

DRILL BUSHINGS (SLIP FIXED RENEWABLE)  
 SPECIFICATIONS: 3/8" O/D, #7(.0201")I/D, LENGTH=3/4"  
 5/16" O/D, 1/8" I/D, LENGTH=3/4"

SUPPLIERS: McMASTER CARR TEL. 630-833-0300  
 www.mcmaster.com

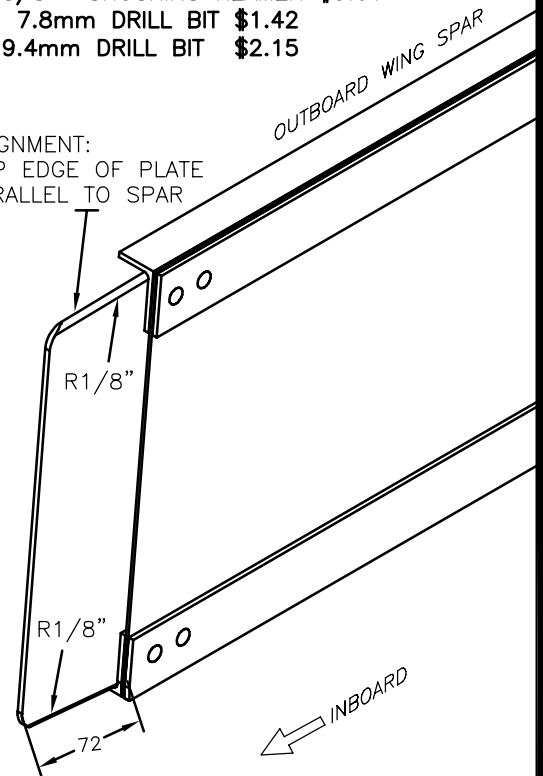
P/N 8493A086 DRILL BIT P/N 2901A313 #7  
 P/N 8493A078 P/N 2901A115 (1/8")

OTHER SUPPLIERS: MSC INDUSTRIAL SUPPLY  
 TEL 800-645-7270  
 FAX 800-722-0703  
 www.mscdirect.com  
 TRAVERS TOOLS  
 TEL 800-221-0270  
 www.travers.com

DRILL JIG BUSHINGS  
 P/N 75-508-203 (5/16" O/D, 1/8" I/D, L=3/4") \$5.10.  
 P/N 75-607-243 (3/8" O/D, #7 I/D, L=3/4") \$6.98  
 P/N 01-001-308 DRILL BIT, 1/8" \$0.93  
 P/N 01-002-307 WIRE GAUGE #7 \$1.70  
 P/N 04-006-020 5/16" CHUCKING REAMER \$6.51  
 P/N 04-006-024 3/8" CHUCKING REAMER \$9.61  
 P/N 01-040-780 7.8mm DRILL BIT \$1.42  
 P/N 01-040-940 9.4mm DRILL BIT \$2.15

- 1) FILE SMOOTH THE SHEARED EDGES OF THE 4130N PLATES.
- 2) FILE A 1/8" RADIUS ALONG THE TOP AND BOTTOM EDGES OF THE REAR PLATES TO MAKE ROOM FOR THE SPAR EXTRUSION.
- 3) **REFERENCE:** POSITION THE REAR PLATE INSIDE THE SPAR EXTRUSIONS WITH THE BOTTOM MIDDLE POINT 72mm FROM THE END OF THE SPAR.  
**ALIGNMENT:** THE TOP EDGE OF THE PLATE IS PARALLEL TO THE SPAR EXTRUSION (TOP).
- 4) CLAMP THE REAR PLATE TO THE SPAR.
- 5) INSERT THE 3/8" O/D DRILL GUIDE BUSHING IN THE OUTBOARD WING SPAR TO DRILL THE FOUR HOLES IN THE OUTBOARD SECTION.
- 6) REMOVE THE PLATE. USE A DRILL PRESS TO OPEN THE HOLES FOR THE BOLTS: FIRST DRILL A 1/4" HOLE, THEN A 5/16" HOLE AND FINALLY A 9.4mm HOLE. FINISH WITH A 3/8" CHUCKING REAMER.
- 7) BOLT THE OLD PLATE ON TOP OF THE NEW PLATE THROUGH THE 3/8" HOLES. USE A 5/16" O/D DRILL GUIDE BUSHINGS TO LOCATE THE REMAINING HOLES. DRILL A 1/4" INTERMEDIARY HOLE FOLLOWED BY A 7.8mm HOLES. FINISH WITH A 5/16" CHUCKING REAMER.
- 8) CENTER THE REAR PLATE ON THE FRONT PLATE, LOCATE THE HOLES THROUGH THE DRILL GUIDE BUSHINGS AND FINISH BY REAMING THE HOLES.

ALIGNMENT:  
 TOP EDGE OF PLATE  
 PARALLEL TO SPAR



DESCRIPTION

## SPAR SPLICE PLATES REPLACEMENT INSTRUCTIONS