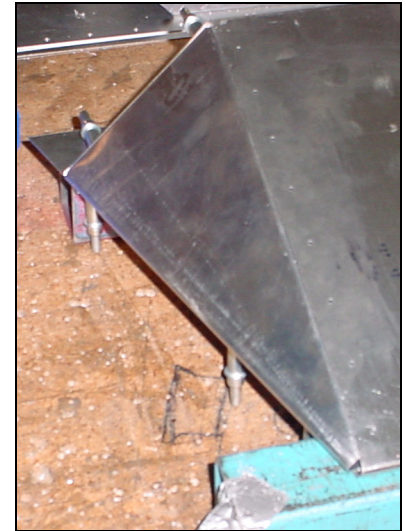
O/B tip.



Drill and cleco the last hole, then drill and cleco every other hole.



Drill and Cleco the bottom side of the tip rib.



Turn the aileron over. Reposition the spacer block under the inboard trailing edge.



Turn the aileron over. Reposition the spacer block under the outboard trailing edge. Start in the middle, drill and cleco the front rivet line.

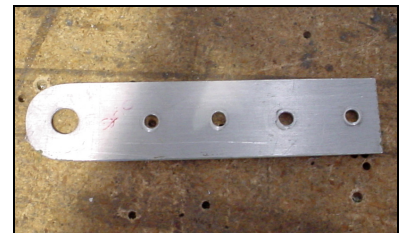
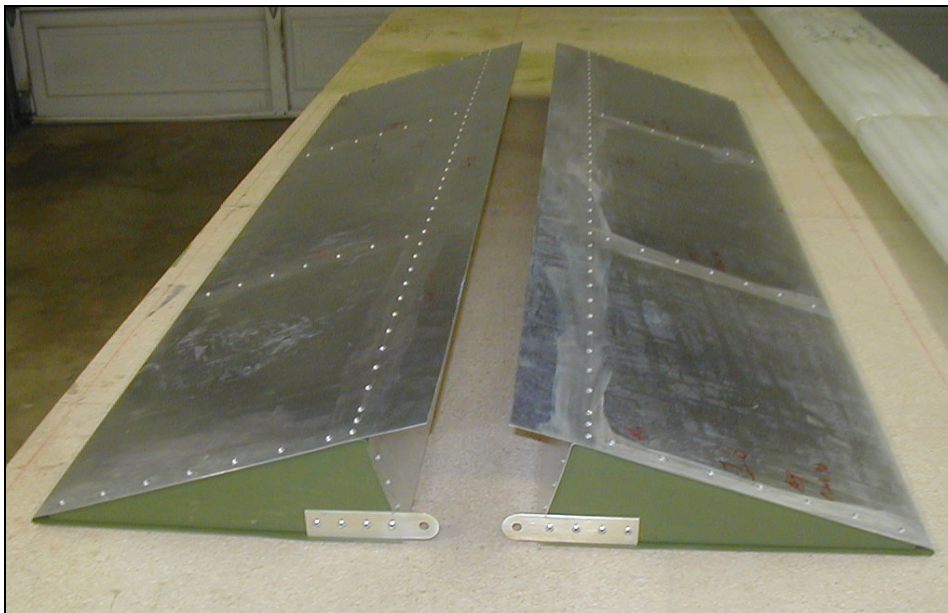


Drill the front flange.



AILERON HORN
6W2-1

Drill the 5/16" hole in the horn 6W2-1. Radius the front corners of the horn.
Layout the rivet line, ref top left diagram on drawing 6-W-2



AILERON HORN
6W2-1

1/B end of left and right ailerons.