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	A	Forward rivets through skin and upper longeron should be left to a 08/24/16 later assembly after windshield skirt is installed, corrected here to pilot holes only. Changed AN525-10R12 bolts through motor mount angles, rudder pedal mount angles, and angle clips to AN525-10R11. Four holes below spar tunnel cutout changed to 1/8" holes instead of rivets to allow for spar bumper install on F02.
	В	Changed Part # SNX-F15-12R & -12L to WXB-F15-12R & -12L Angle 10.23.16 Clip.

(-01R) Right Hand Forward Side Panel Assembly (shown)

(-01L) Left Hand Forward Side Panel Assembly (opposite -01R)

Note: Forward Wing Attach Angle and Gussets attached to the Angle are not riveted at this time

SNB-F13-01 Forward Fuselage Side Skin 1 Required on -01R / -01L

Cherry CCP-44 Blind Rivet, 19 Required on -01R / L Thru Skin and Horizontal Angle. Install Rivets with Head against Skin

- SNB-F14-13R Right Hand Horizontal Angle, 1 Required on -01R SNB-F14-13L Left Hand Horizontal Angle, 1 Required on -01L

SNX-F14-12R Right Hand Seat Belt Attach Angle, 1 Required on -01R SNX-F14-12L Left Hand Seat Belt Attach Angle, 1 Required on -01L Locate per Detail D

 WXB-F13-06R Right Hand Lower Longeron, 1 Required on -01R
 WXB-F13-06L Left Hand Lower Longeron, 1 Required on -01L Locate bottom edge even with bottom edge of skin and with forward and aft ends even with edge of skin

-Cherry CCP-44 Blind Rivet, 30 Required on -01R / L Thru Skin and Lower Longeron, Locate per pilot holes in Skin. Install Rivets with Head against Skin

SNX-F14-12R/L Seat Belt Attach Angle Reference

- SNX-F14-10 Gusset Reference

- Cherry CCP-44 Blind Rivet, 6 Required on -01R / L Locate Rivets per pilot holes in Gusset Install Rivets with Head against Skin

AN525-10R11 Bolt, 2 Required on -01R / L AN960-10 Washer, 2 Required on -01R / L AN365-1032 Nut, 2 Required on -01R / L Locate Bolt per pilot holes in Angle Clips

Cherry CCP-44 Blind Rivet, 2 Required on -01R / L Thru Skin and Seat Belt Attach Angle. Install Rivets with Head against Skin

Lower Longeron Reference

Note: General Construction Order 1) Lay Lower Longeron Angle down on edge of flat

- building table.
- 2) Lav Side Skin on table face down with bottom edge
- of Longeron even with bottom of Side Skin. 3) Locate, pilot drill & cleco Lower Longeron in place using pilot holes in Side Skin
- 4) Locate, pilot drill & cleco Upper Longeron in place using pilot holes in Side Skin. 5) Locate, pilot drill & cleco WXB-F14-01 Fwd Angle
- Assembly using pilot holes in Angle Assy 6) Cleco Forward Rudder Pedal Angle to Side Skin
- 7) Cleco Wing Attach Angle 1 and 2 to Side Skin
  8) Cleco SNB-F14-13 Horizontal Angle to Side Skin
  9) Cleco Gear Attach Angle to Side Skin
  10) Cleco Seat Belt Attach Angle to Side Skin
- 11) Locate, pilot drill & cleco Upper Motor Mount using pilot holes in Mount (see Detail "E")
  12) Locate, pilot drill & cleco Lower Motor Mount using
- pilot holes in Mount (see Detail "F") 13) Locate, pilot drill & cleco SNX-F14-10 Gusset (5
- places each side) using pilot holes in Gusset 14) Locate, pilot drill & cleco Rudder Pedal Mount Assy using pilot holes in Mount
- 15) Cleco Lower Gear Gusset to Side Skin 16) Cleco Upper Gear Gusset to Side Skin
- 17) Locate, pilot drill & cleco Seat Belt Attach Angle
- Gusset using pilot holes in Gusset 18) Locate, pilot drill & cleco SNX-F15-12 Angle Clip
- using pilot holes in Clip 19) Drill all holes out to size for the Fasteners
- 20) Disassemble, Deburr and Reassemble Side Panel
- 21) Install Fasteners as called out (Note: make sure Side Panel remains flat, no twist, while installing fasteners

WXB-F12-01L	1	Left Hand Forward Side Panel	WXB-F11	
WXB-F12-01R	1	Right Hand Forward Side Panel	WXB-F11	
Part / Ass'y Number	Qty. Req'd	Part Title	Next Assembly	
waiex-B				

**Fuselage Forward Side Panel** 

Drawing Scale 1/4 & Noted

Drawing Number **WXB-F12**  Revision Β