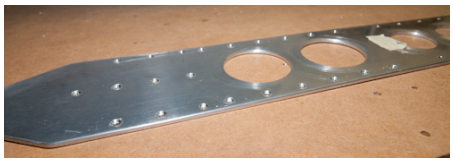
Matchdrilling - 29/01/2011 - 7h10

Category: 1.2. Vertical Stabilo
Published: Saturday, 29 January 2011 17:32
Hits: 1816

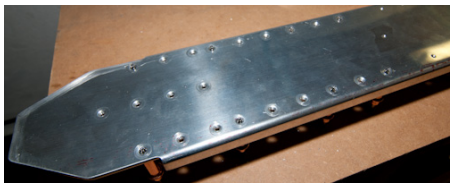
Very productive day. Prepared the steps well during the week by studying the plans over and over again.
The vertical stabilo is very similar to the horizontal one. Jacques dropped by to help, this surely speeded up things.

First clecoed the reinforcement spar, rear spar and the hinges.
Drilled remaining two holes in the top hinge VS410.
After checking the alignment yesterday, the matchdrilling is a walk in the parc.
Once matchdrilled, all holes are deburred.

The bottom side of the vertical stabilo will later be assembled with the tail section of the fuselage.The bottom side will be attached by bolts to the fuselage and the front side of rear spar will lay flush against the fuselage.
To achieve this, flush head AN426 rivets are used in the bottom section. This requires countersinking the reinforcement spar.



The rear spar is dimpled. This is the side that will be attached later to the fuserlage. The reinforcement spar lays on the inside of this part.



Then cleco them back together and attach all ribs that form the skeleton of the vertical stabiliser.

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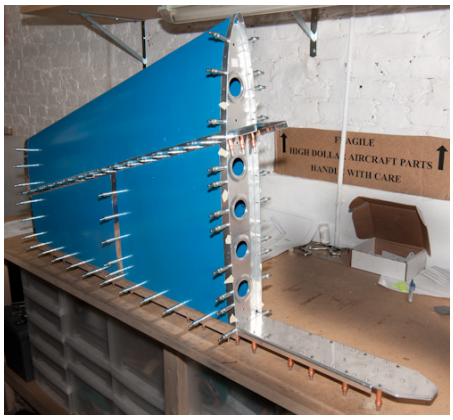
Matchdrill all connection joints to #30. De-assemble, deburr and re-assemble. I forgot the little front rib when matchdrilling at first so had to do it all over again for this one piece. Used the angle drill and achieved perfect drilling.

Next step is to fit the skin over the skeleton and cleco all in place.As you can see in the picture, I have put some tape over some holes. These must not be drilled or dimpled. They will be used to attach the fiberglass fairing later on to the fuselage using nutplates.



Overall I'm much more satisfied about the work then with the previous steps. I feel more confident and there were no mistakes so far. Ok... I admit, there is a scratch in the skin which will need some polishing 'Oh die, evil cleco's !'.

Then matchdrilled all skin joints, de-assembled and deburred all holes.

After that, it's time to dimple the skin using the C_Frame. Smack that aluminum !

Finally dimpled all ribs using the squeezer. Hell of a job. Will have painfull chest again tomorrow by all that squeezing.

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