



Title:

Control system assembly manual

Document no.:

D2_R0_00

Revision:

R05

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Table of revisions

Revision	Affected pages	Short description of change
00	All	Original issue
01	02, 60, 67, 76, 80, 84 104 – 107 deleted 124 – 126 deleted 156,157 deleted	Table of revision added, nuts in pushrod BOMs corrected, connection of pushrods to ailerons (pages 105 – 108) and elevator (pages 121 – 123) and rudder cables to rudder (pages 150, 151) removed – as it's a part of final assembly manual – D2_00_00.
02	150 – added	Added a step with the installation of a foot rest to the rudder pedals.
03	03, 88, 89, 91, 92, 93, 94	General instructions updated, bushing PCMF was replaced with a bushing D2_SP_01.
04	04 – added	General instructions updated
05	All	Bolt lengths corrected. Pages reduces.

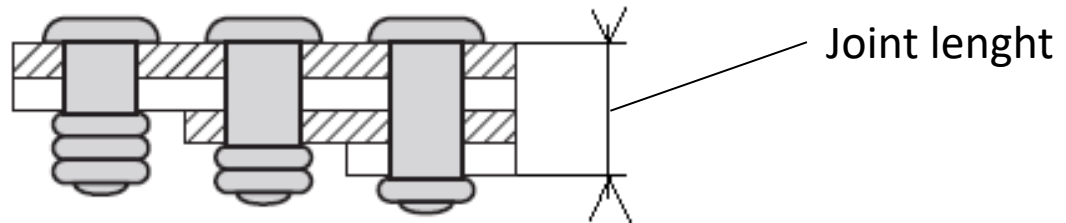
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General instructions:



- Mark all bolt connections
- It is the responsibility of each assembler, to check that the thickness of riveted parts matches the length of the rivet – follow **“Permissible joint length of the rivets“**:



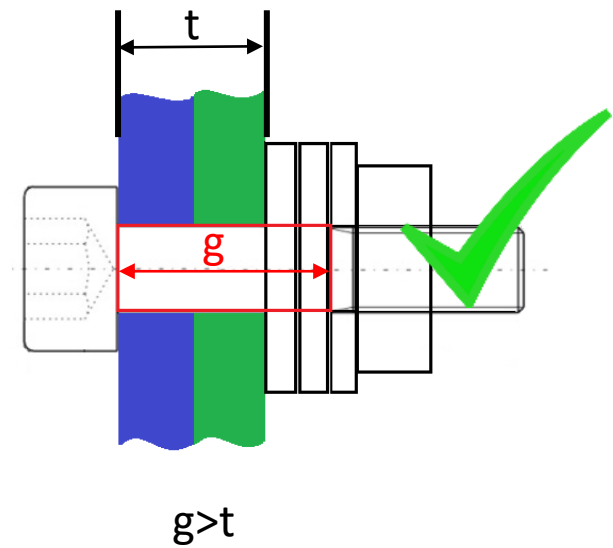
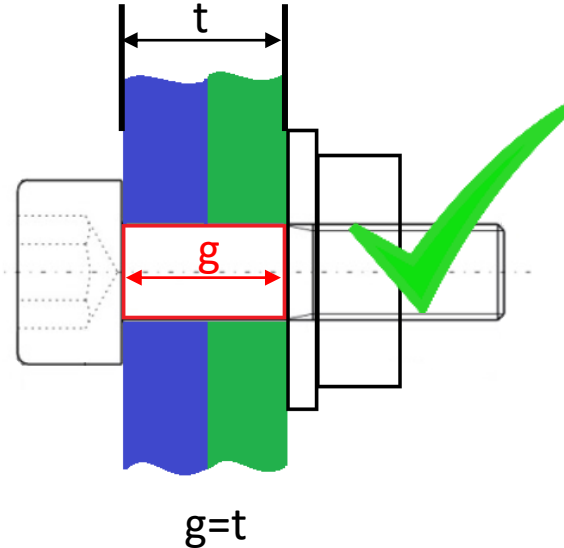
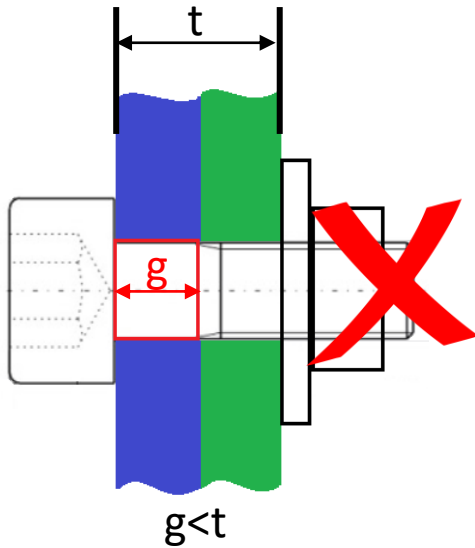
Blind rivet type:	Manufacturer part number:	Can be also marked as:		Min. length:	Max. length:
AVEX $\Phi 3,2 \times 7,9$ Al/St	16910410	Al 3,2x7,9	AVEX $\Phi 3,2 \times 7,9$ Al/Fe	0,8mm	4,8mm
AVEX $\Phi 3,2 \times 9,5$ Al/St	10013209	Al 3,2x9,5	AVEX $\Phi 3,2 \times 9,5$ Al/Fe	2,0mm	6,5mm
AVEX $\Phi 3,2 \times 11,2$ Al/St	16910414	Al 3,2x11,2	AVEX $\Phi 3,2 \times 11,2$ Al/Fe	4,0mm	7,9mm
AVEX $\Phi 4 \times 9,5$ Al/St	16910512	Al 4x9,5	AVEX $\Phi 4 \times 9,5$ Al/Fe	1,0mm	6,0mm
AVEX $\Phi 4 \times 12,7$ Al/St	16910516	Al 4x12,7	AVEX $\Phi 4 \times 12,7$ Al/Fe	4,0mm	9,6mm

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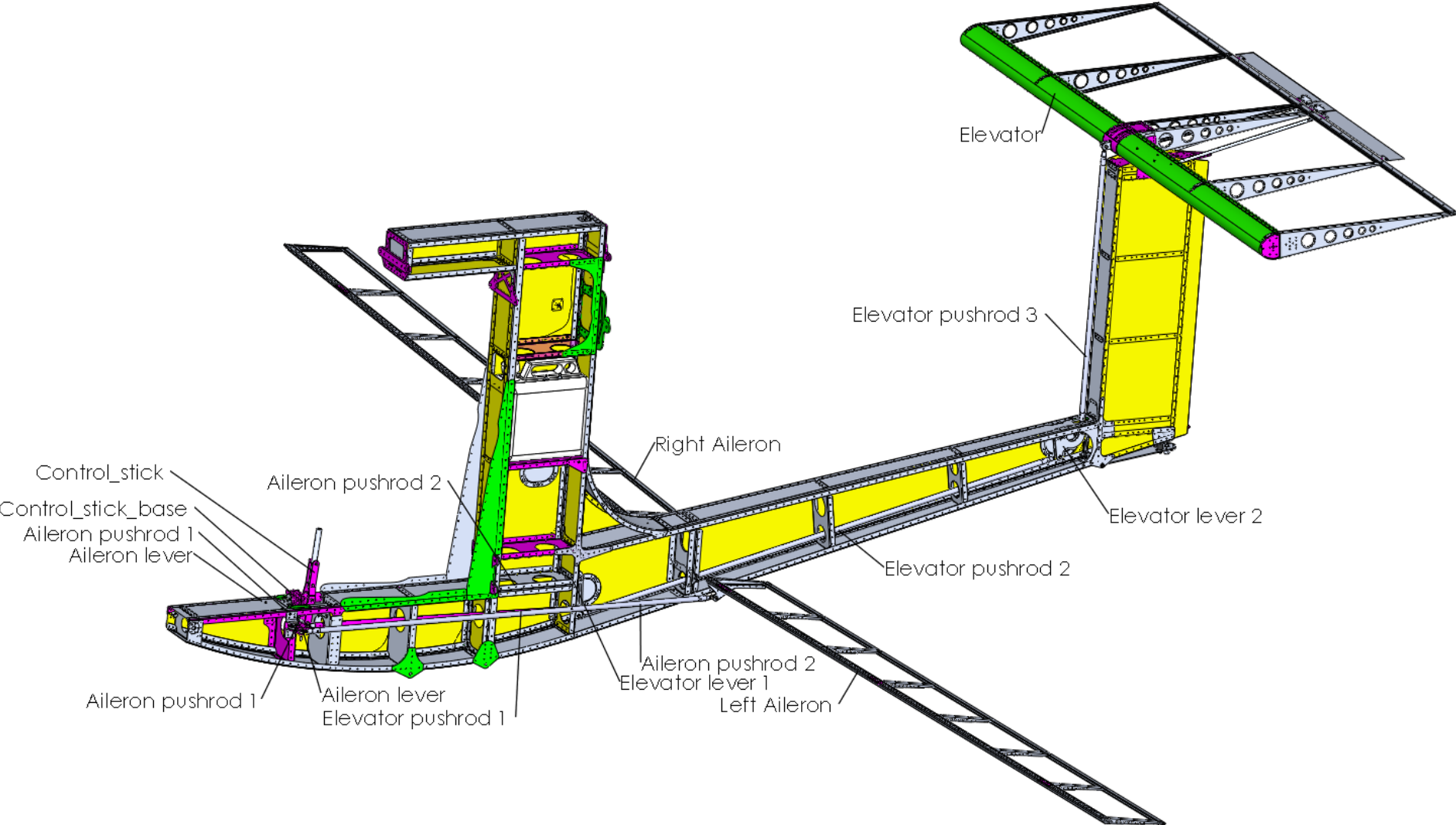


General instructions:

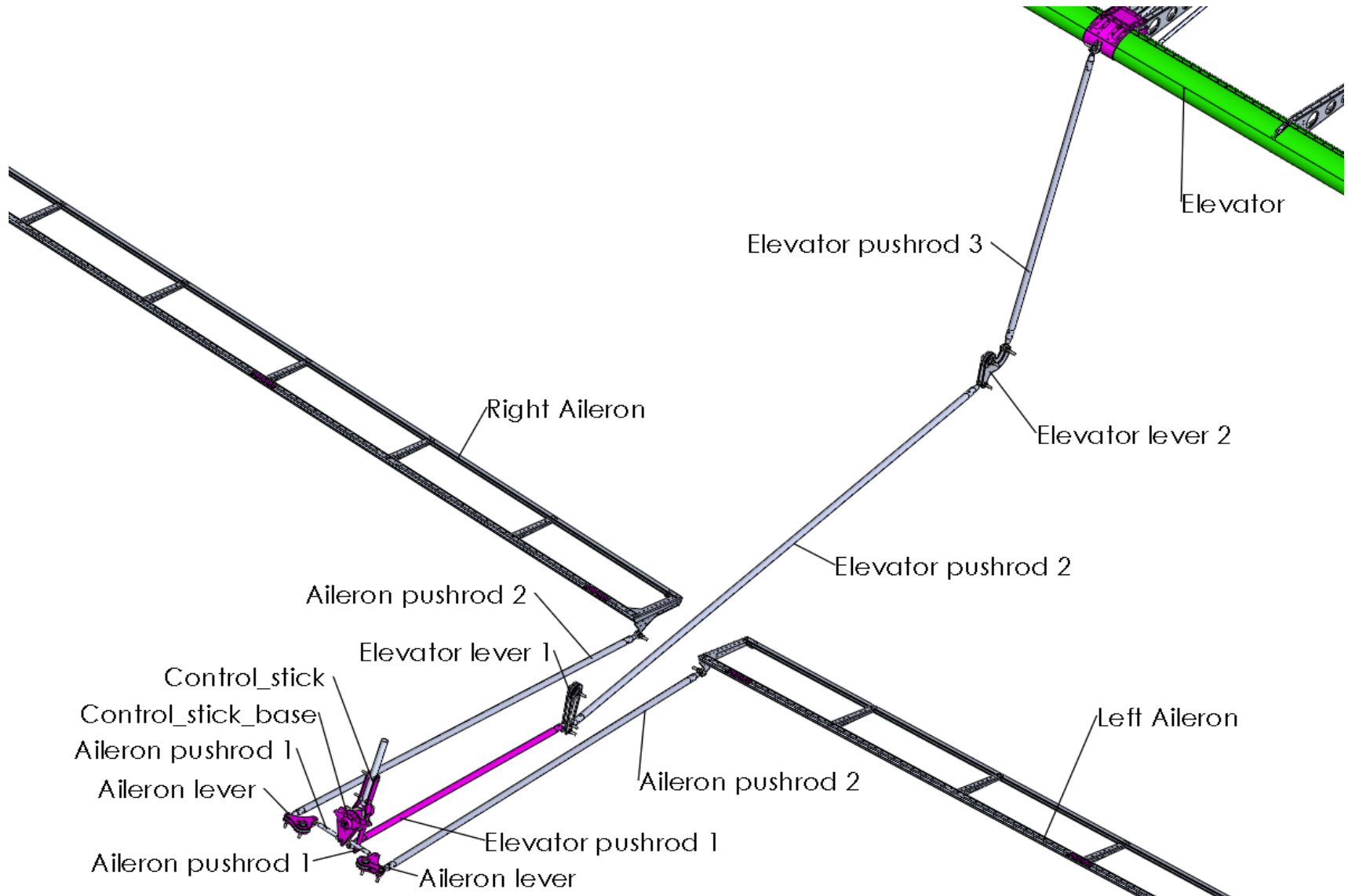
- It is the responsibility of each assembler, to check the grip length of the bolt and ensure, that the grip length (g) matches, or exceeds the thickness (t) of connected parts.



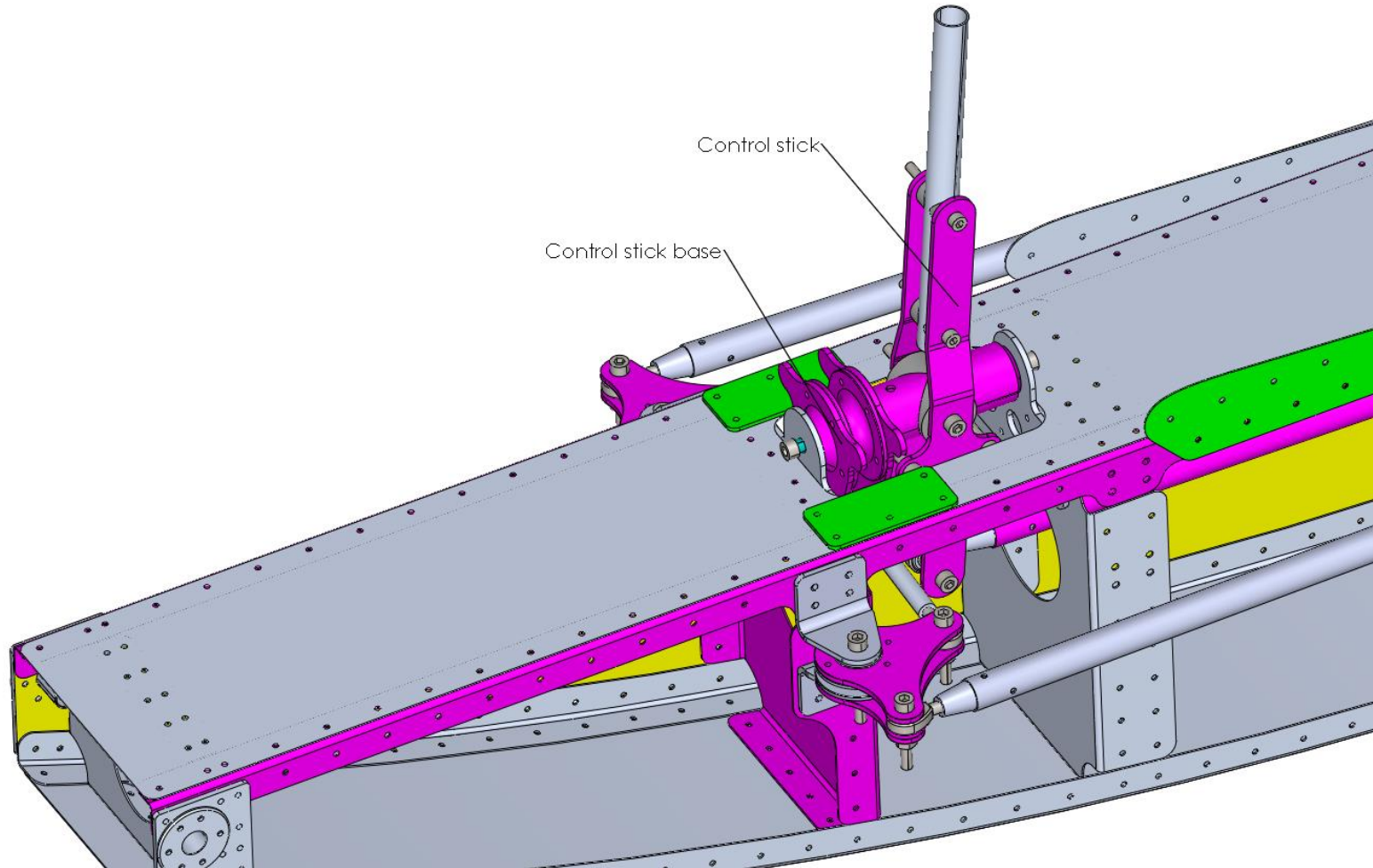
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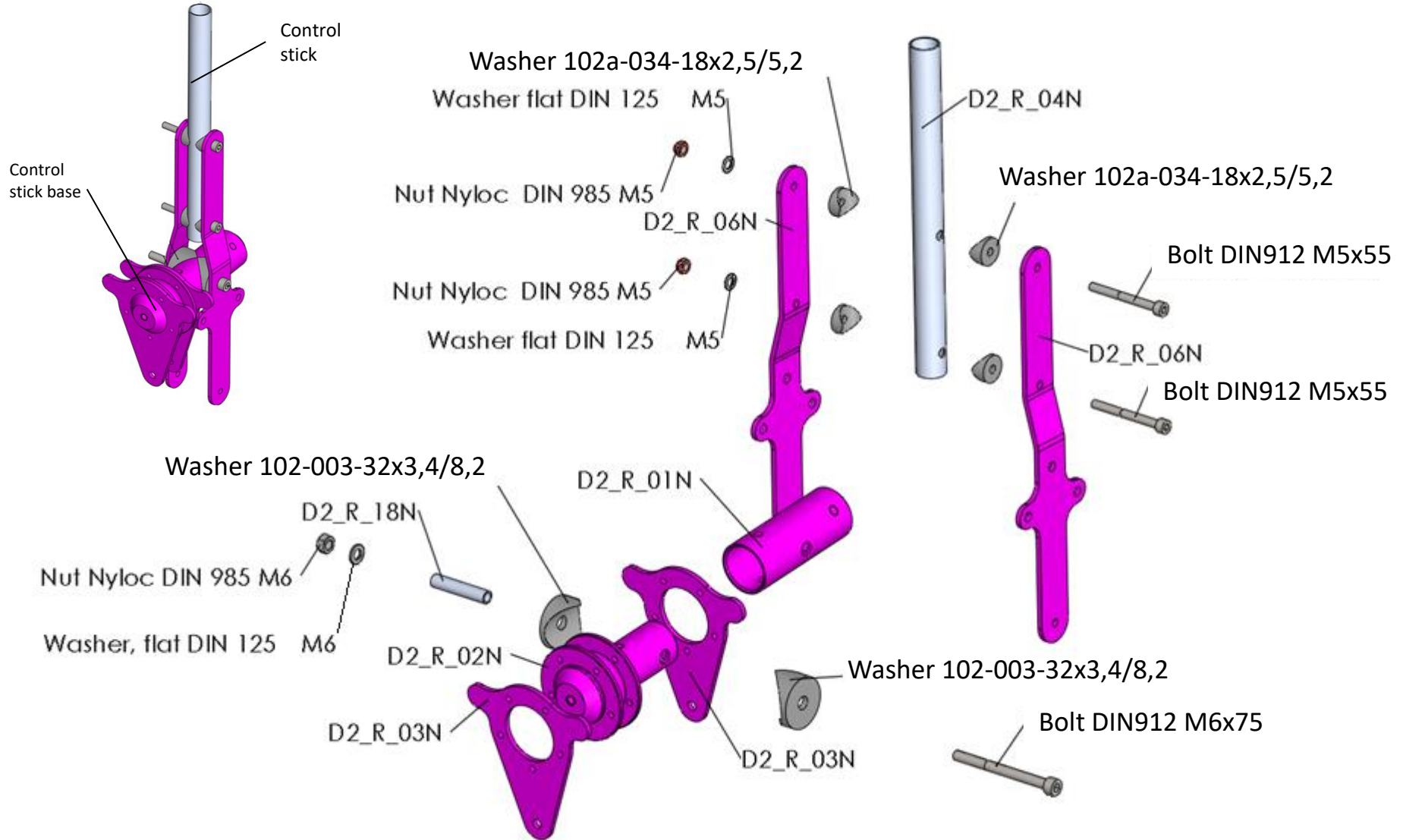
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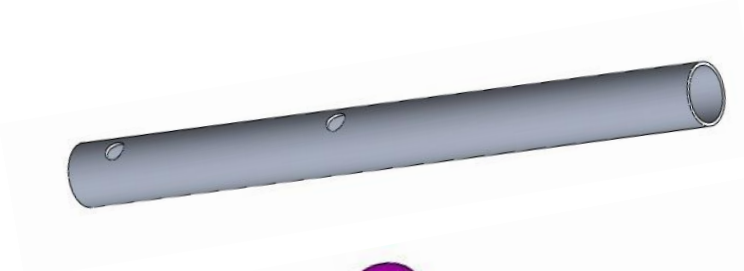
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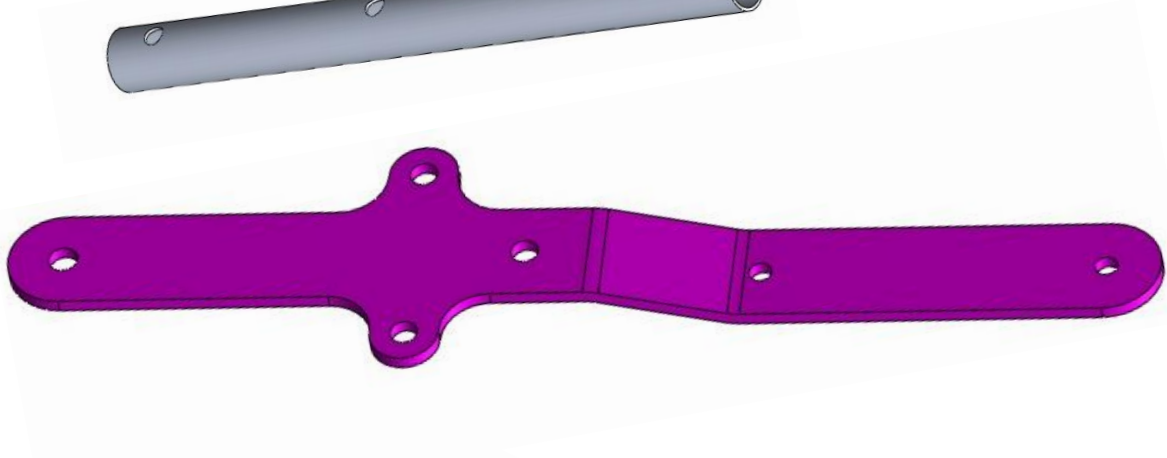
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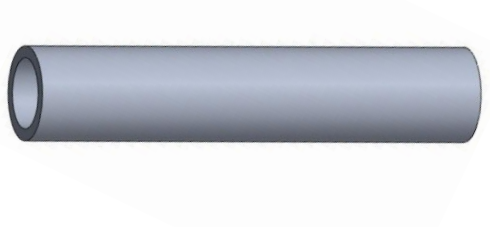
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Quantity: 1 piece



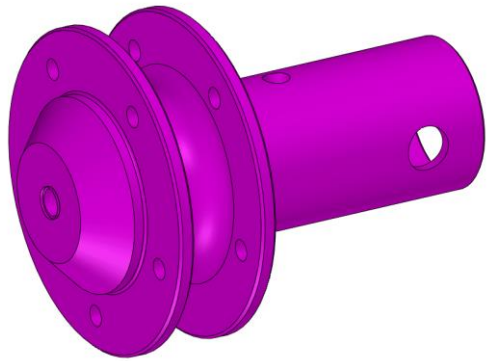
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Part: D2_R_18
Quantity: 1 piece



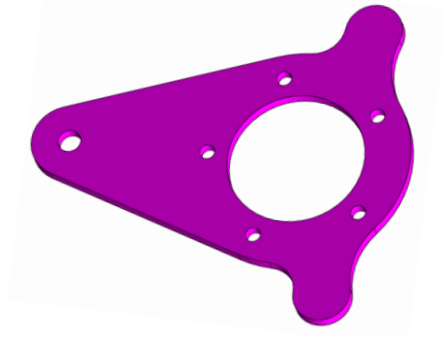
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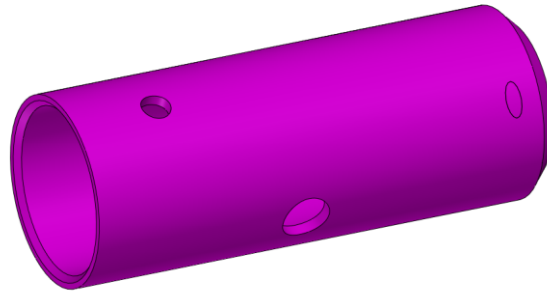
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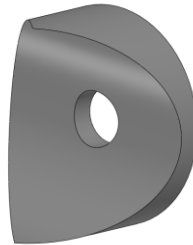
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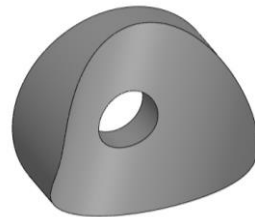
Part: D2_R_01N
Quantity: 1 piece



Part: Washer 102-003-32x3,4/8,3
Quantity: 2 piece










Part: Washer 102a-034-18x2,5/5,2
Quantity: 4 piece



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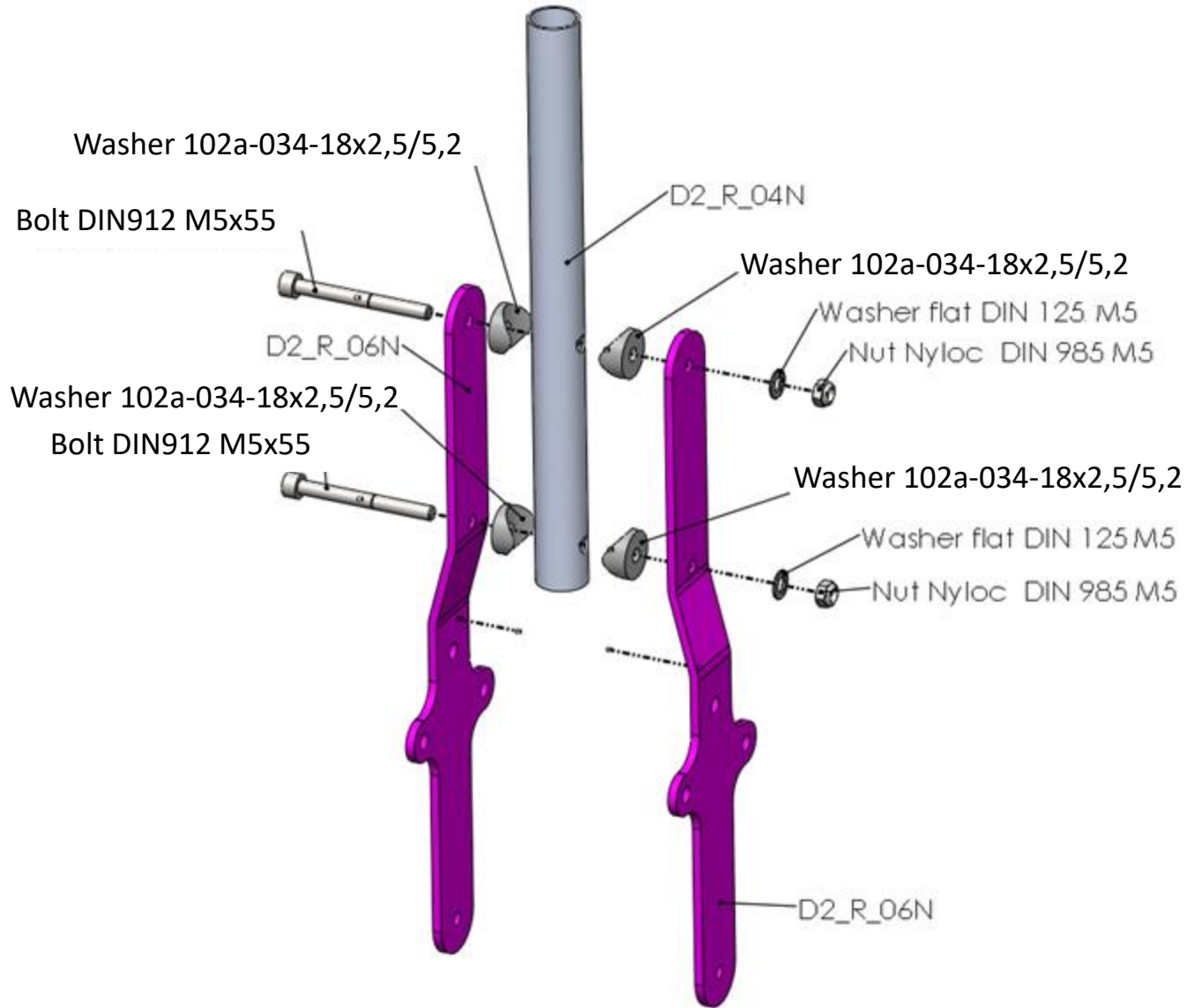


Standard Parts		
Detail picture	Part	Quantity
	Nut Nyloc DIN 985 M5	2
	Bolt DIN 912 M6x75	1
	Washer flat DIN 125 M6	1
	Bolt DIN 912 M5x55	2
	Nut Nyloc DIN 985 M6	1
	Washer flat DIN 125 M5	2
	Blind rivets AVEX Ø 4,0x9,5 AL/St	10

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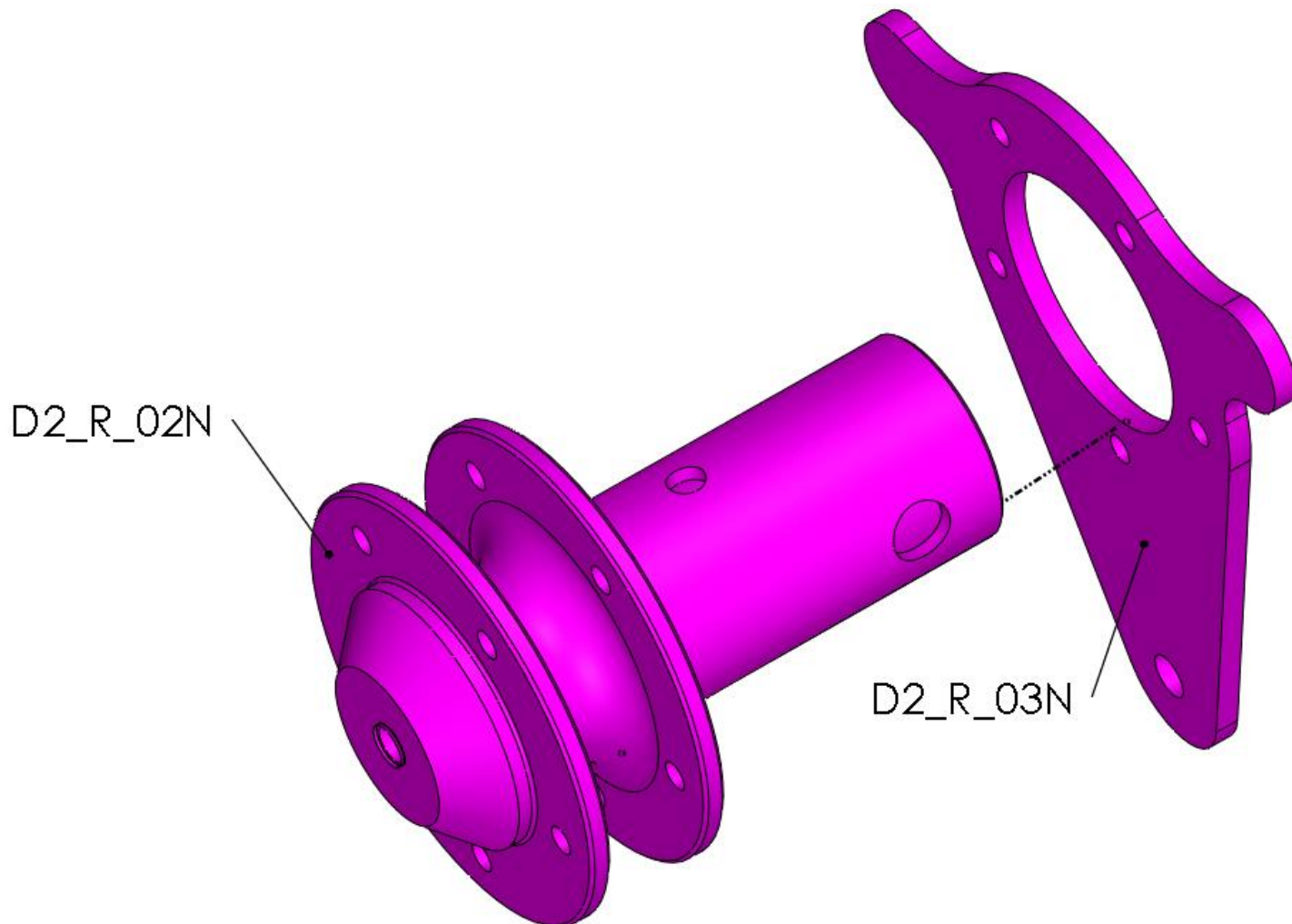
Step 1



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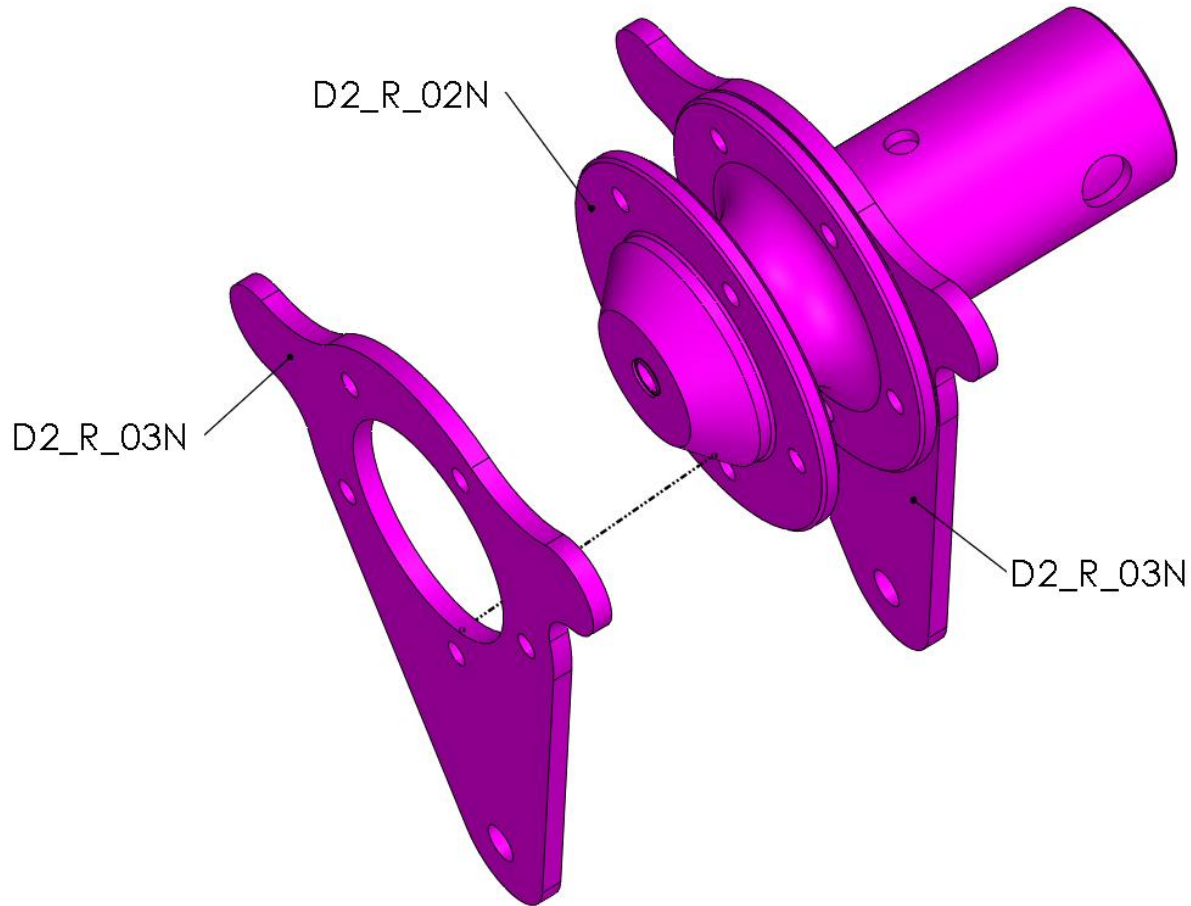
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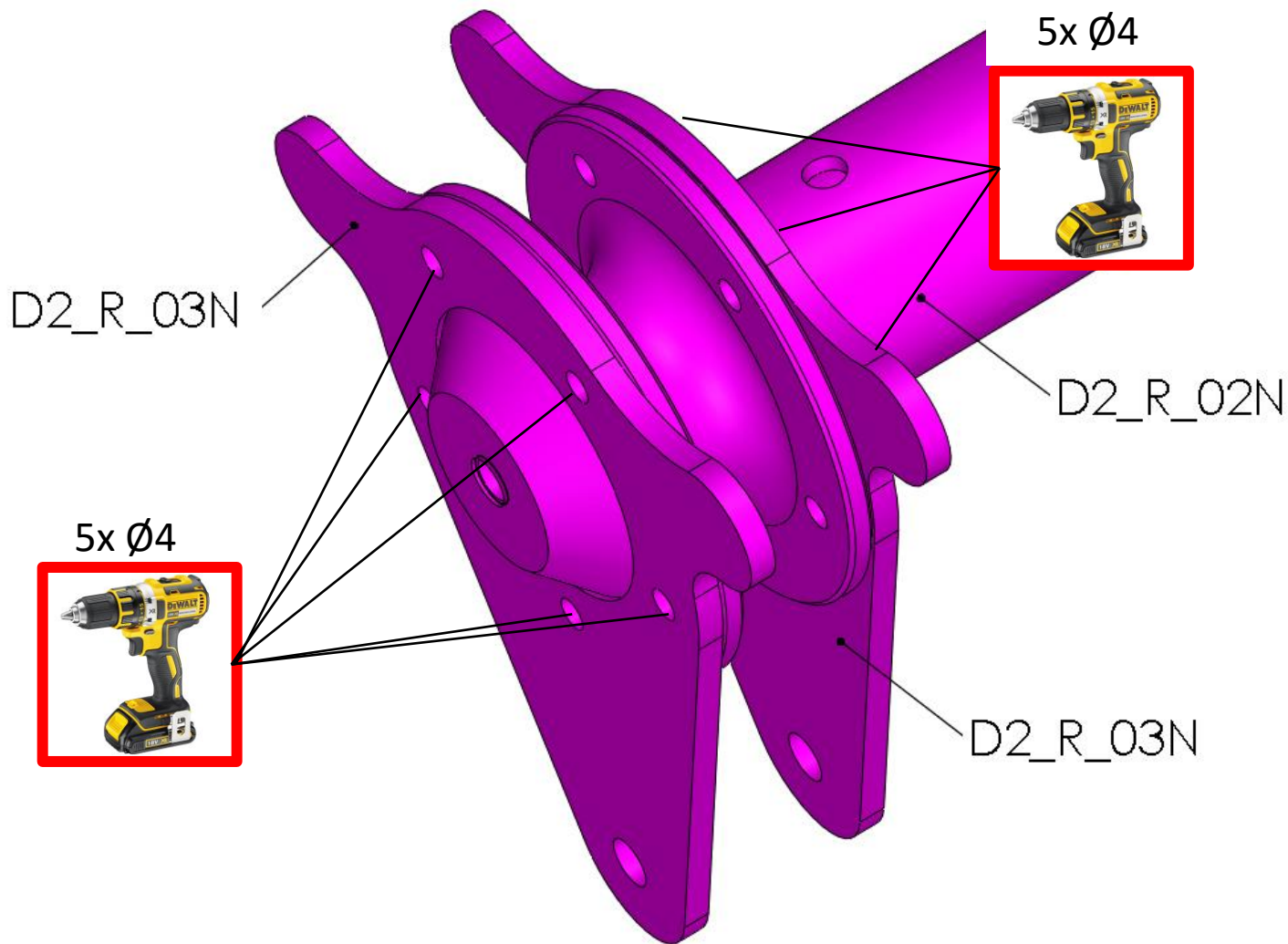
Step 3



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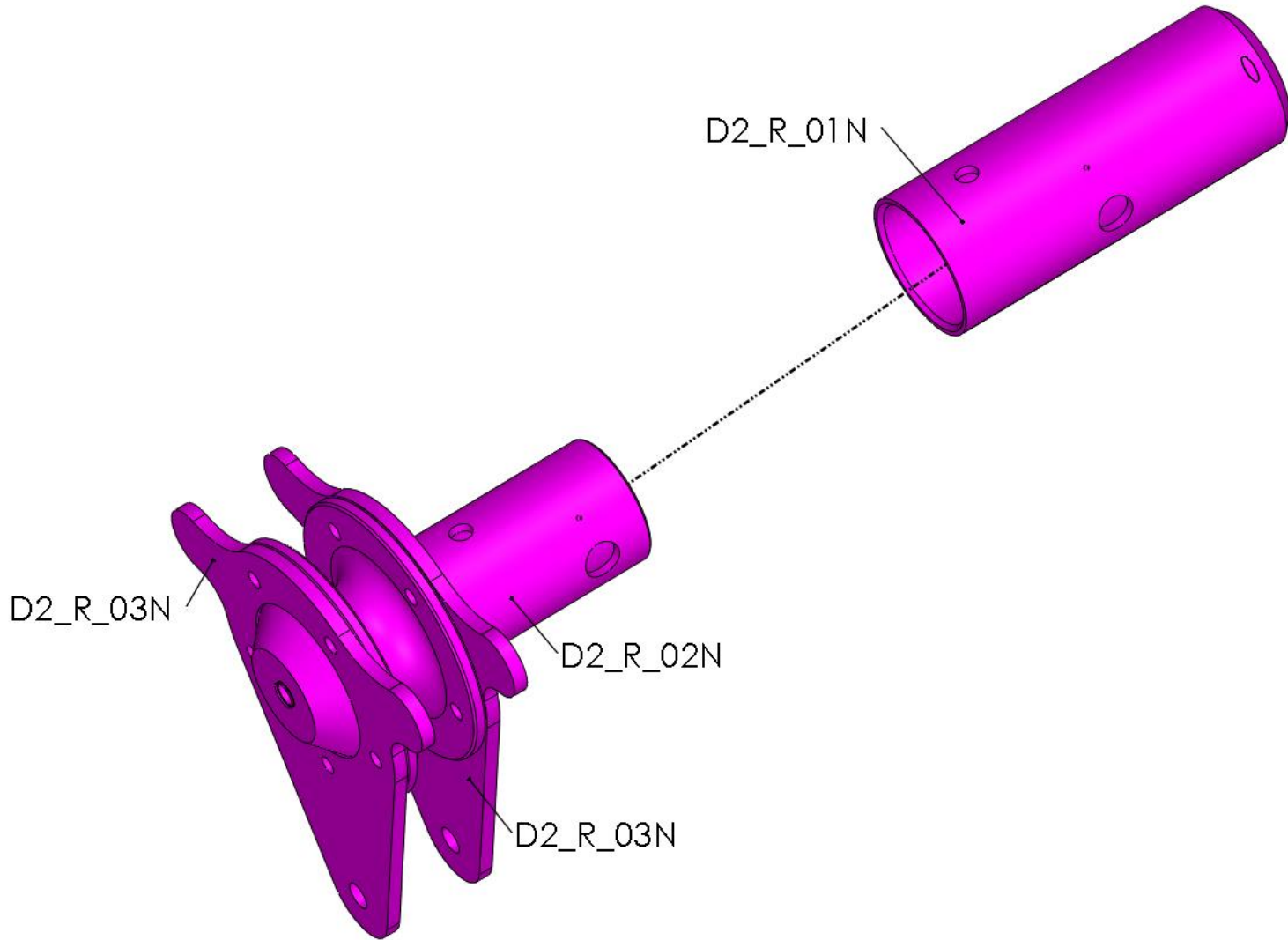
Step 4



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Step 5



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Step 6

5x Rivet
AVEX 4x9,5 Al/St



D2_R_02N

D2_R_03N

5x Rivet
AVEX 4x9,5 Al/St



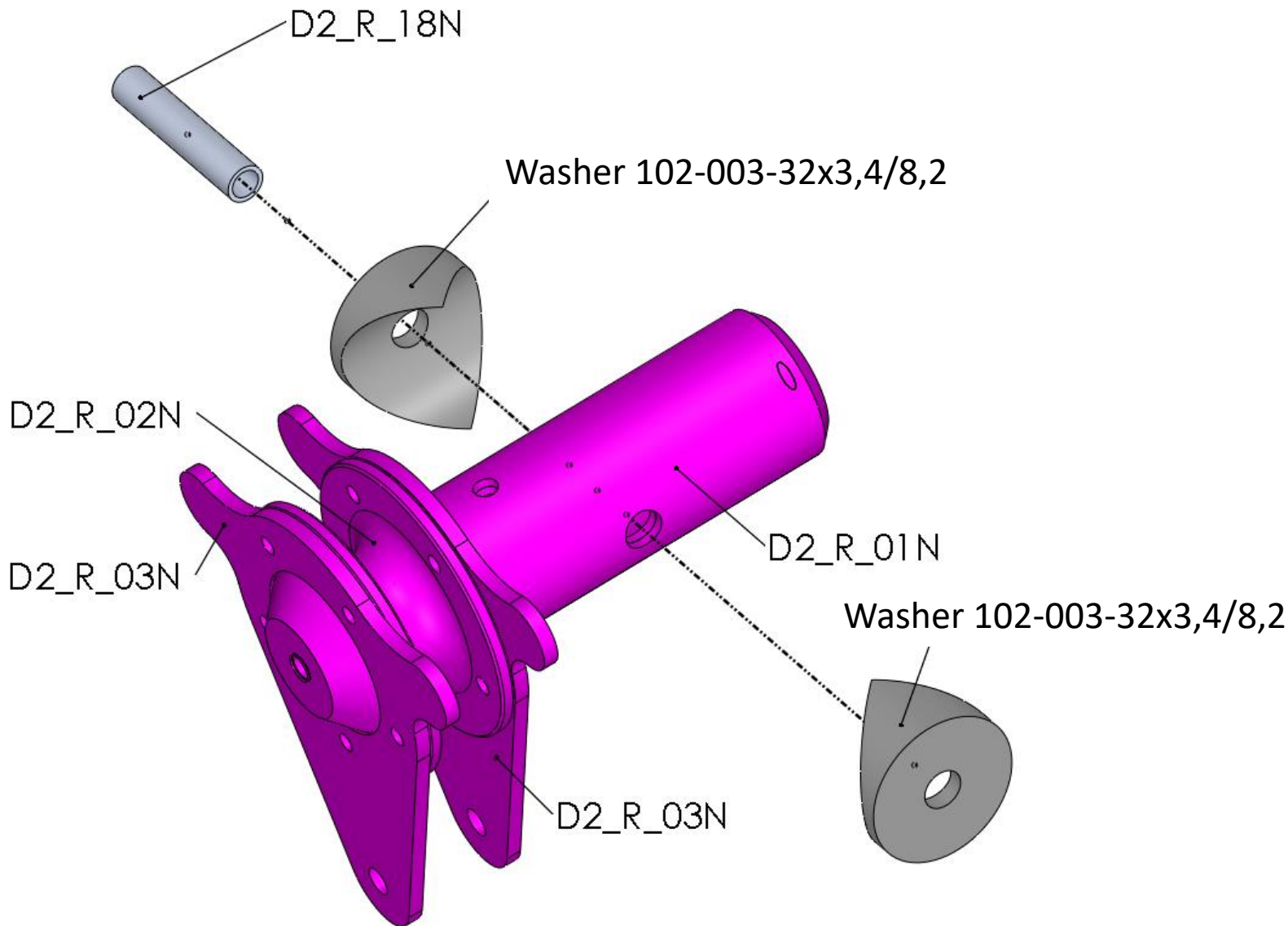
D2_R_03N

D2_R_01N

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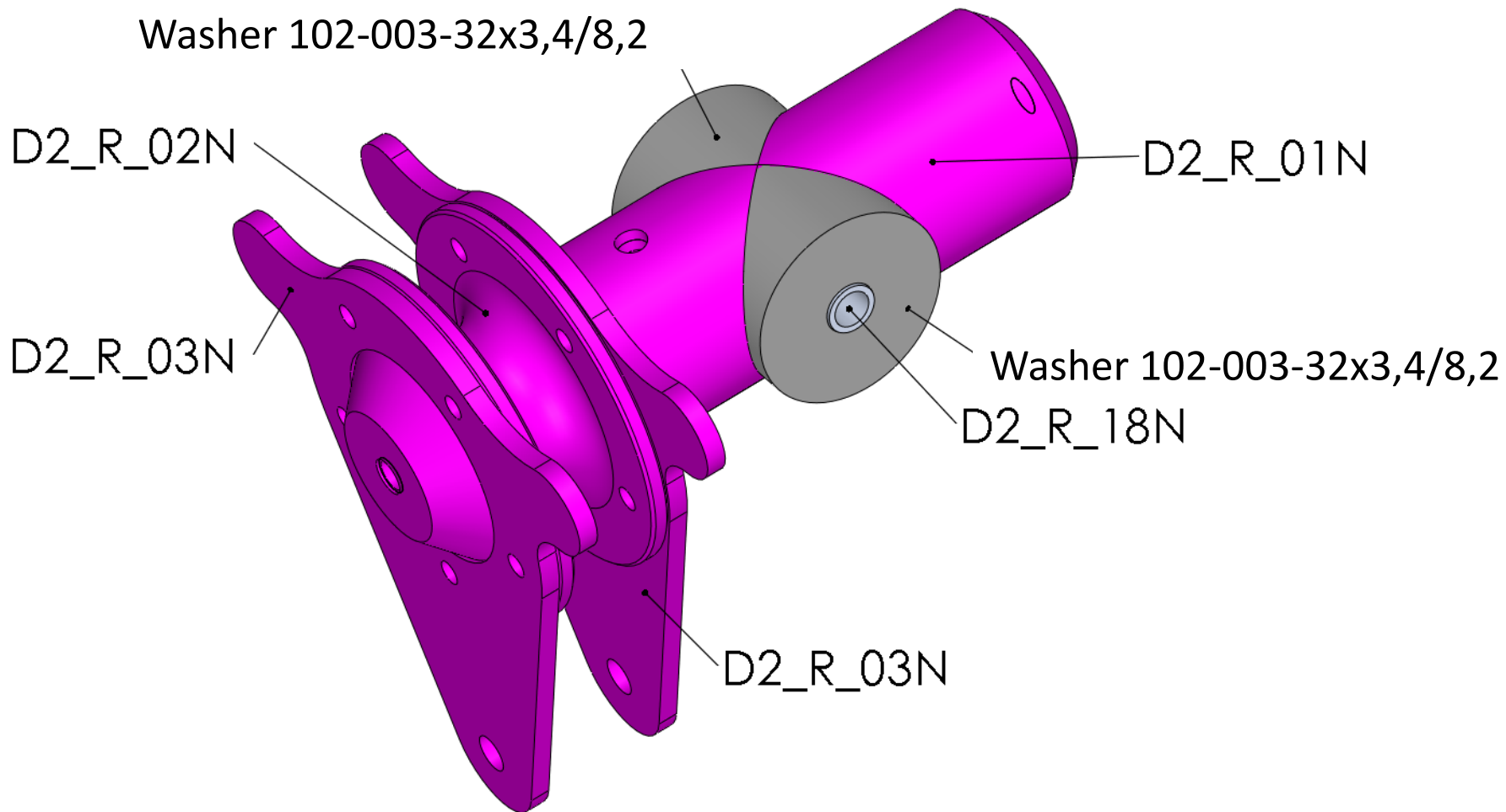
Step 7



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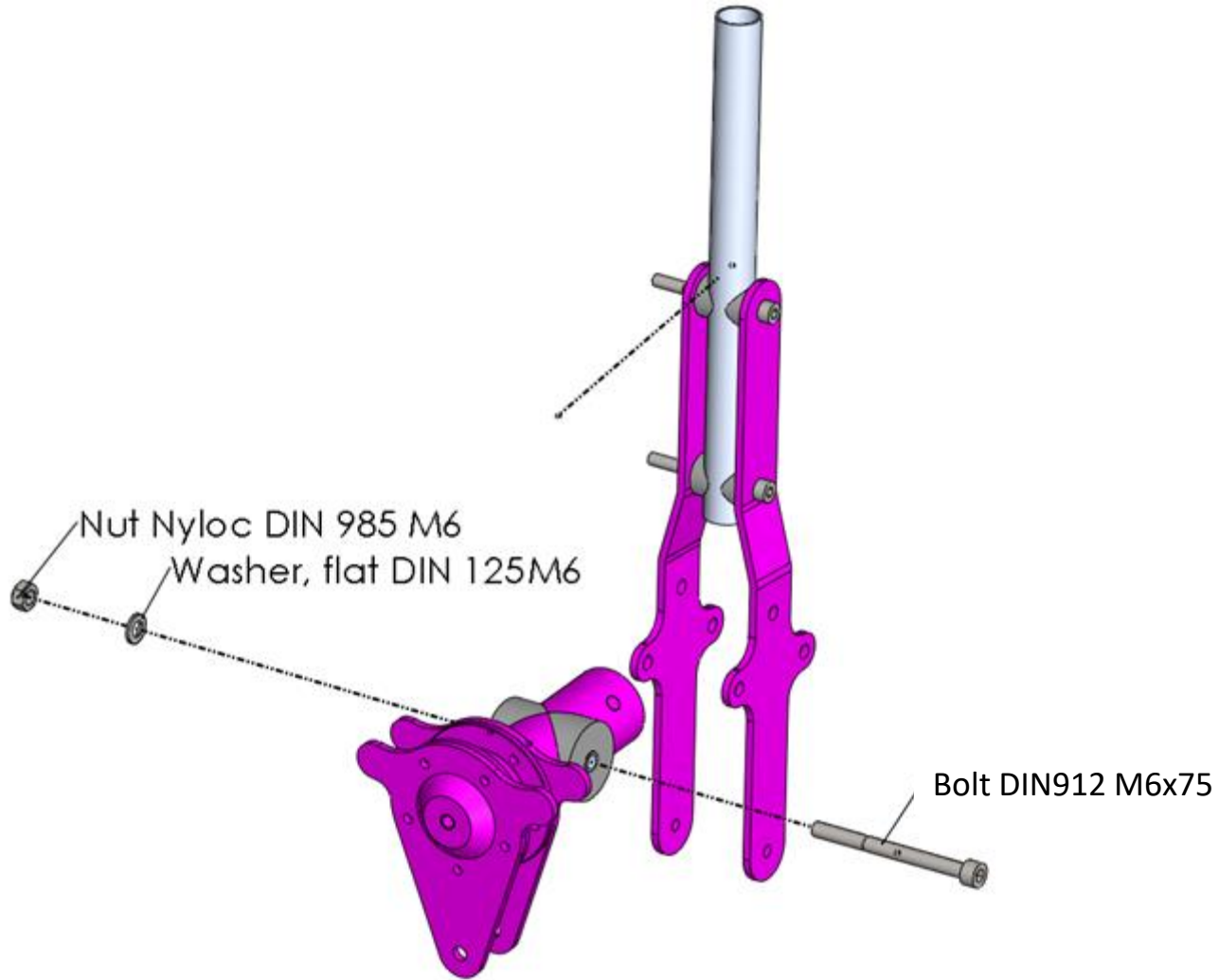
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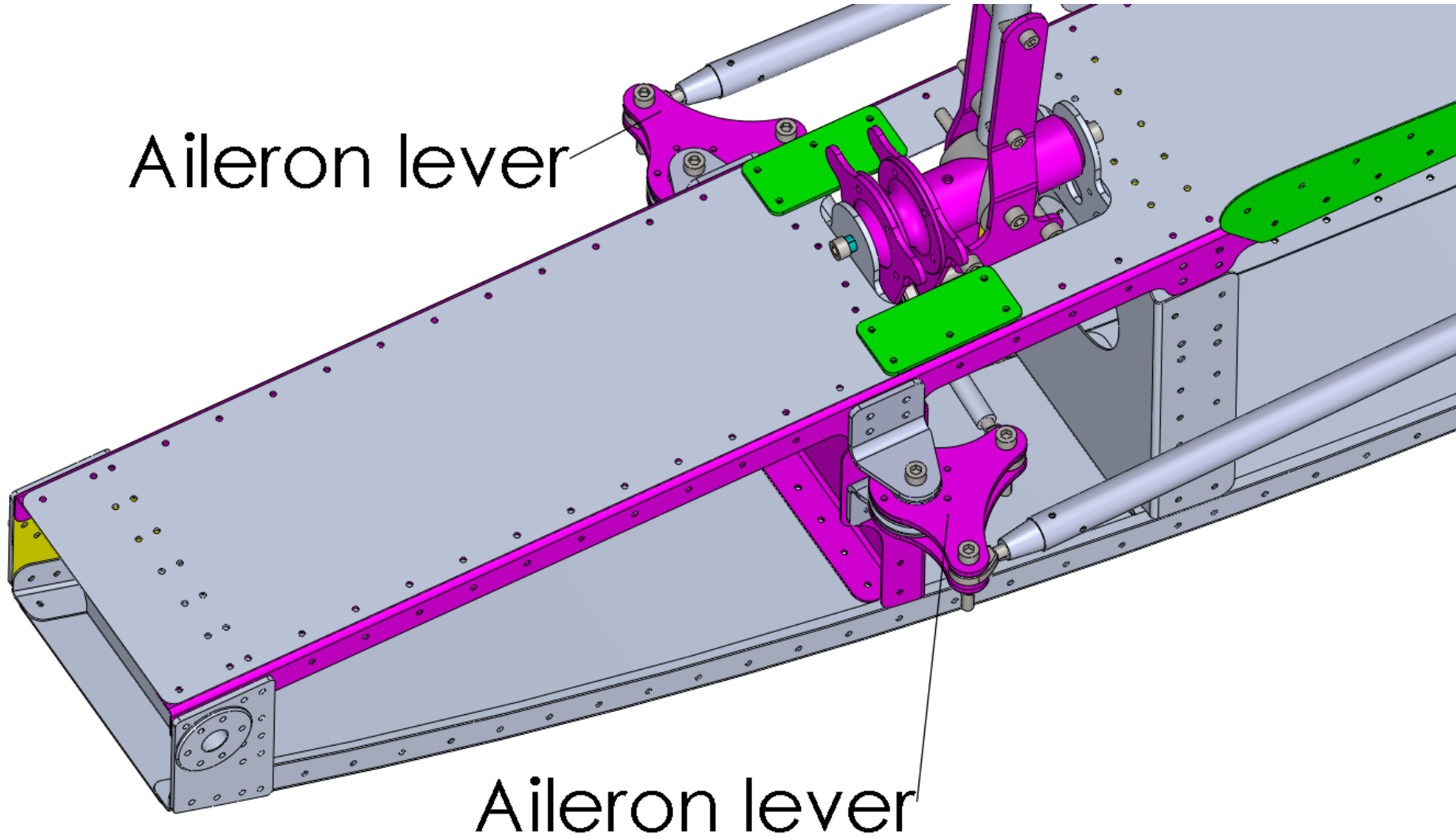
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Step 9



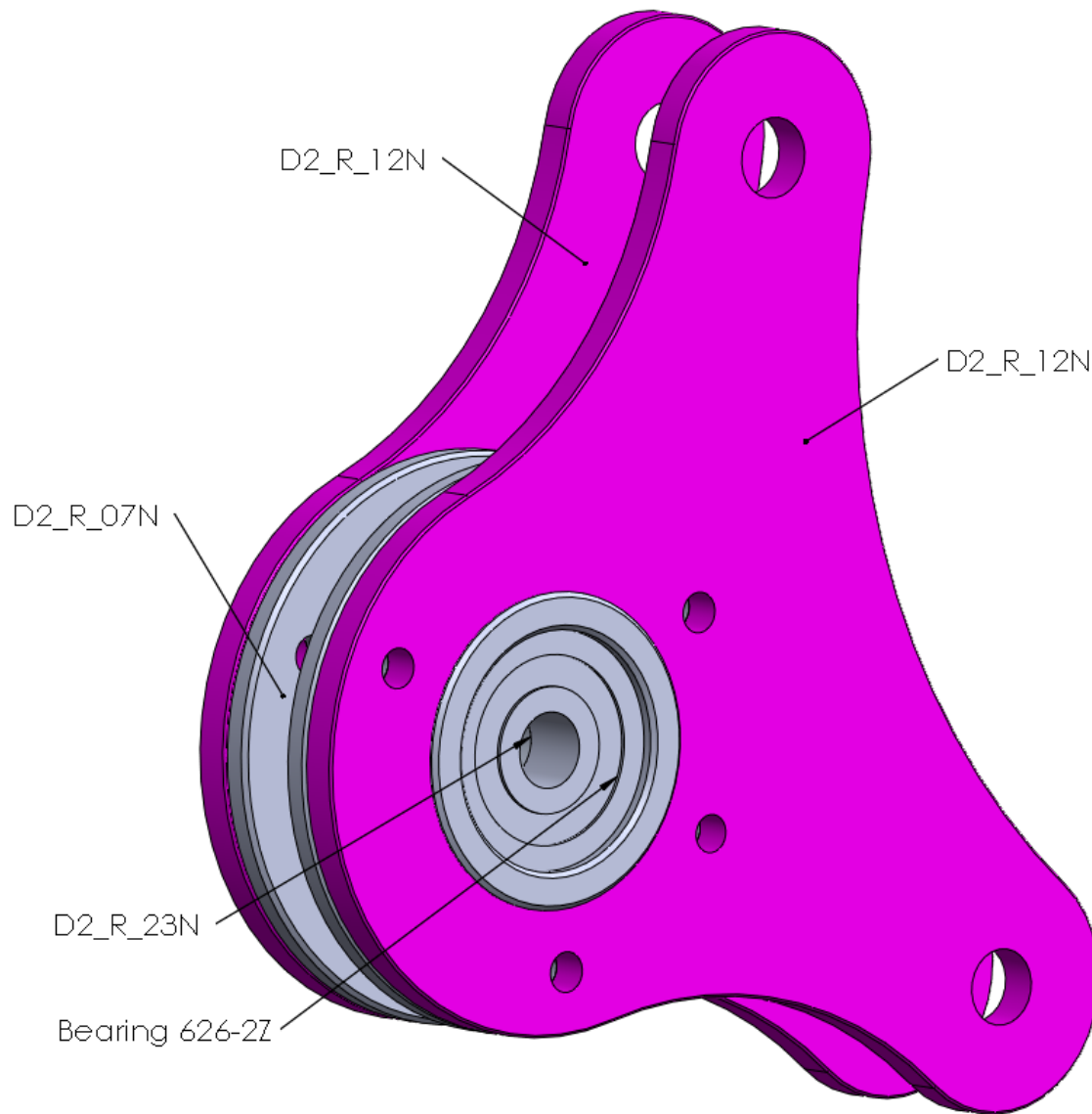
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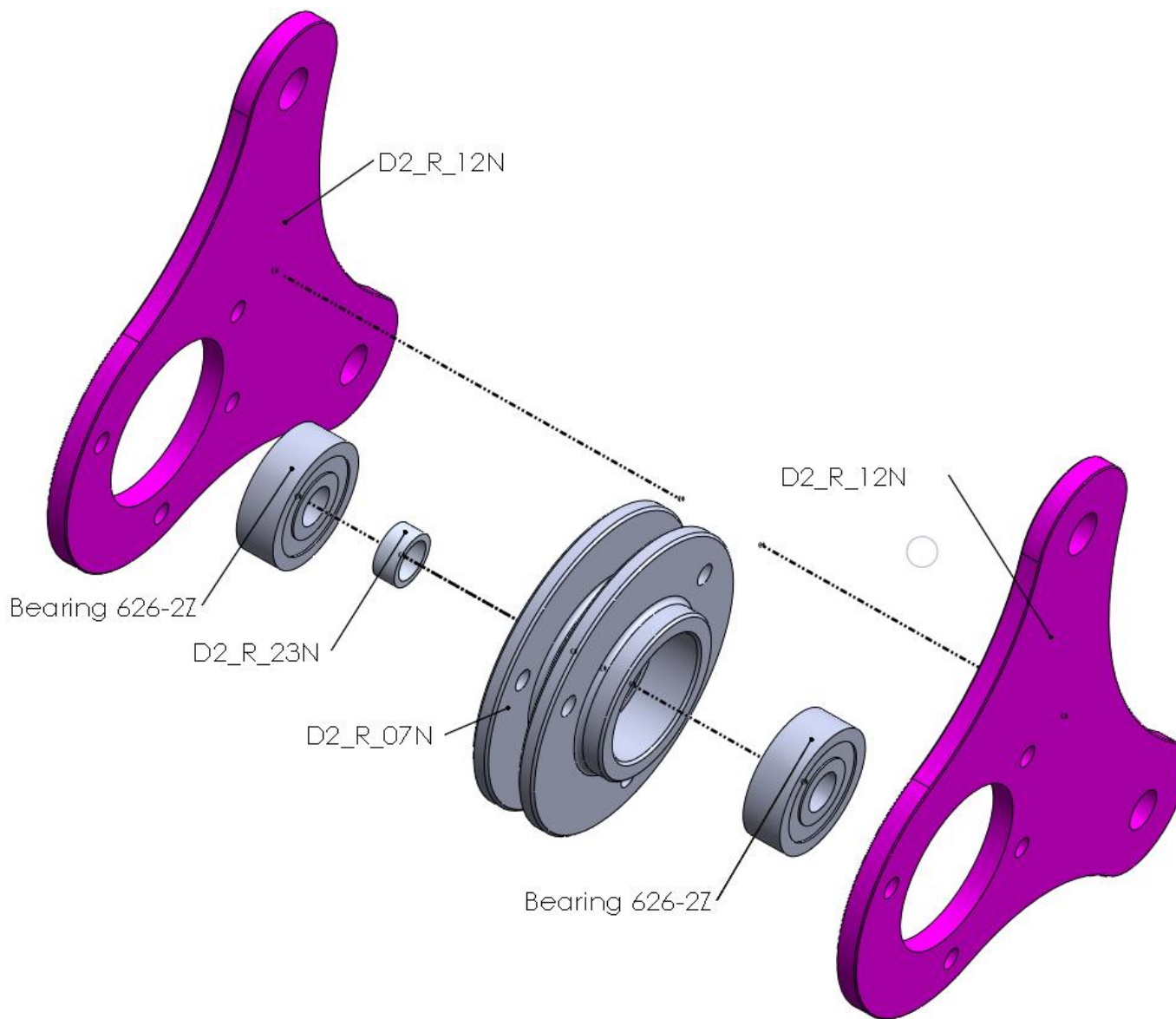
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Aileron lever
Quantity: 2



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Part: D2_R_12N
Quantity: 2+2





Part: D2_R_07N
Quantity: 1+1



Part: D2_R_23N
Quantity: 1+1



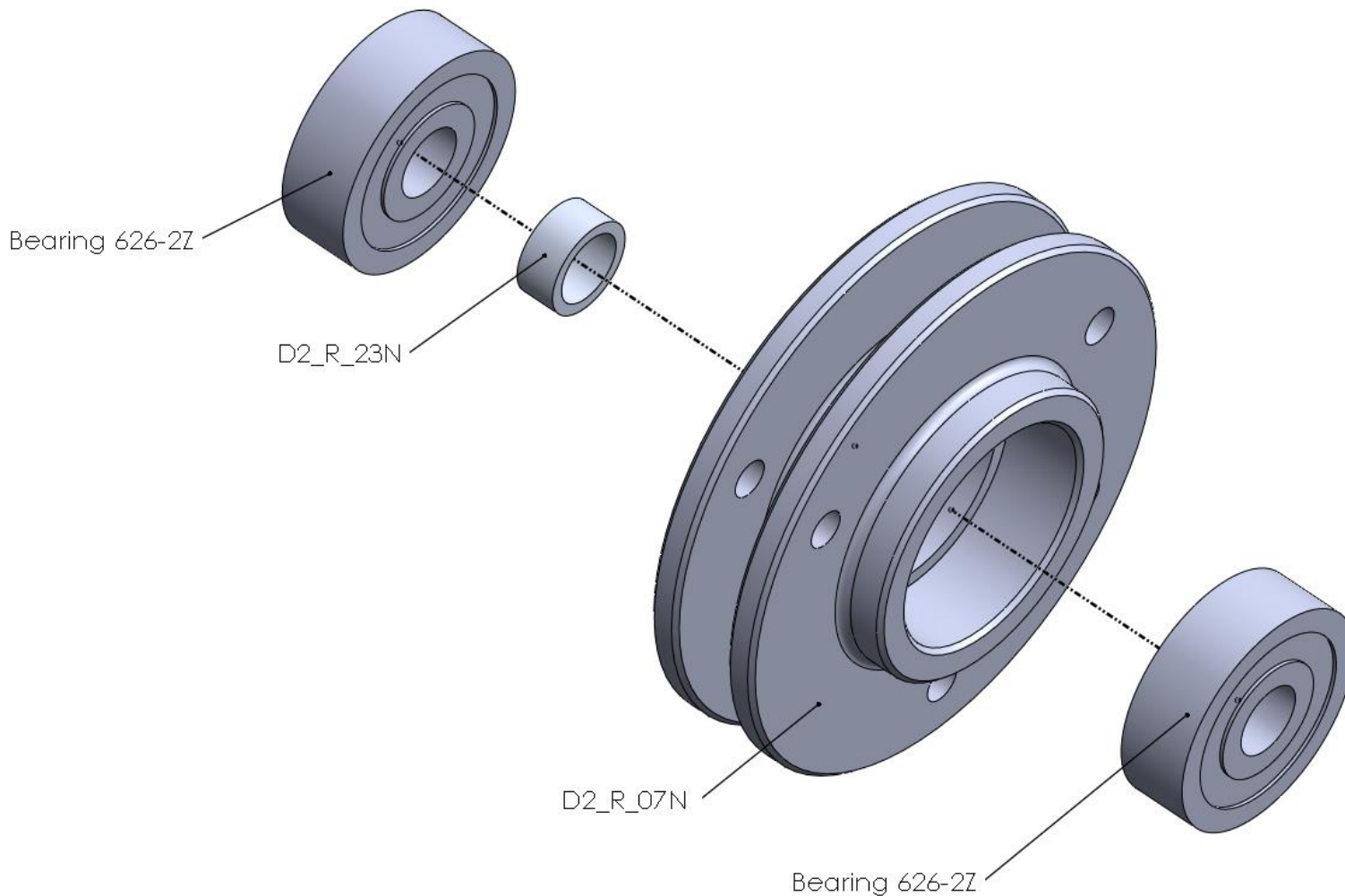
Standard Parts

Detail picture	Part	Quantity
	Bearing 626-2Z	2+2
	Blind rivets AVEX Ø 3,2x9,5 AL/st	6+6

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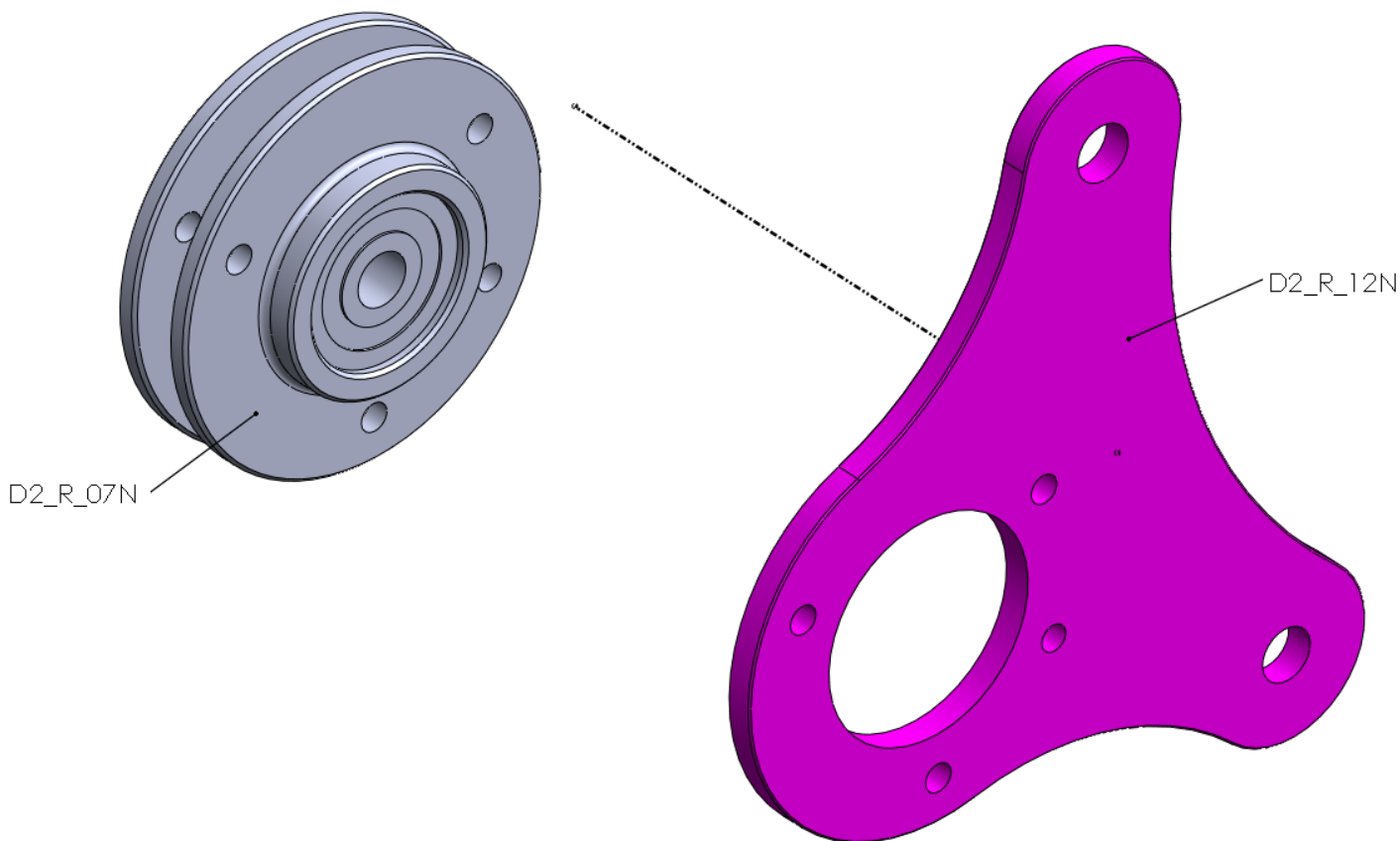
Step 1



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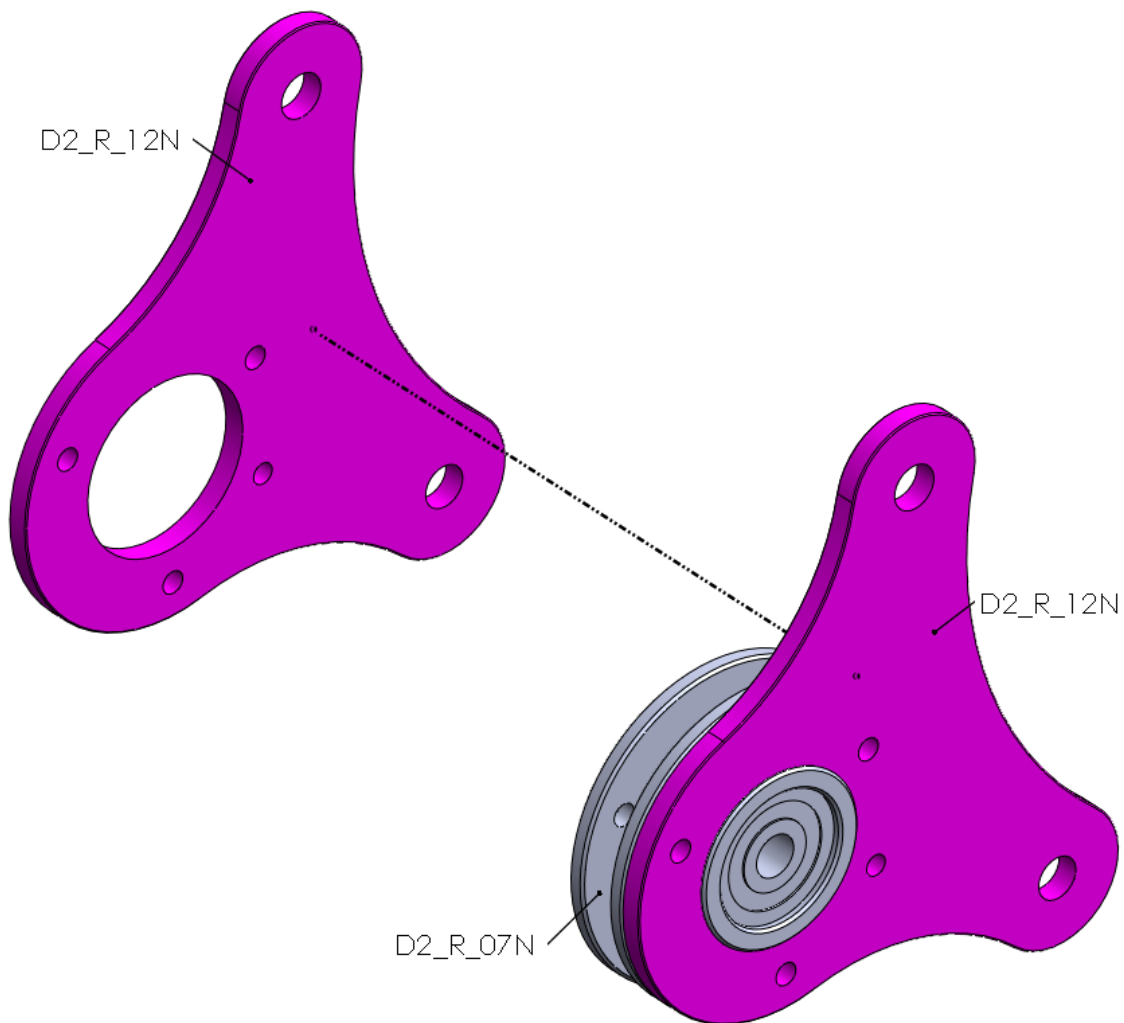
Step 2



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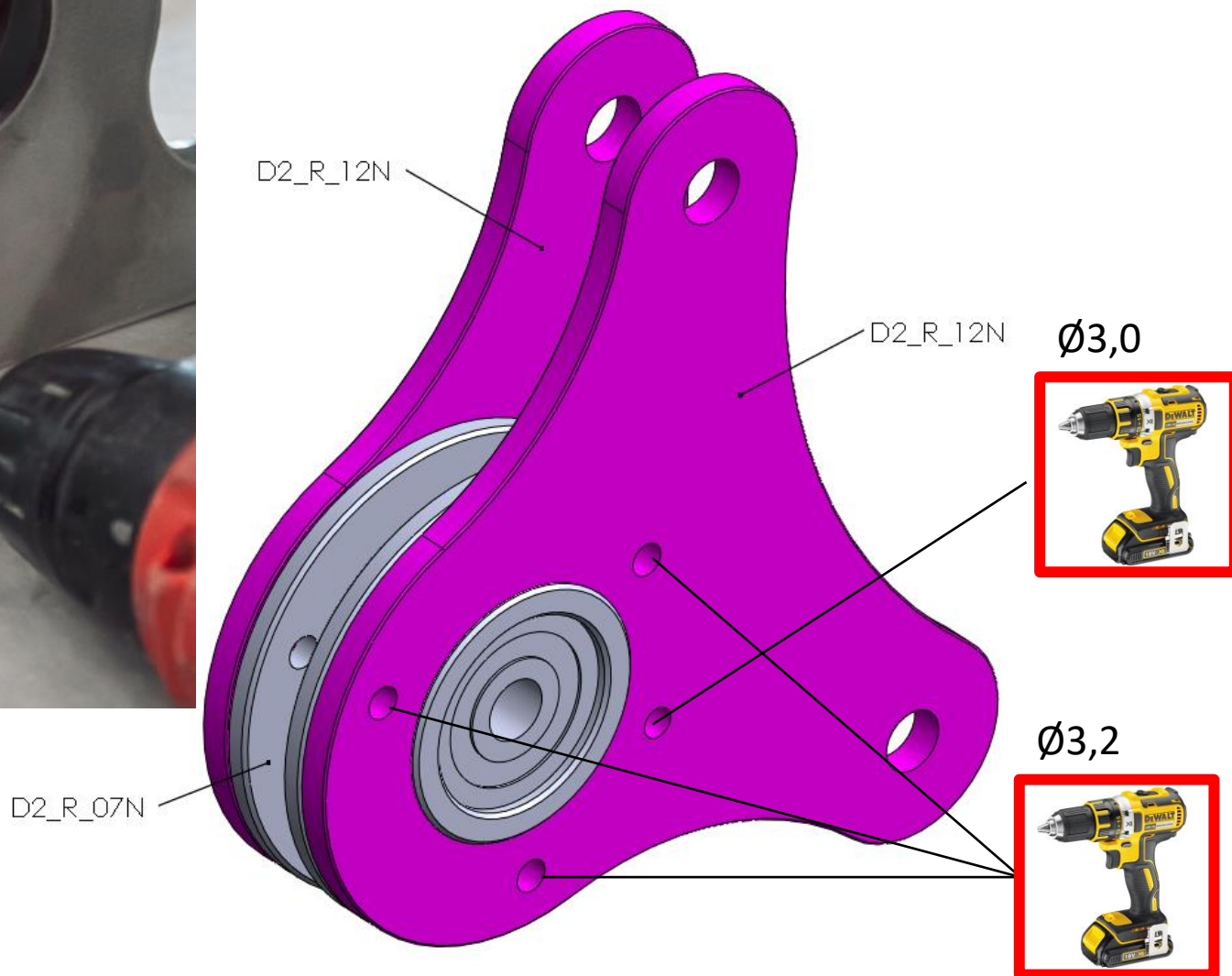


Step 3



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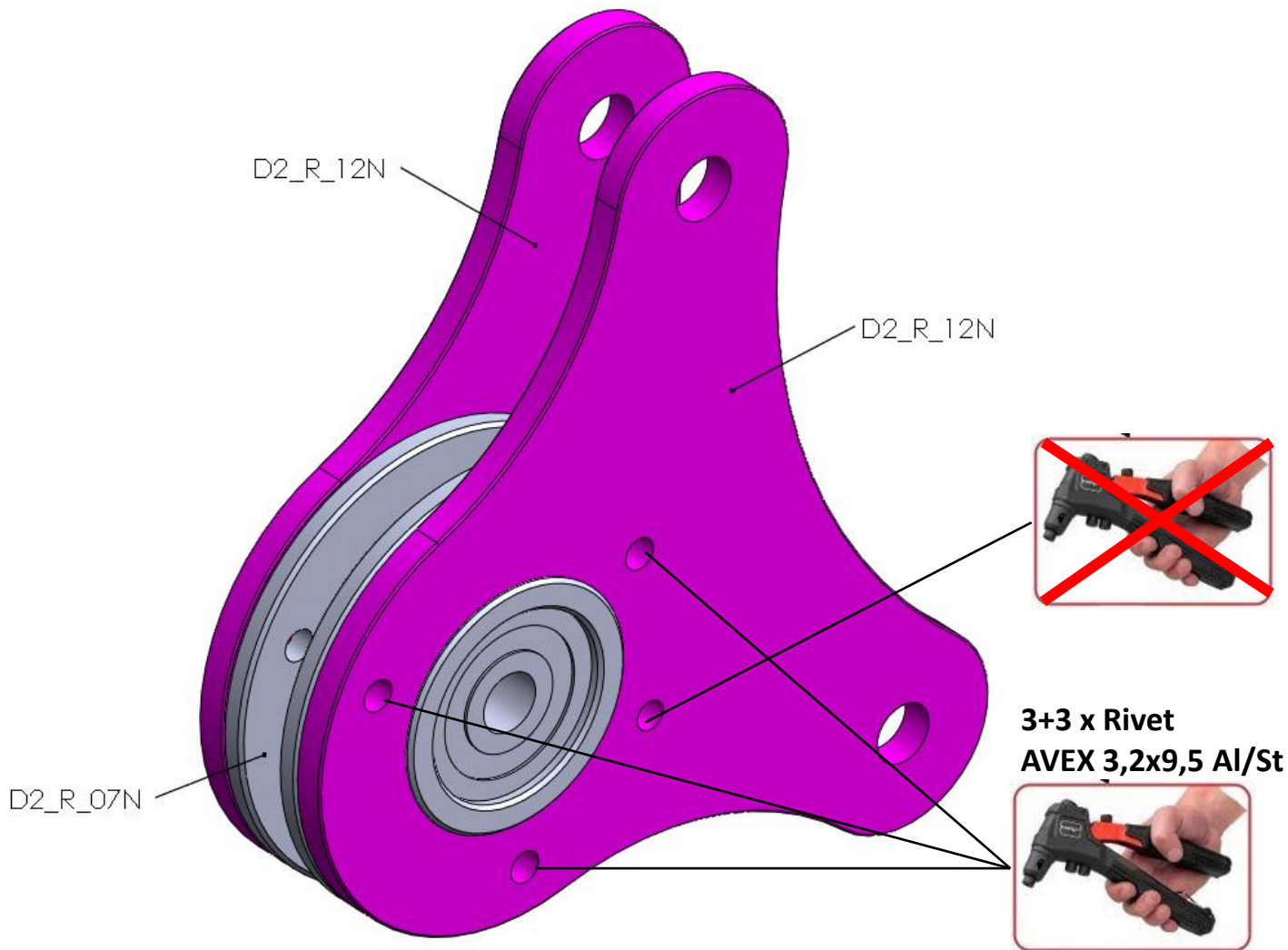
Step 4



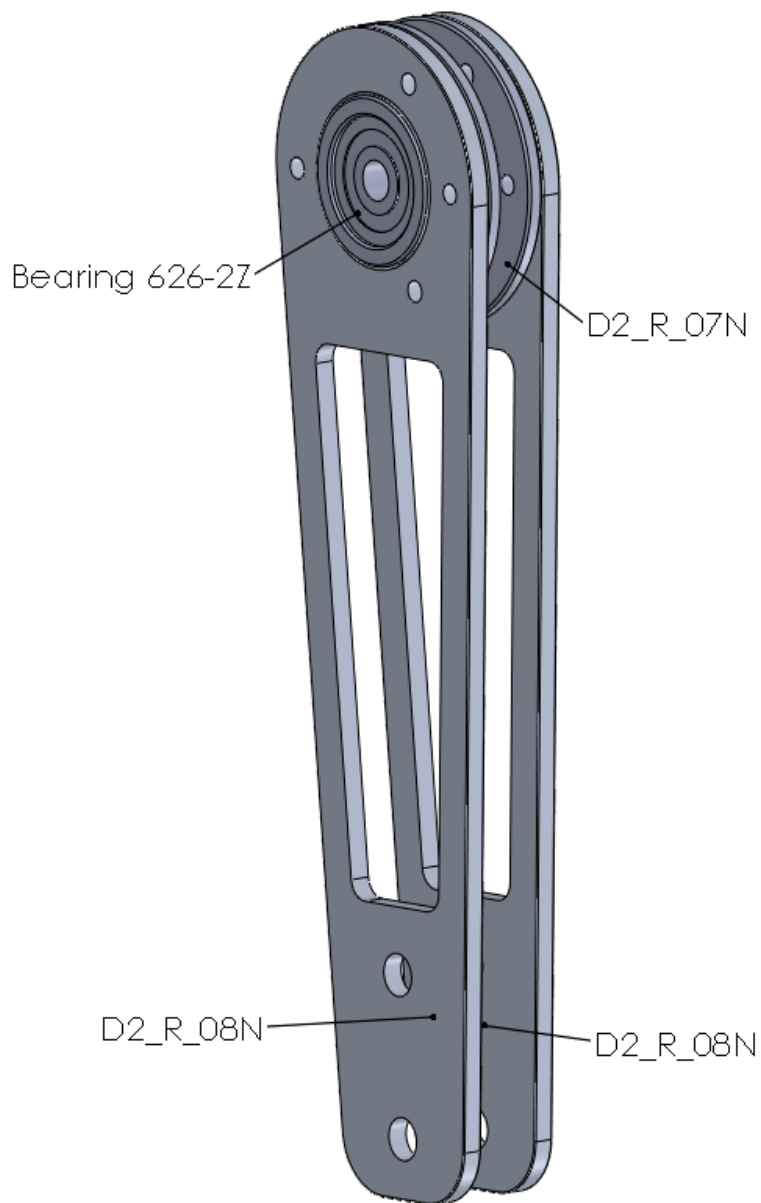
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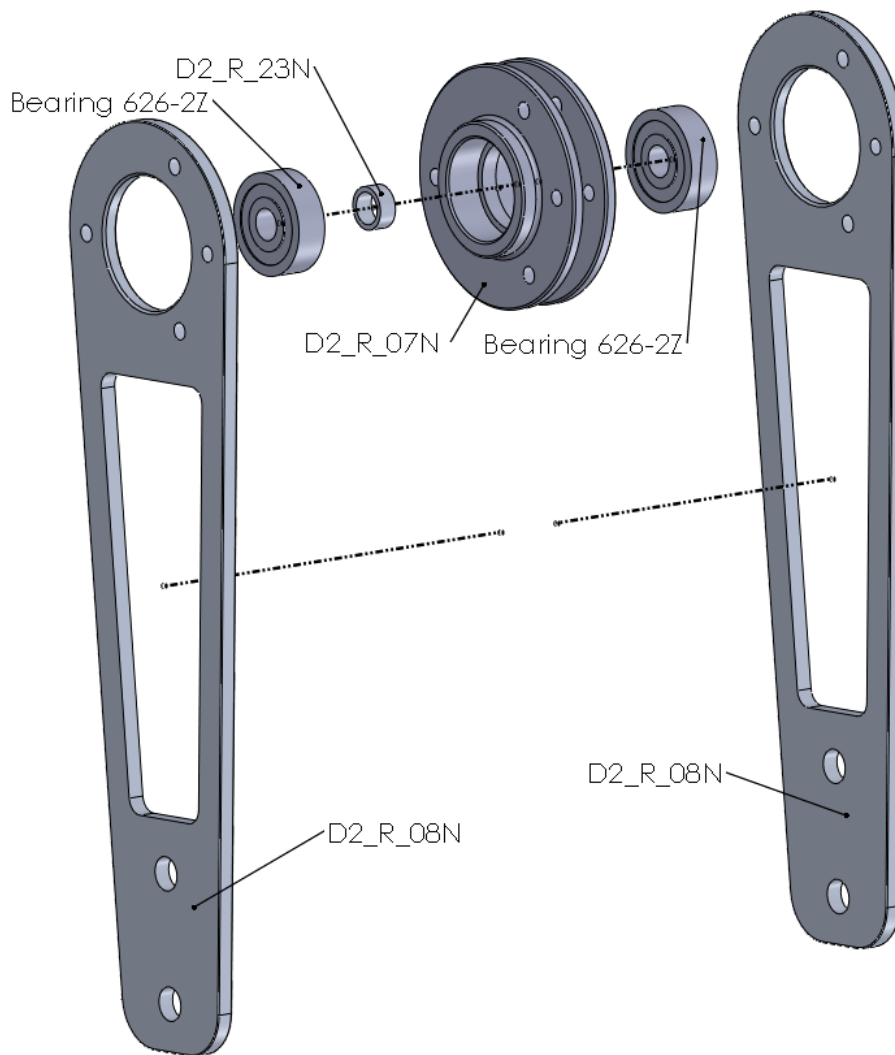
Step 5



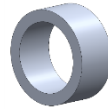
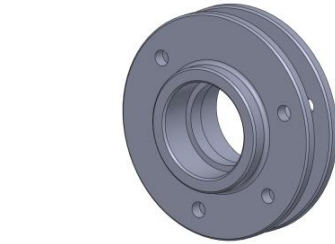
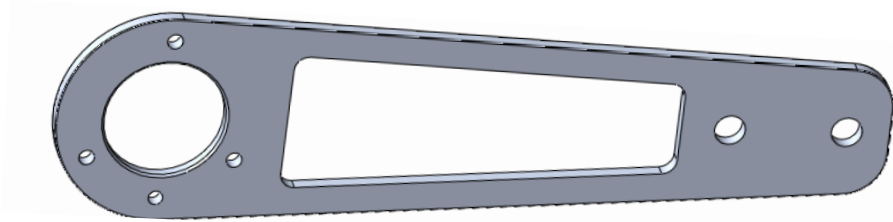
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Part: D2_R_08N
Quantity: 2 piece

Part: D2_R_07N
Quantity: 1 piece

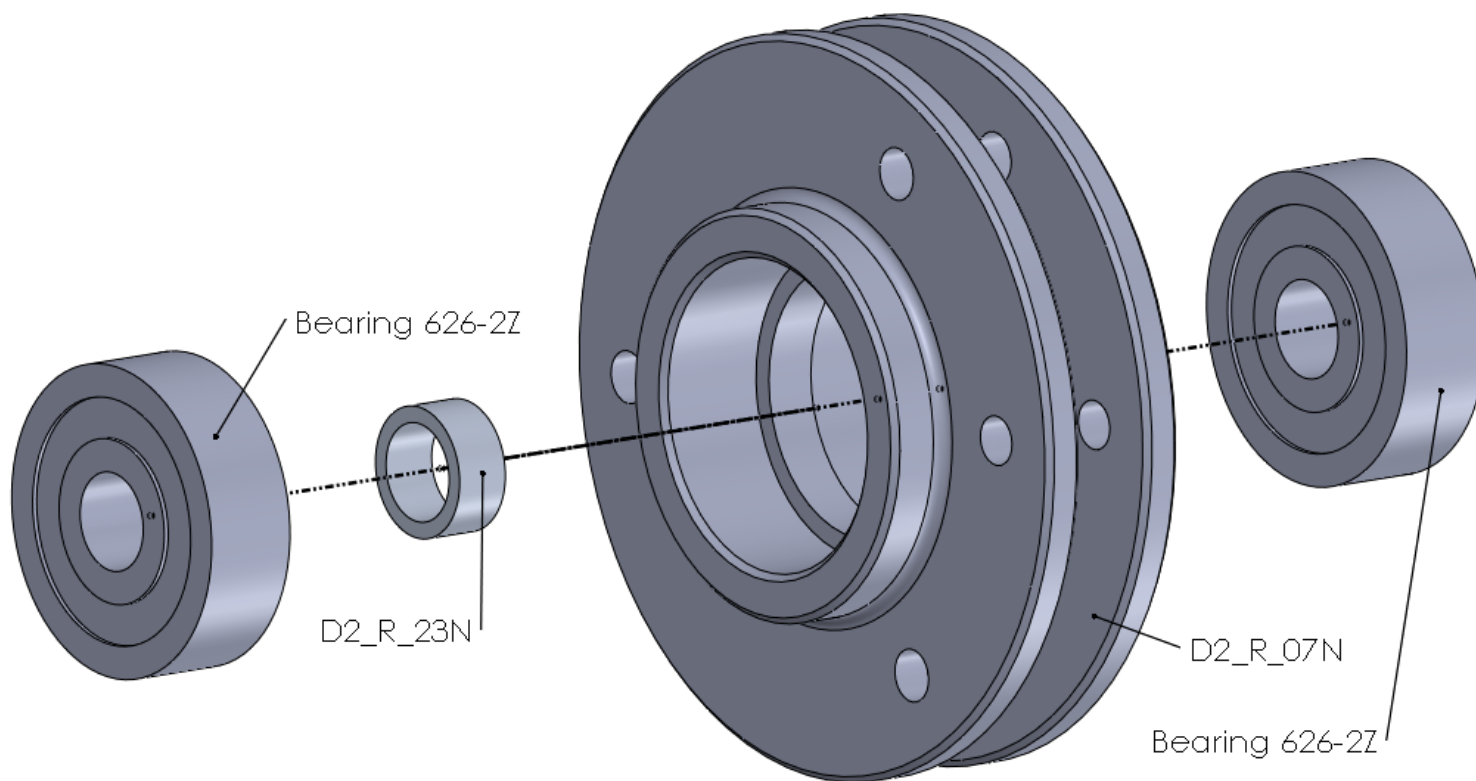
Part: D2_R_23N
Quantity: 1 piece

Standard Parts		
Detail picture	Part	Quantity
	Bearing 626-2Z	2
	Blind rivets AVEX Ø 3,2x9,5 AL/st	6

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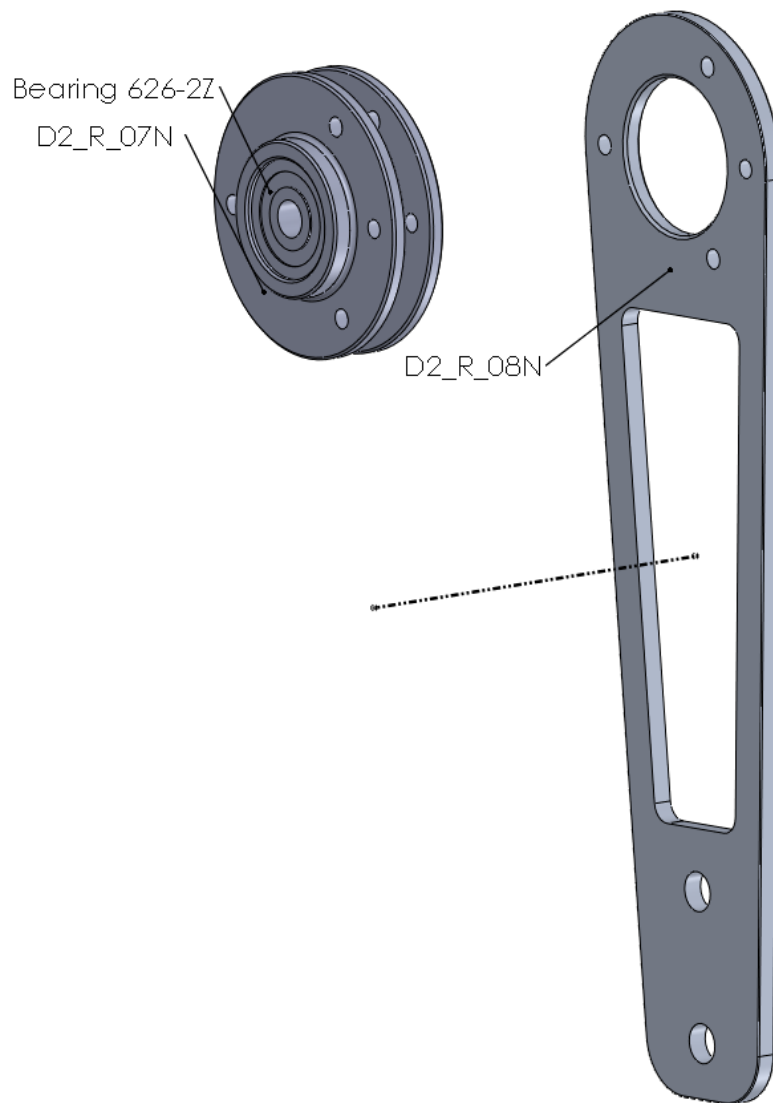
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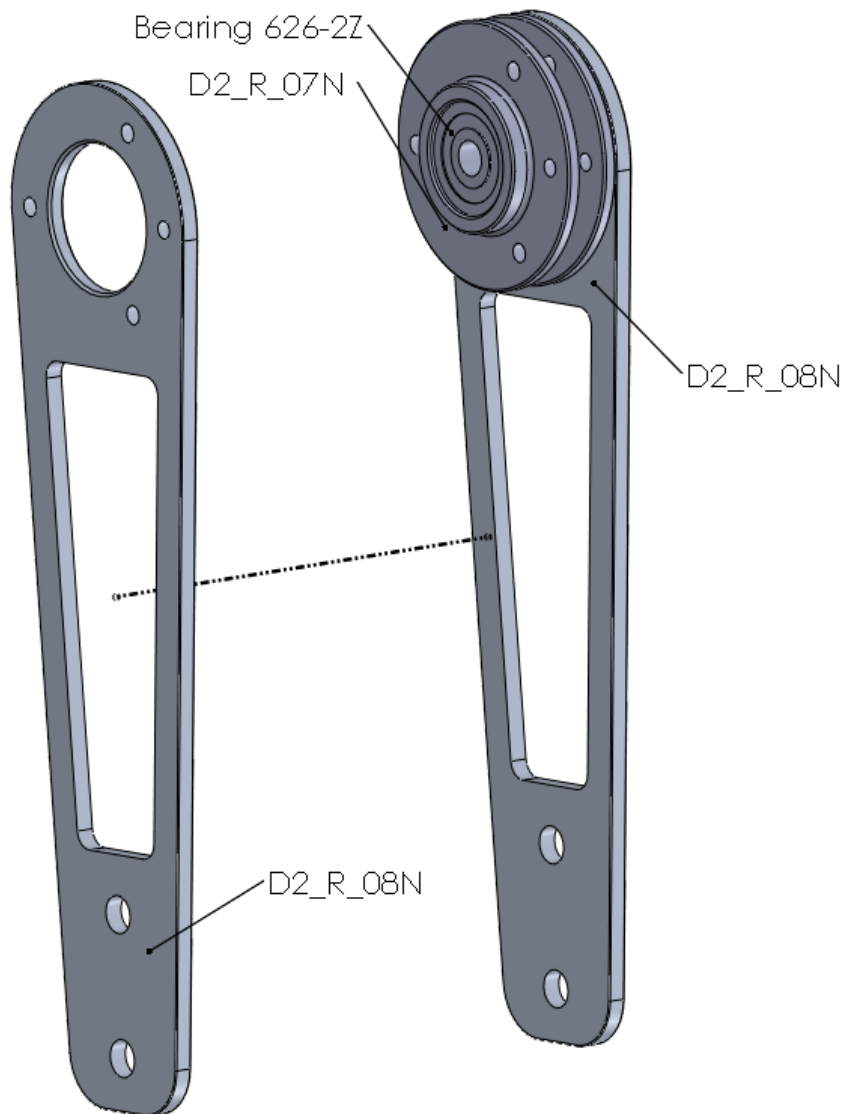
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Step 3



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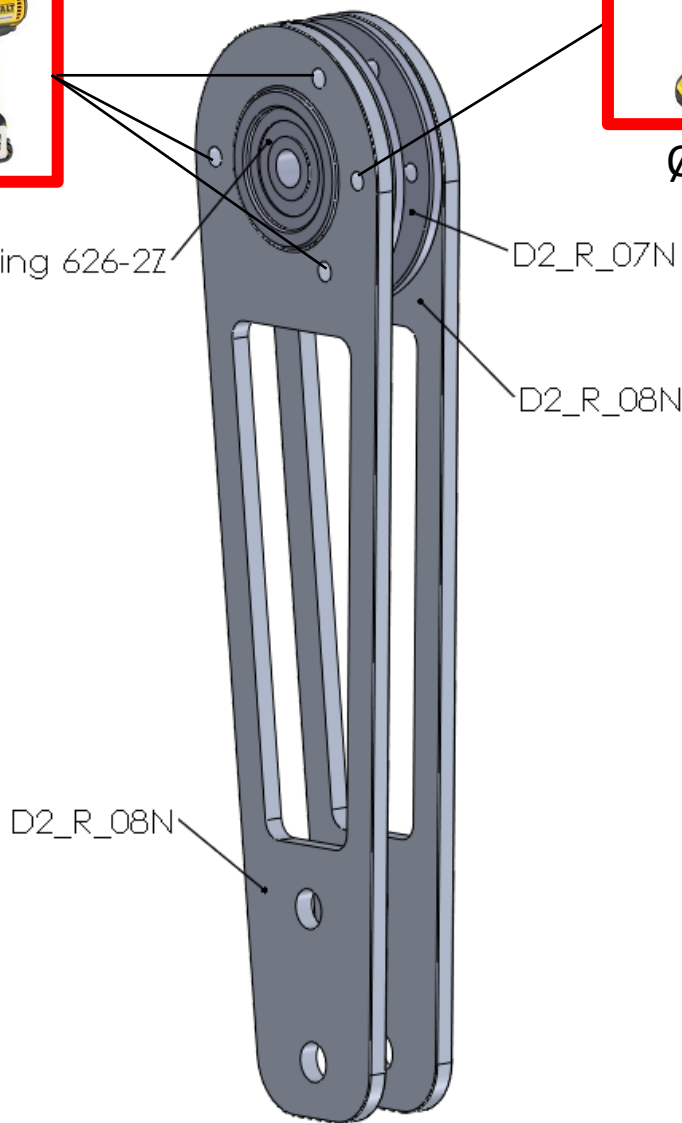


Ø3,2

Bearing 626-2Z



Ø3,0

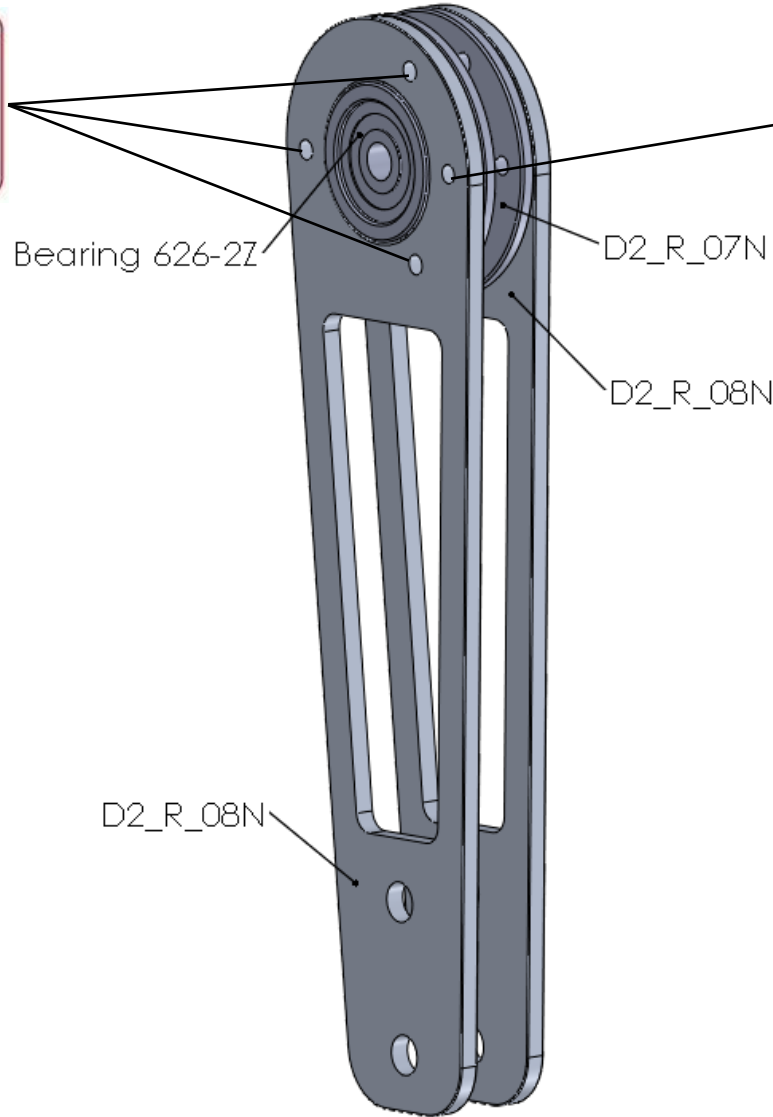


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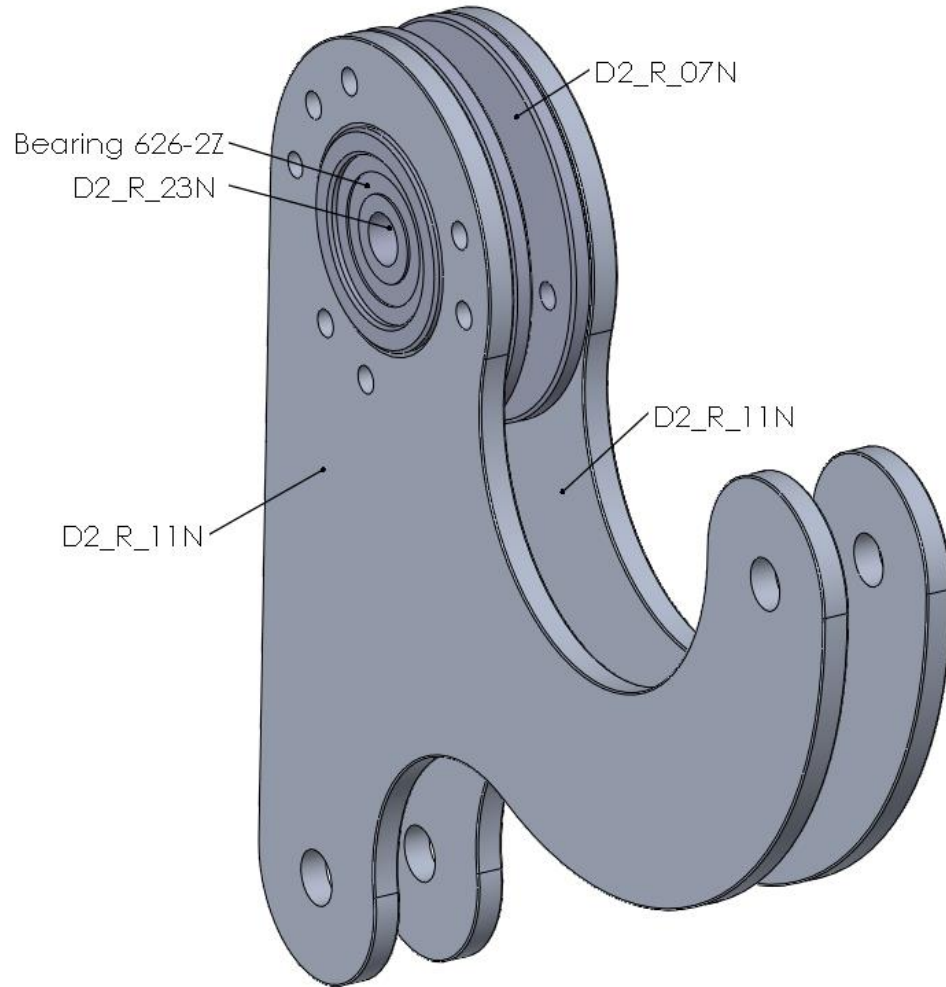


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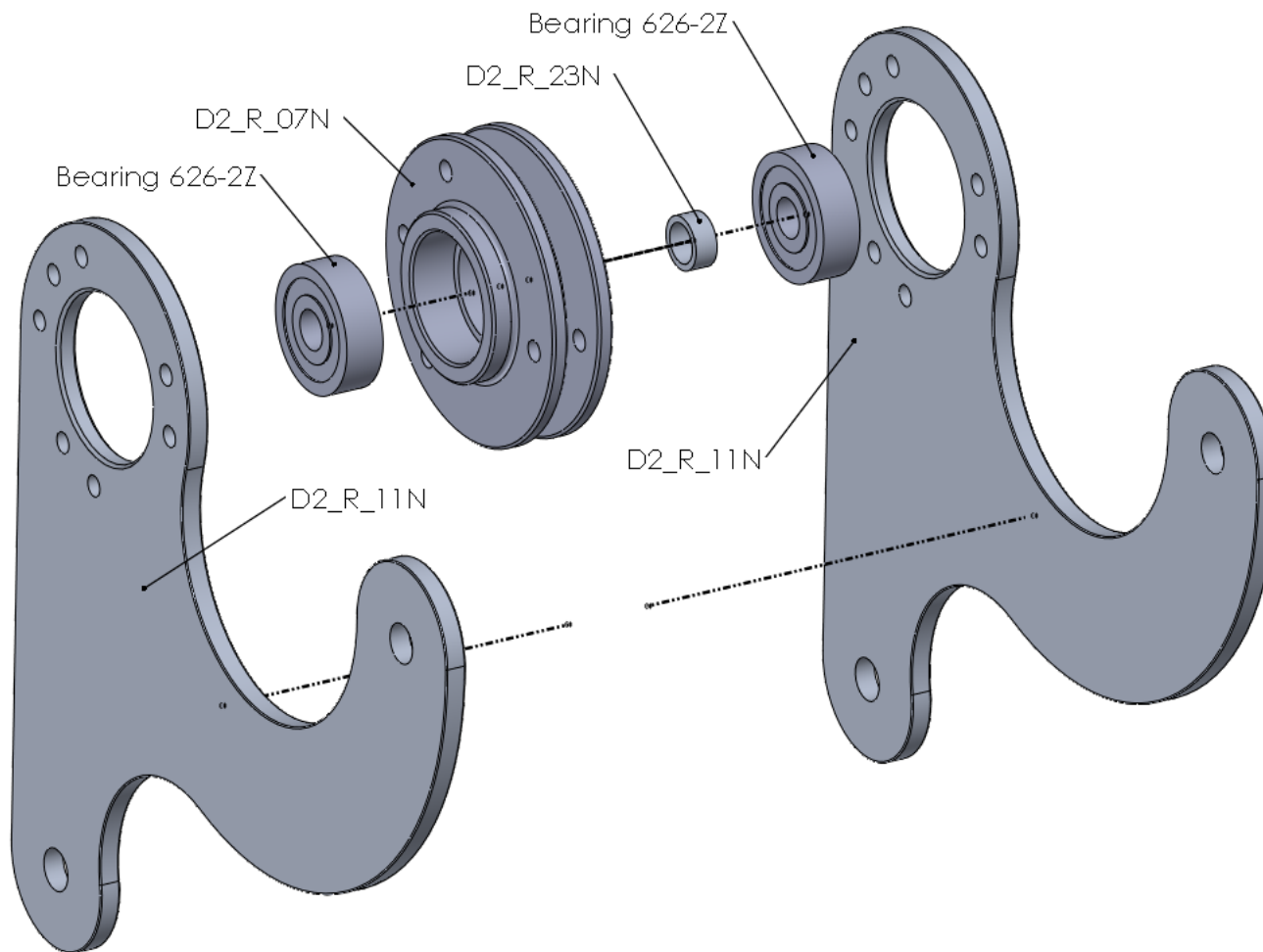
3+3 x Rivet
AVEX 3,2x9,5 Al/St



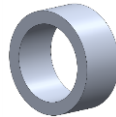
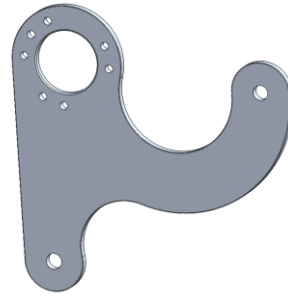
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Part: D2_R_11N
Quantity: 2

Part: D2_R_07N
Quantity: 1

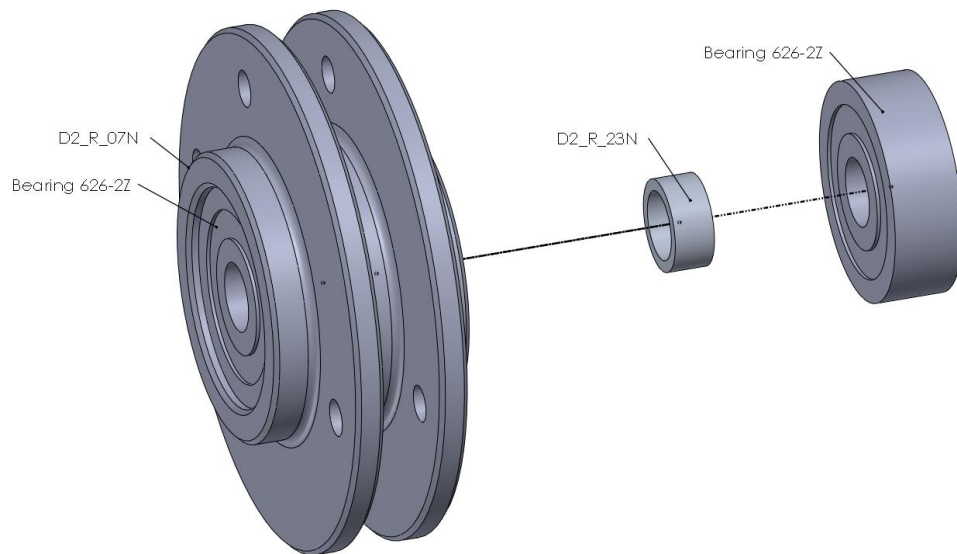
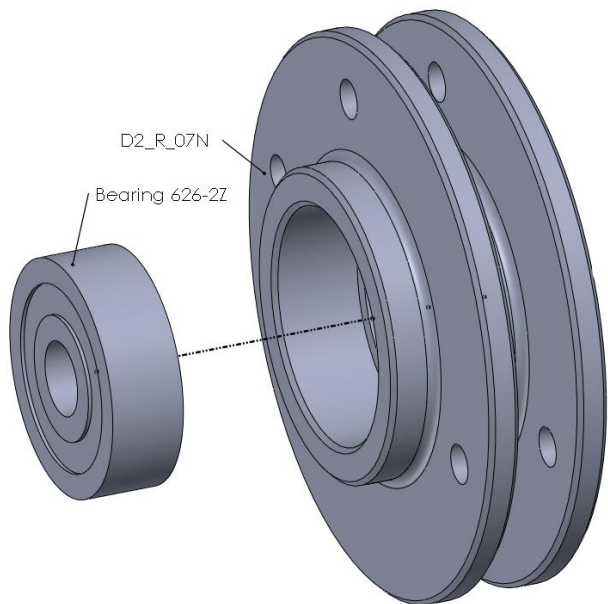
Part: D2_R_23N
Quantity: 1

Standard Parts		
Detail picture	Part	Quantity
	Bearing 626-2Z	2
	Blind rivets AVEX Ø 3,2x9,5 AL/st	6

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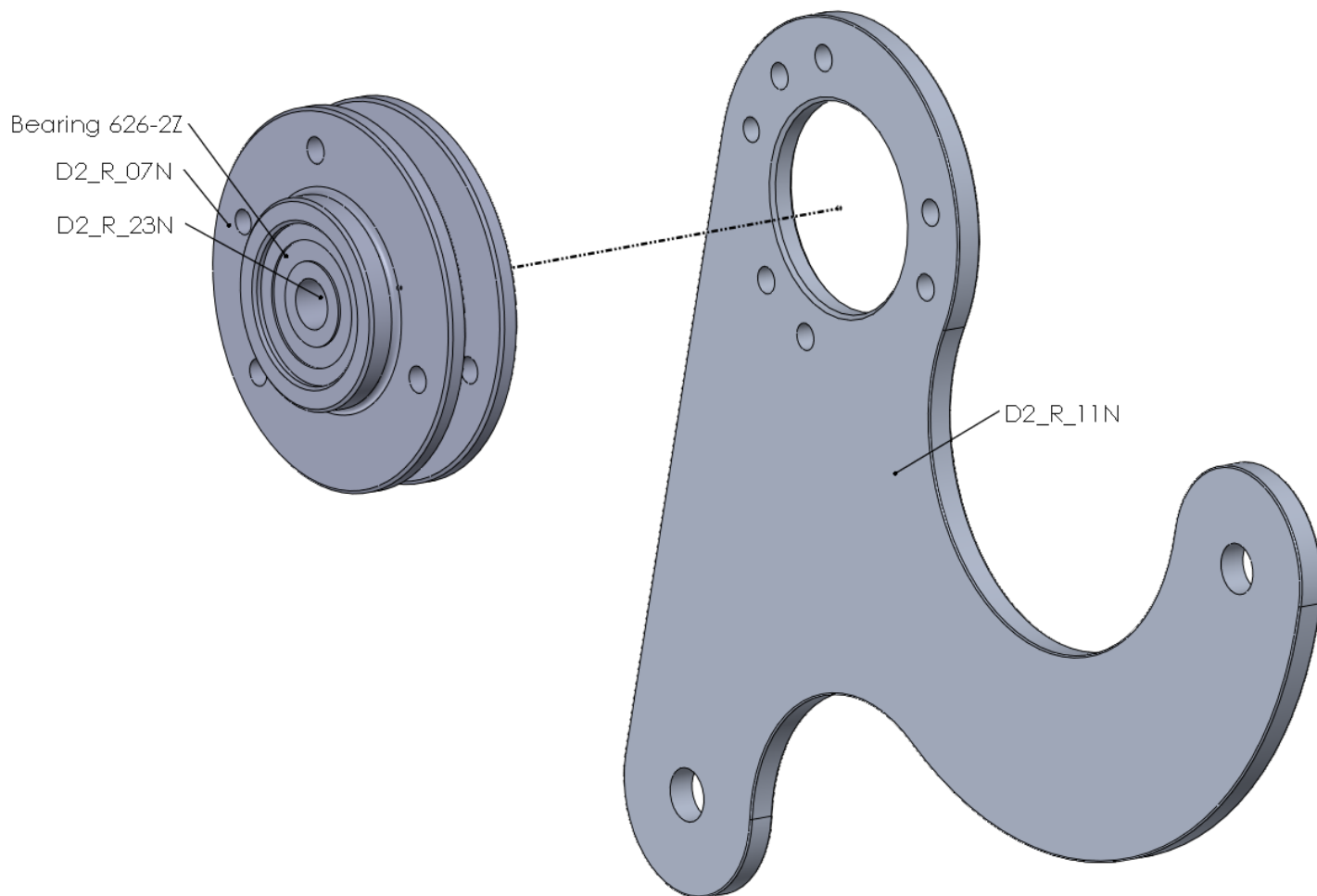
Step 1



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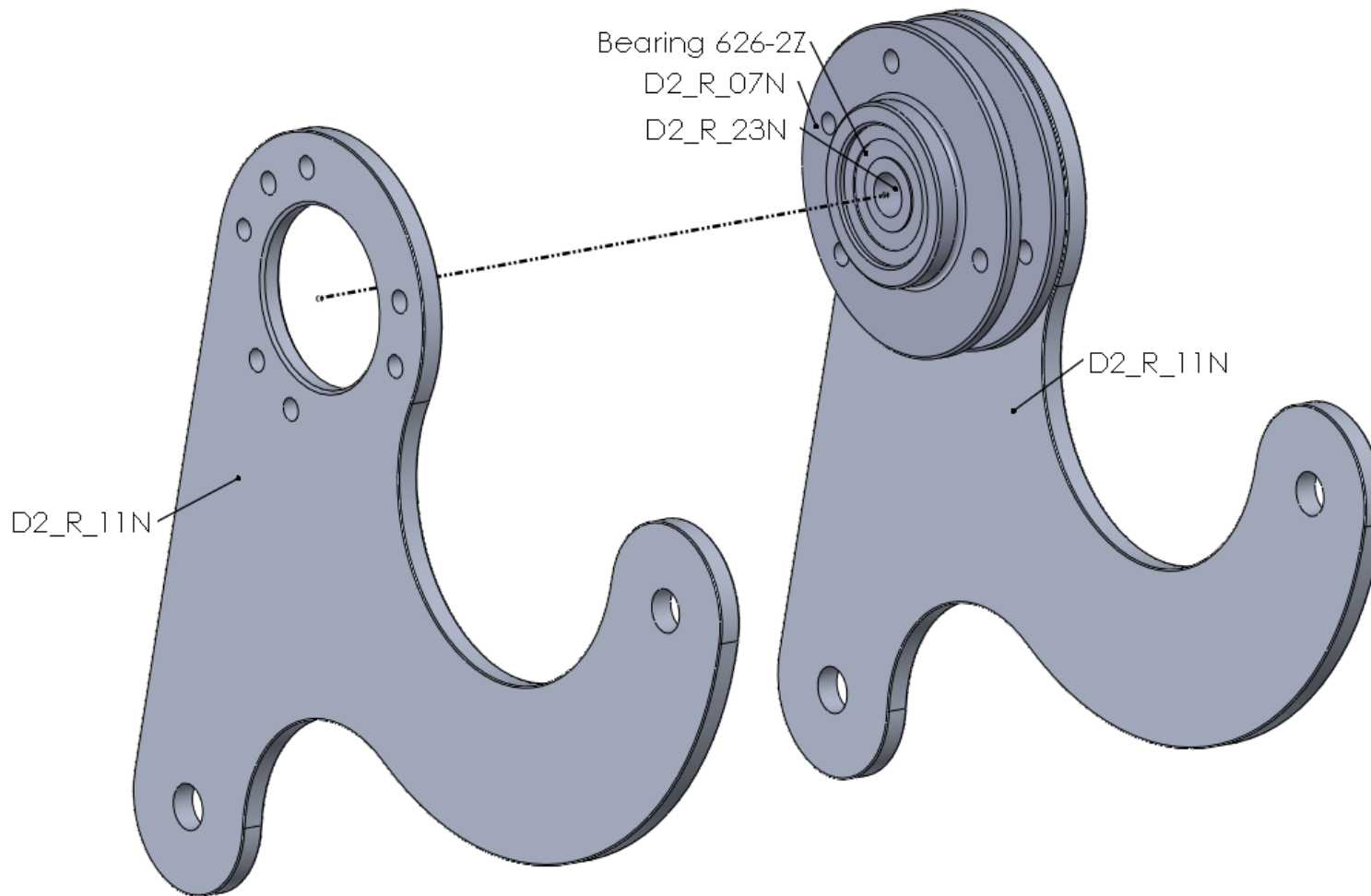
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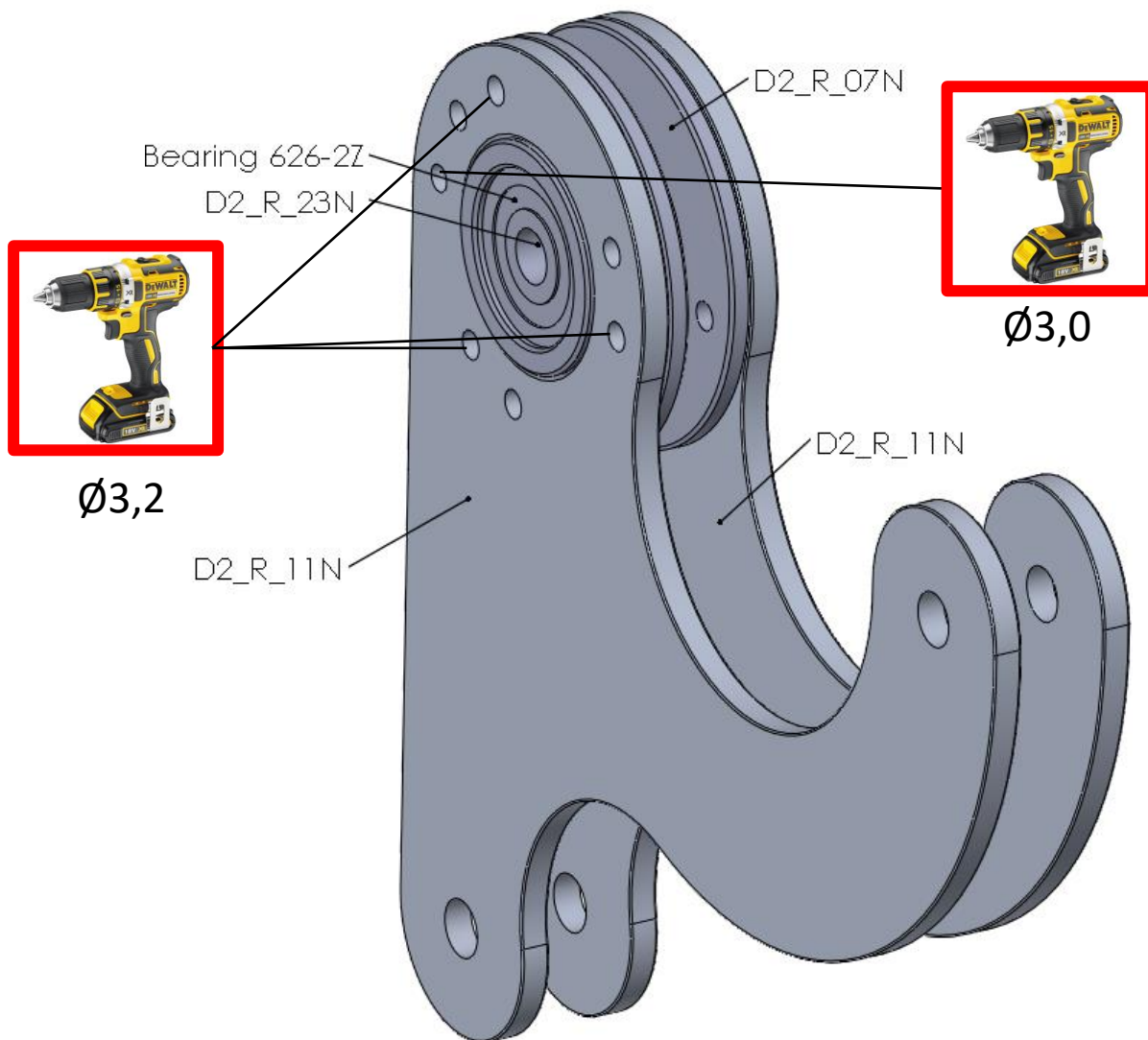
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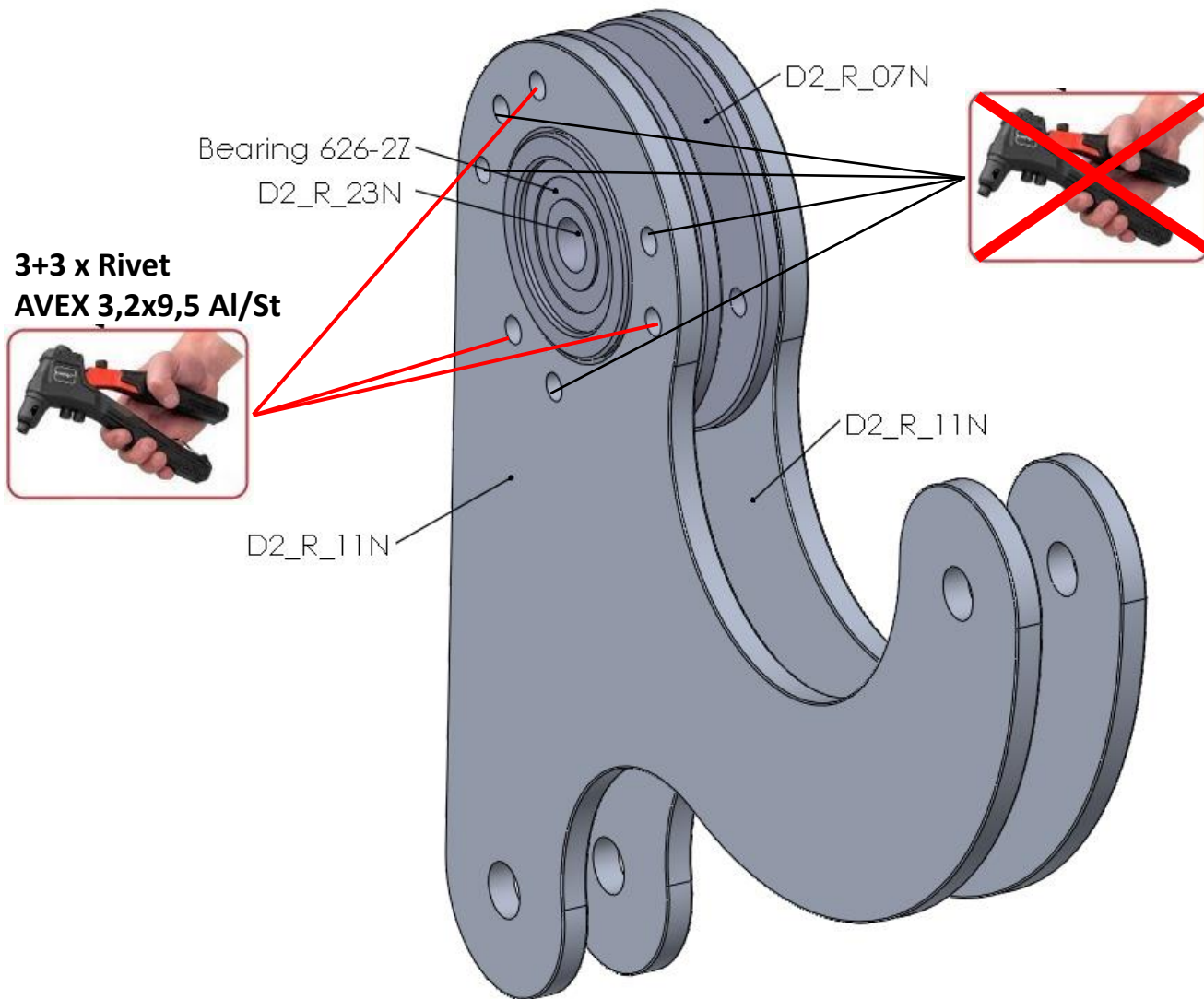
Step 4



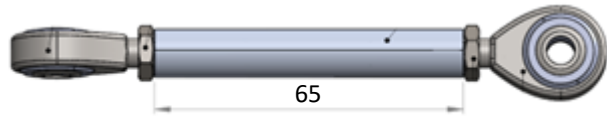
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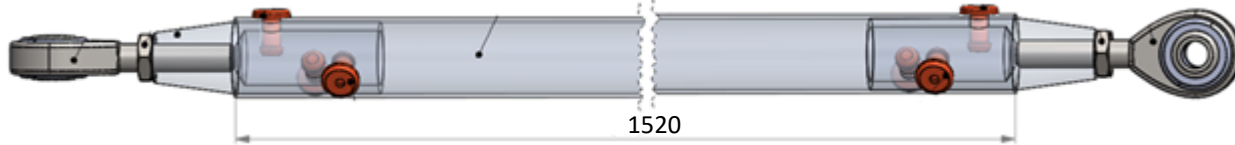


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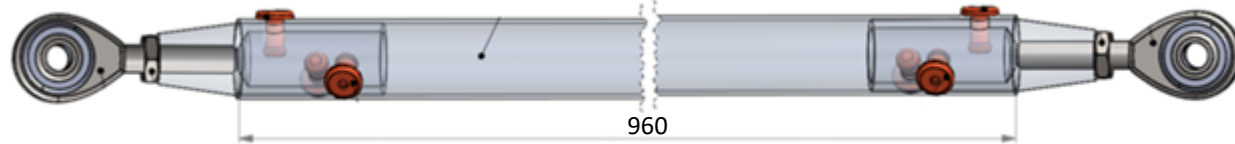
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Aileron pushrod 1



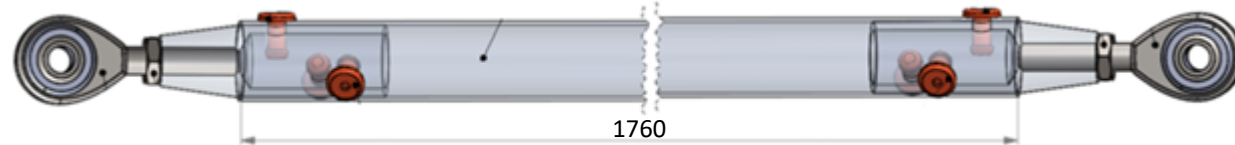
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Aileron pushrod 2



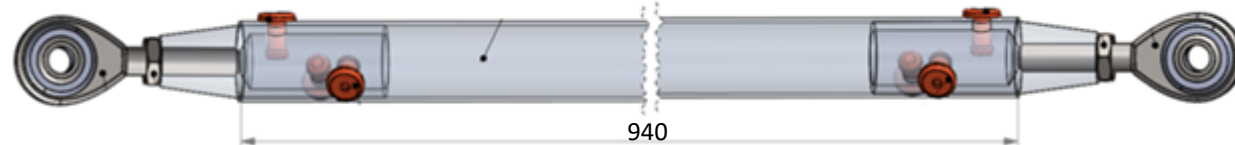
960

Elevator pushrod 1



1760

Elevator pushrod 2



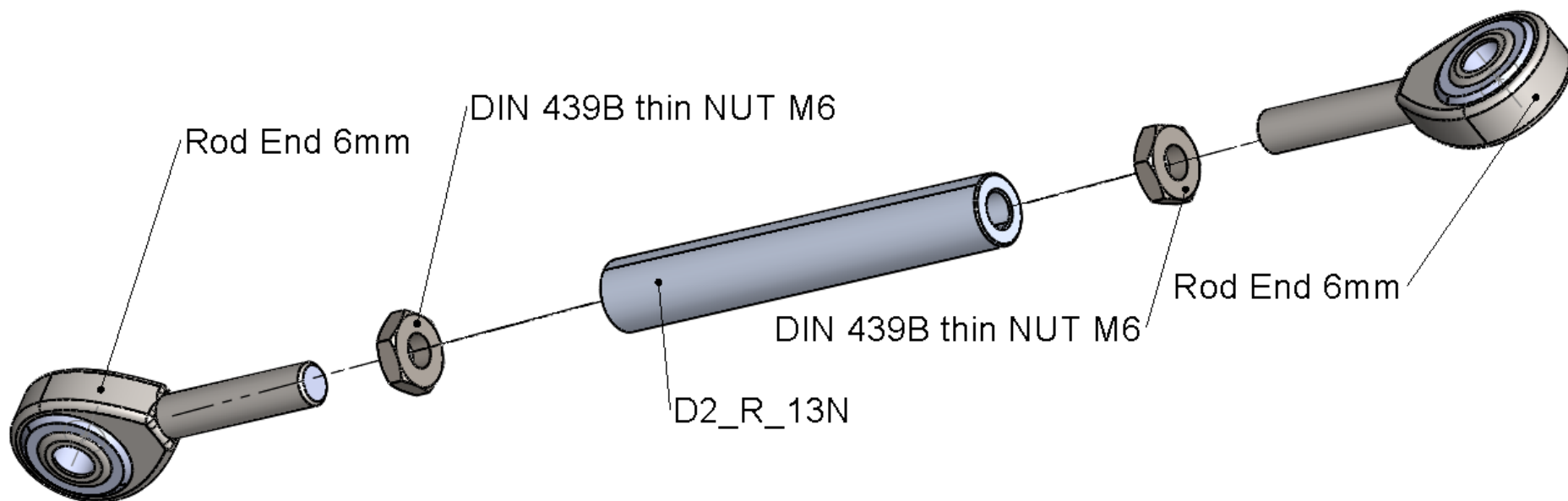
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Elevator pushrod 3

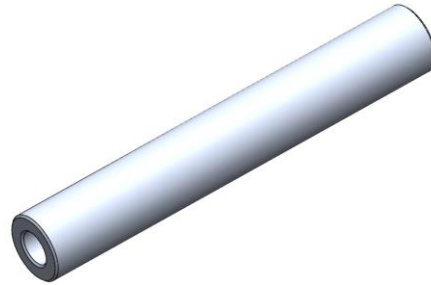
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Aileron pushrod 1
Quantity: 2

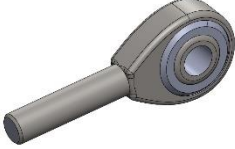
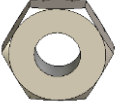


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Part: D2_R_13N

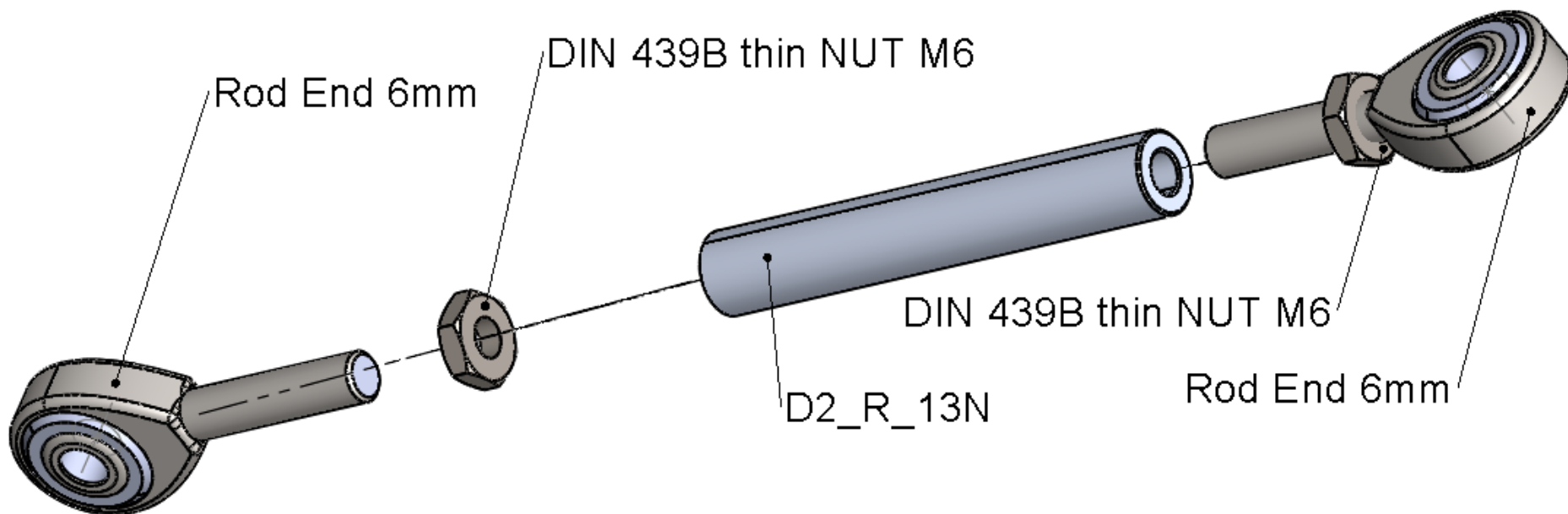
Quantity: 1+1

Standard Parts		
Detail picture	Part	Quantity
	MM4	2+2
	DIN 439B M6	2+2

Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	48	121



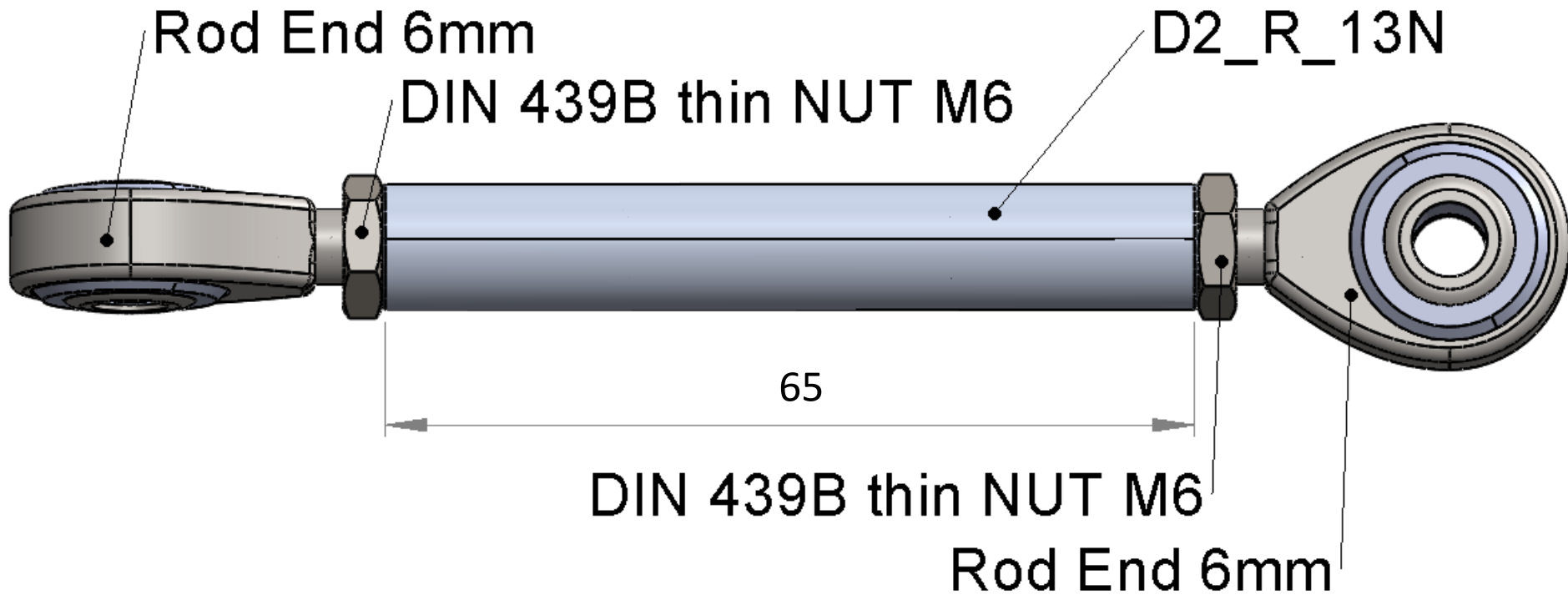
Step 1



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Control system assembly manual	D2_R0_00	Rev. 05	49	121



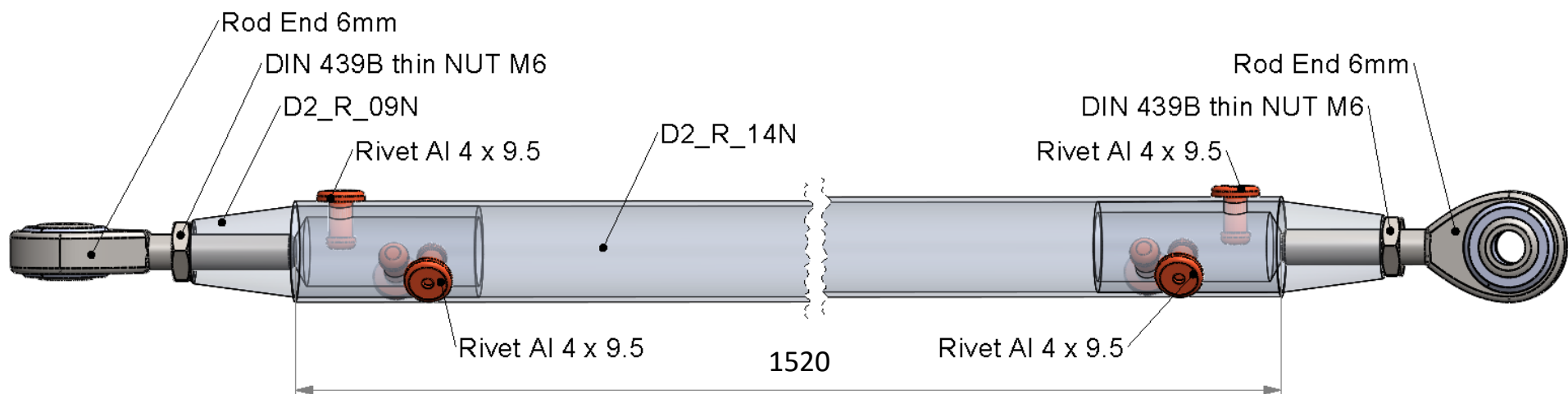
Step 2



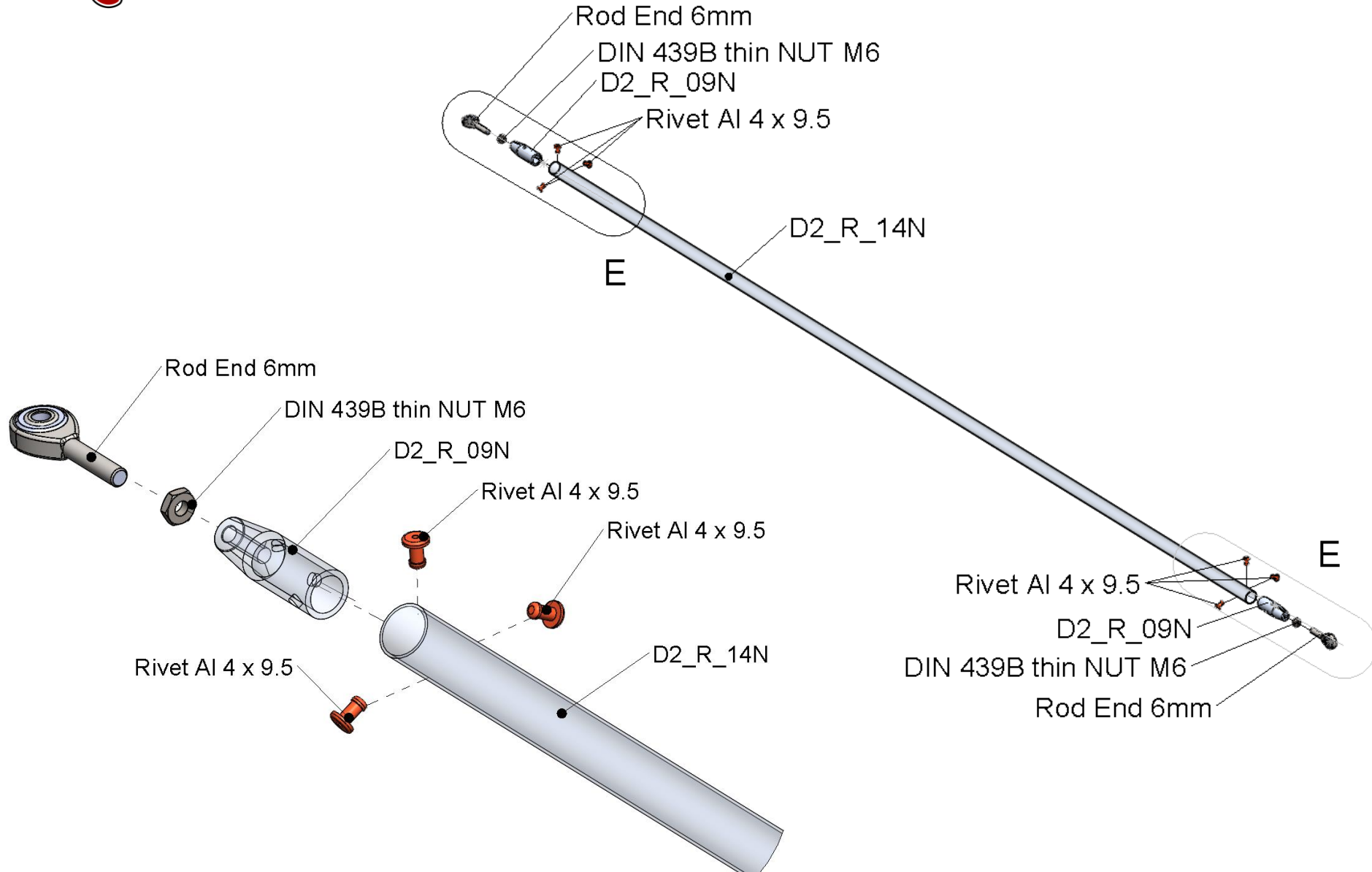
Title	Document no.	Revision	Page	Pages
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Aileron pushrod 2
Quantity: 2



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	51	121

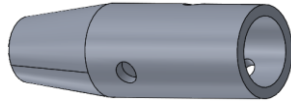


Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	52	121



Part: D2_R_09N

Quantity: 2+2

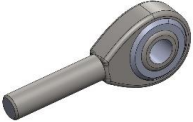




Part: D2_R_14N

Quantity: 1+1



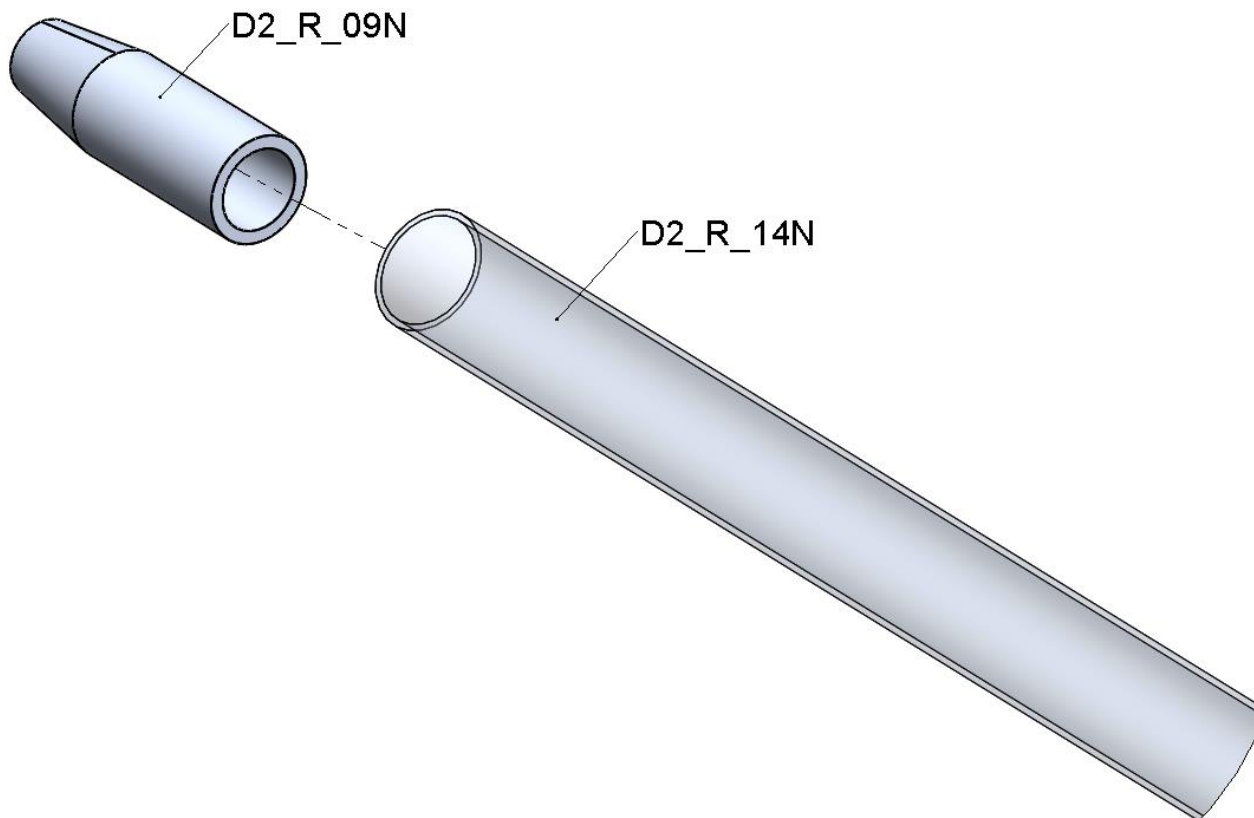
Standard Parts

Detail picture	Part	Quantity
	MM4	2+2
	Blind rivets AVEX Ø 4x9,5 Al/St	6+6
	DIN 439B M6	2+2

Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	53	121



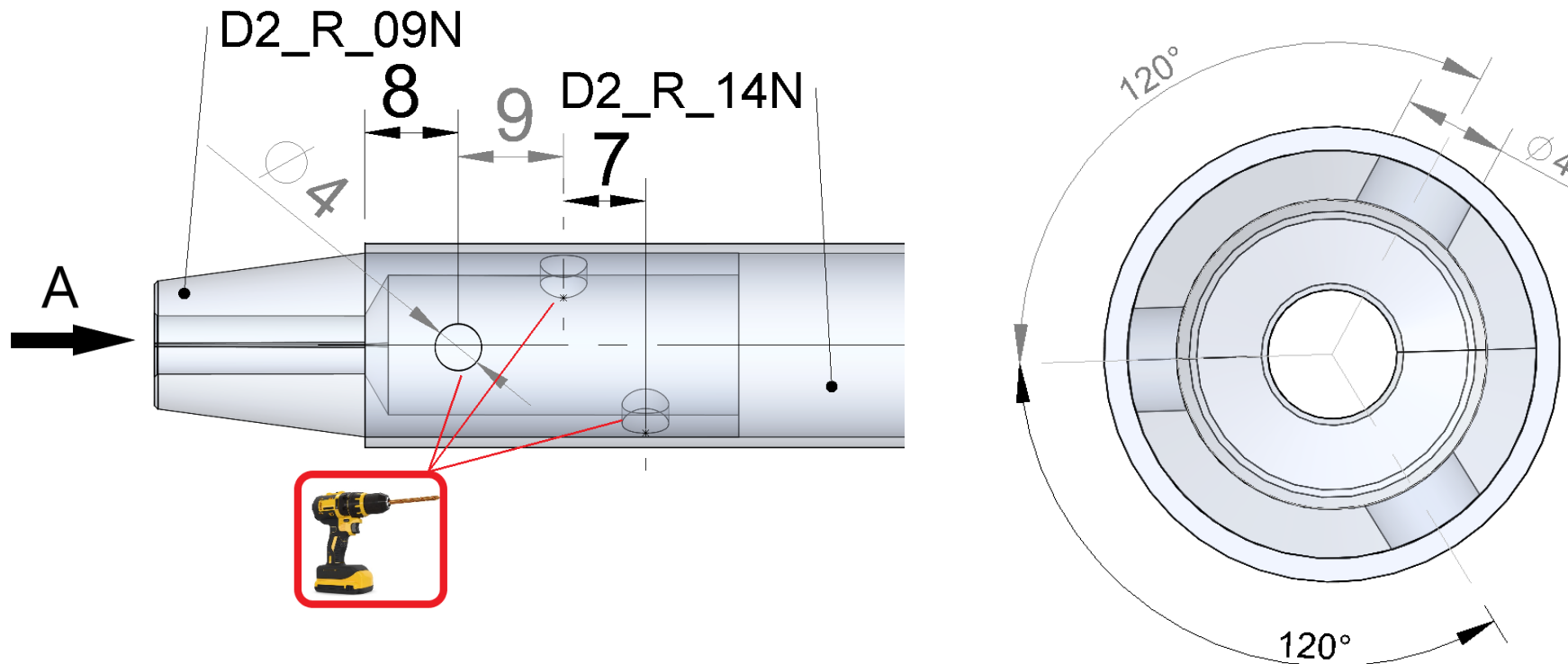
Step 1



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	54	121



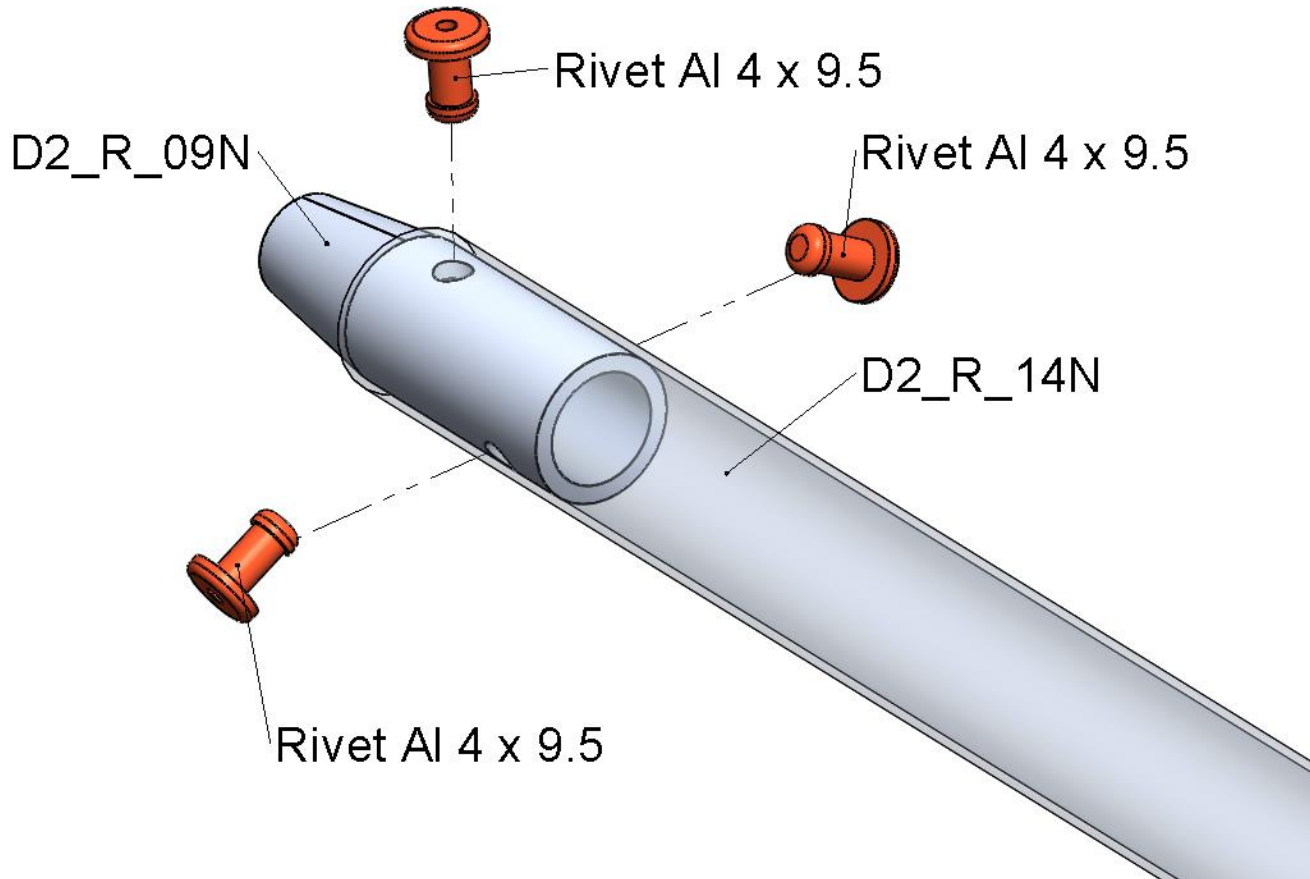
Step 2



Title	Document no.	Revision	Page	Pages
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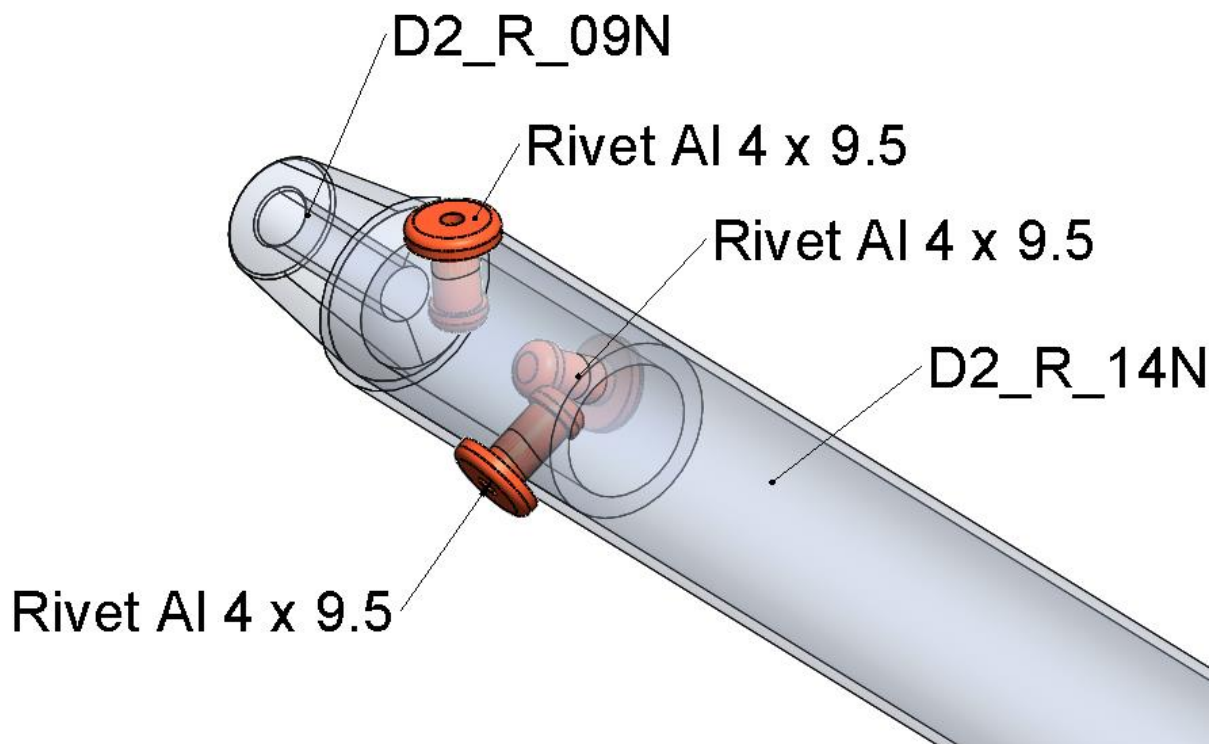
Step 3



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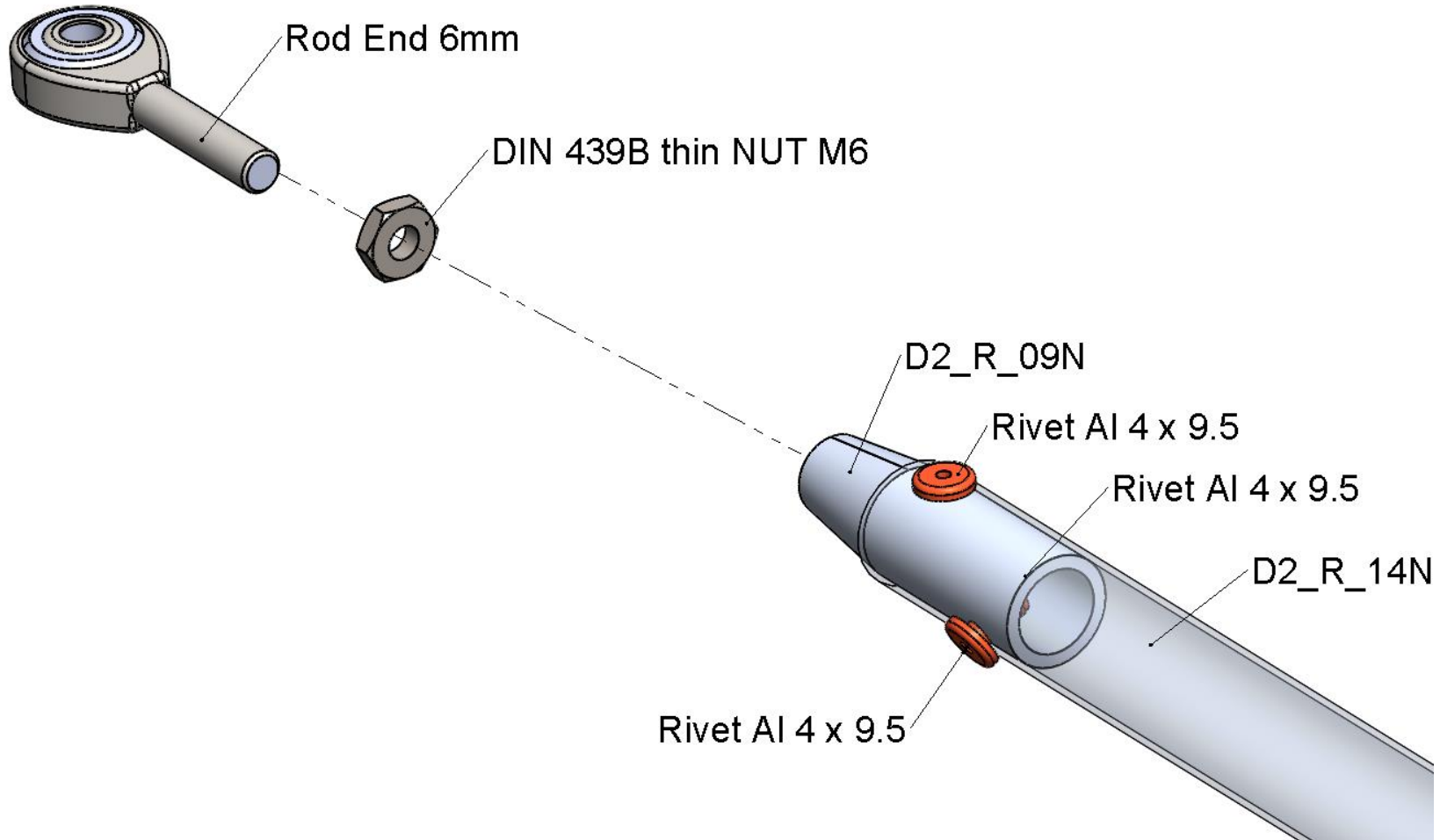
Step 4



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	57	121



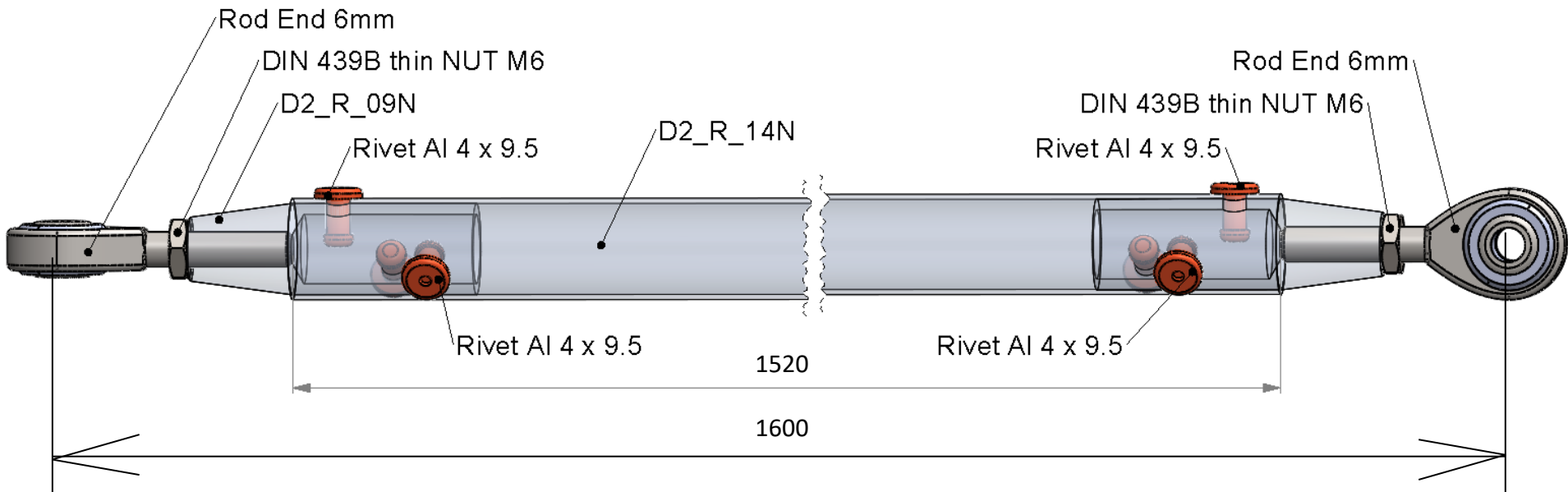
Step 5



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	58	121



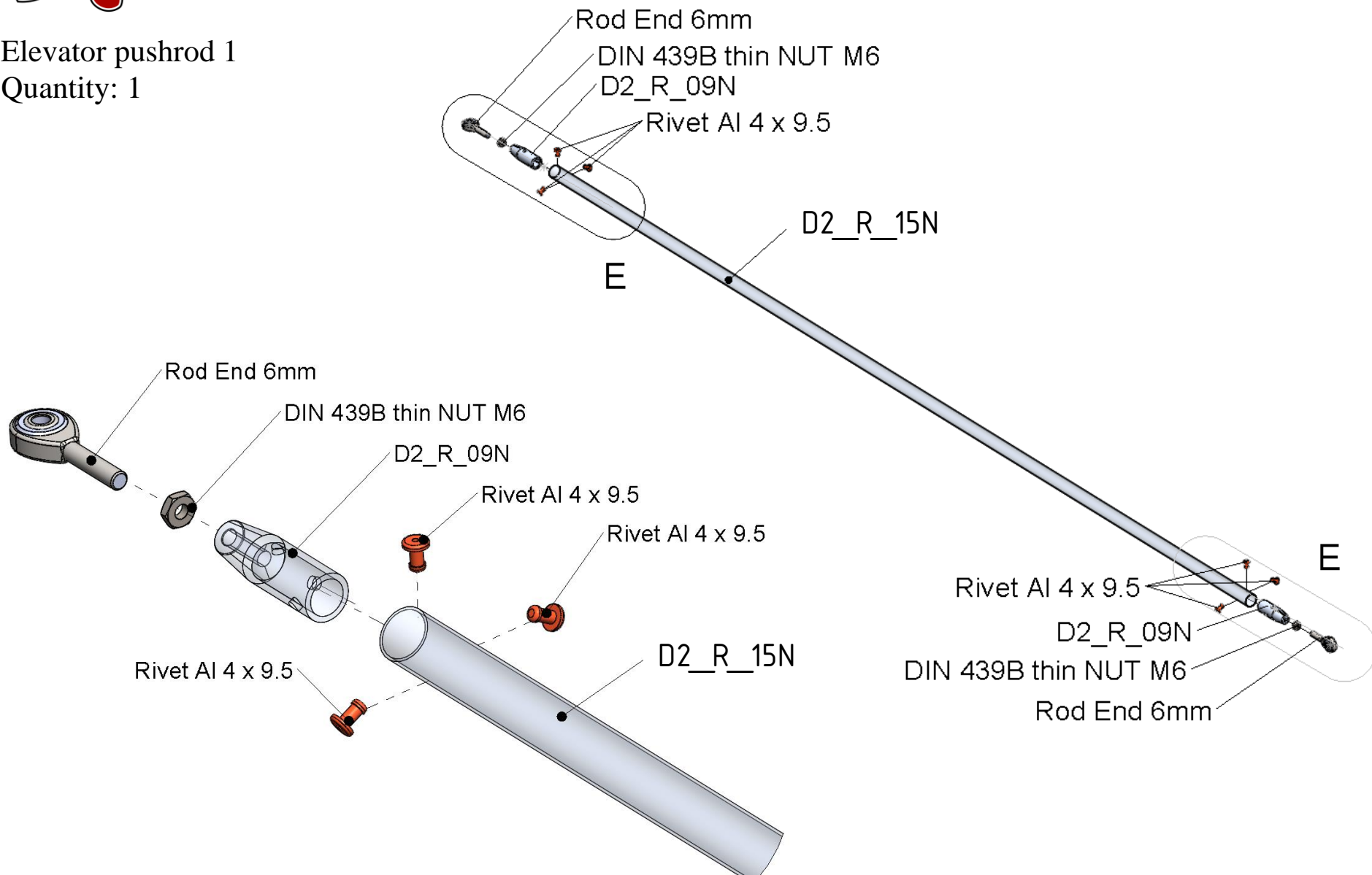
Step 6



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	59	121



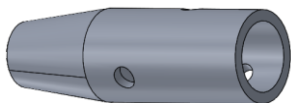
Elevator pushrod 1
Quantity: 1



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	60	121



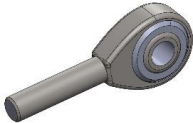


Part: D2_R_09N
Quantity: 2



Part: D2_R_15N
Quantity: 1



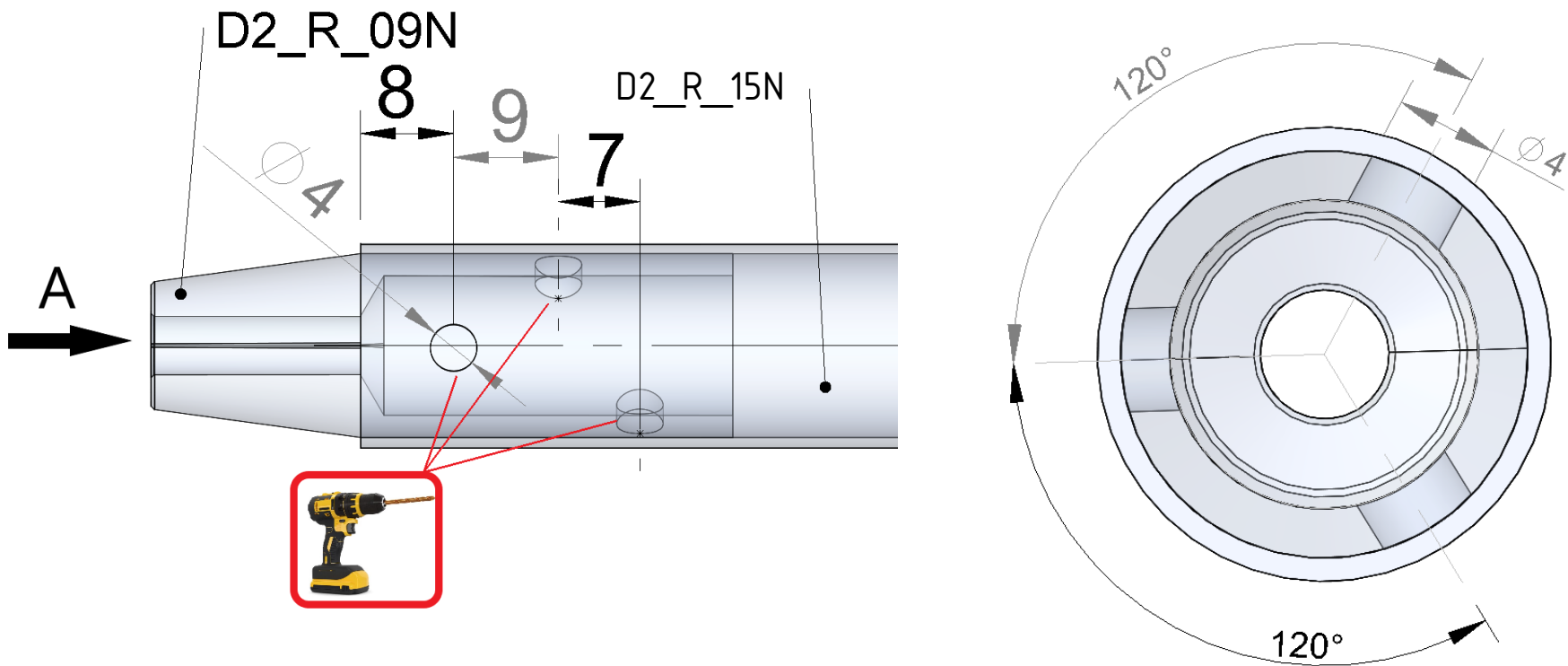
Standard Parts

Detail picture	Part	Quantity
	MM4	2
	Blind rivets AVEX Ø 4x9,5 Al/St	6
	DIN 439B M6	2

Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	61	121



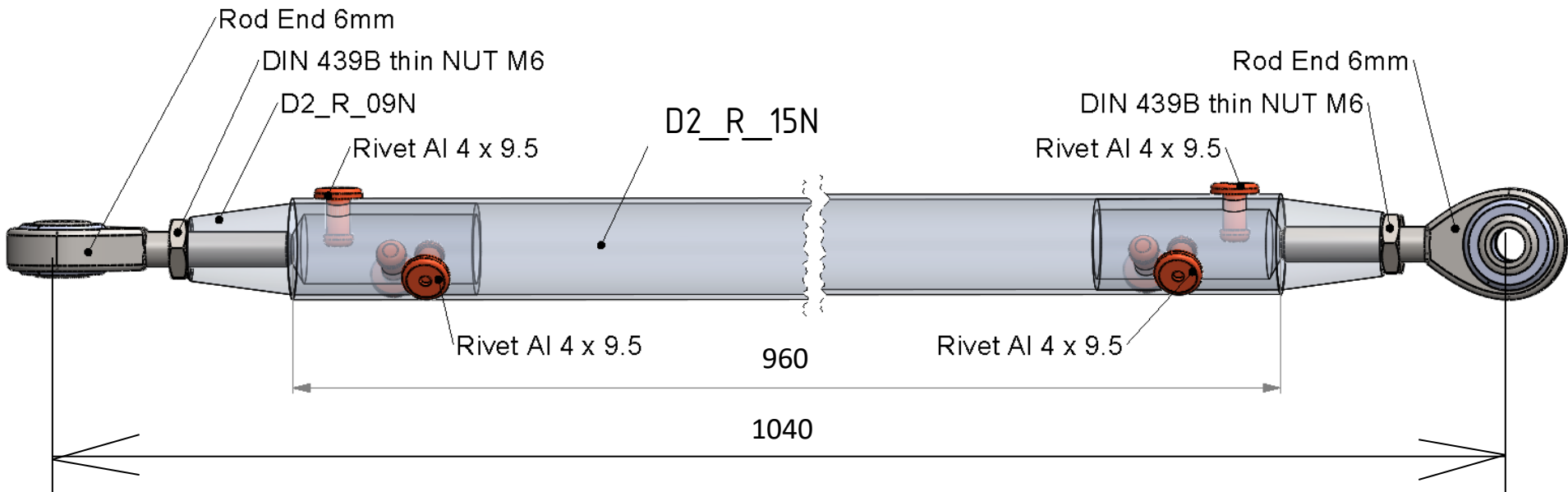
Step 1



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	62	121



Step 2

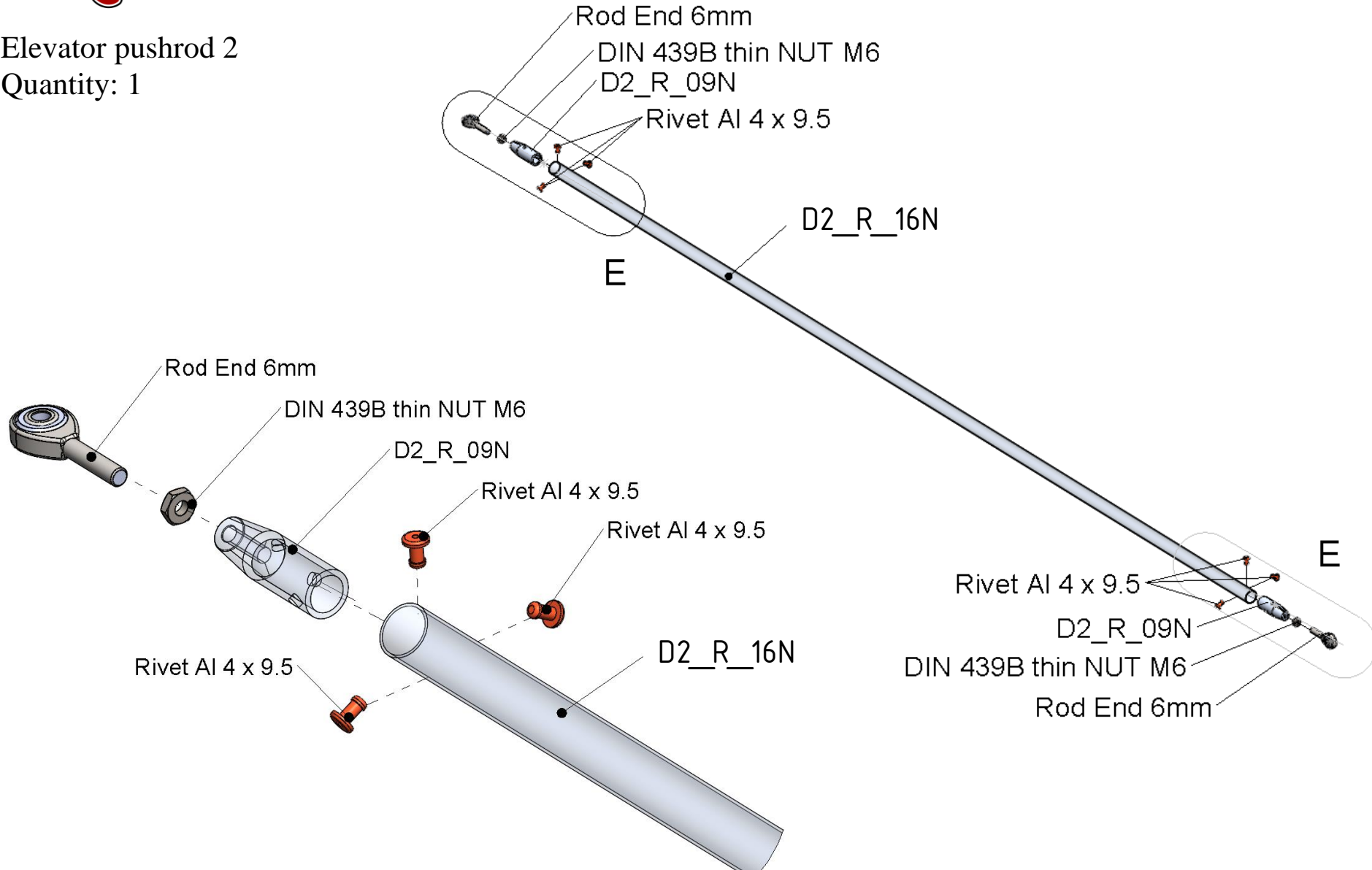


Title	Document no.	Revision	Page	Pages
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Elevator pushrod 2

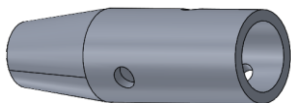
Quantity: 1



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	64	121



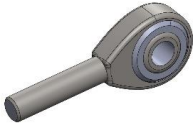


Part: D2_R_09N
Quantity: 2



Part: D2_R_16N
Quantity: 1



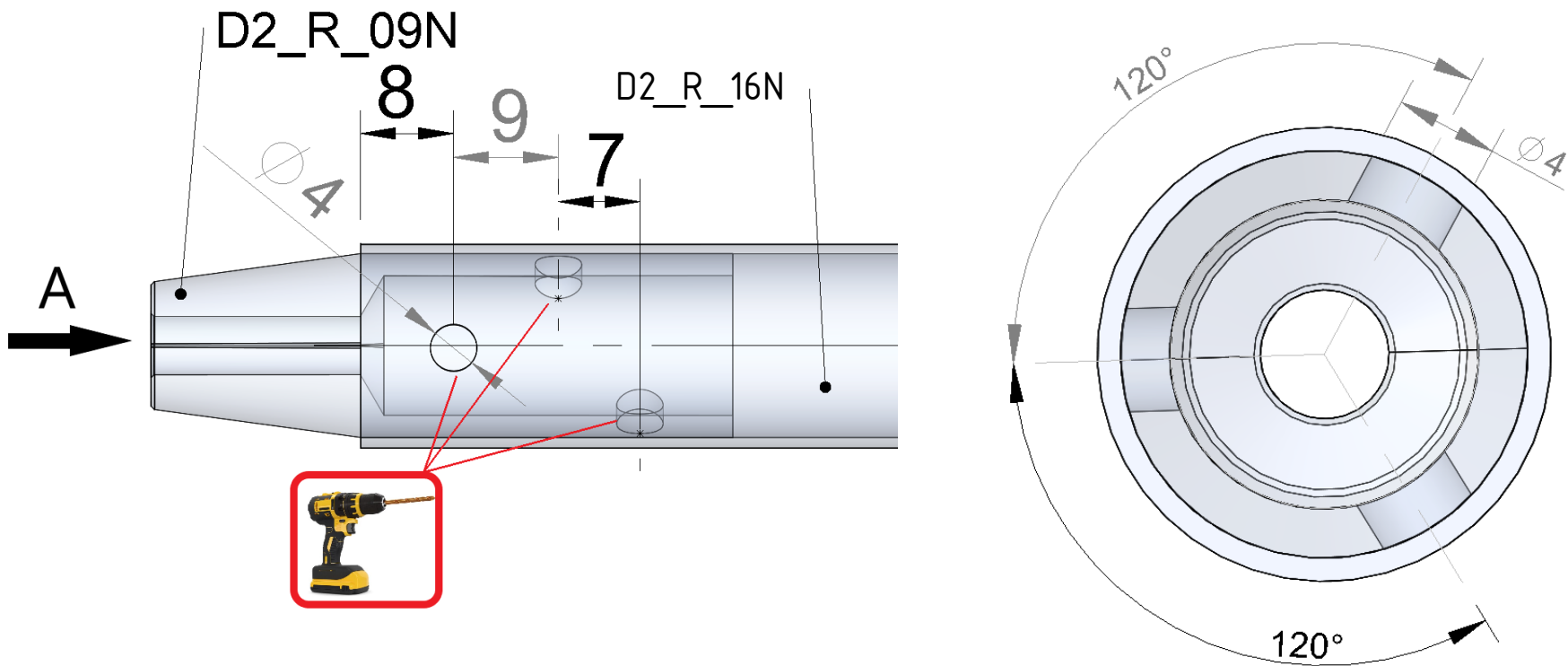
Standard Parts

Detail picture	Part	Quantity
	MM4	2
	Blind rivets AVEX Ø 4x9,5 Al/St	6
	DIN 439B M6	2

Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	65	121



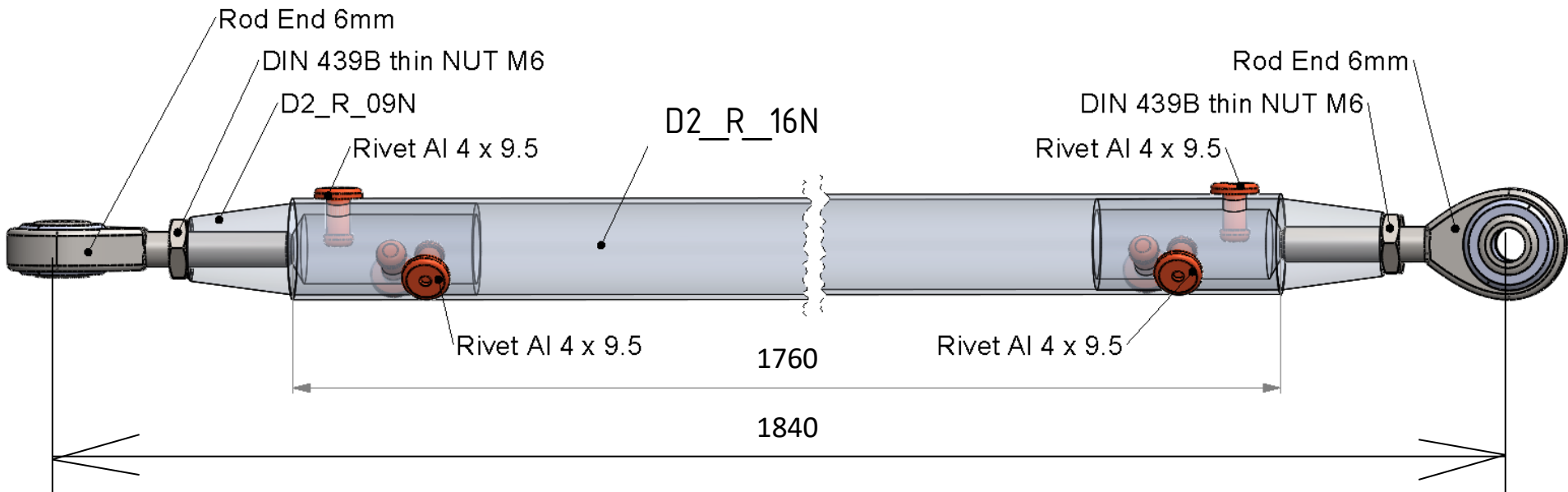
Step 1



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Control system assembly manual	D2_R0_00	Rev. 05	66	121



Step 2

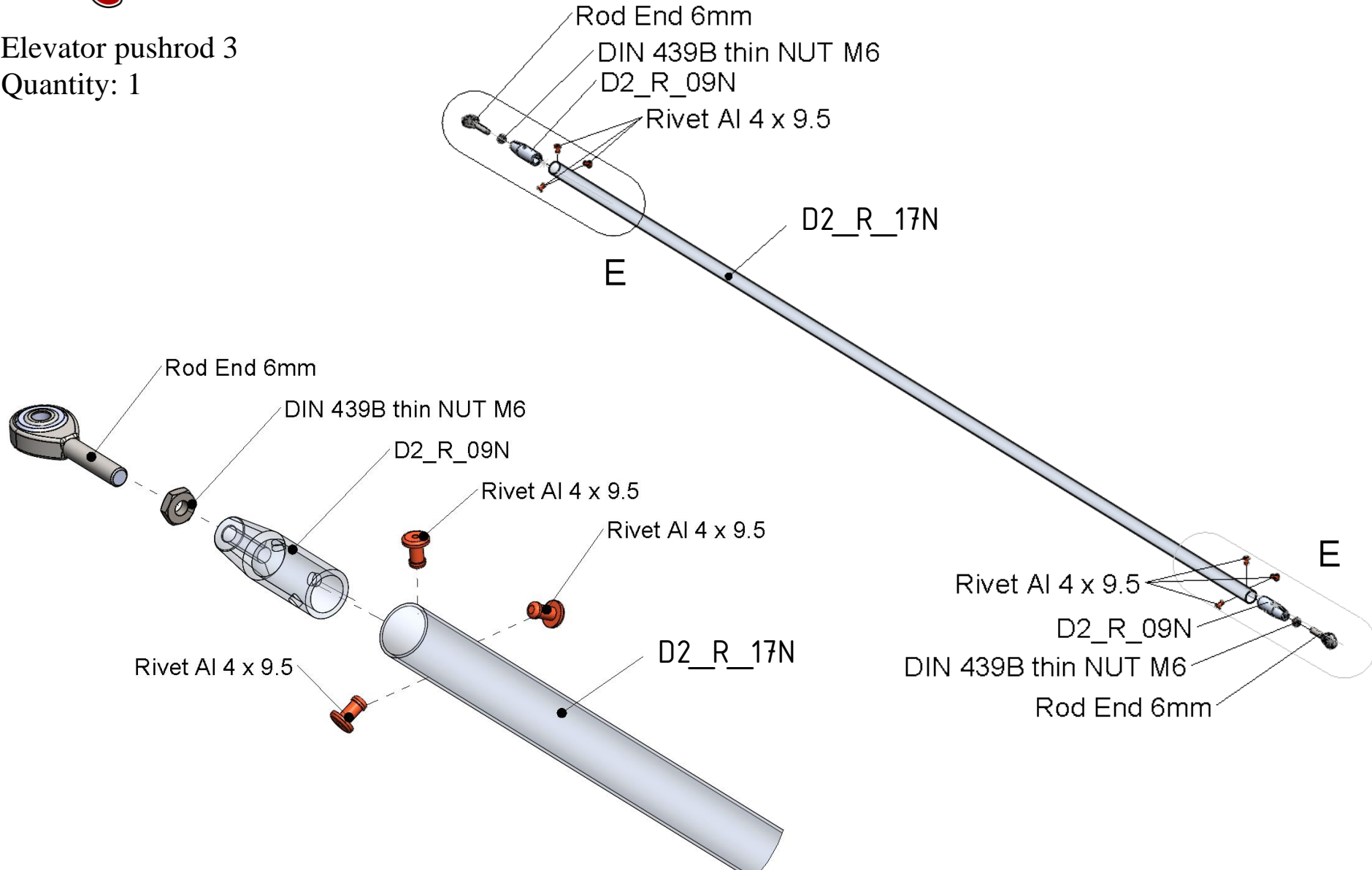


Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	67	121



Elevator pushrod 3

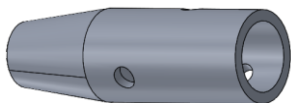
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Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	68	121

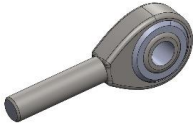




Part: D2_R_09N
Quantity: 2



Part: D2_R_17N
Quantity: 1

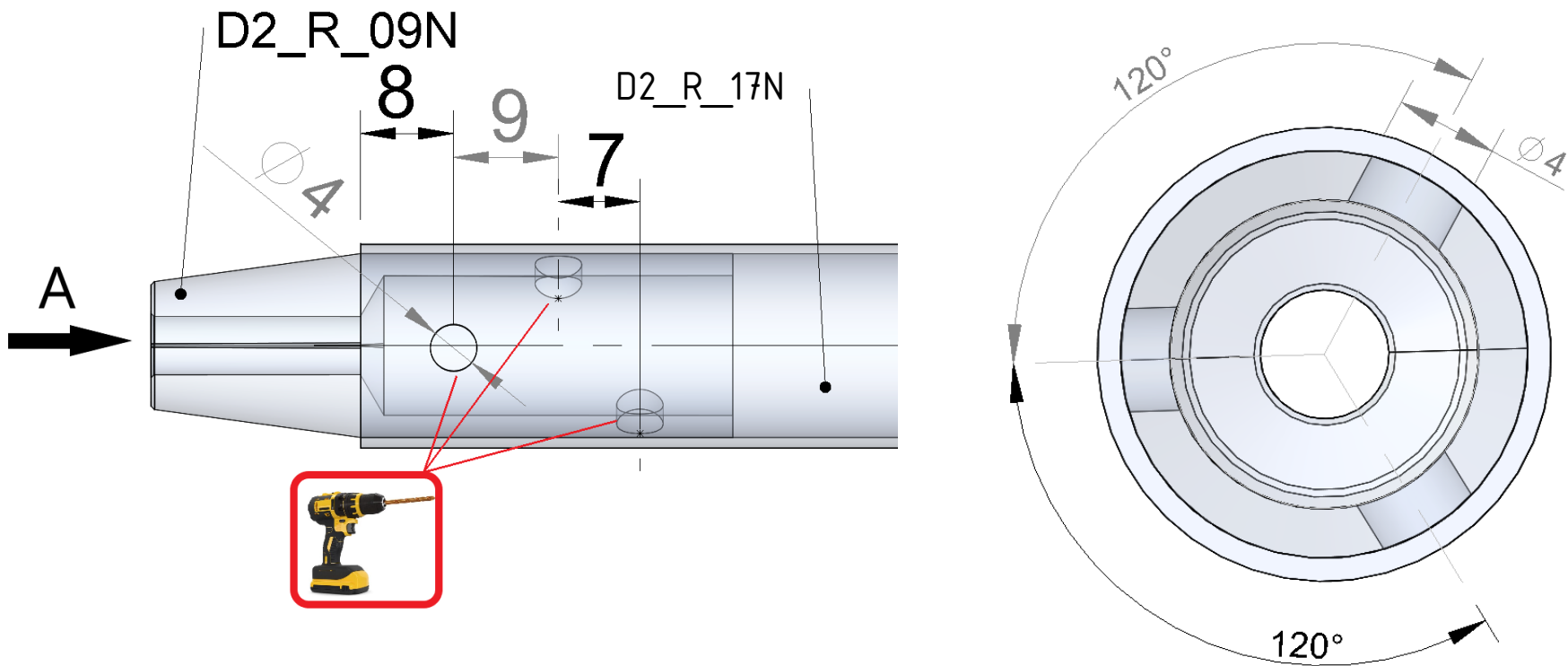


Standard Parts		
Detail picture	Part	Quantity
	MM4	2
	Blind rivets AVEX Ø 4x9,5 Al/St	6
	DIN 439B M6	2

Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	69	121



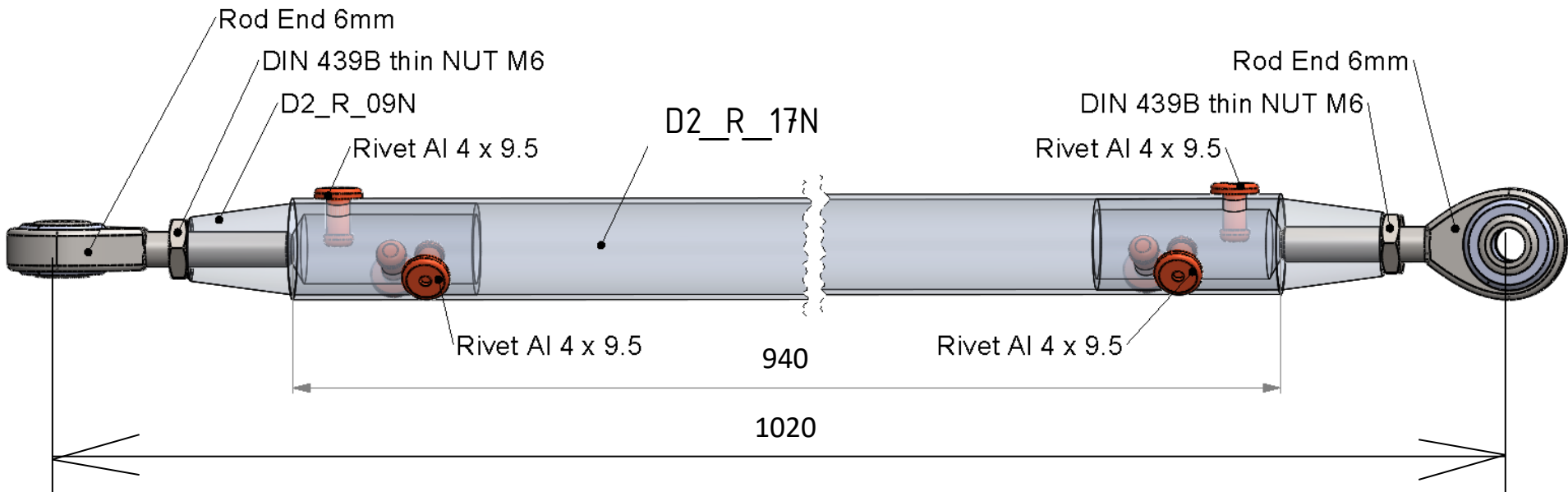
Step 1



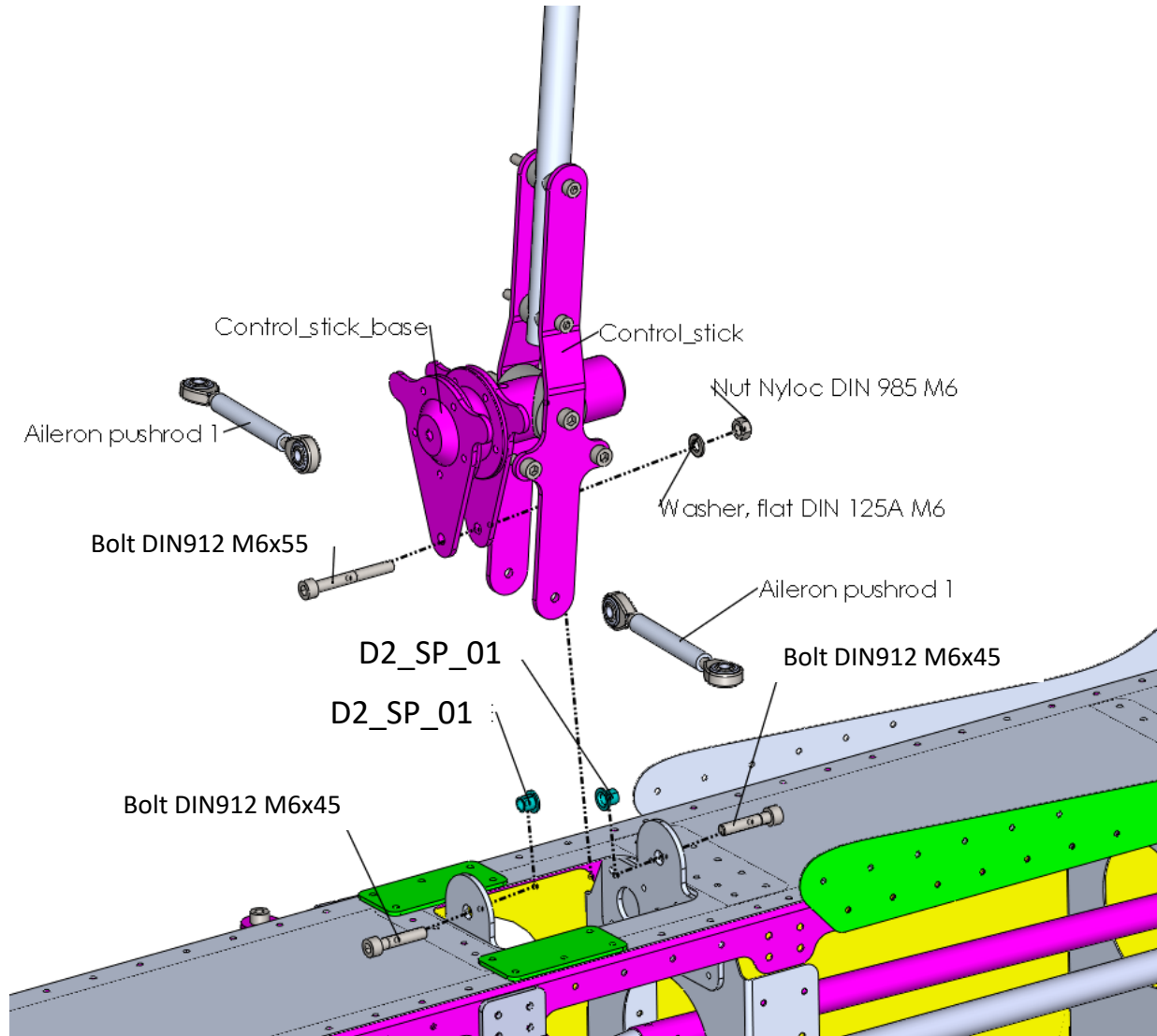
Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	70	121



Step 2



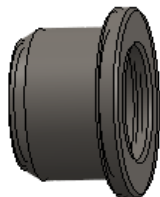
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Control system assembly manual	D2_R0_00	Rev. 05	71	121







Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	72	121



D2_SP_01
2 pcs

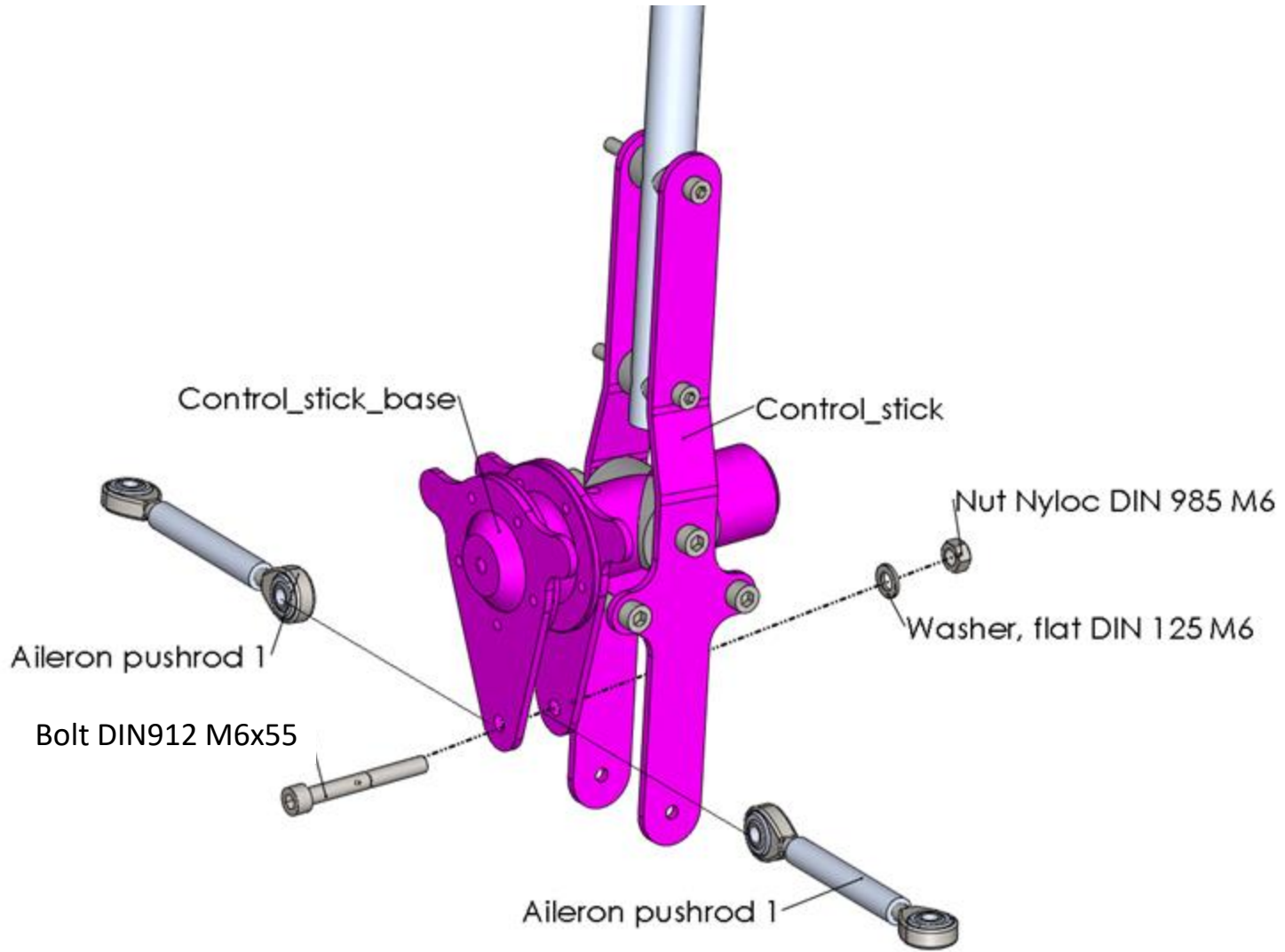


Standard Parts		
Detail picture	Part	Quantity
	Bolt DIN 912 M6x55	1
	Nut Nyloc DIN 985 M6	1
	Washer, flat DIN 125 M6	1
	Bolt DIN 912 M6x45	2

Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	73	121



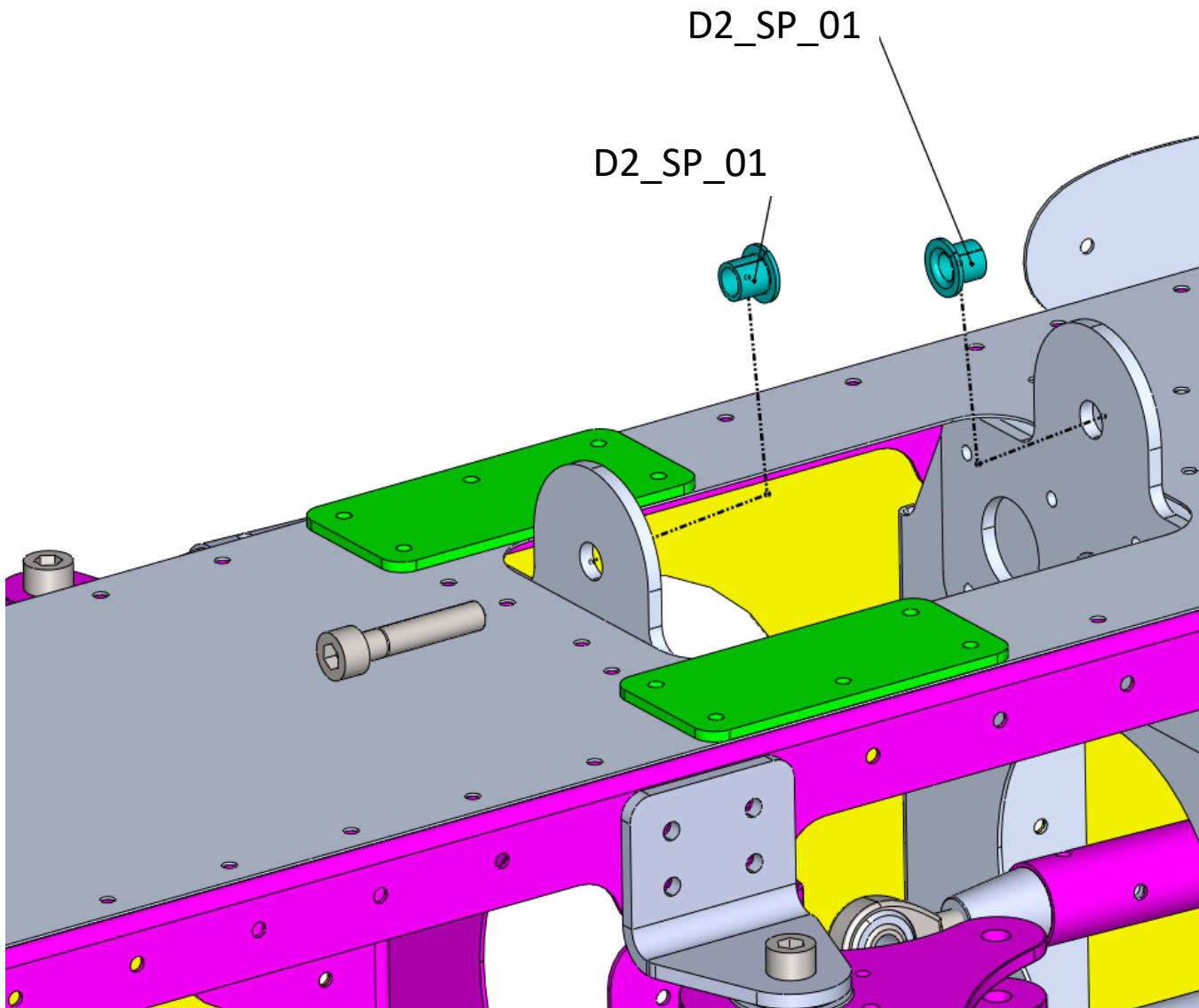
Step 1



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	74	121



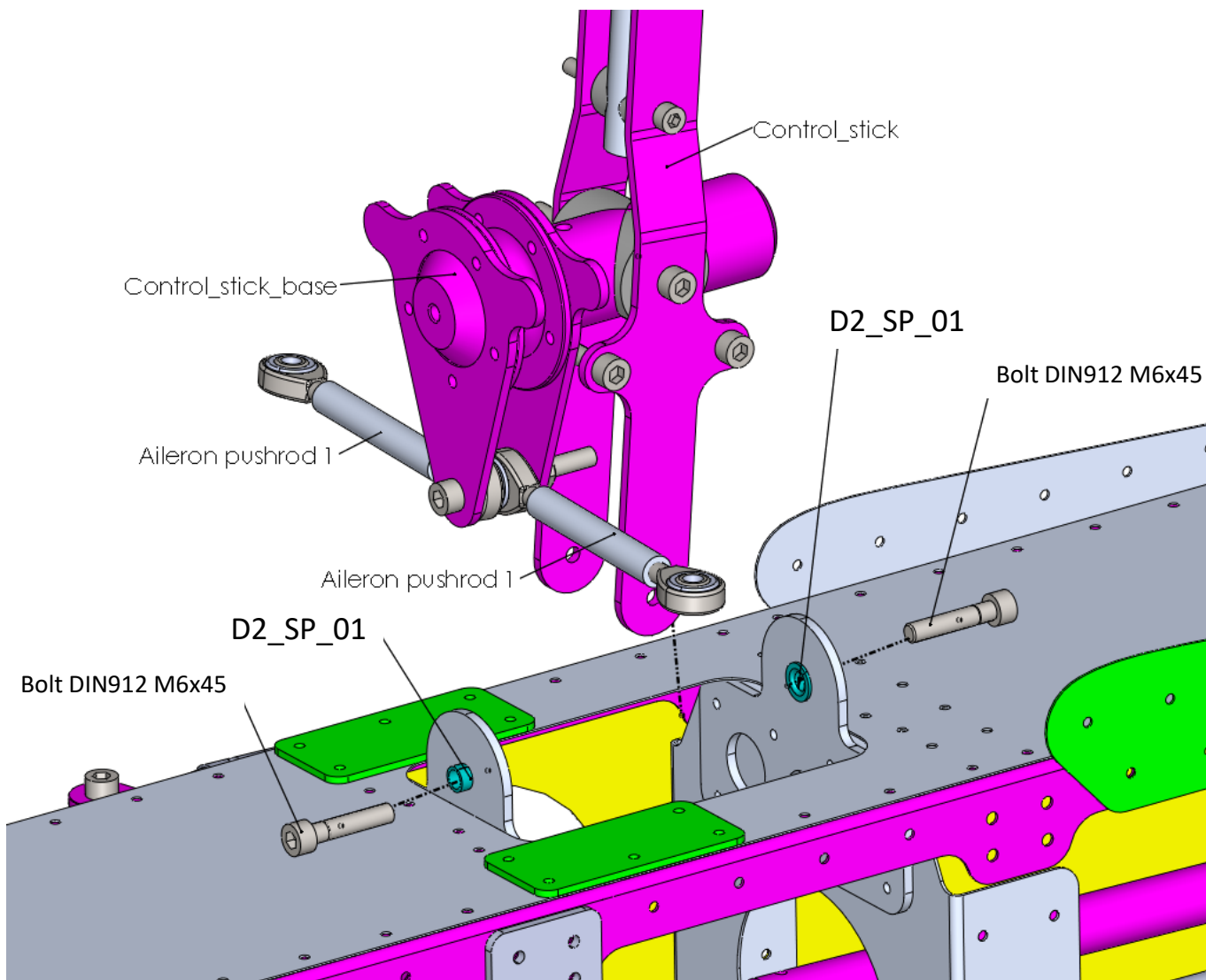
Step 2



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	75	121



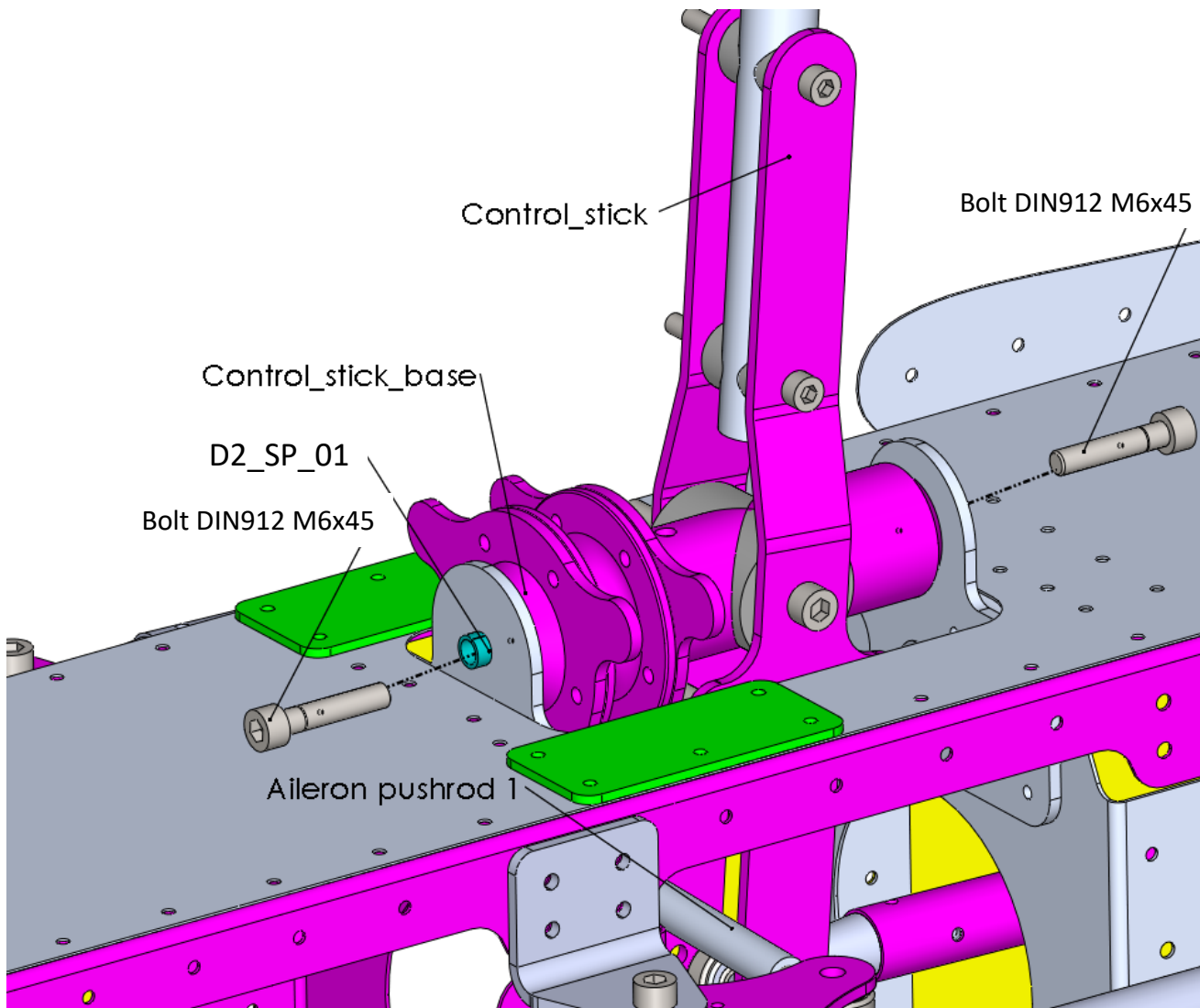
Step 3



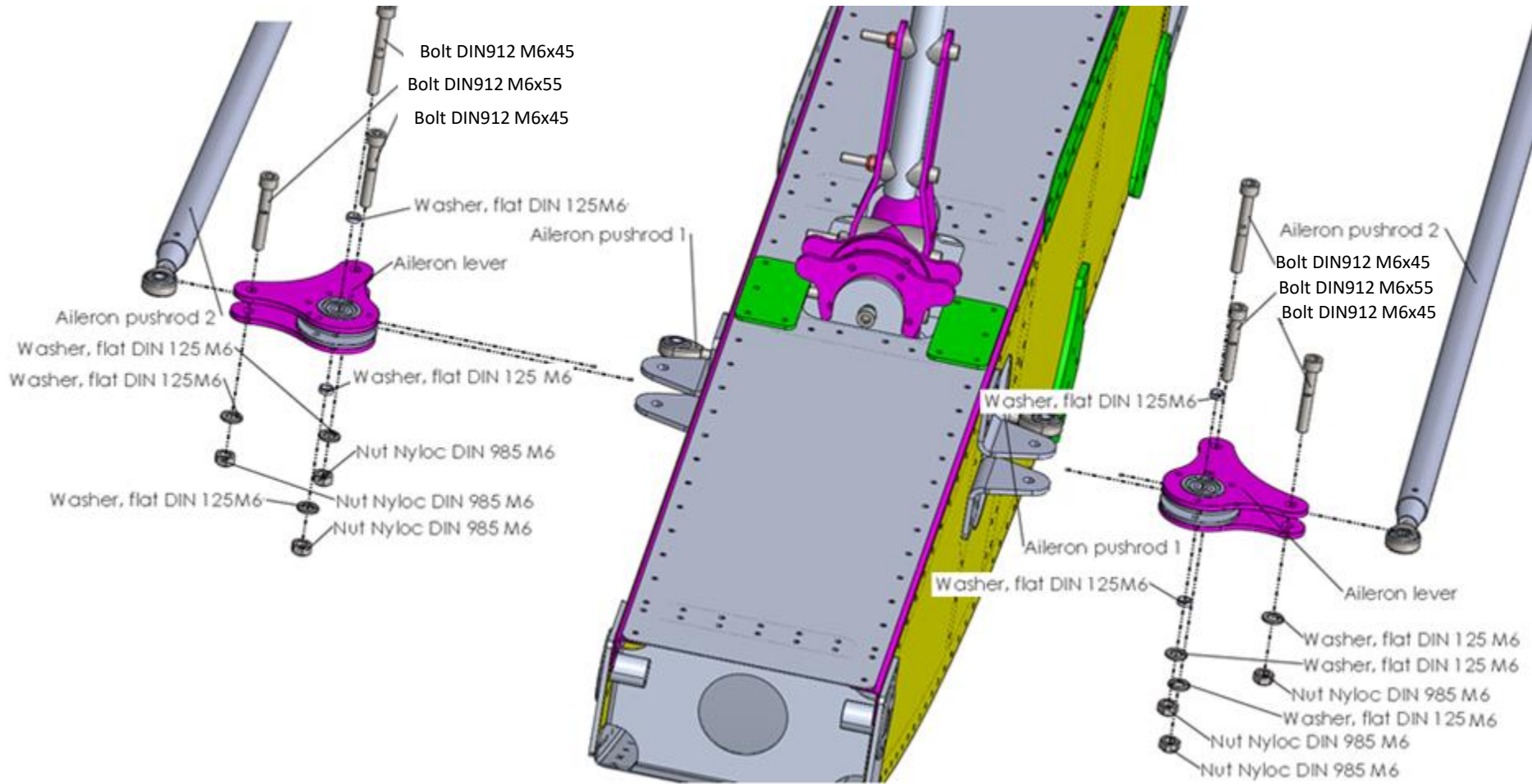
Title	Document no.	Revision	Page	Pages
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Step 4







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Control system assembly manual	D2_R0_00	Rev. 05	77	121



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	78	121

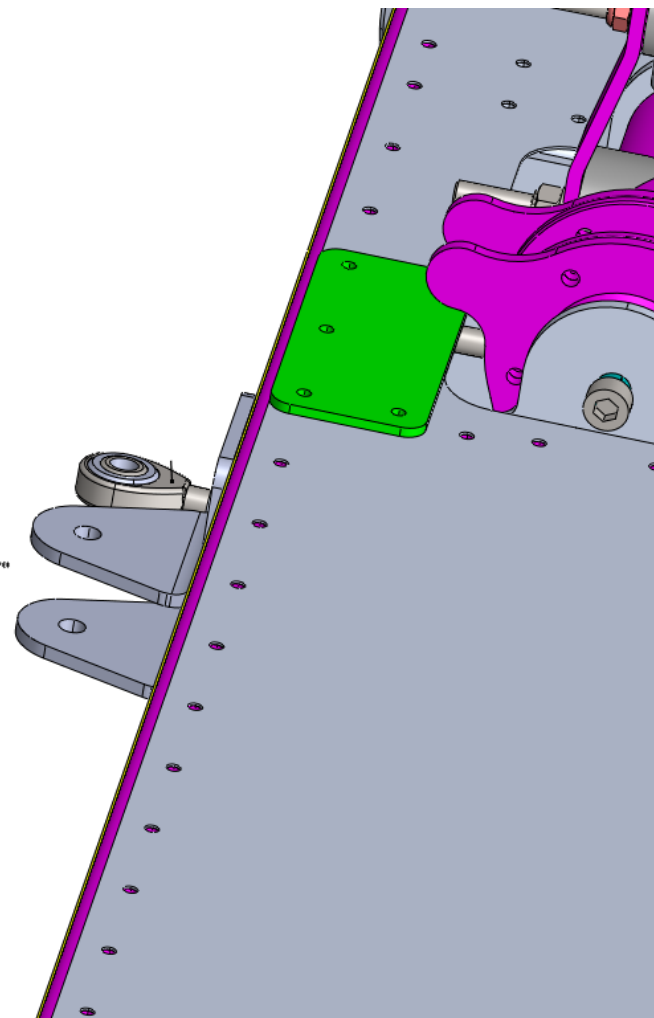
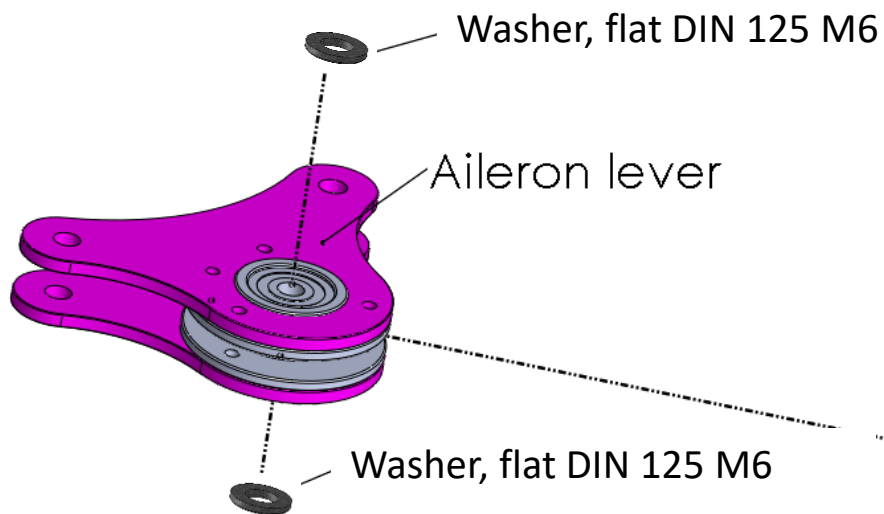


Standard Parts		
Detail picture	Part	Quantity
	Bolt DIN 912 M6x55	2
	Bolt DIN 912 M6x45	4
	Nut Nyloc DIN 985 M6	6
	Washer, flat DIN 125A M6	10

Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	79	121



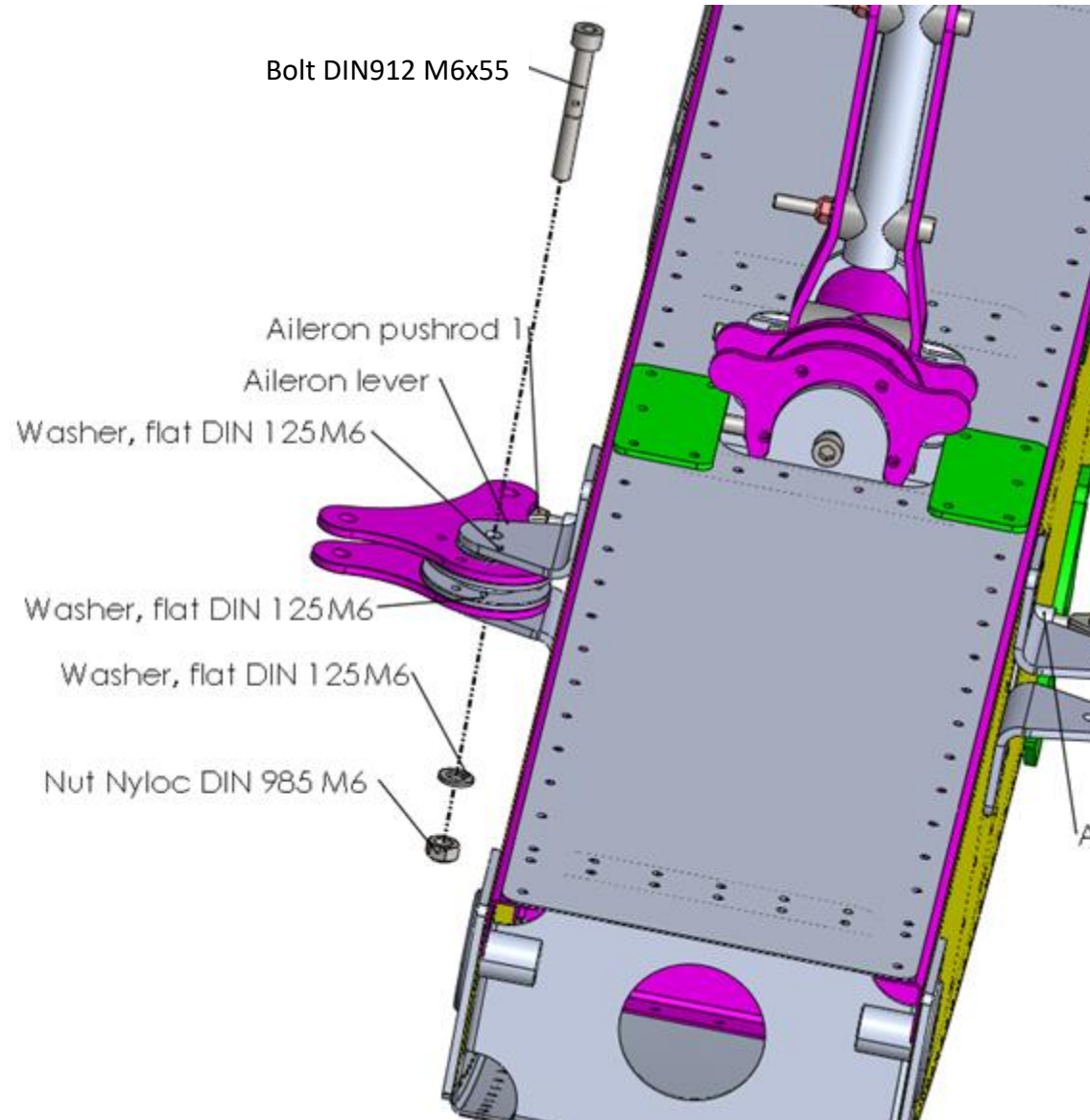
Step 1



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Control system assembly manual	D2_R0_00	Rev. 05	80	121



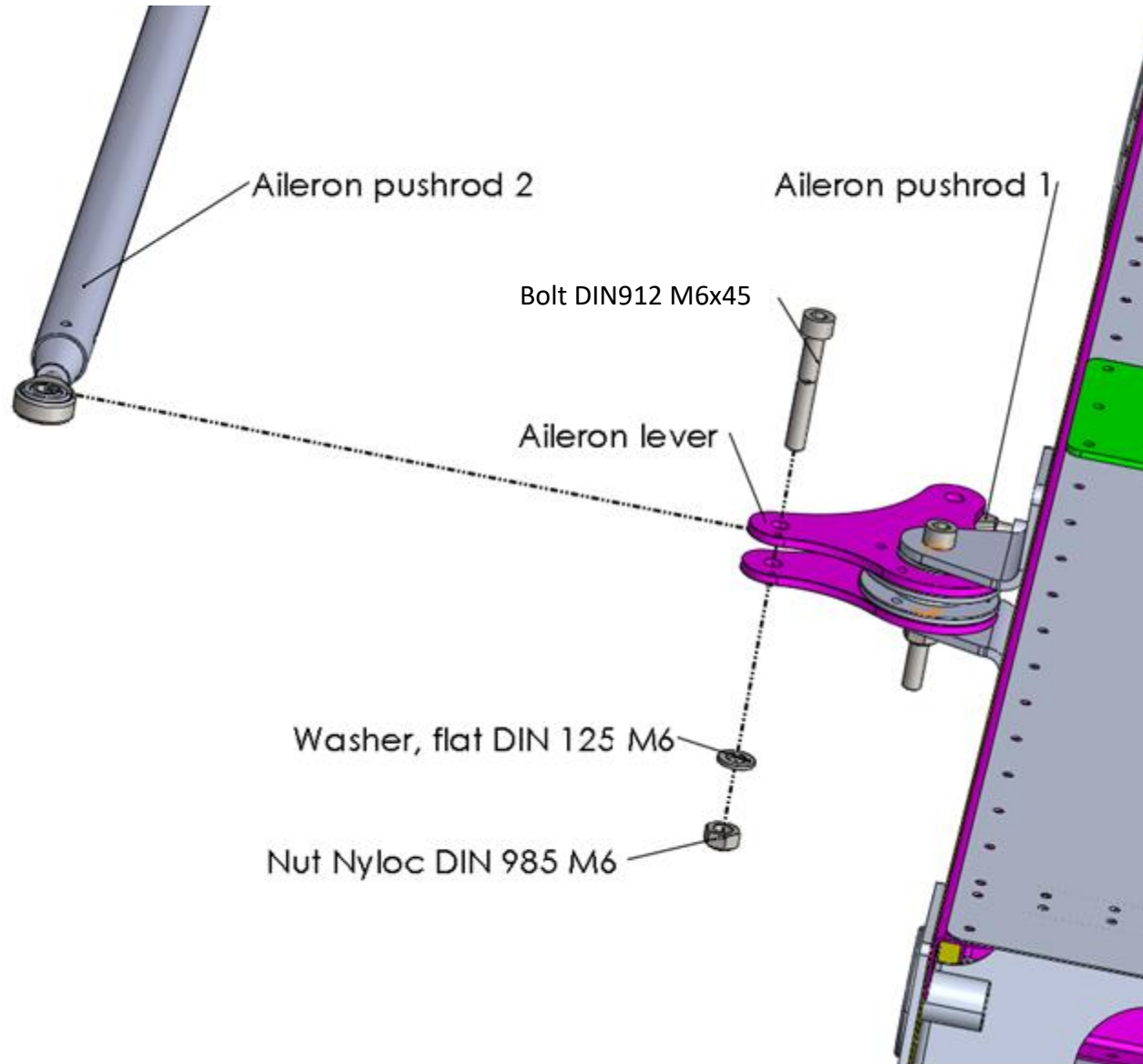
Step 2



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Control system assembly manual	D2_R0_00	Rev. 05	81	121



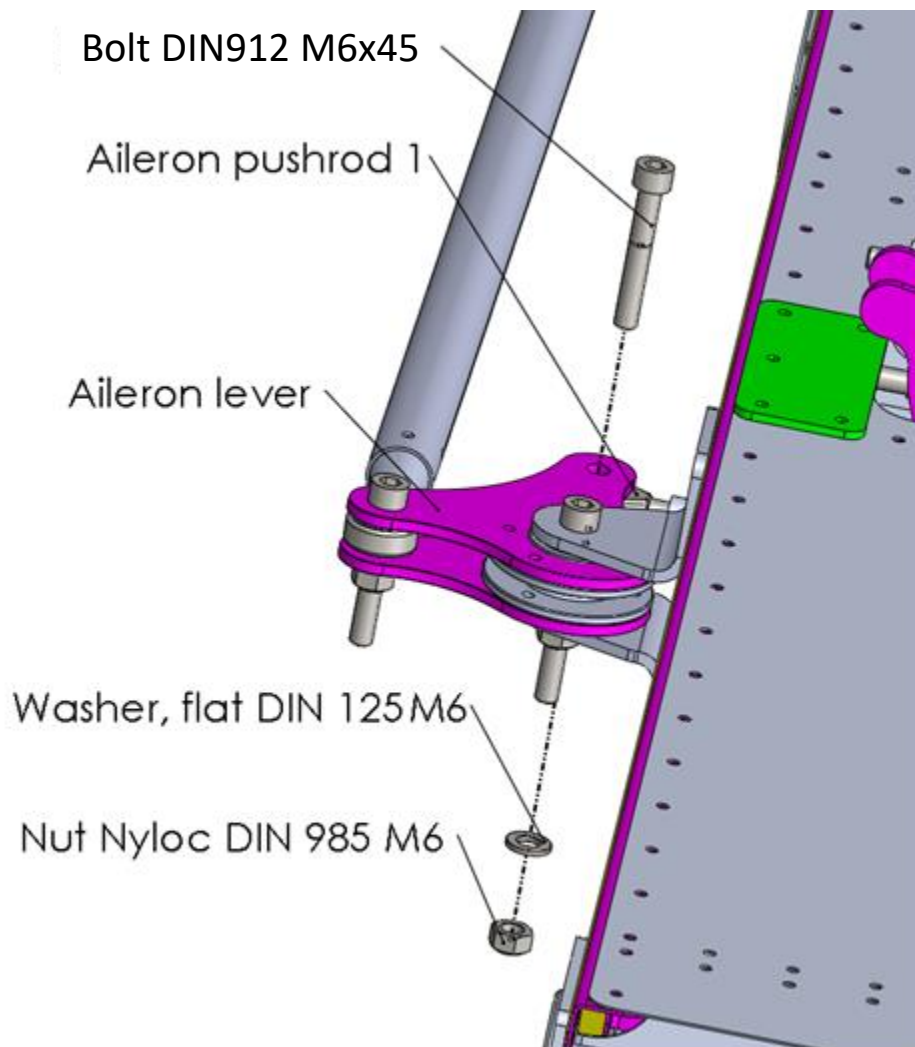
Step 3



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Control system assembly manual	D2_R0_00	Rev. 05	82	121



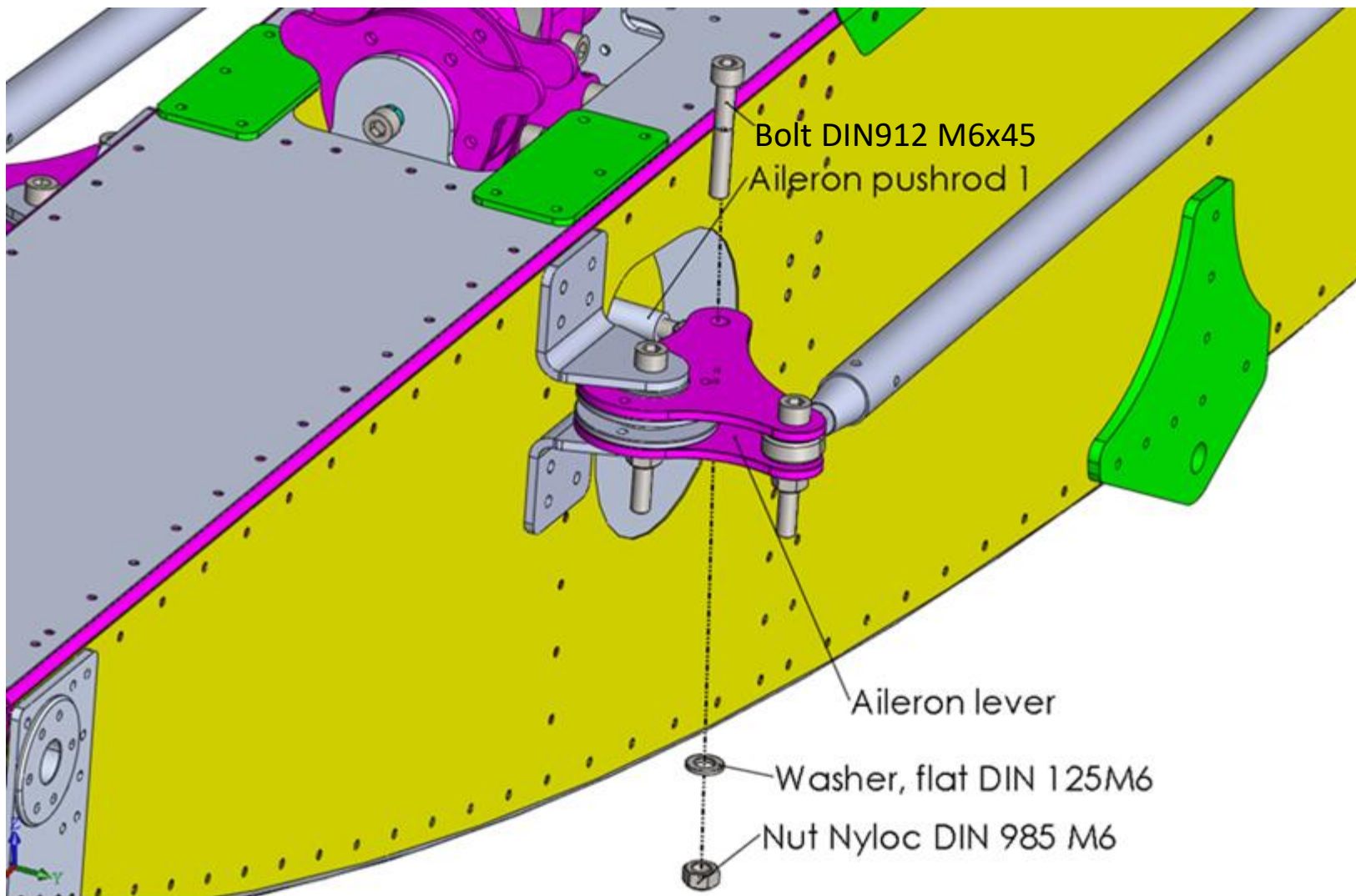
Step 4



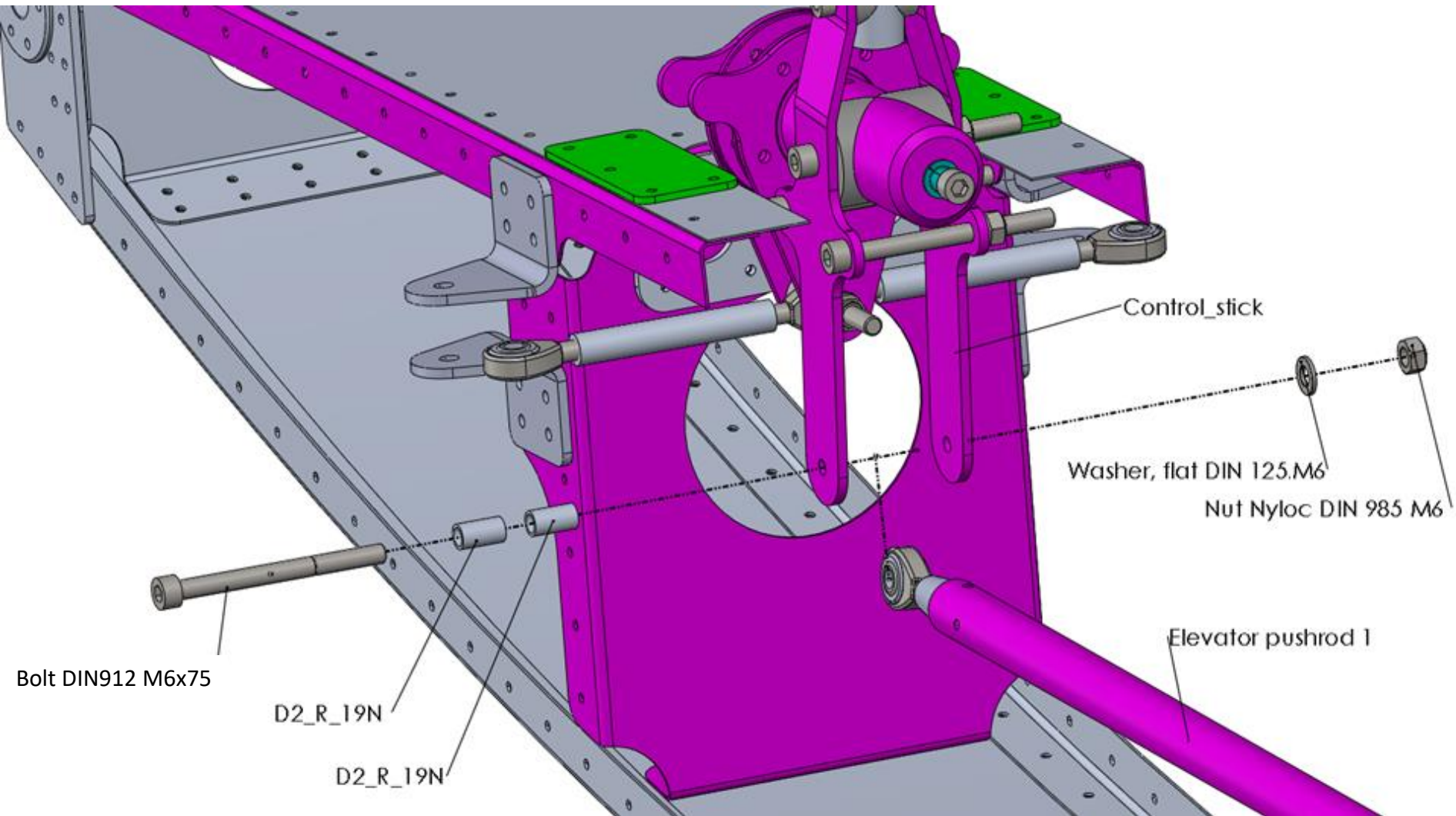
Title	Document no.	Revision	Page	Pages
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Step 5



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Control system assembly manual	D2_R0_00	Rev. 05	84	121

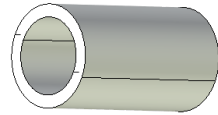





Title	Document no.	Revision	Page	Pages
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D2_R_19N

Quantity: 2

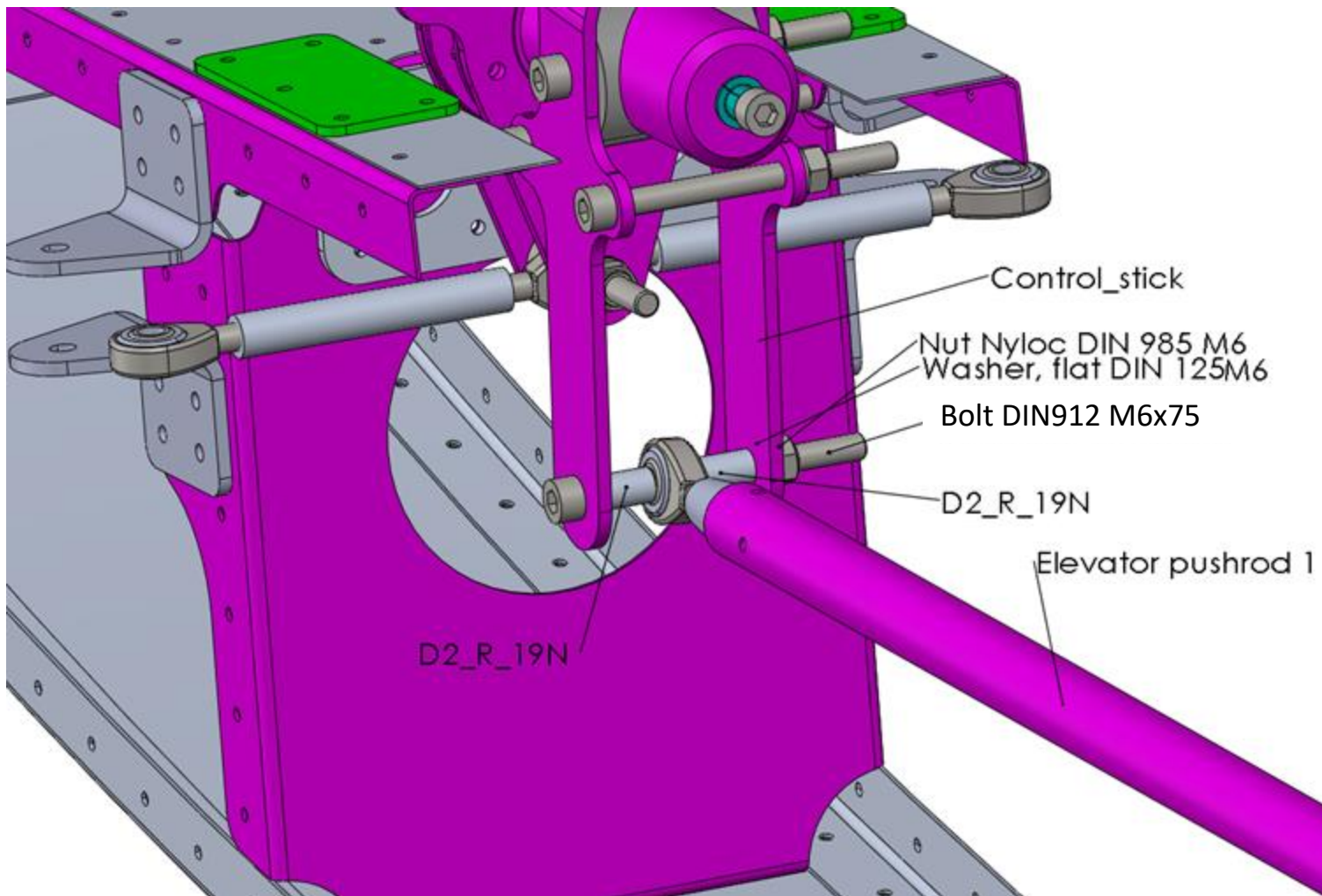


Standard Parts		
Detail picture	Part	Quantity
	Bolt DIN 912 M6x75	1
	Nut Nyloc DIN 985 M6	1
	Washer, flat DIN 125 M6	1

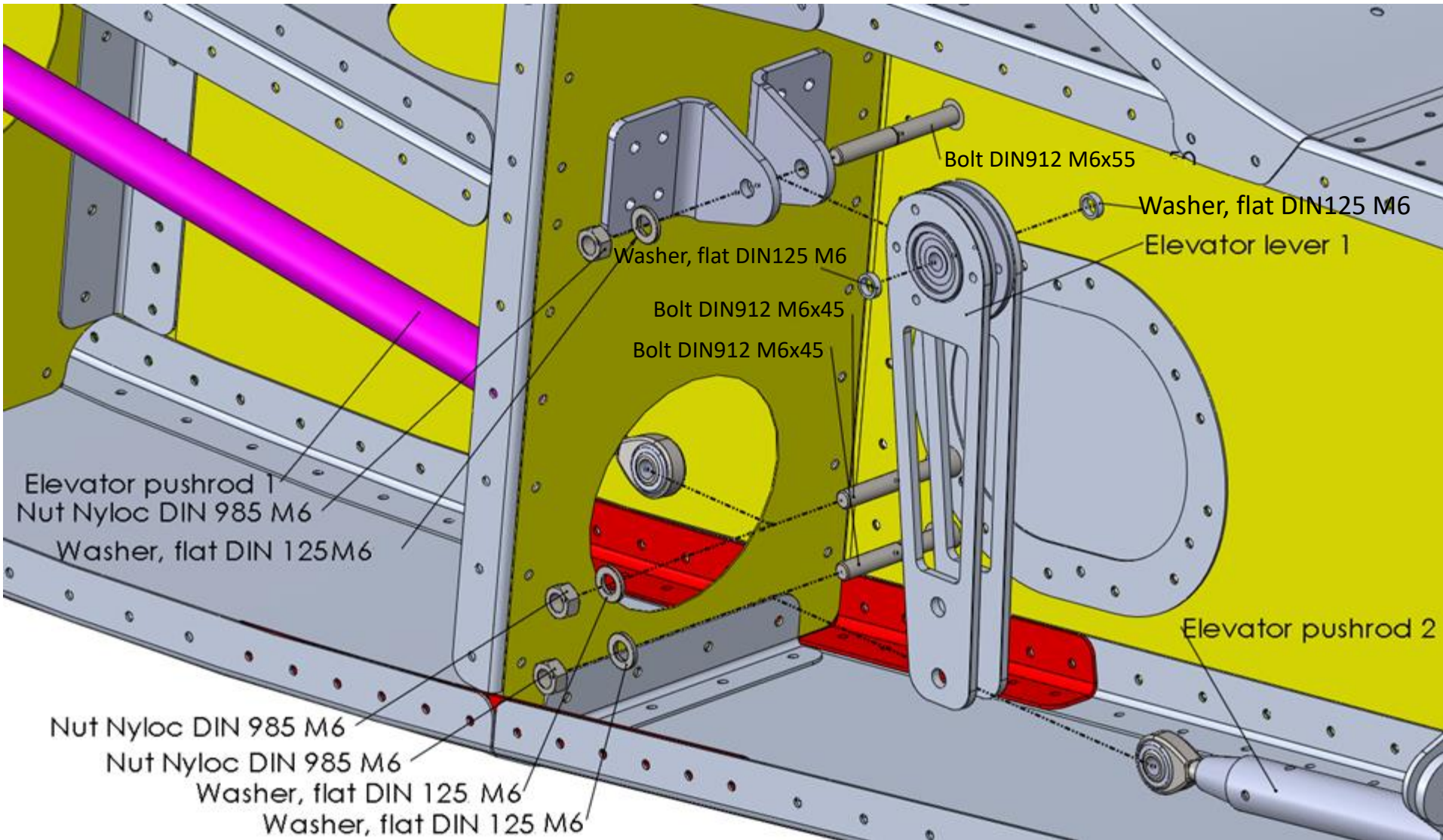
Title	Document no.	Revision	Page	Pages
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Step 1







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Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	88	121

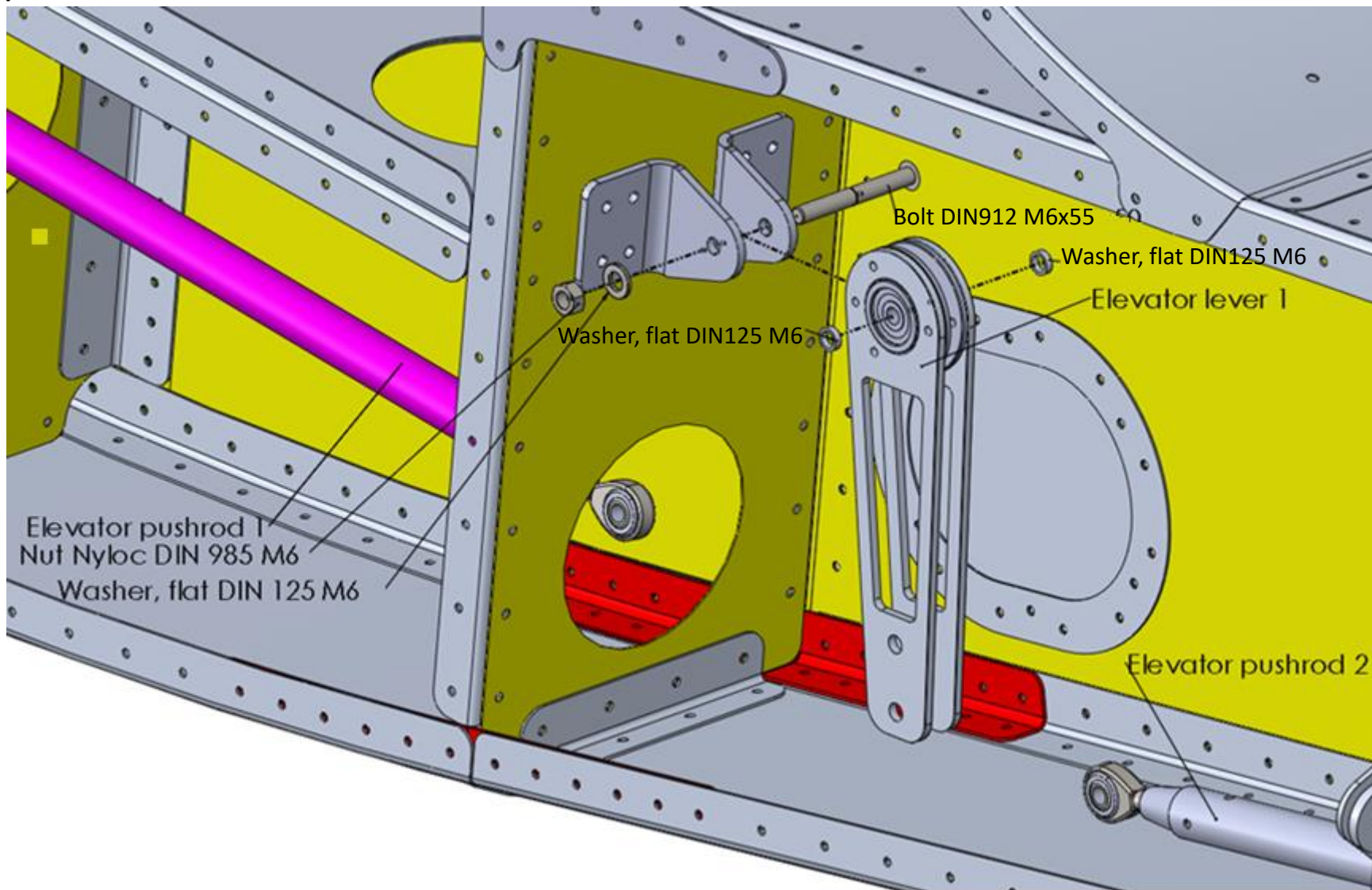


Standard Parts		
Detail picture	Part	Quantity
	Bolt DIN 912 M6x55	1
	Bolt DIN 912 M6x45	2
	Nut Nyloc DIN 985 M6	3
	Washer, flat DIN 125 M6	5

Title	Document no.	Revision	Page	Pages
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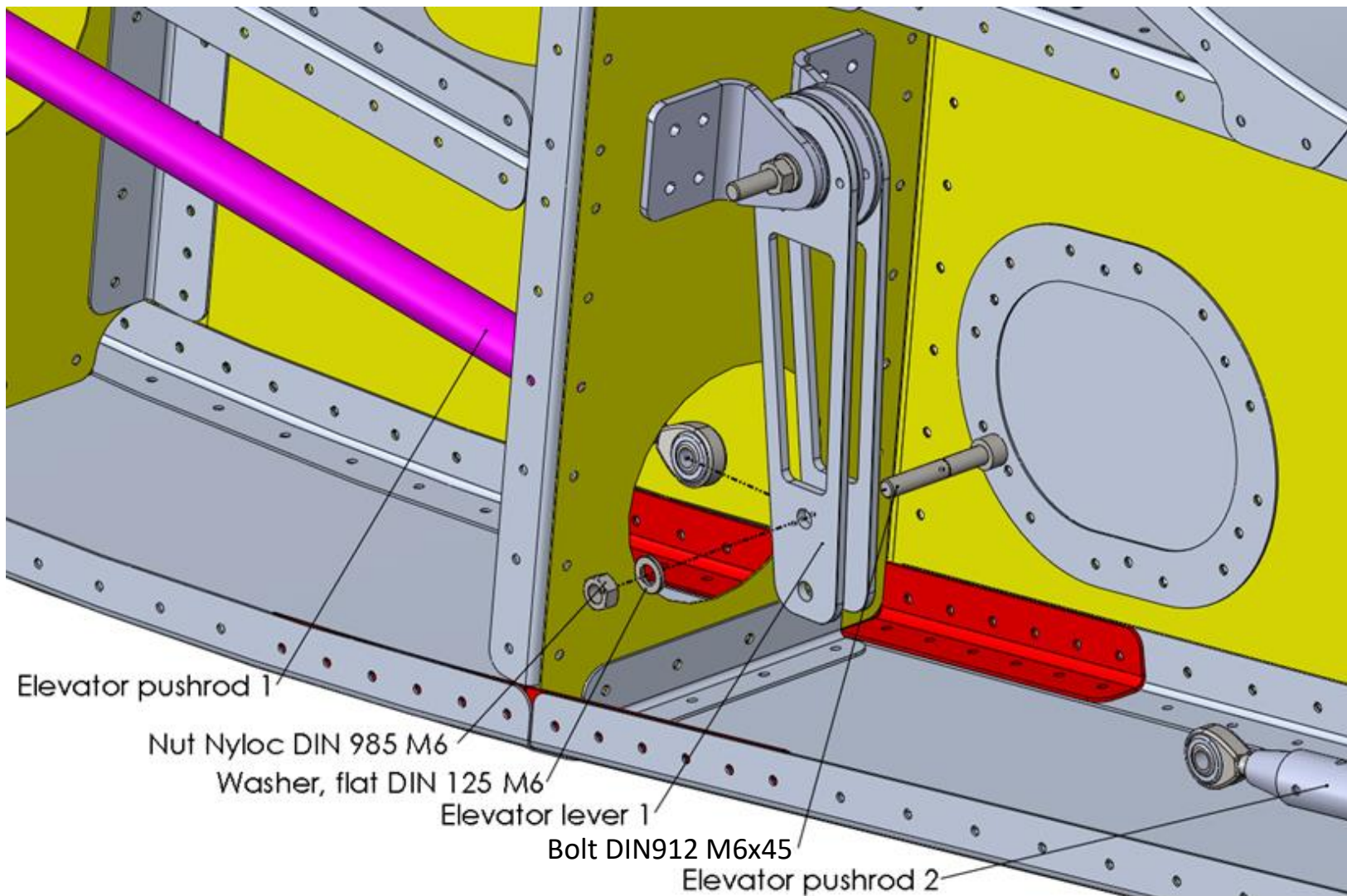
Step 1



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	90	121



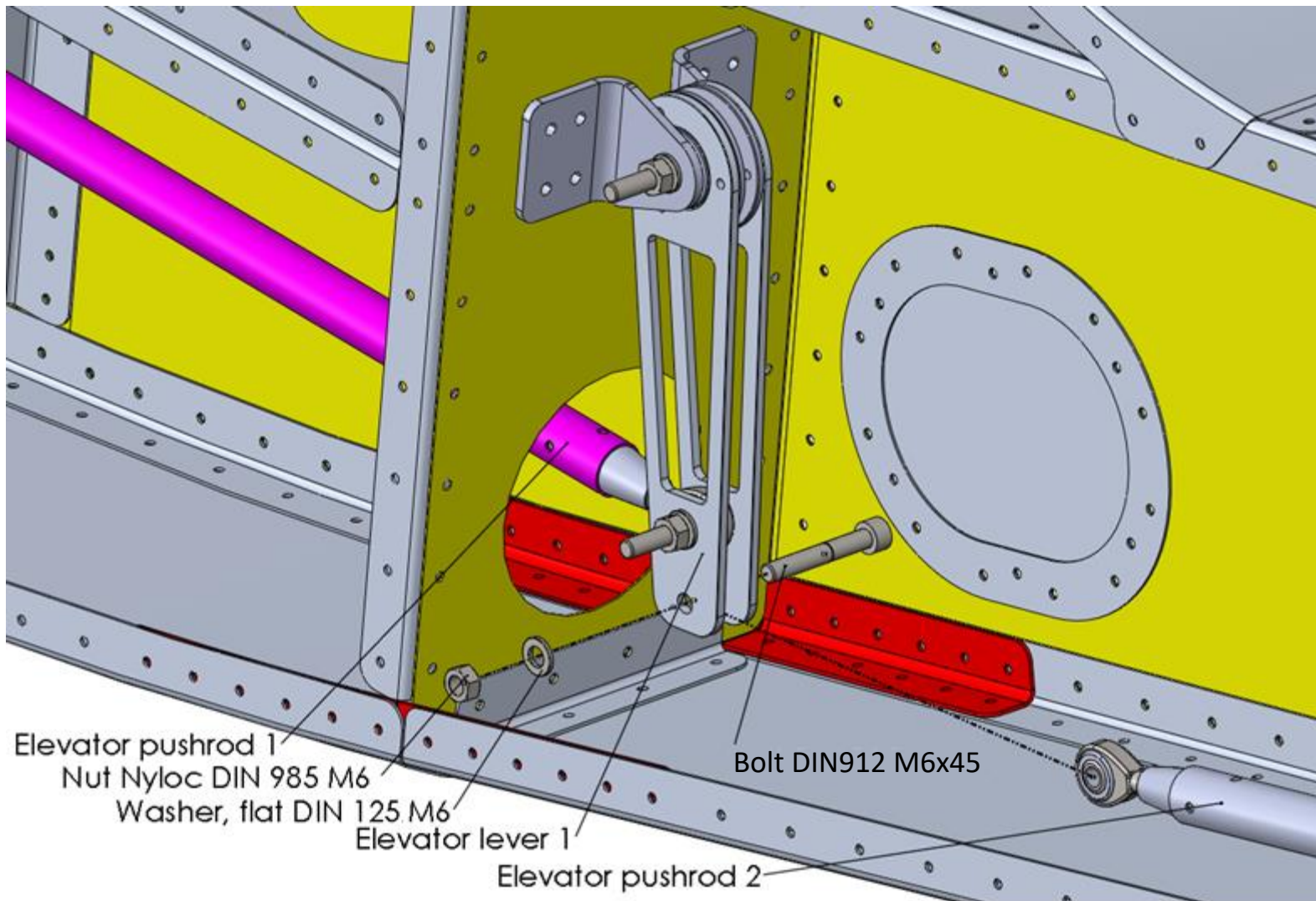
Step 2



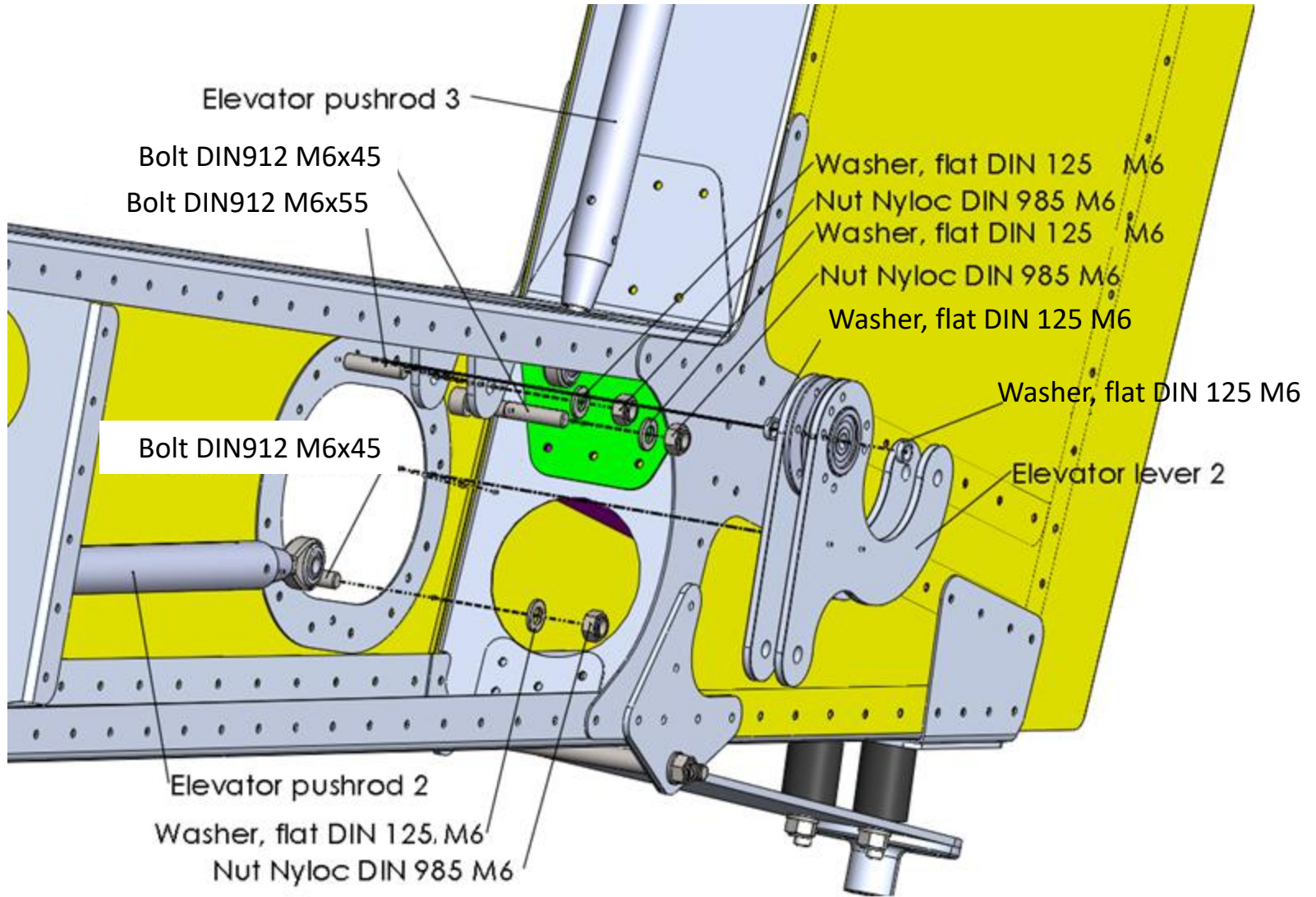
Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	91	121



Step 3







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Control system assembly manual	D2_R0_00	Rev. 05	92	121

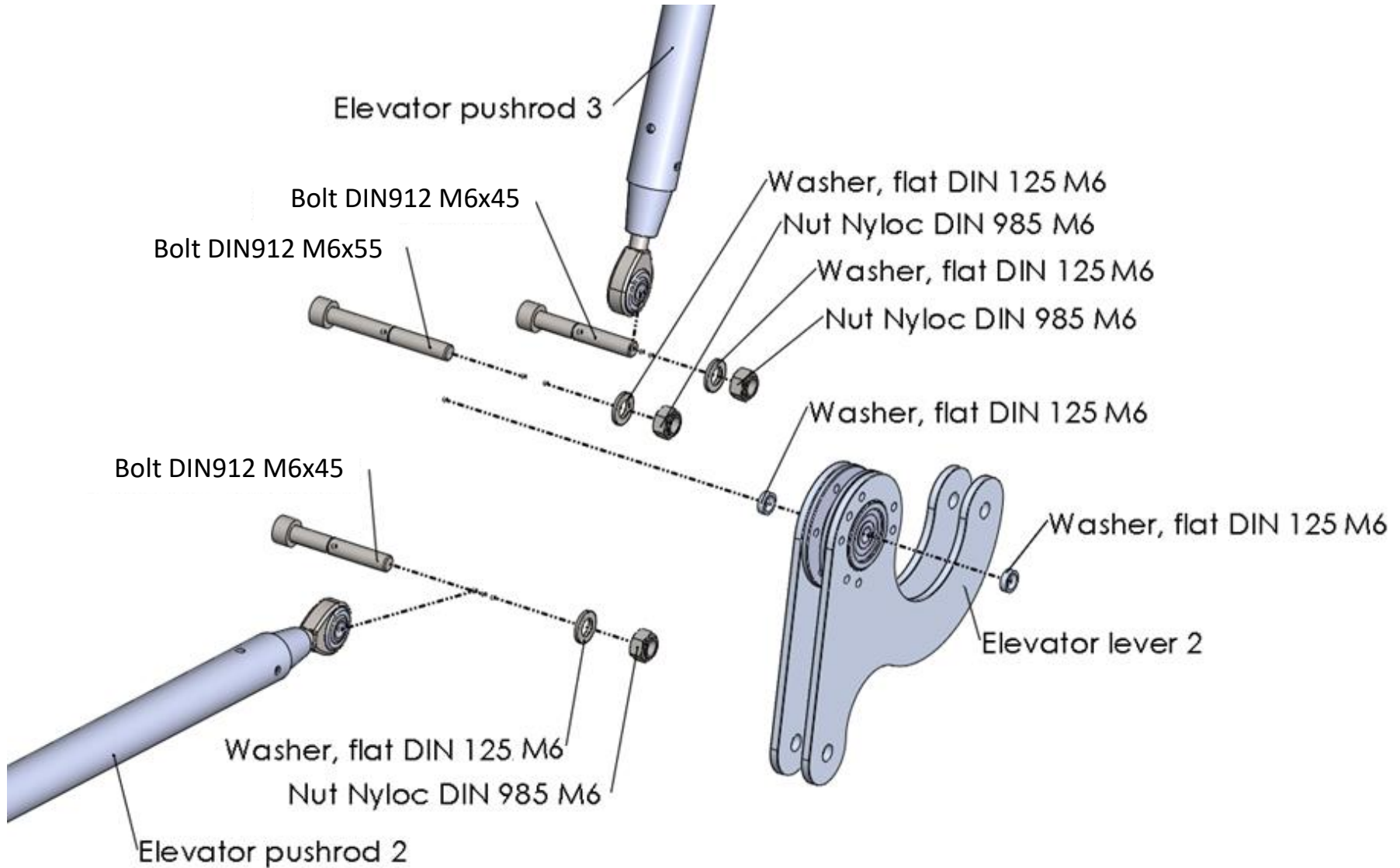


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Control system assembly manual	D2_R0_00	Rev. 05	93	121



Standard Parts		
Detail picture	Part	Quantity
	Bolt DIN 912 M6x55	1
	Bolt DIN 912 M6x45	2
	Nut Nyloc DIN 985 M6	3
	Washer, flat DIN 125 M6	5

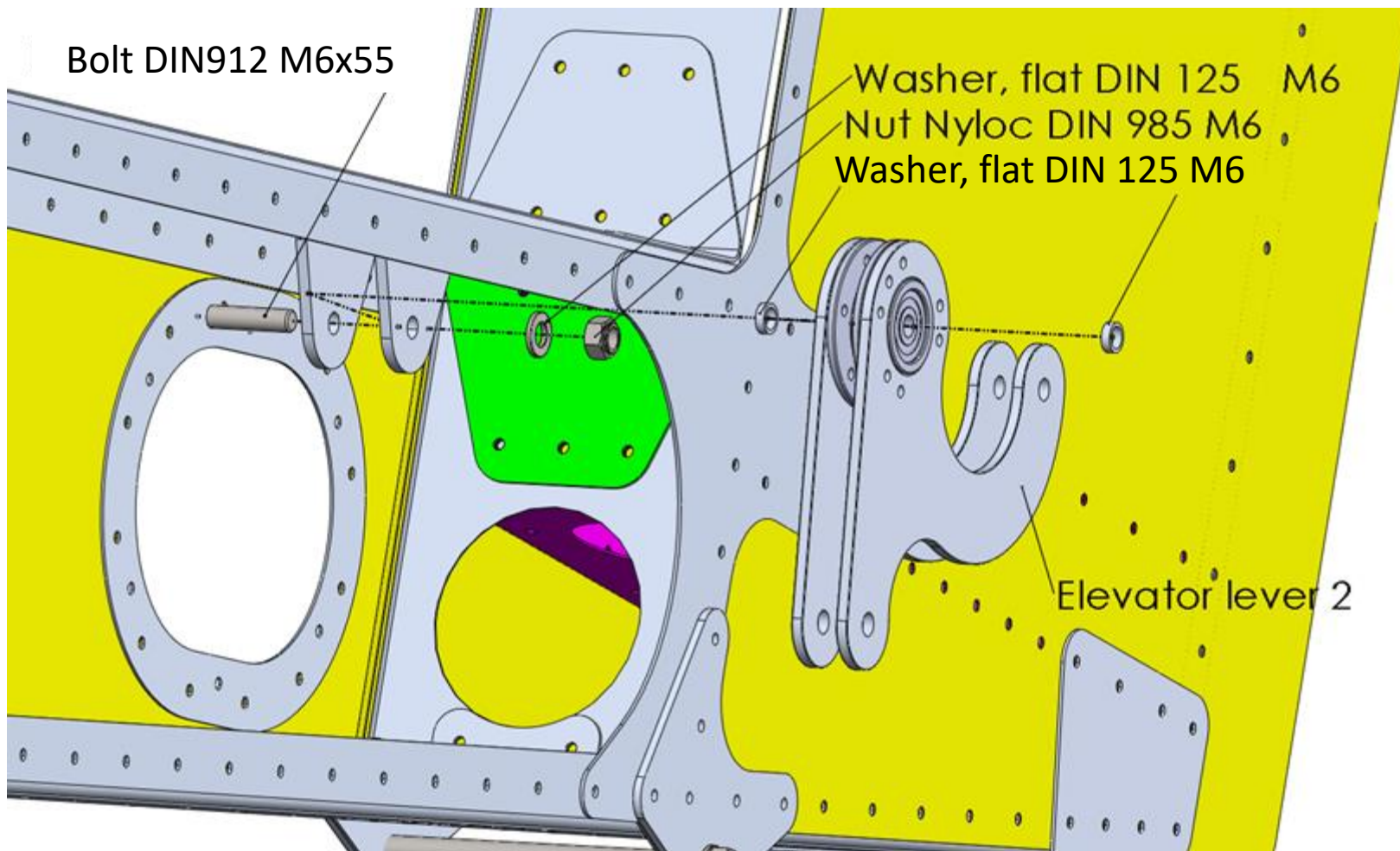
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Title	Document no.	Revision	Page	Pages
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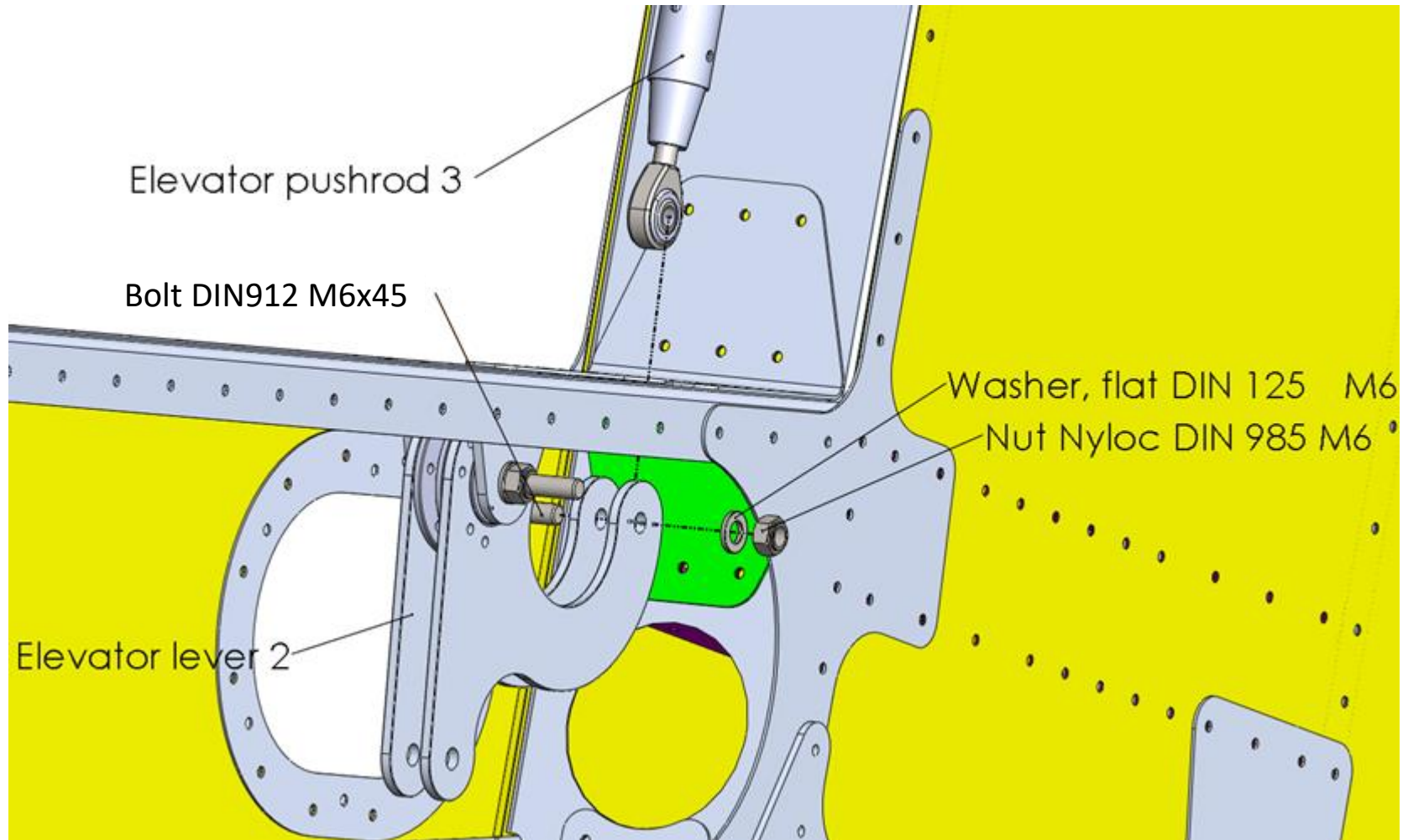
Step 1



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Control system assembly manual	D2_R0_00	Rev. 05	96	121



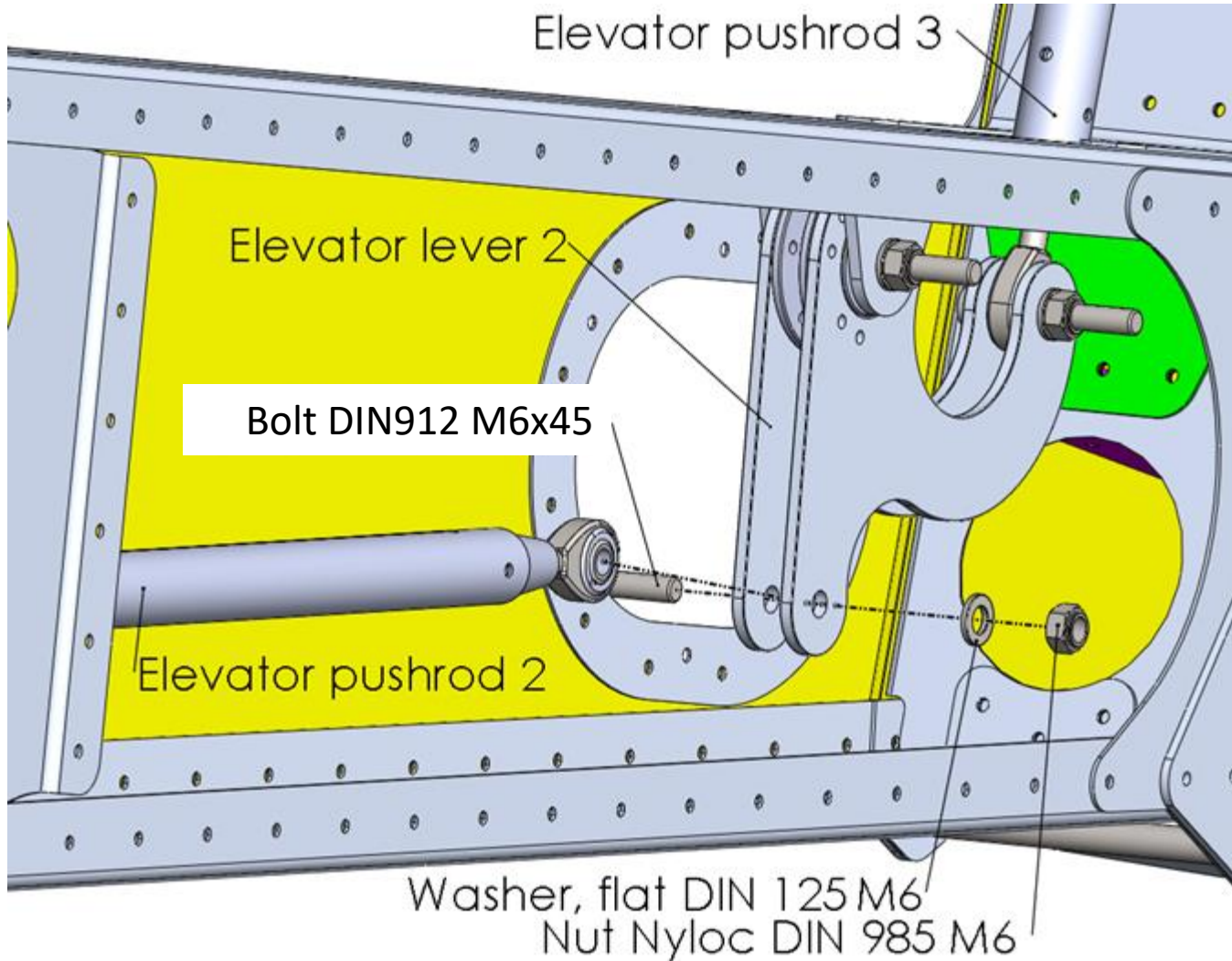
Step 2



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	97	121



Step 3



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Control system assembly manual	D2_R0_00	Rev. 05	98	121



Rudder control system assembly



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	99	121



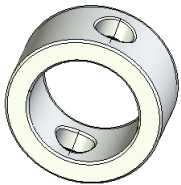
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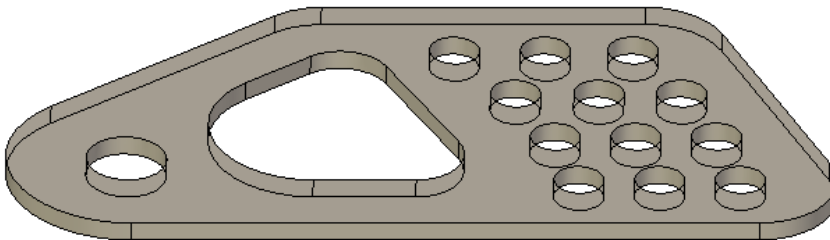
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Quantity: 2



D2_R_30N

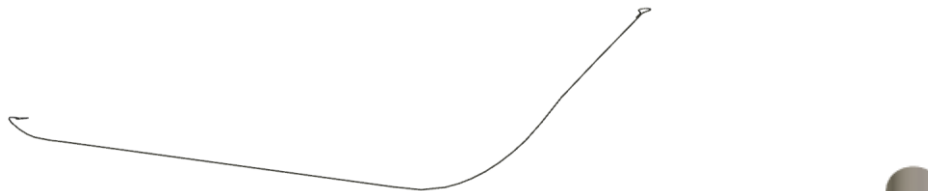
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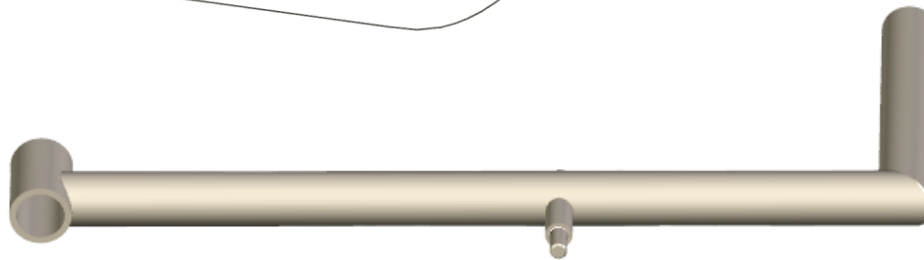
Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 05	100	121



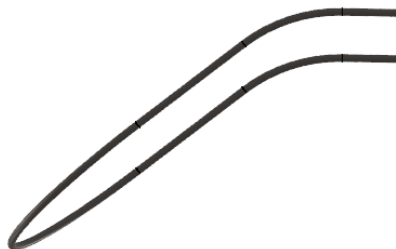
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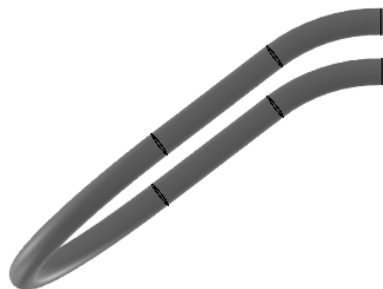
D2_R_33N
Quantity: 2



D2_R_35N
Quantity: 2




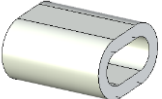
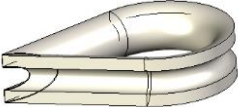



D2_R_36N
Quantity: 2



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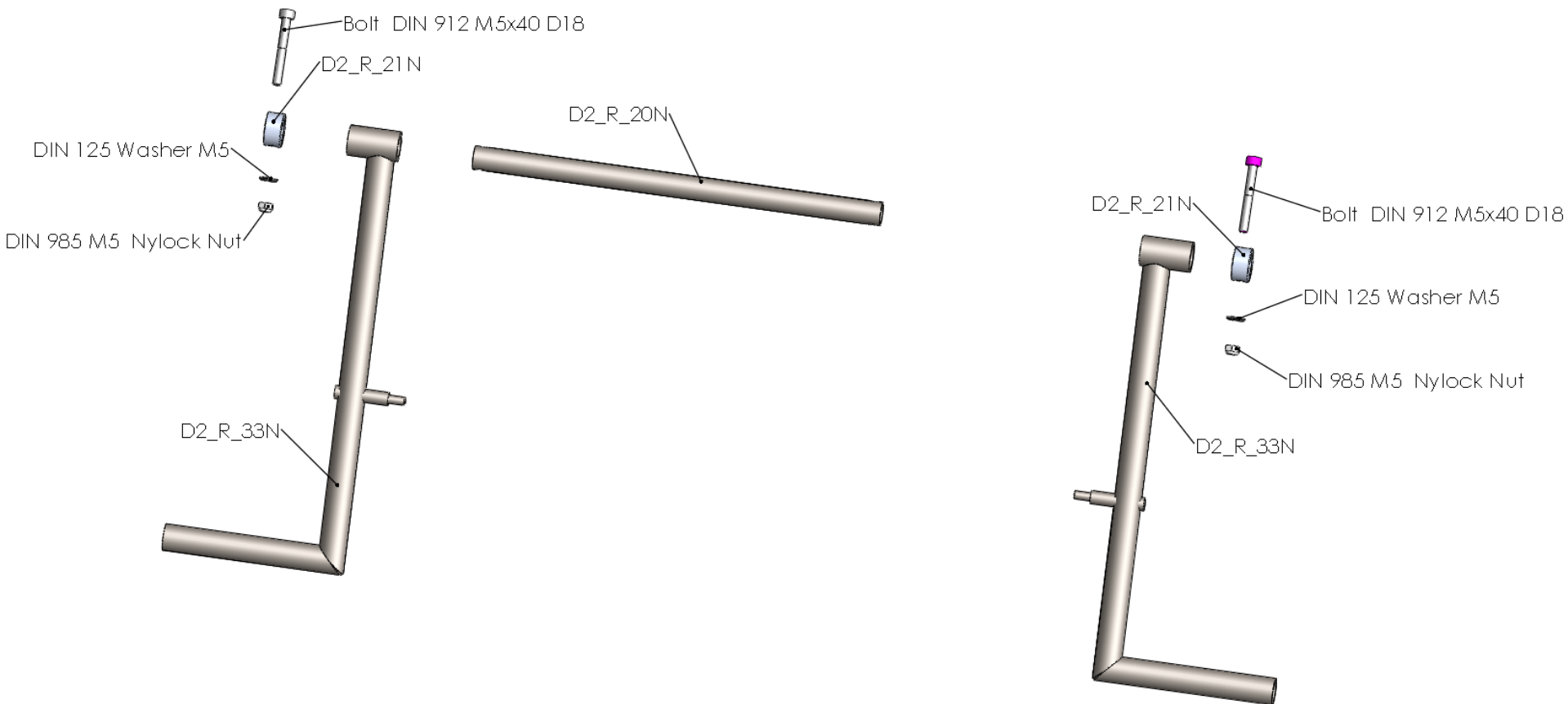


Standard Parts		
Detail picture	Part	Quantity
	Bolt DIN 912 M5x40	2
	Nut Nyloc DIN 985 M5	4
	Washer, flat DIN 125 M5	4
	Crimp sleeve	8
	Thimble	4
	Crimp sleeve	4

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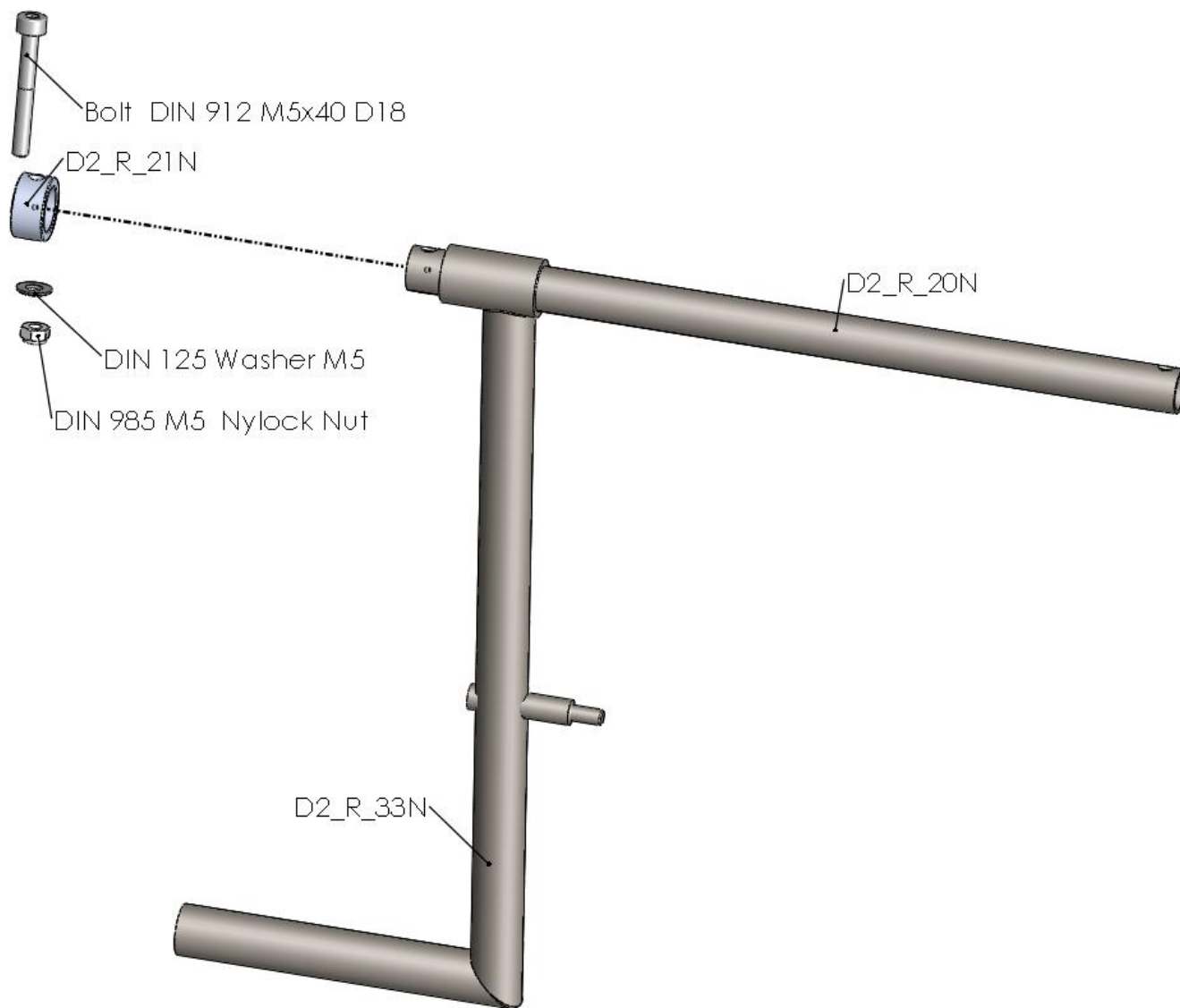
Step 1



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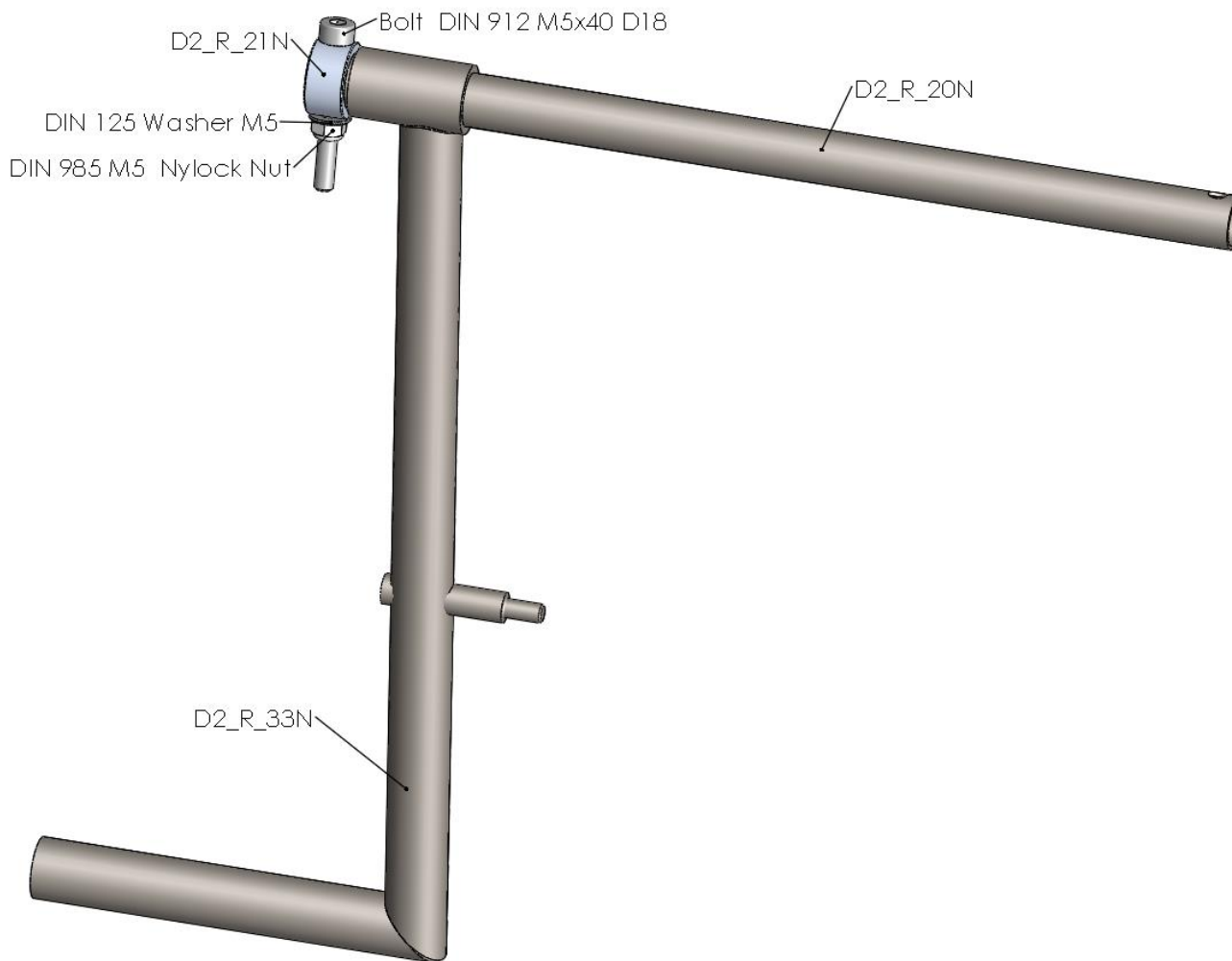
Step 2



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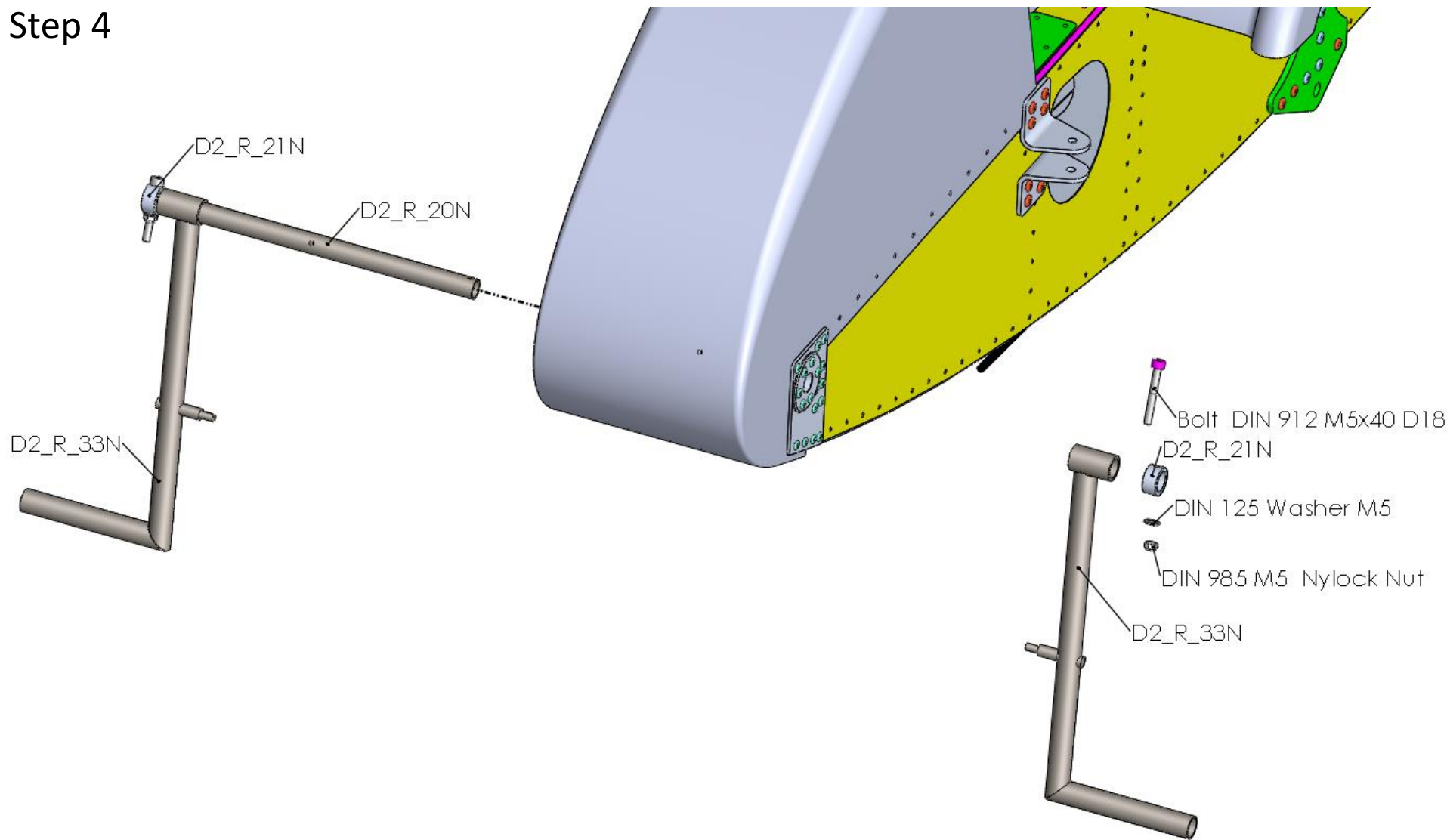
Step 3



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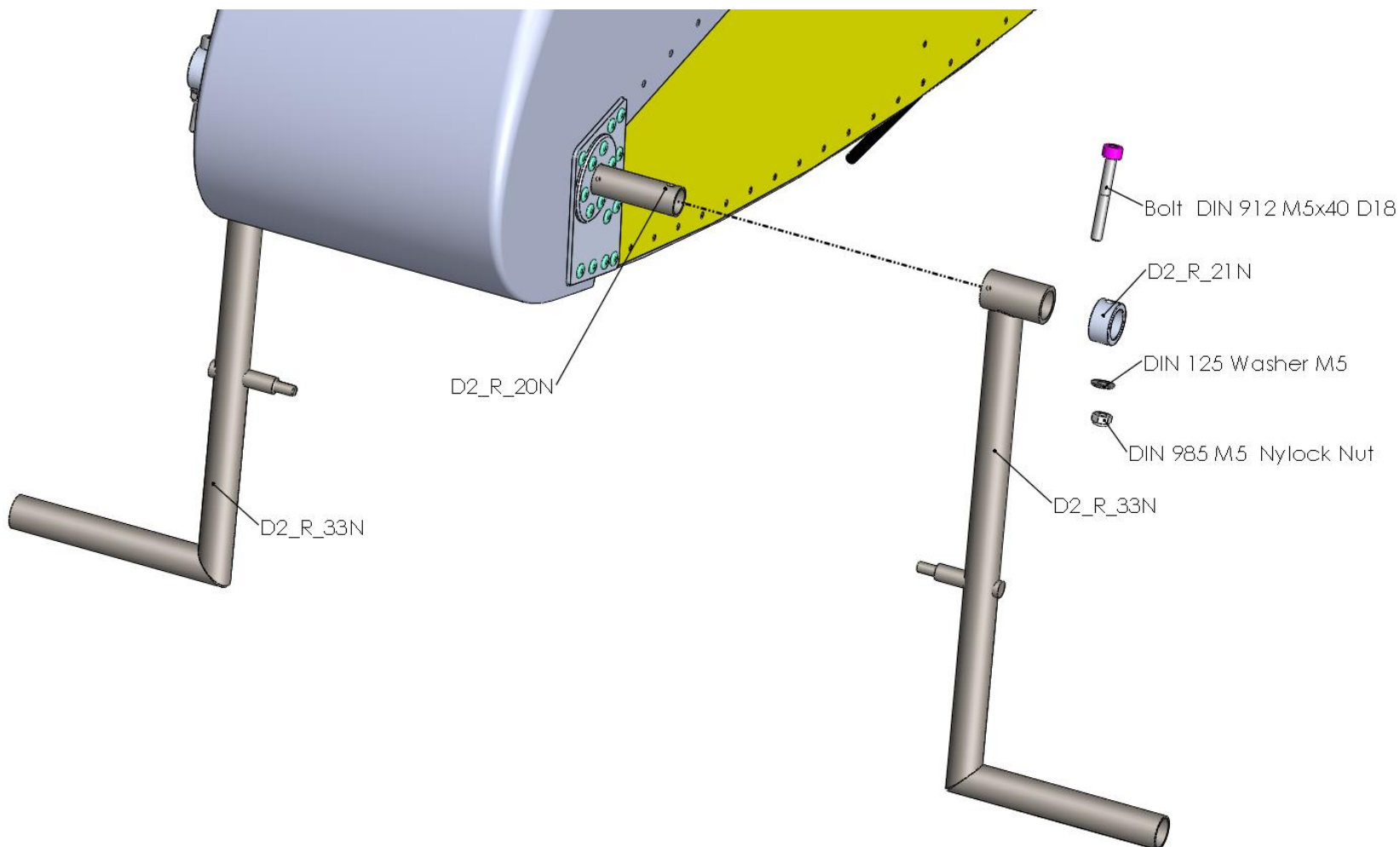
Step 4



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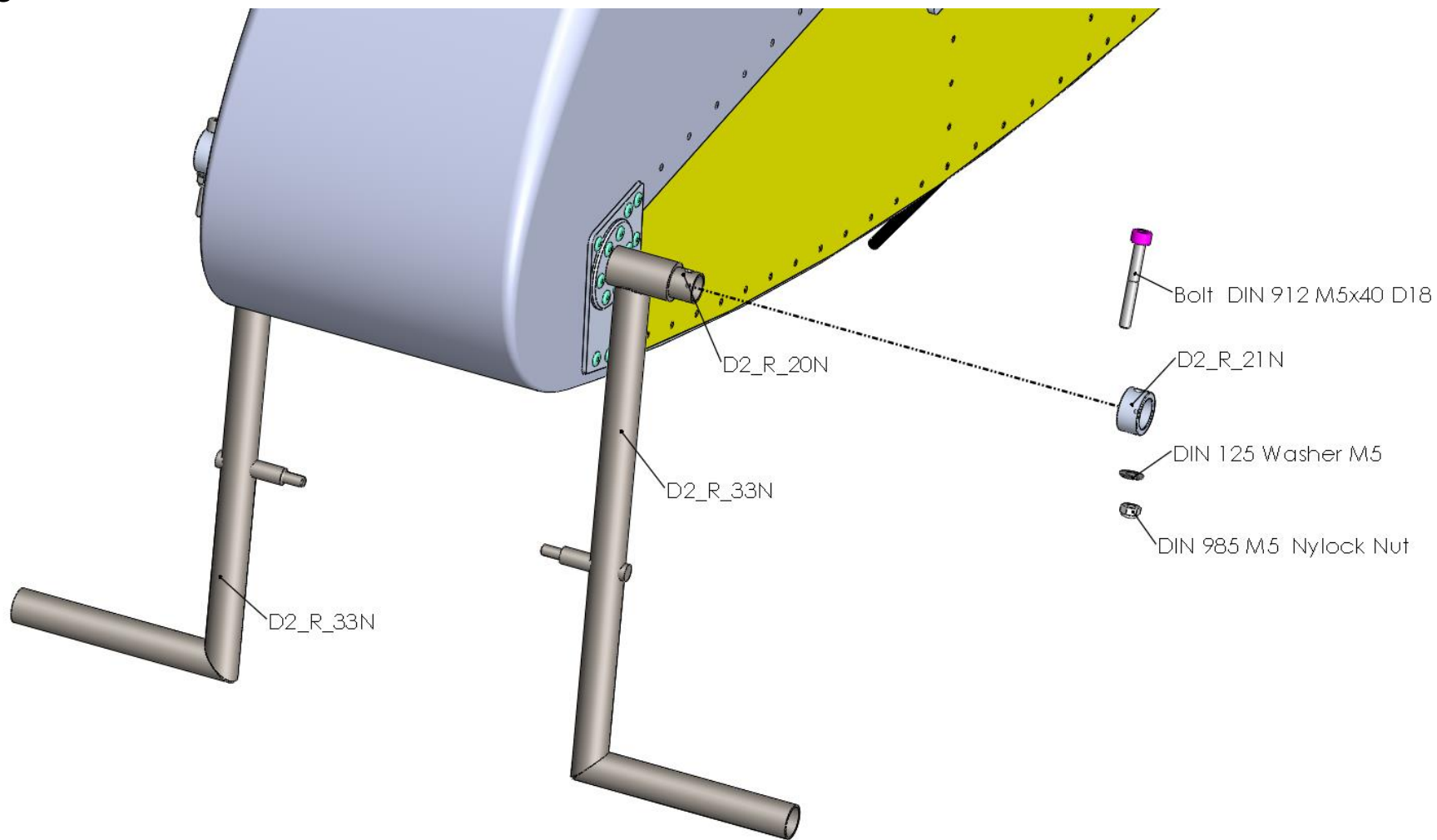
Step 5



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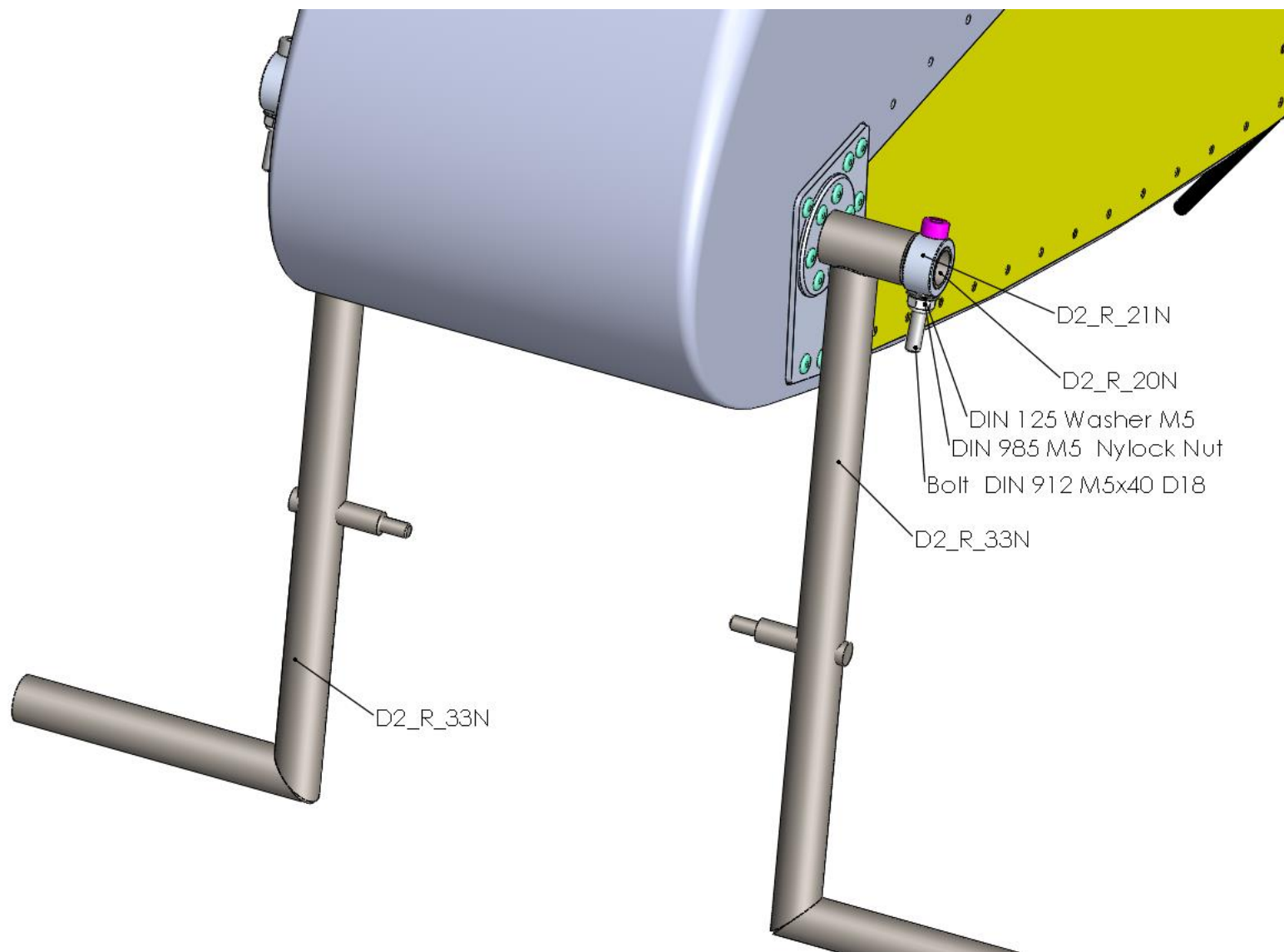
Step 6



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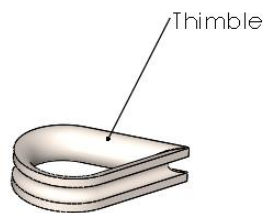
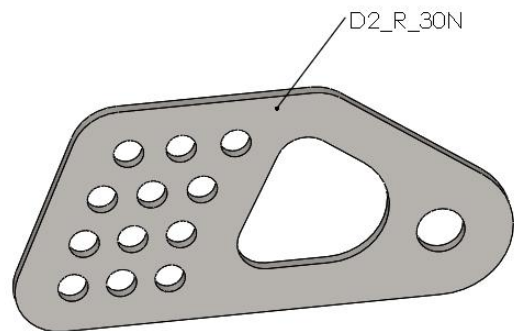
Step 7



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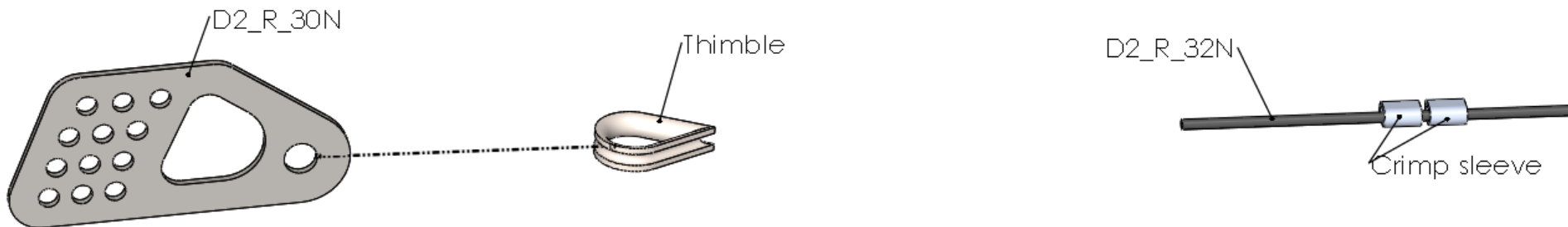
Step 8



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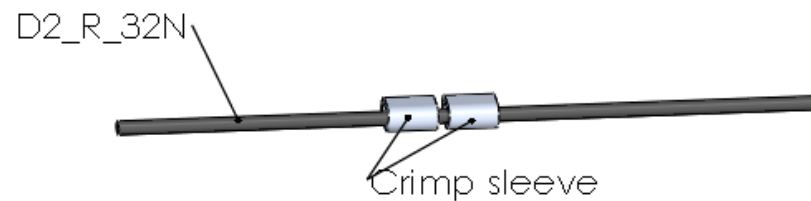
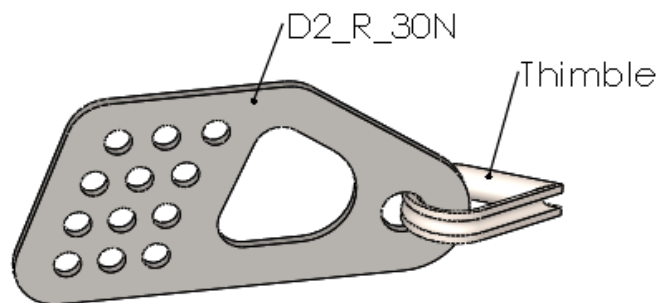
Step 9



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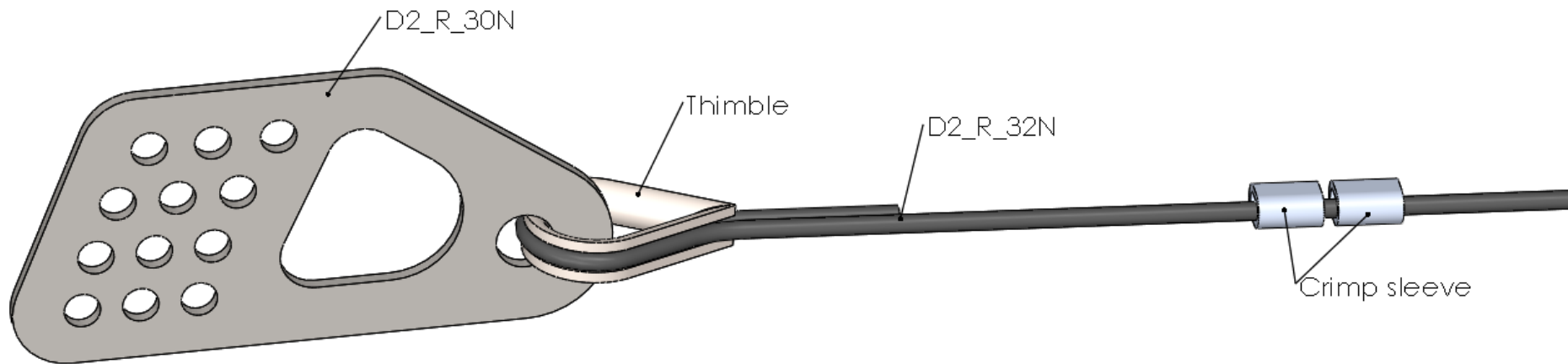
Step 10



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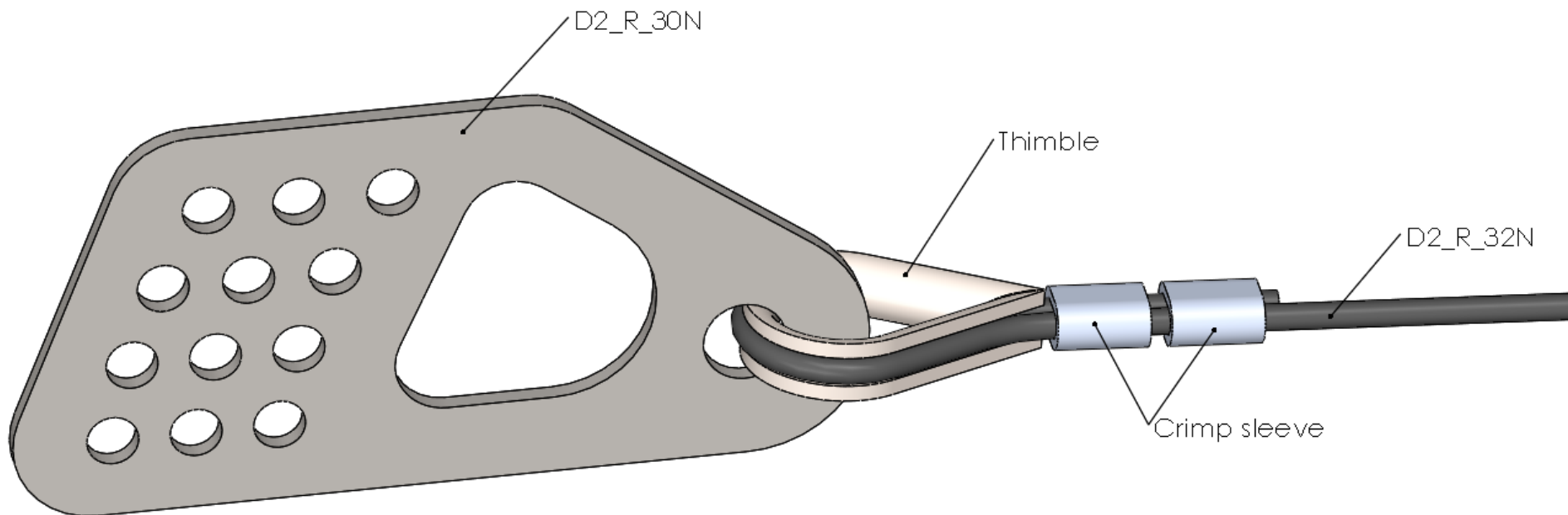
Step 11



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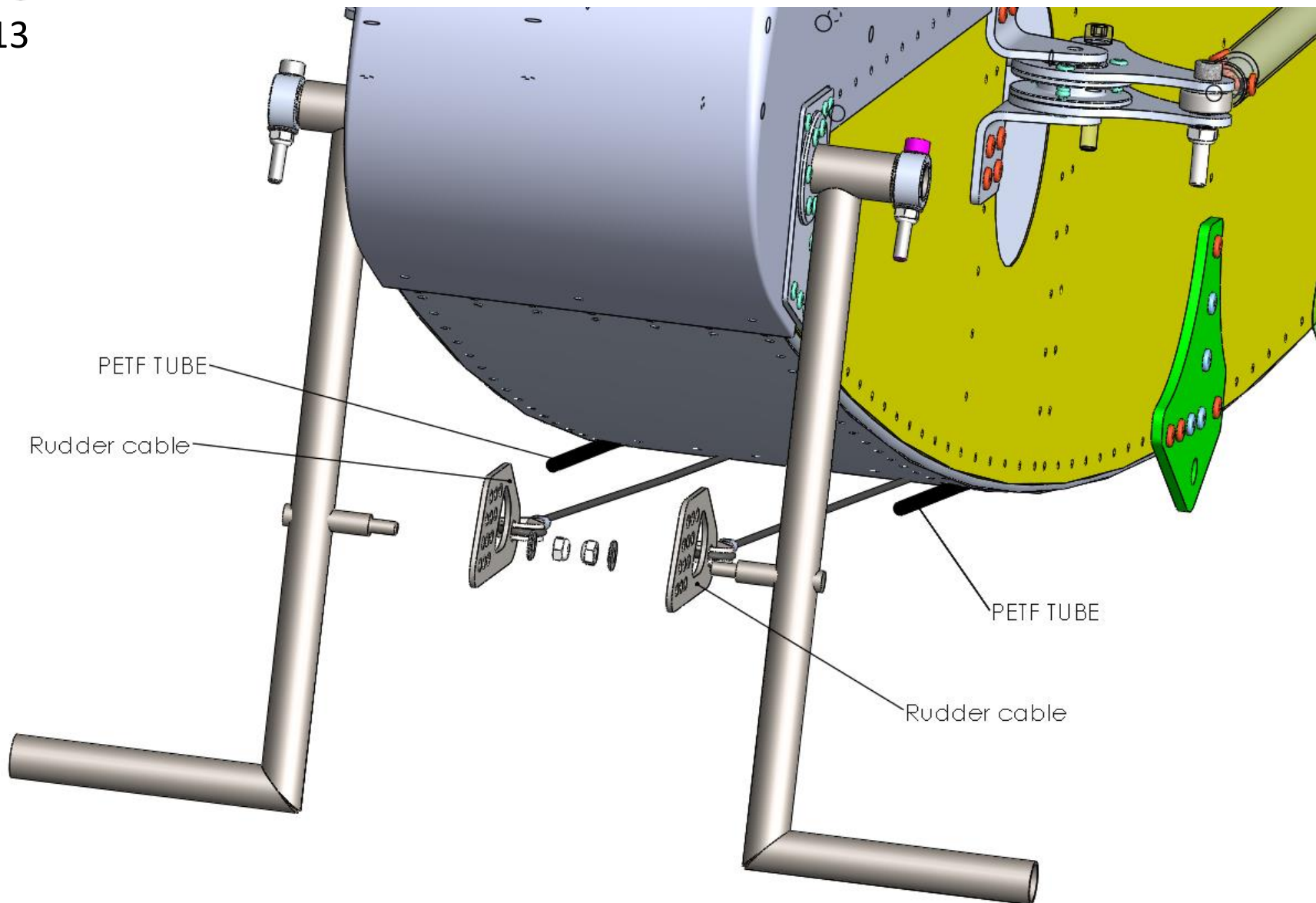
Step 12



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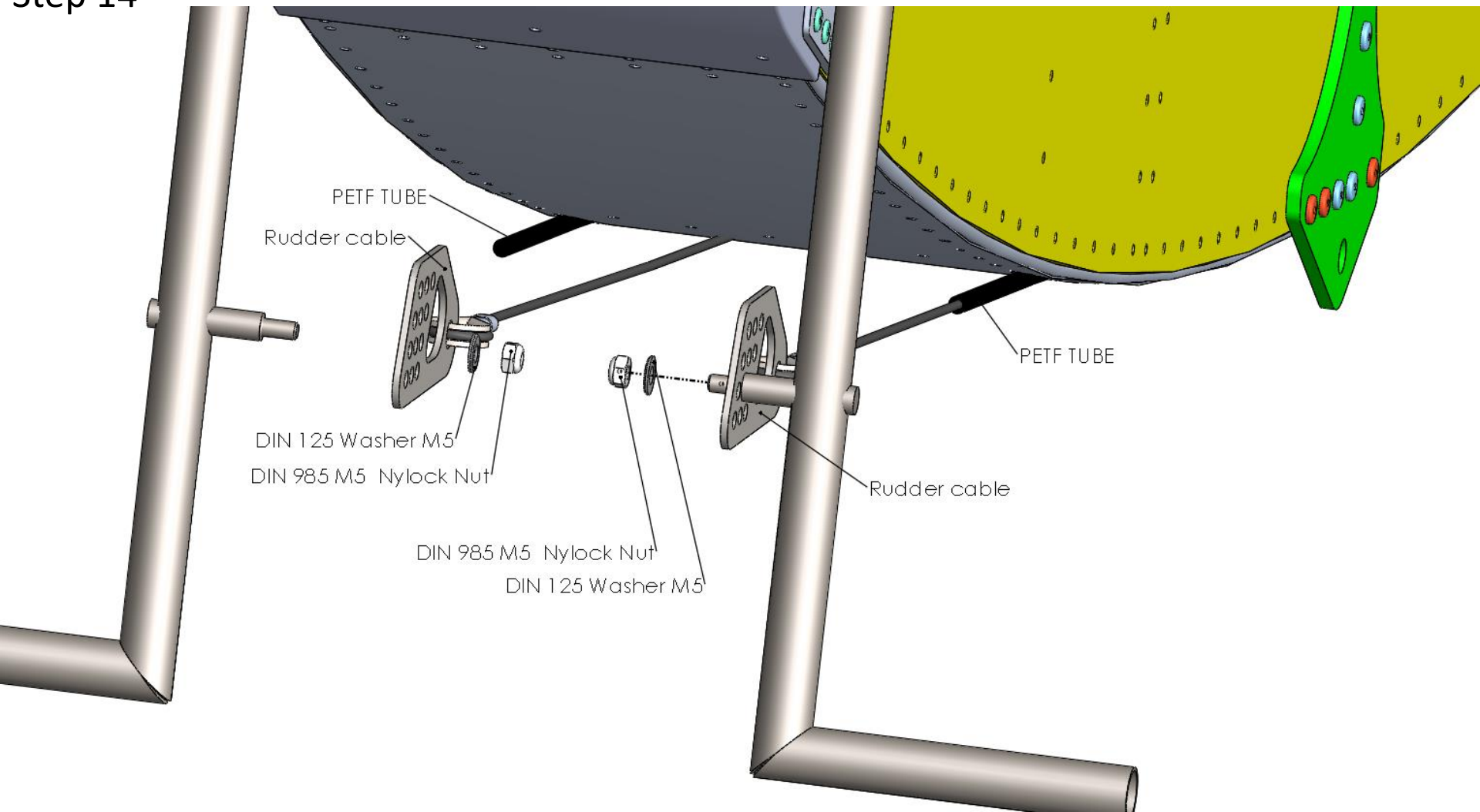
Step 13



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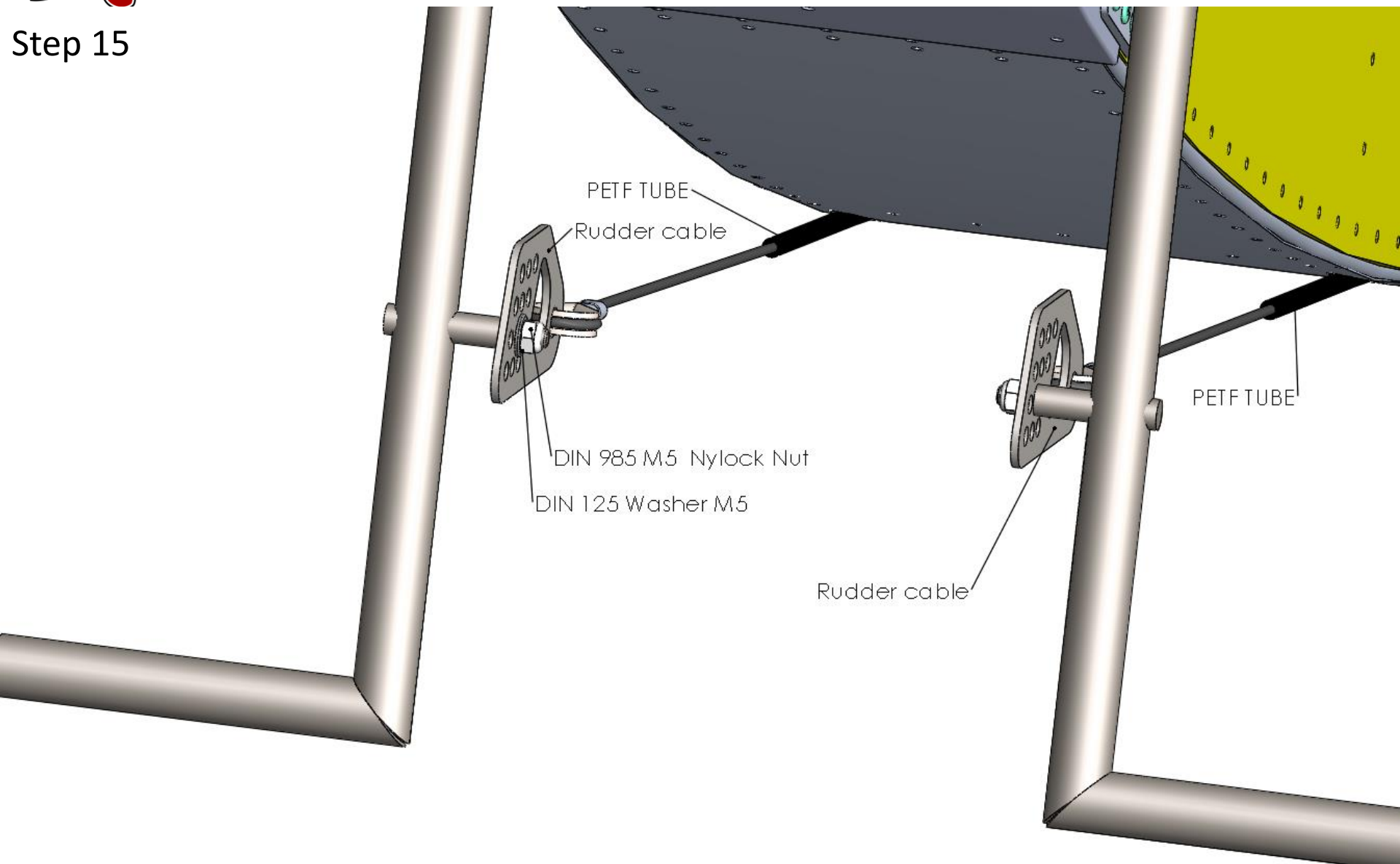
Step 14



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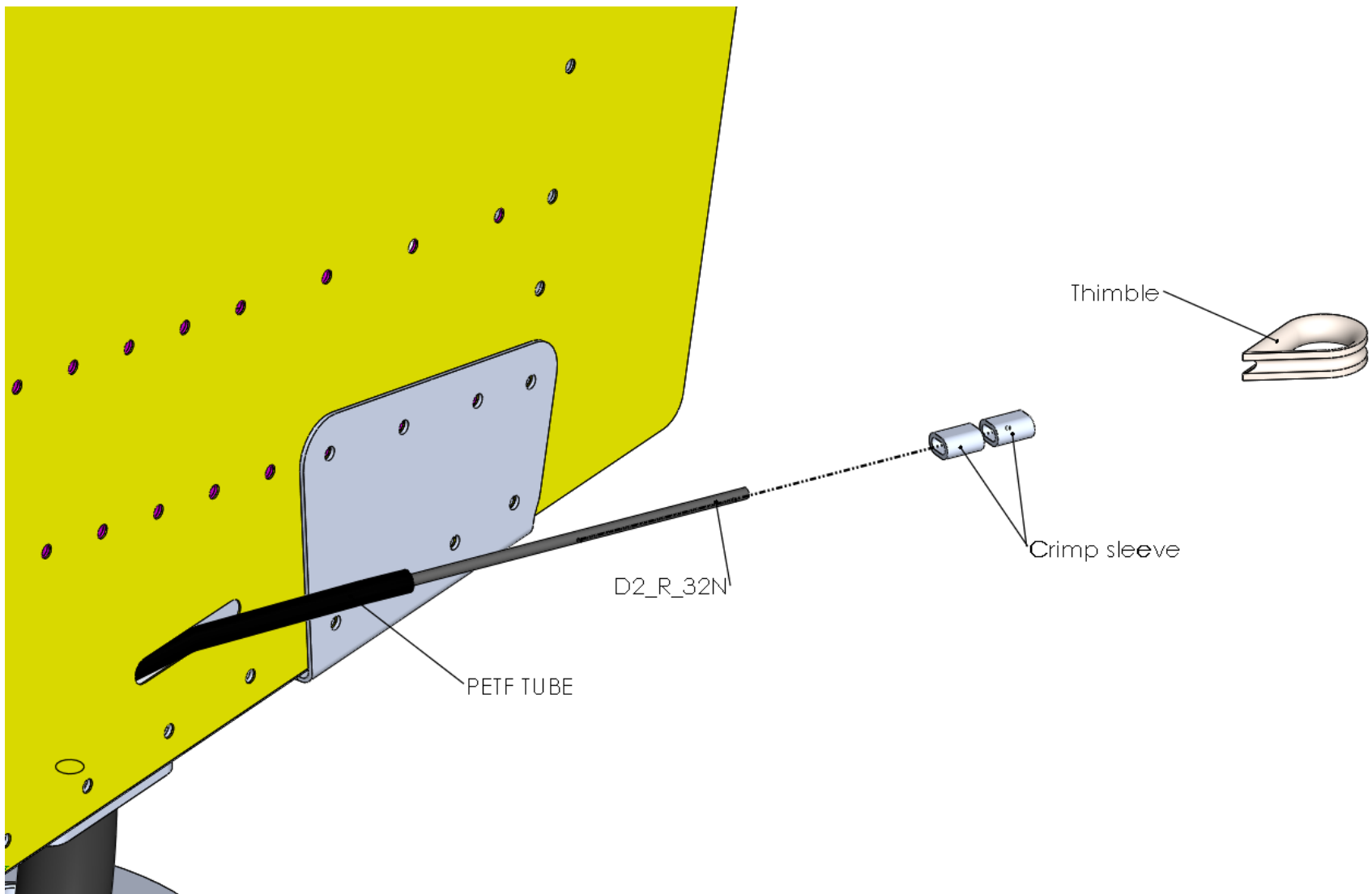
Step 15



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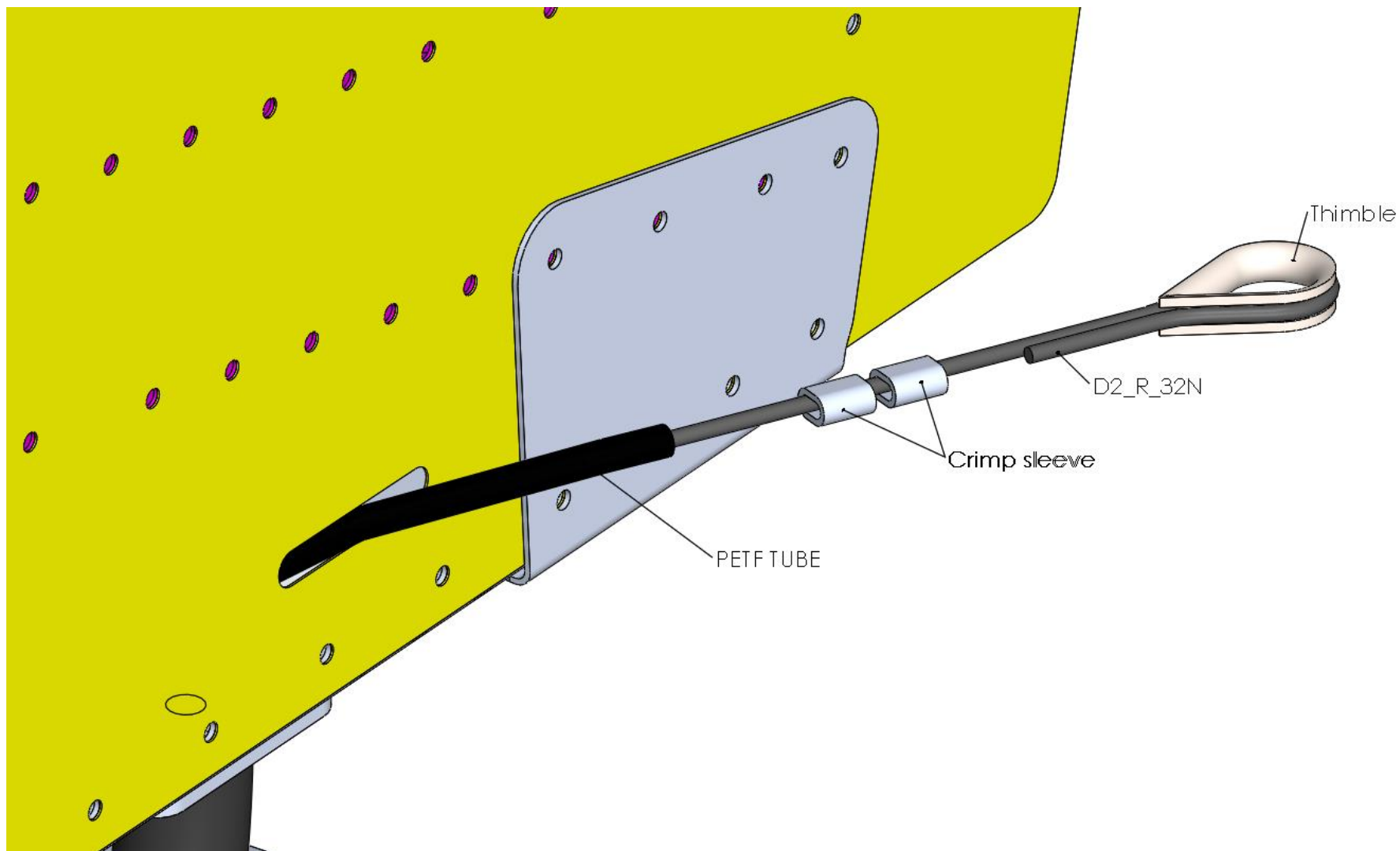
Step 16



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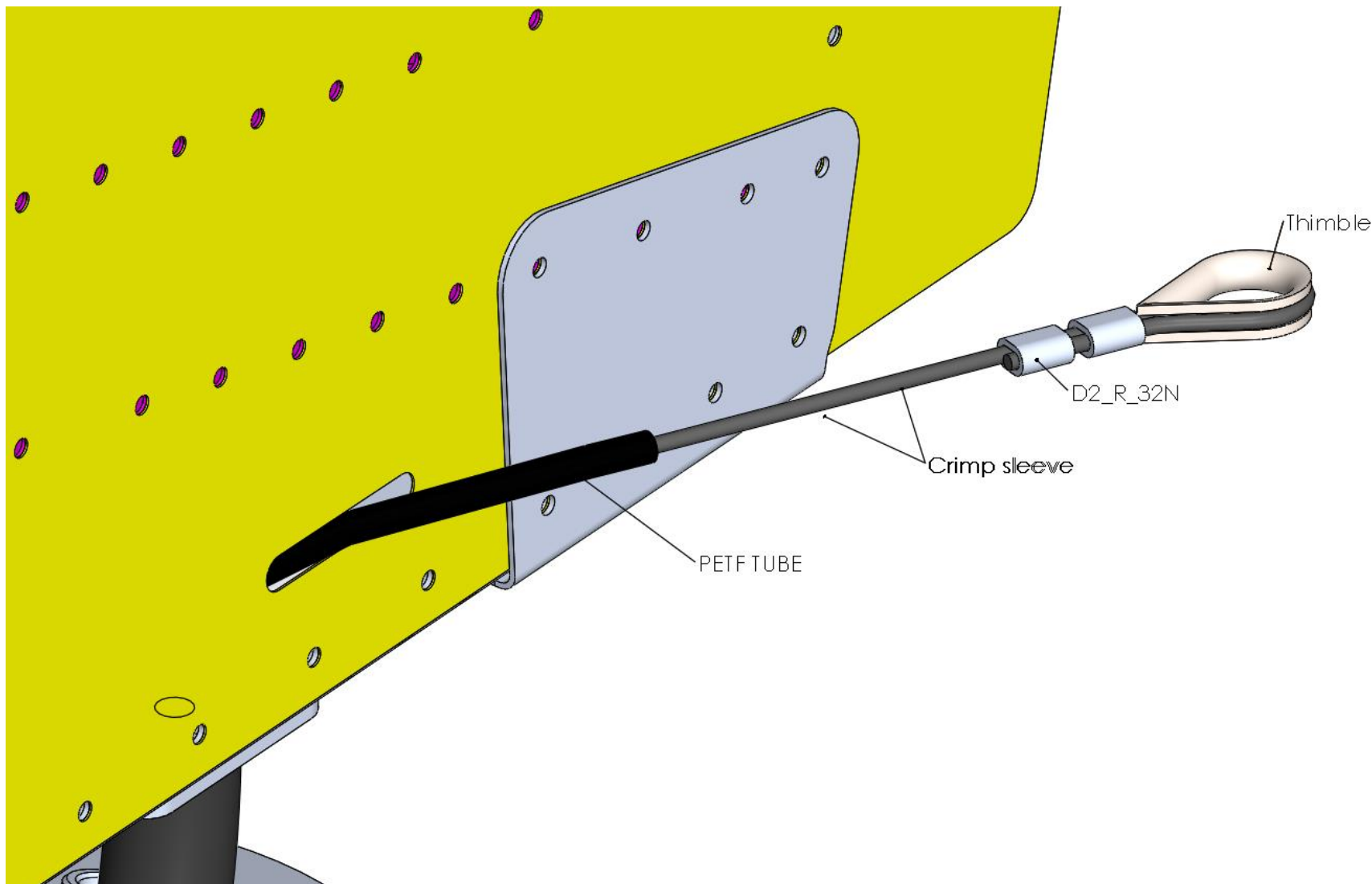
Step 17



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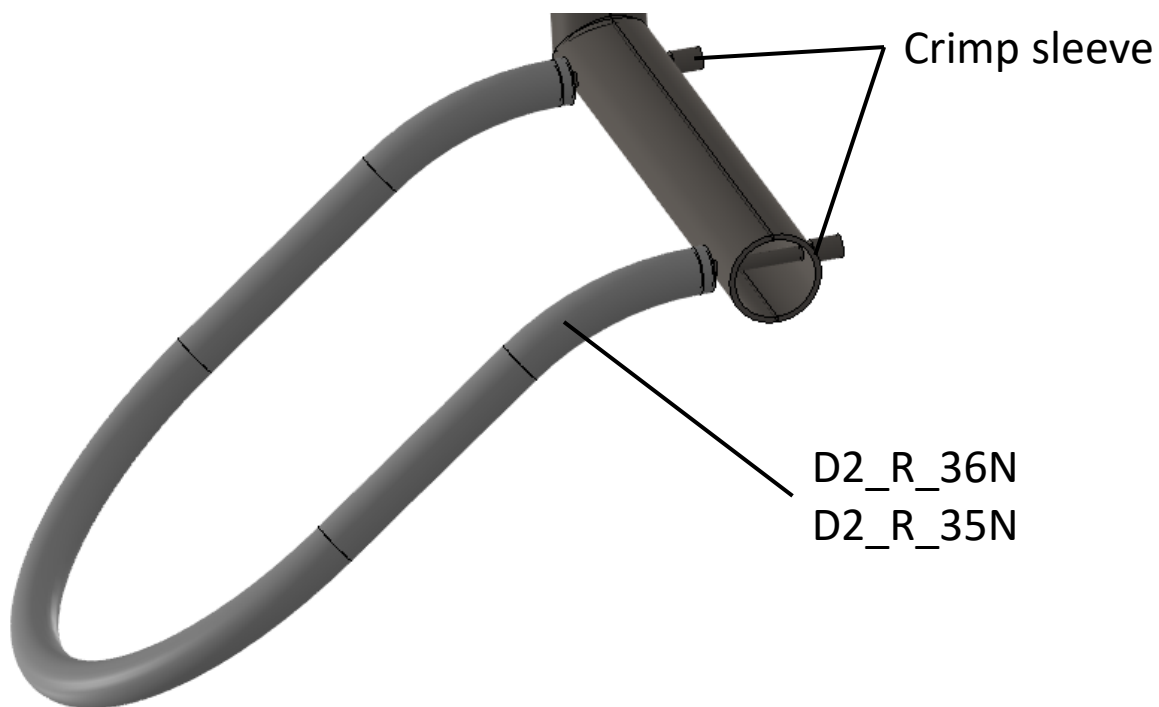
Step 18



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Step 19



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