



Title:

## Elevator assembly manual

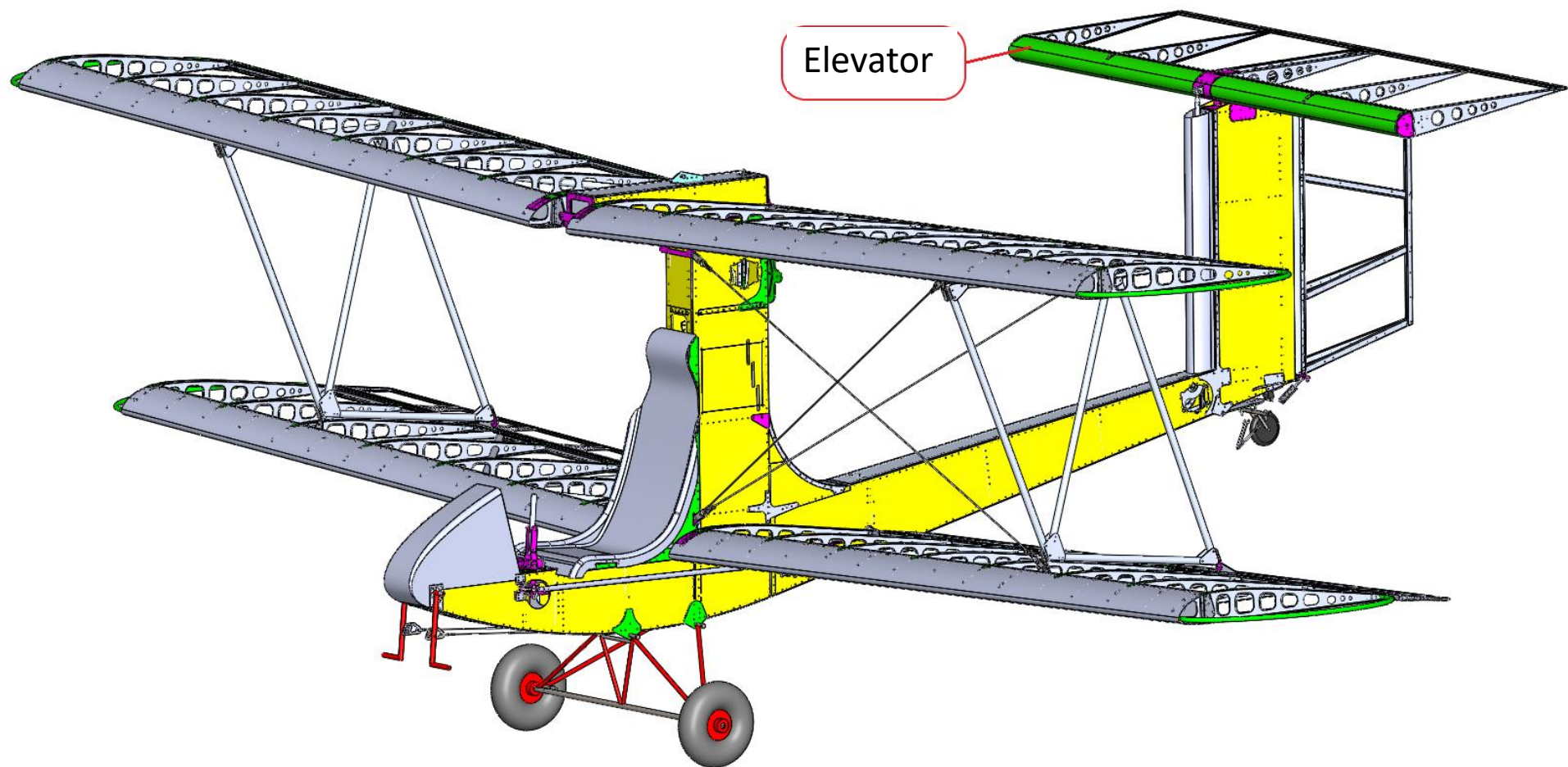
Document no.:

**D2\_T0\_00**

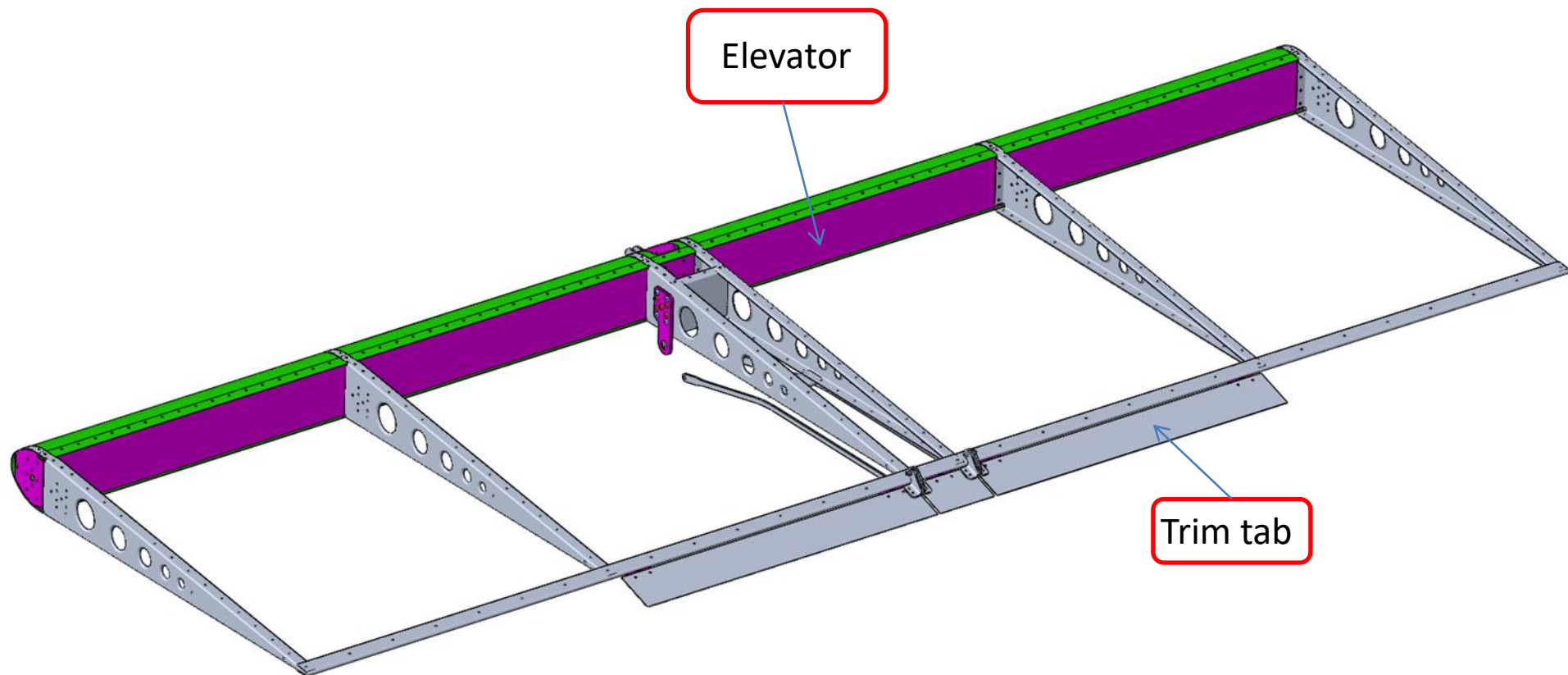
Revision:

**R00**

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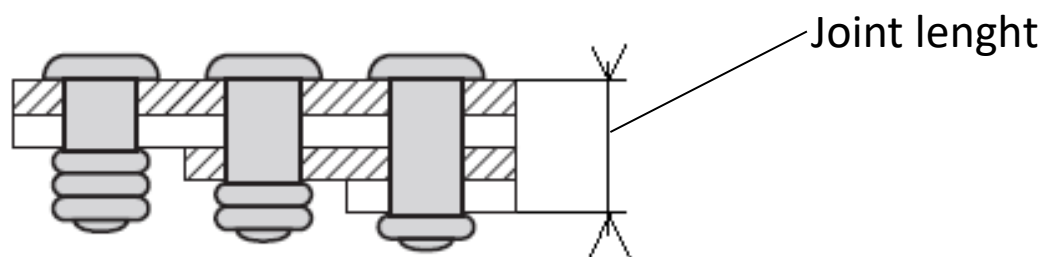
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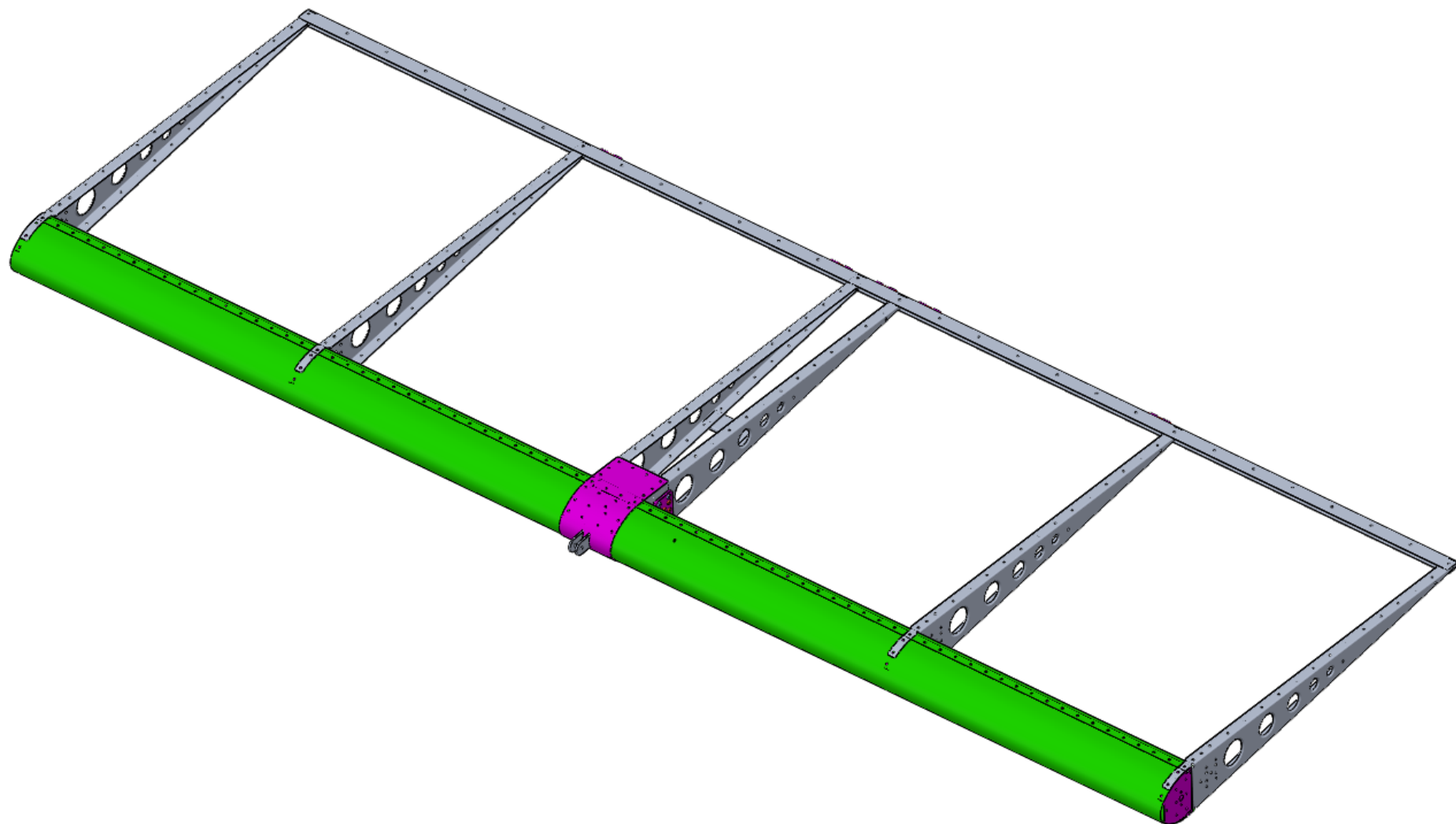
## General instructions:

- If there is no specific rivet shown or called in the assembly, use rivet AVEX 3,2x7,9 Al/St
- Use clecos for the preassembly, as shown in the video tutorial
- Use Polyurethan adhesive PU 50 Emfimastic, where shown in the manual
- 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 $\Phi$ 3,2x7,9 Al/St	16910410	Al 3,2x7,9	AVEX $\Phi$ 3,2x7,9 Al/Fe	0,8mm	4,8mm
AVEX $\Phi$ 3,2x11,2 Al/St	16910414	Al 3,2x11,2	AVEX $\Phi$ 3,2x11,2 Al/Fe	4,0mm	7,9mm
AVEX $\Phi$ 4x9,5 Al/St	16910512	Al 4x9,5	AVEX $\Phi$ 4x9,5 Al/Fe	1,0mm	6,0mm
AVEX $\Phi$ 4x12,7 Al/St	16910516	Al 4x12,7	AVEX $\Phi$ 4x12,7 Al/Fe	4,0mm	9,6mm
AVINOX $\Phi$ 4x12 EST/EST PH	14514012	INOX 4x12	AVINOX $\Phi$ 4x12 EST/EST PH	3,5mm	7,0mm

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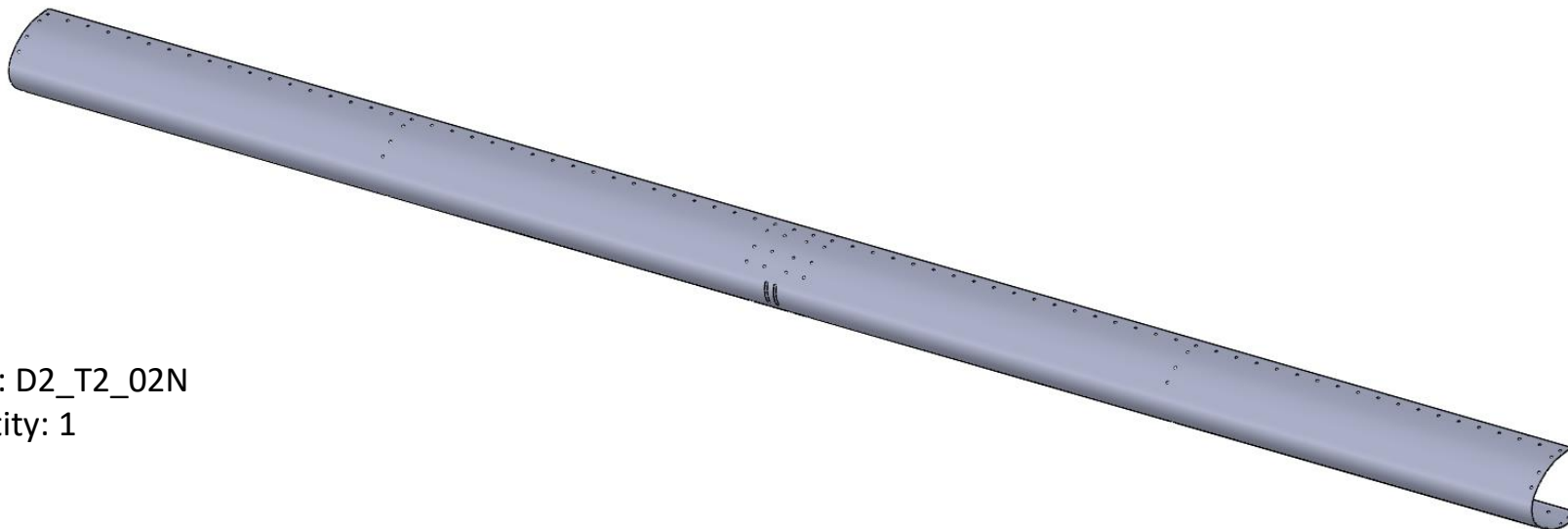


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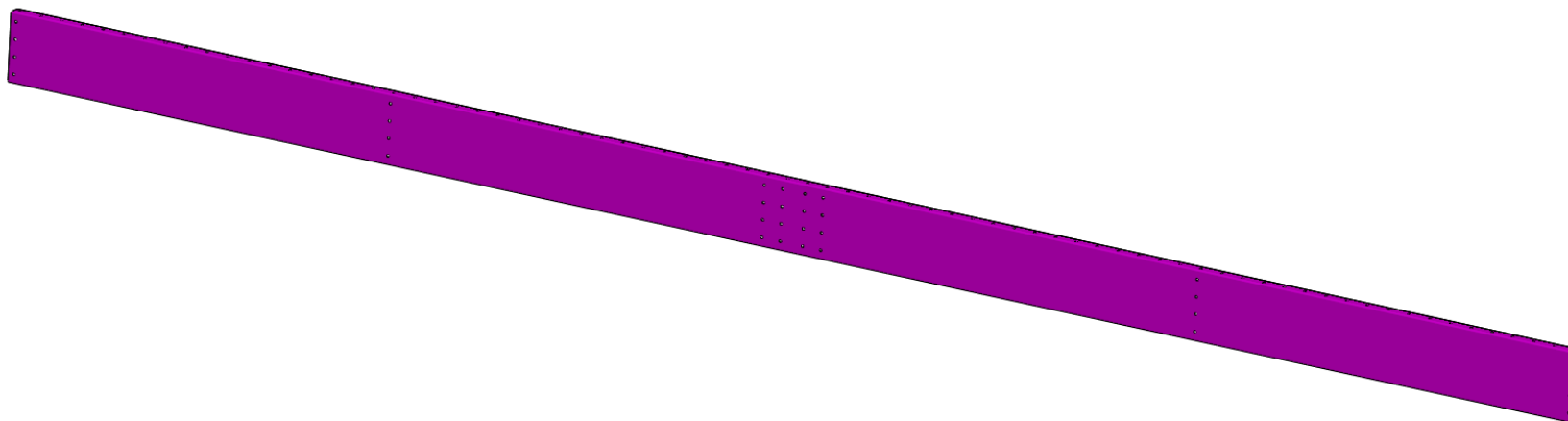
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Quantity: 1



Detail: D2\_T2\_02N

Quantity: 1

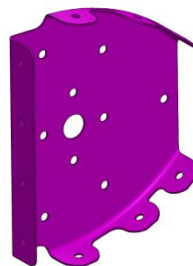


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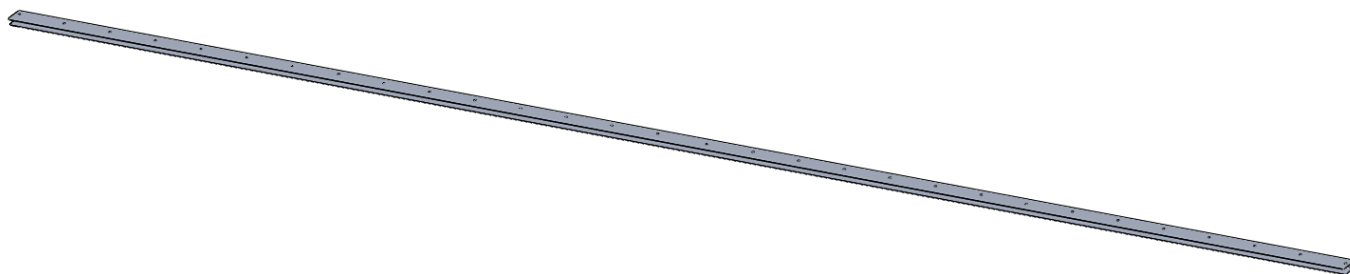
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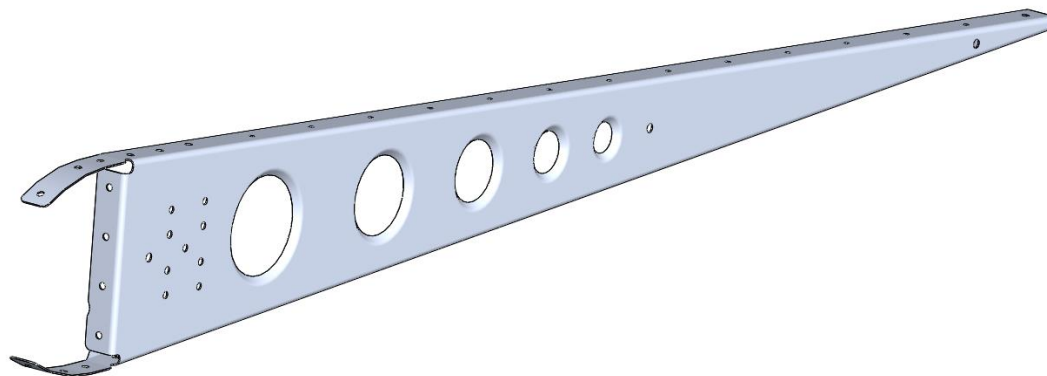
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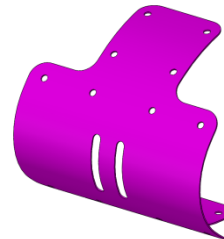
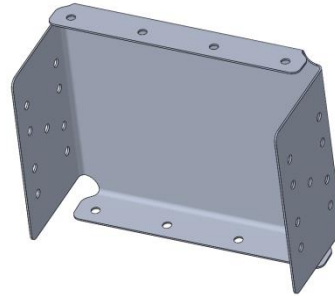
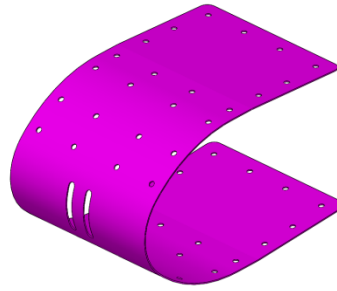


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Detail: D2\_T2\_07N  
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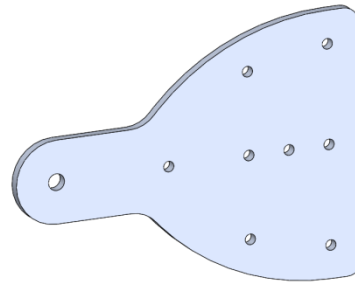
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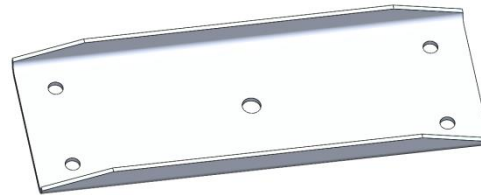




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Detail: D2\_T2\_12N  
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Detail: D2\_T2\_13N  
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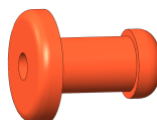
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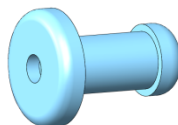
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Quantity: 10



Detail: Rivet INOX 4 x12

Quantity: 14



Detail: Rivet Al/St 3,2x7,9

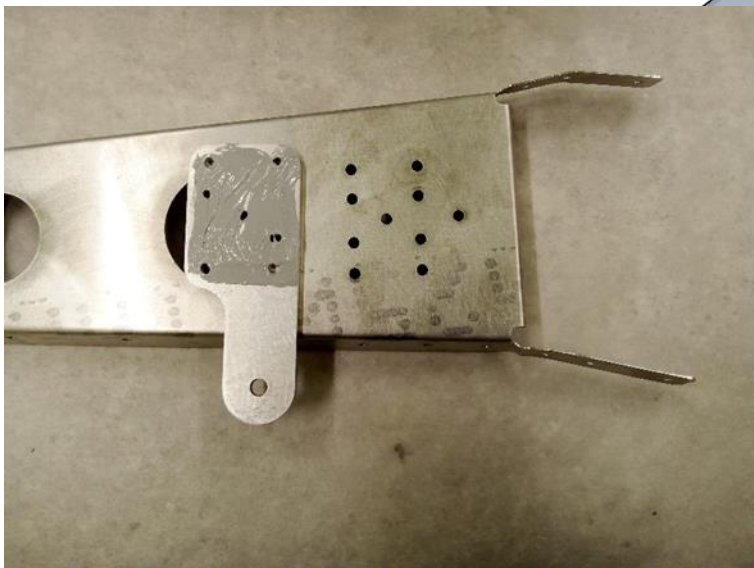
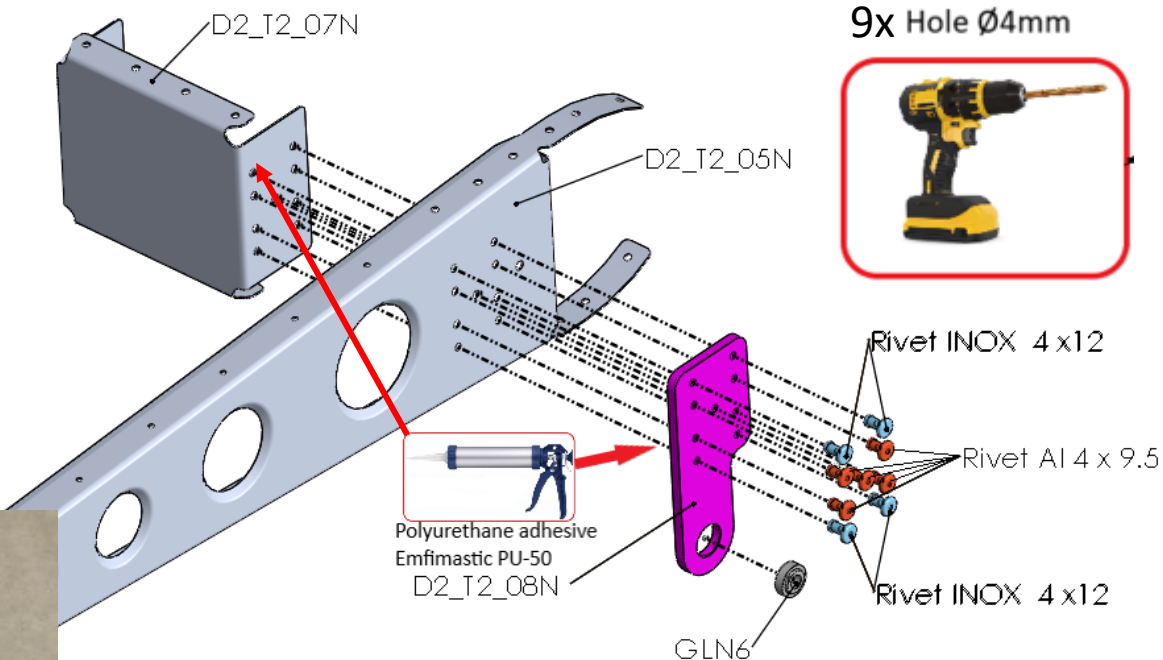
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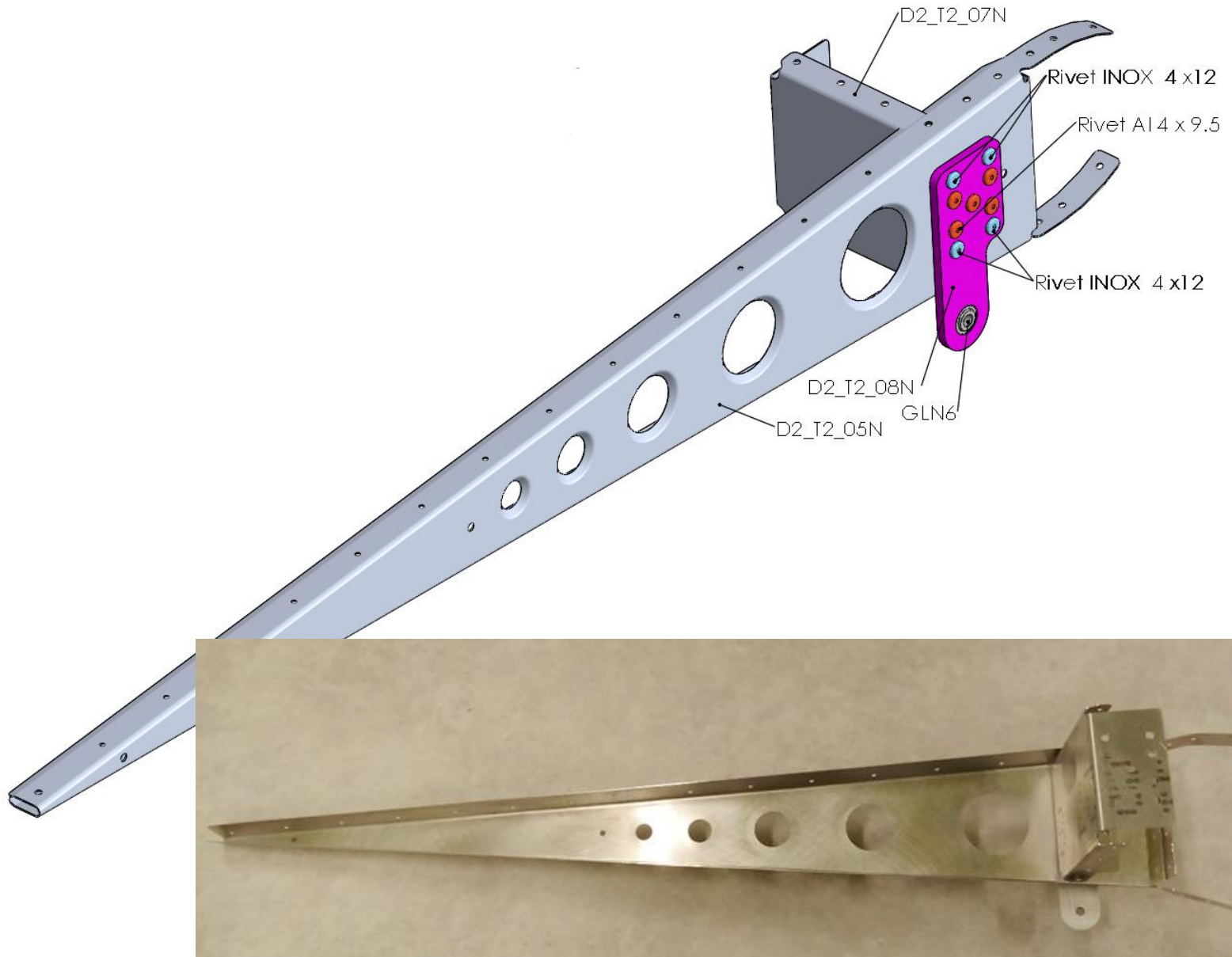
Step 1



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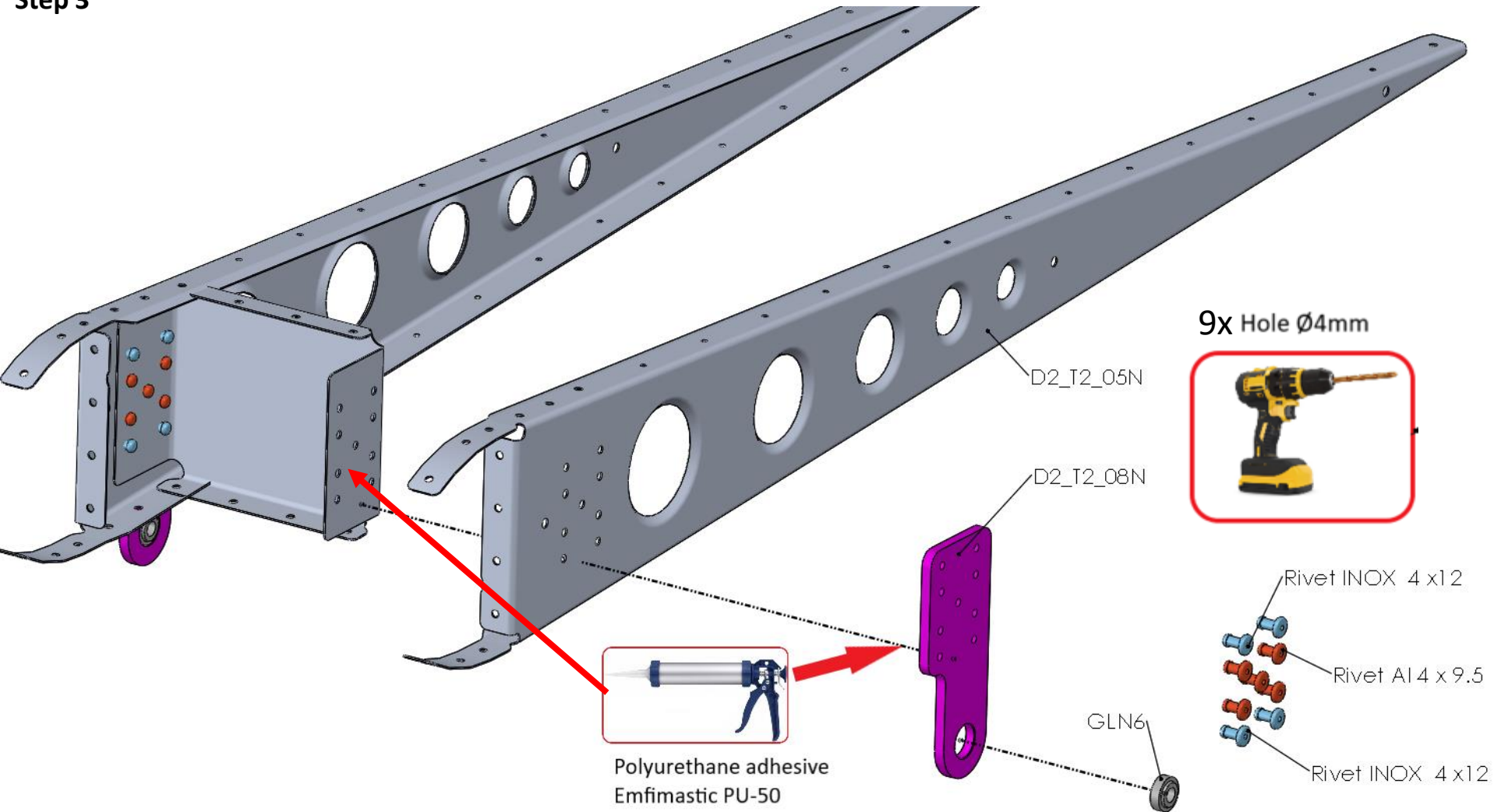
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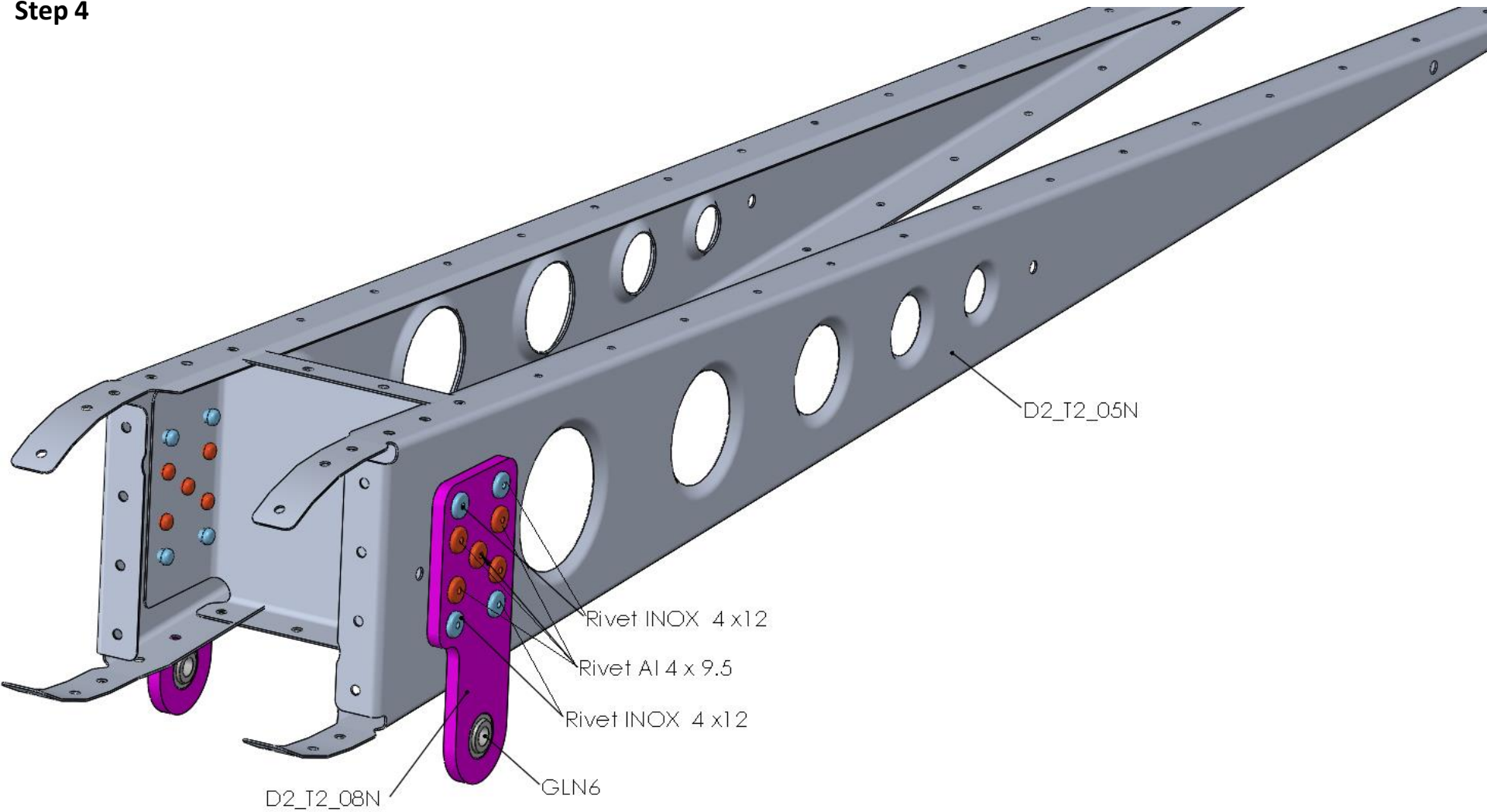
Step 3



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Step 4

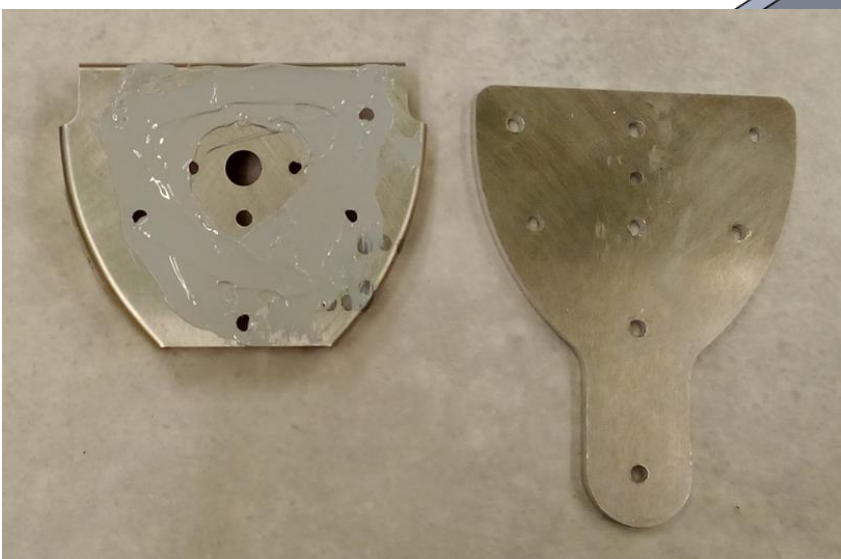
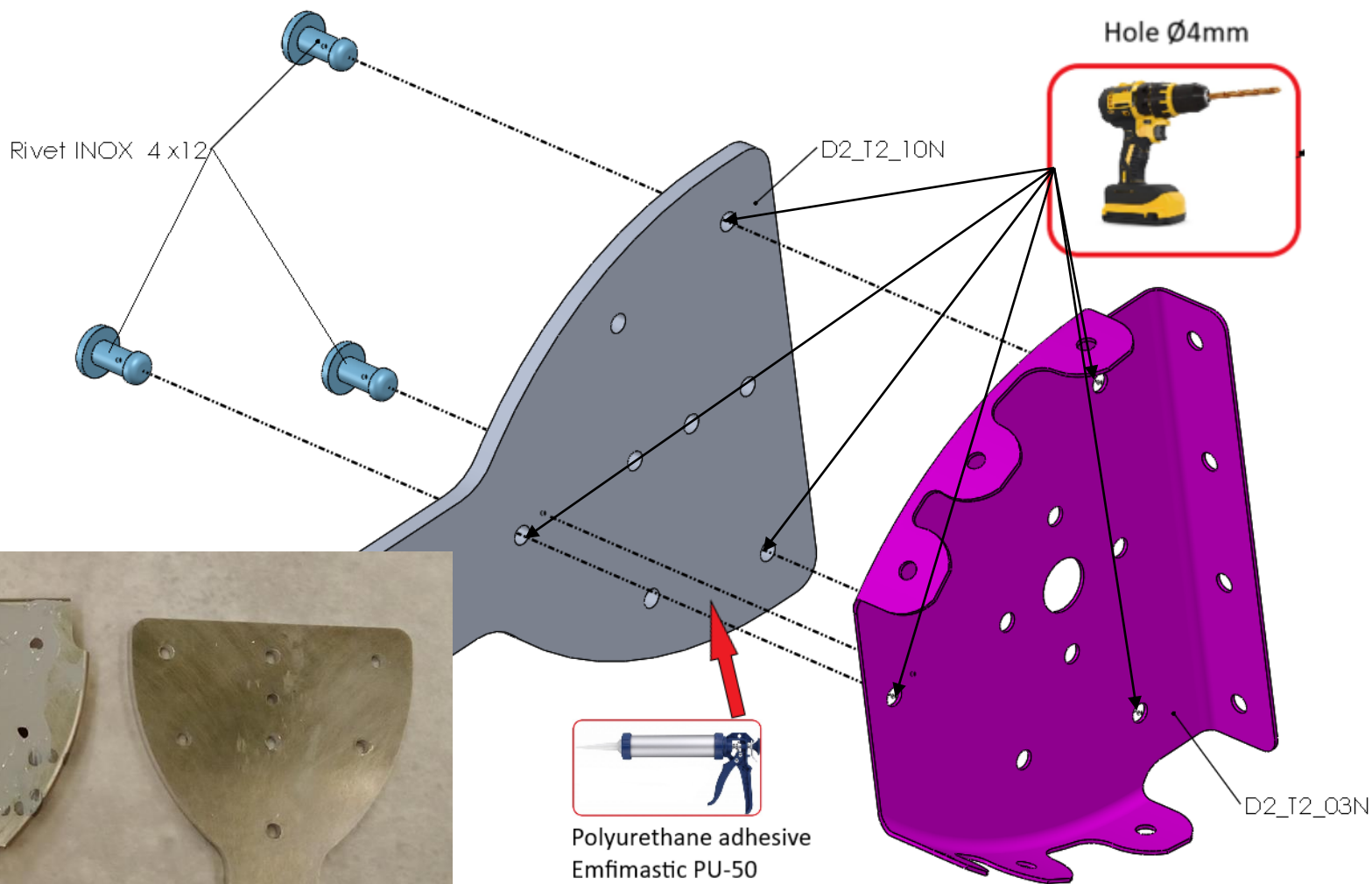


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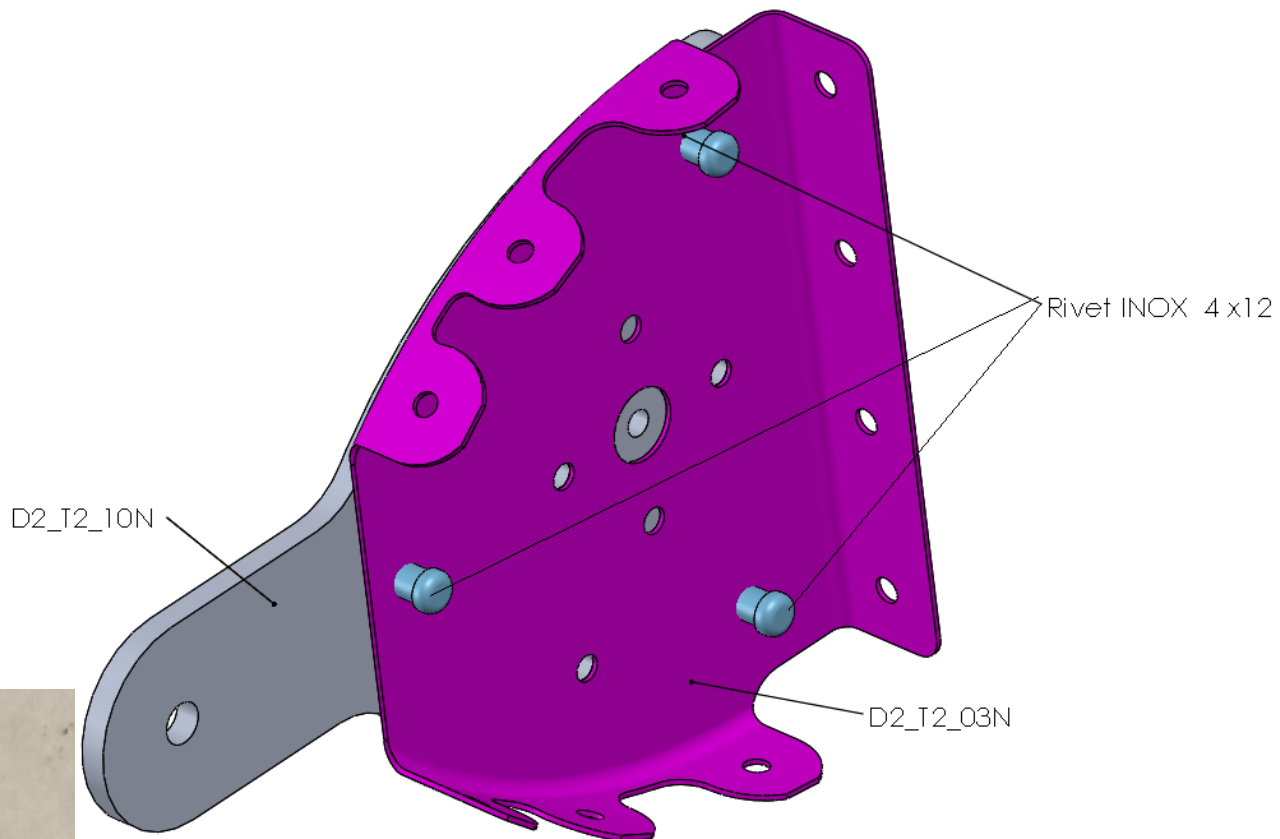
Step 5



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Step 6

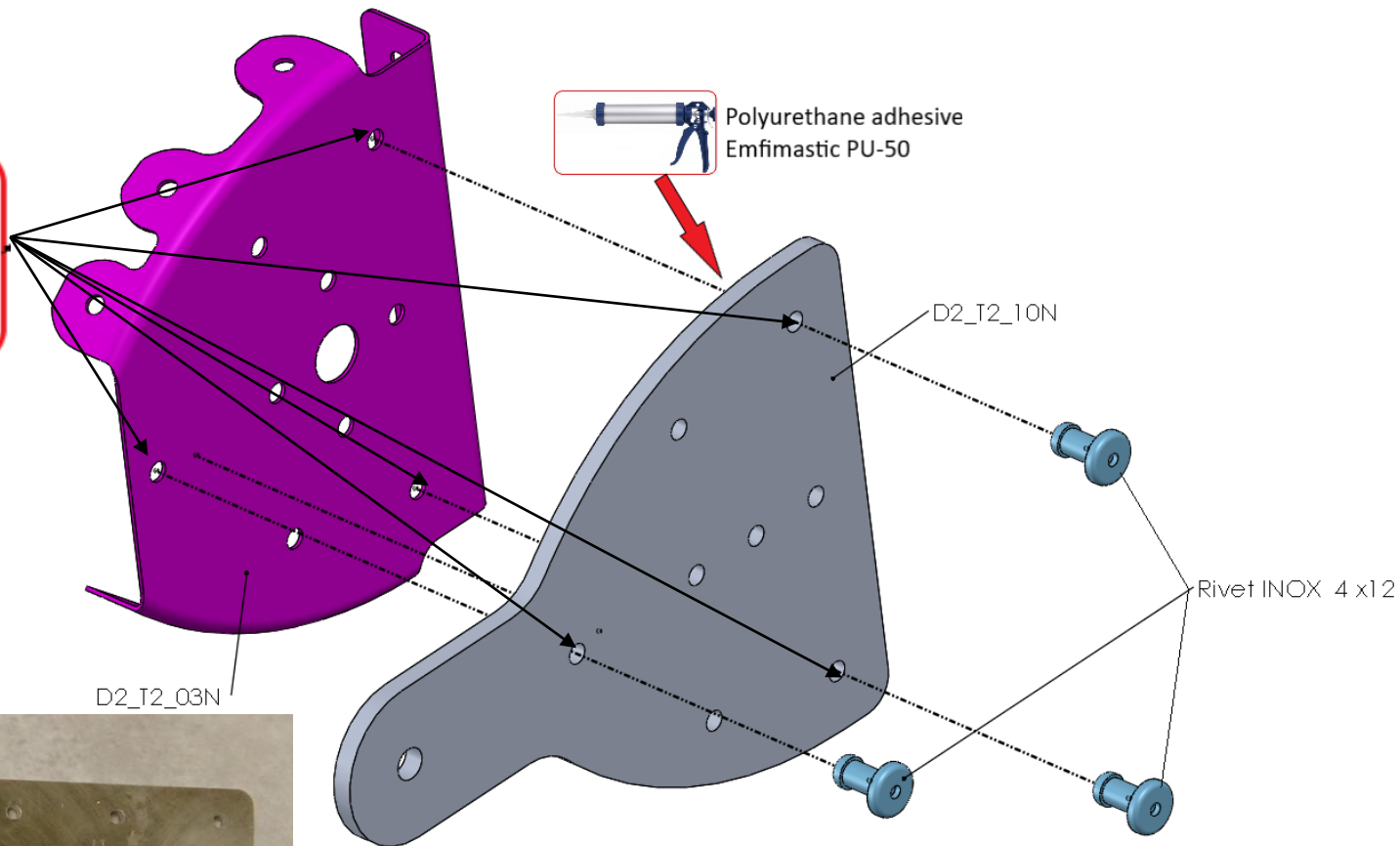


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Step 7

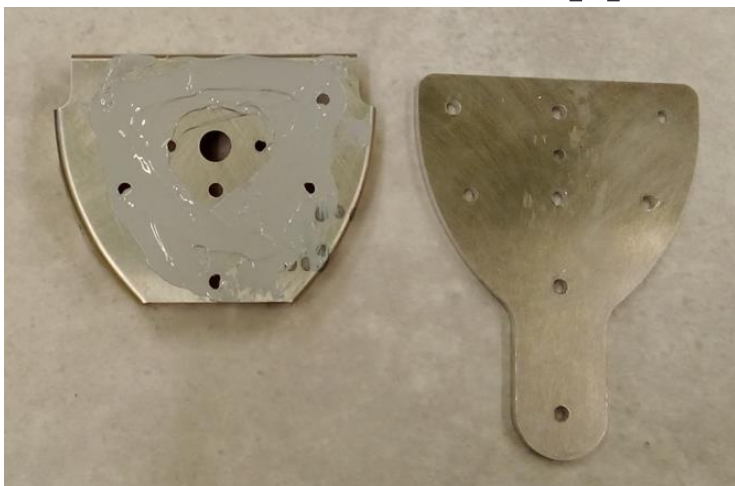
Hole Ø4mm



D2\_I2\_03N

D2\_I2\_10N

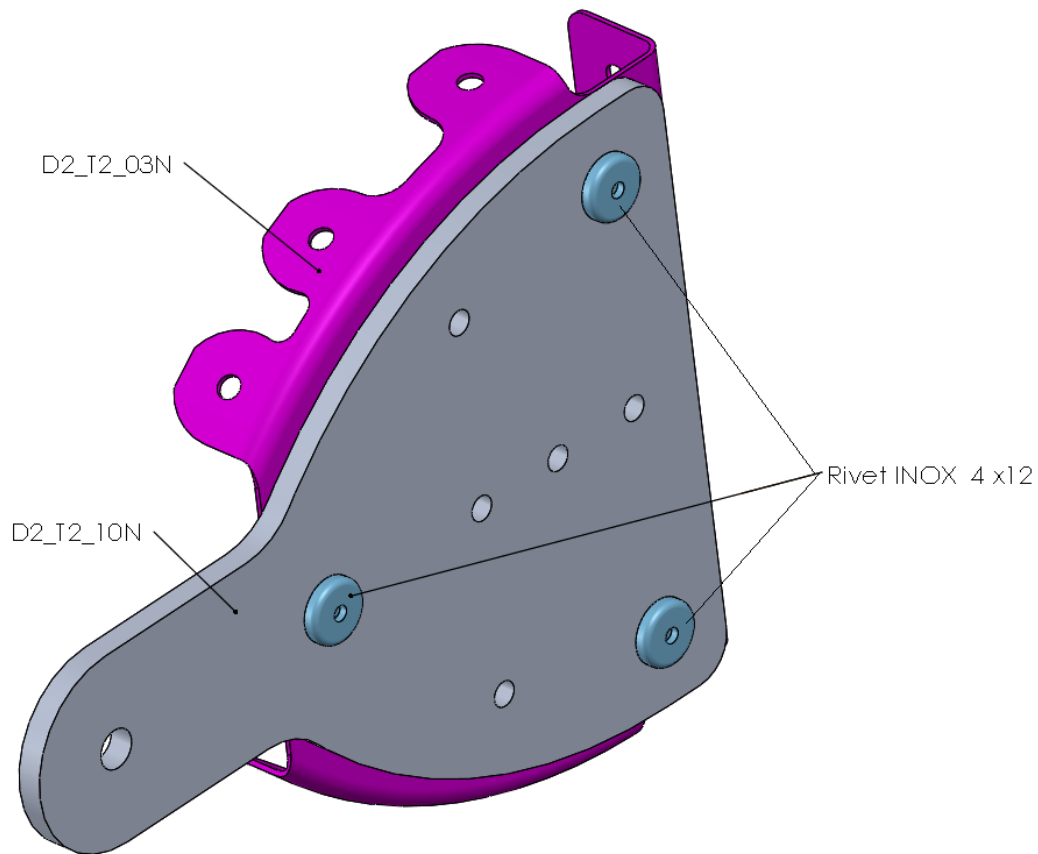
Rivet INOX 4 x12



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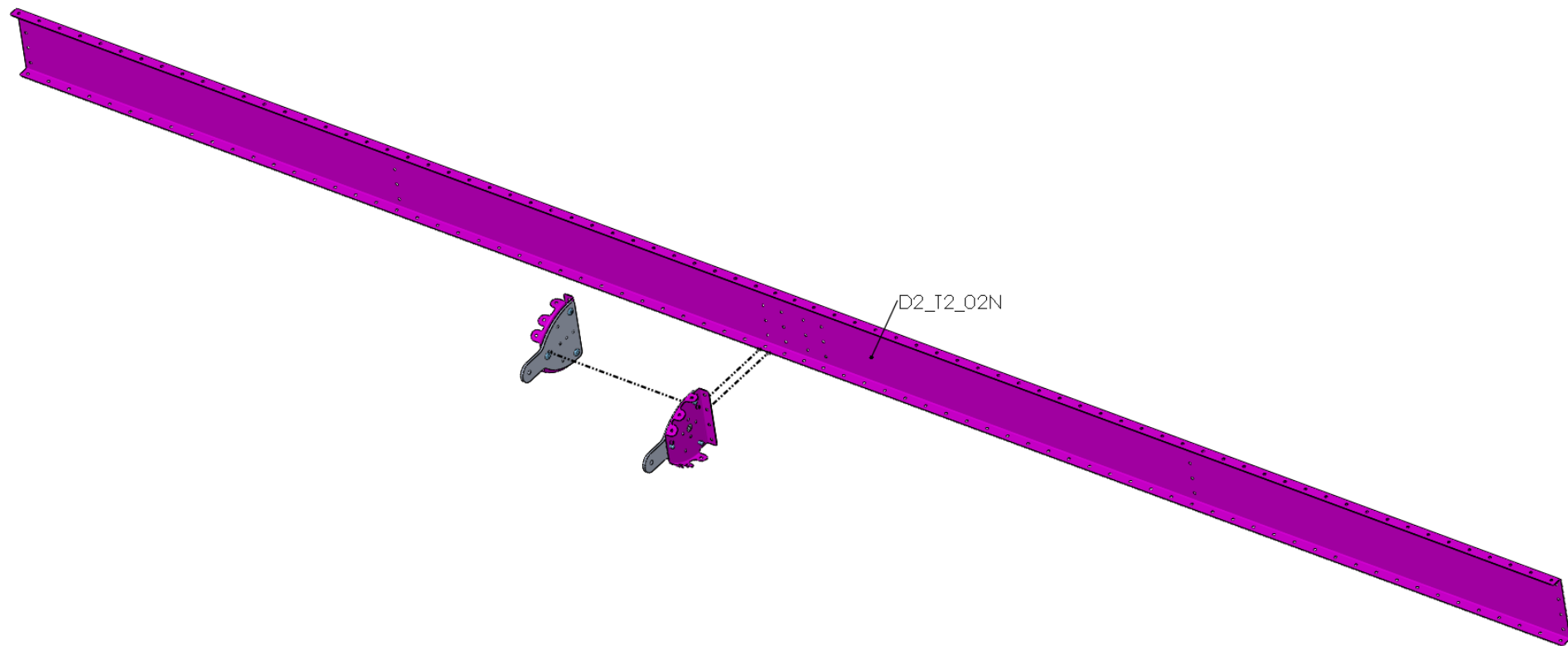
Step 8



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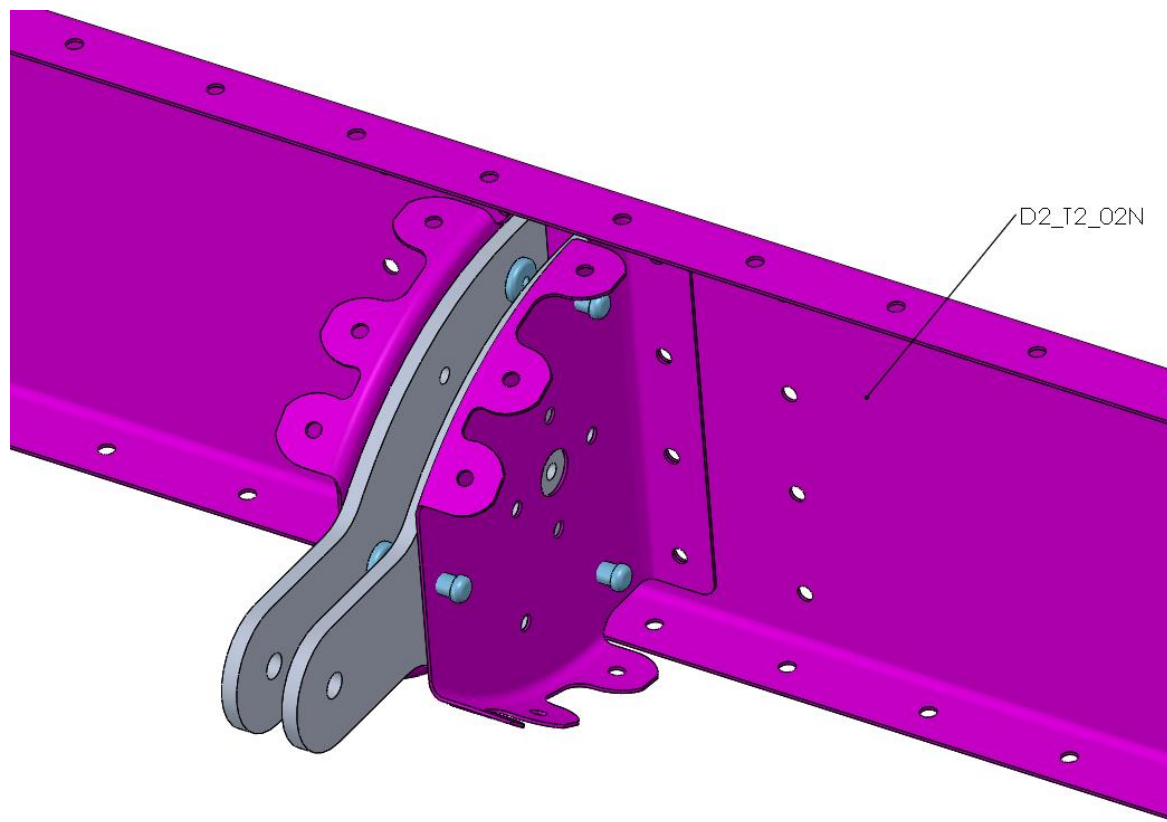
Step 9



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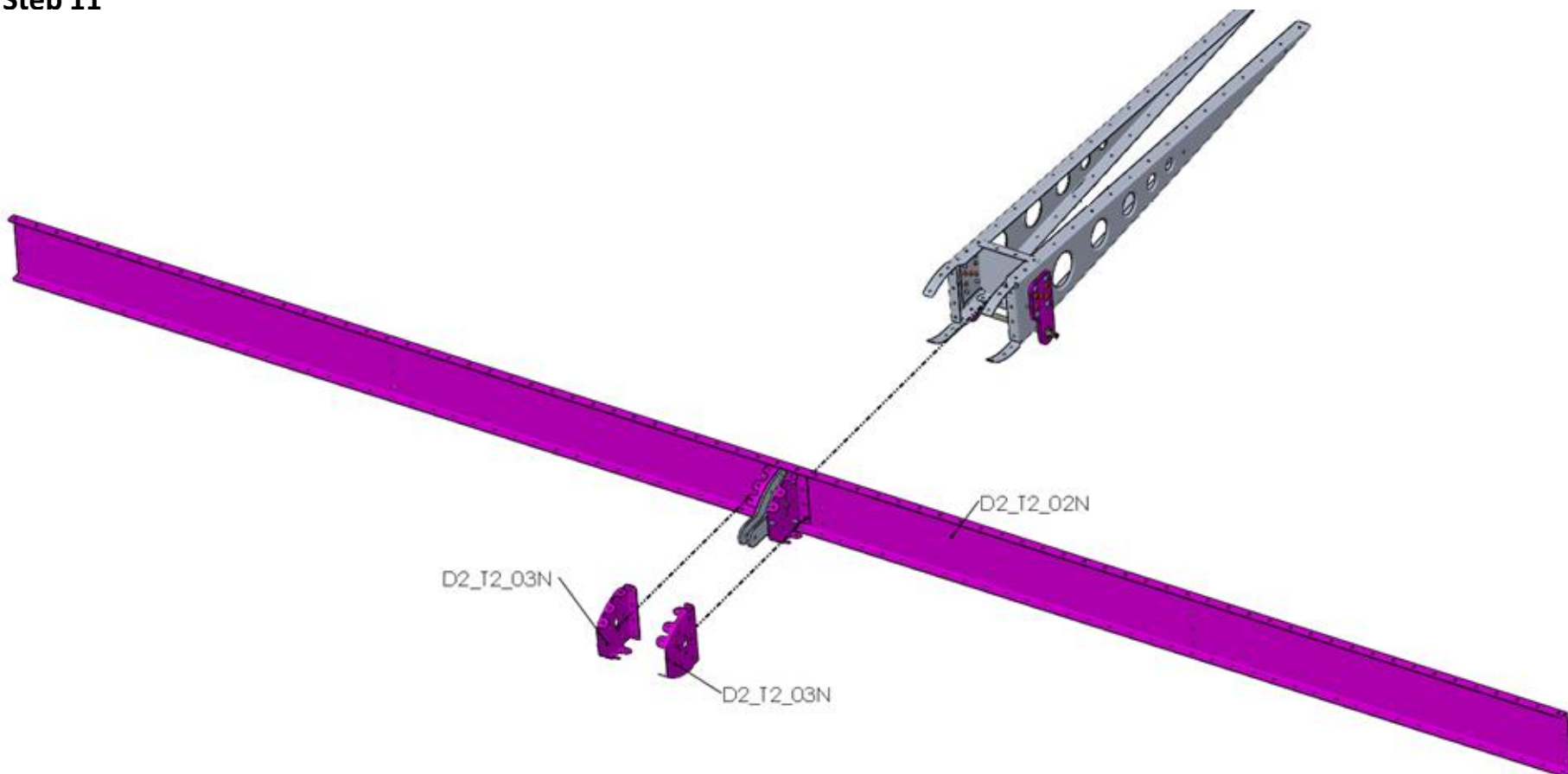
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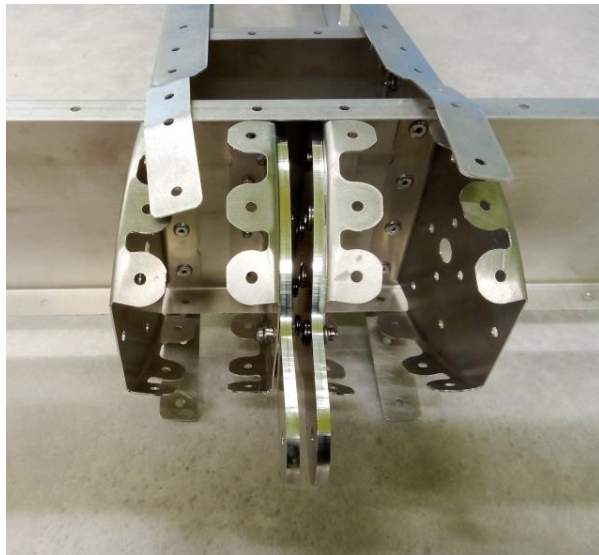
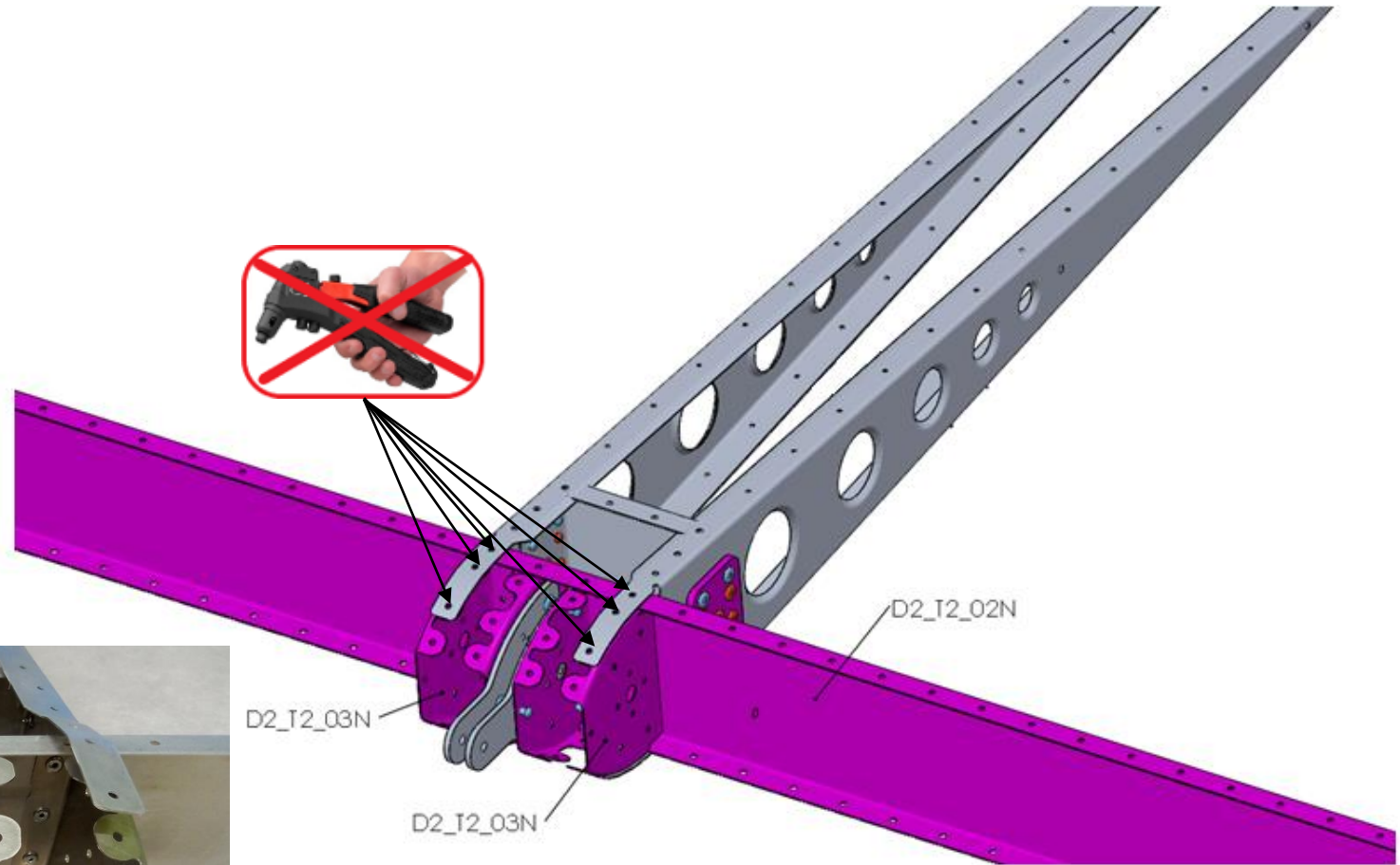
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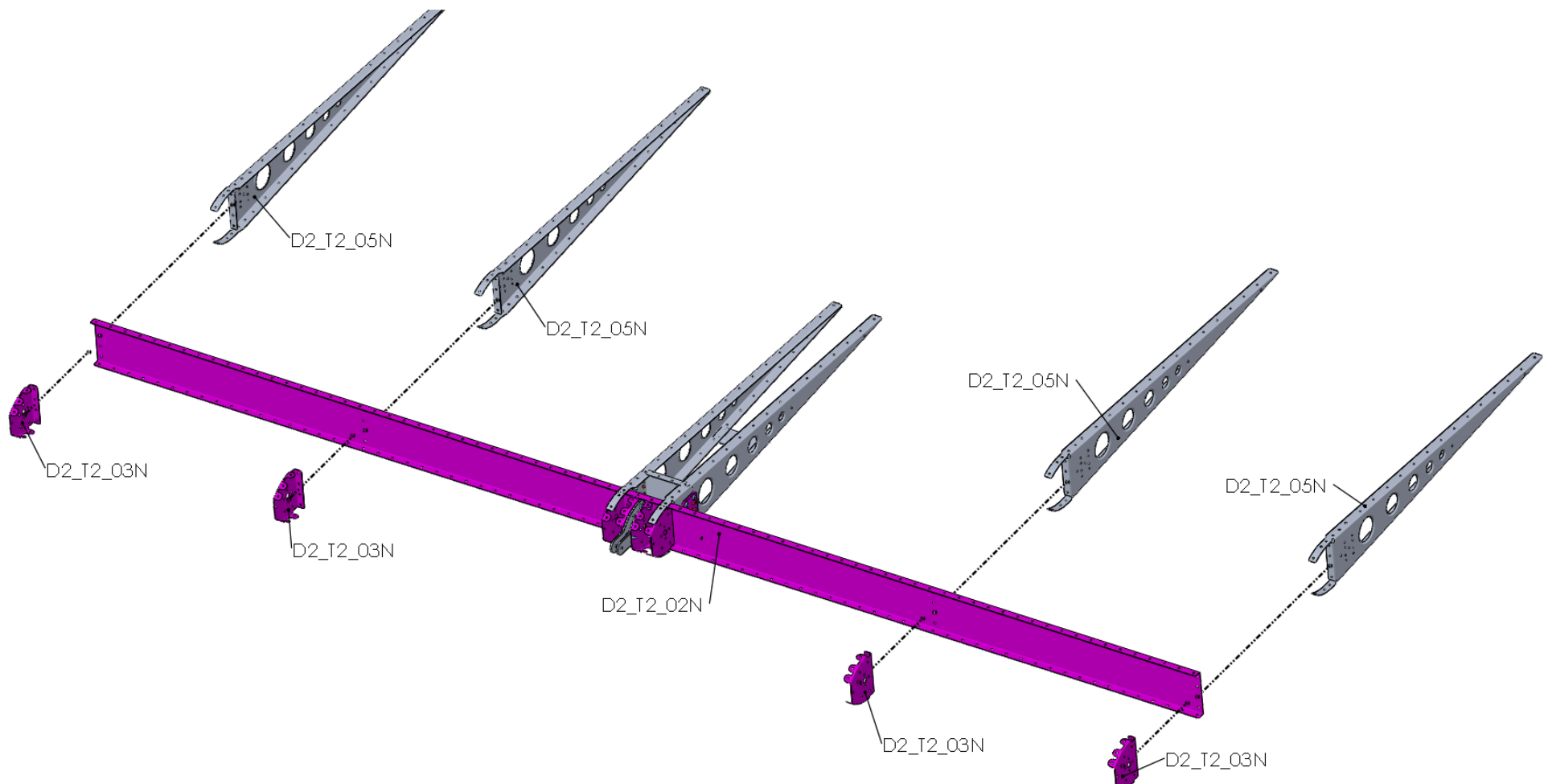
Step 12



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Step 13

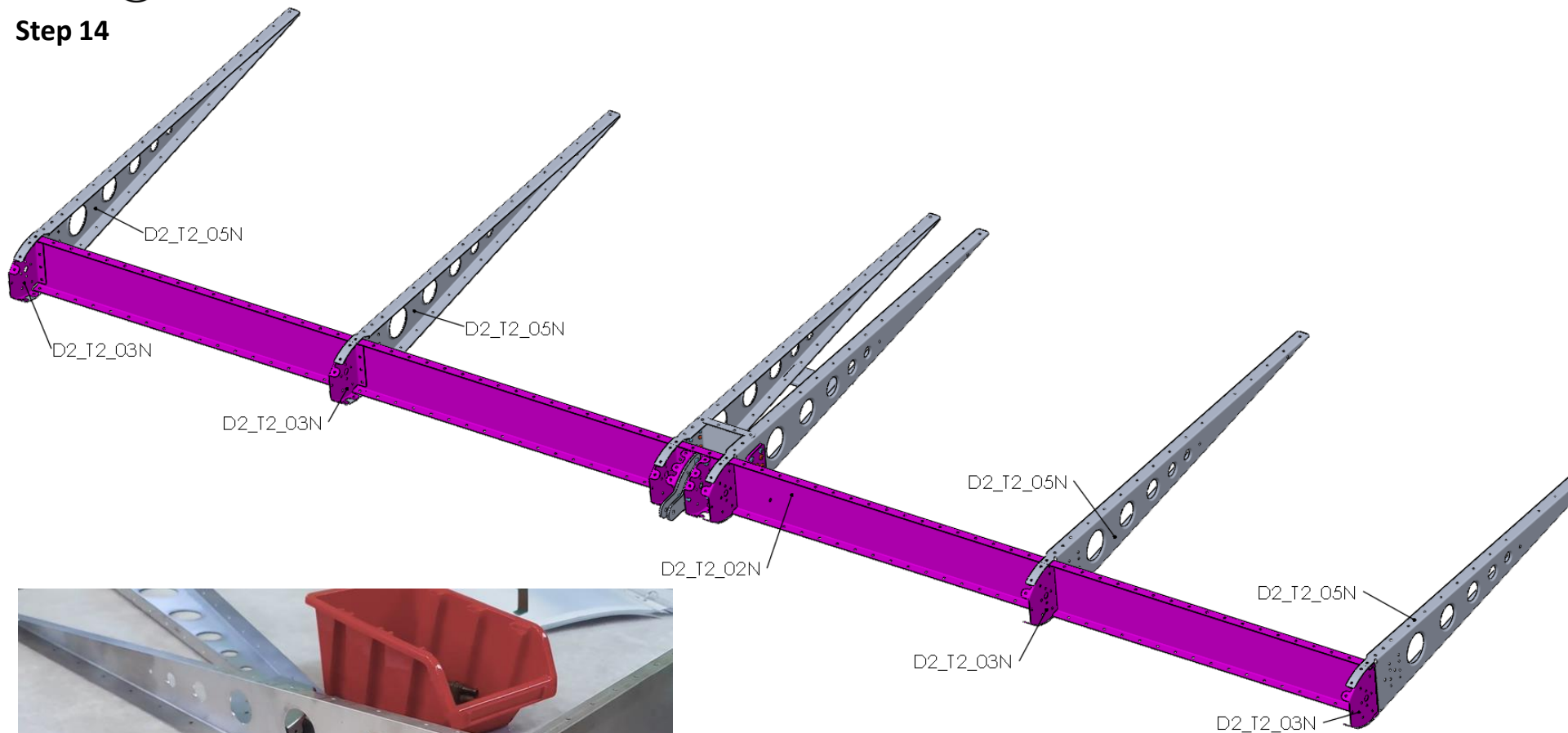


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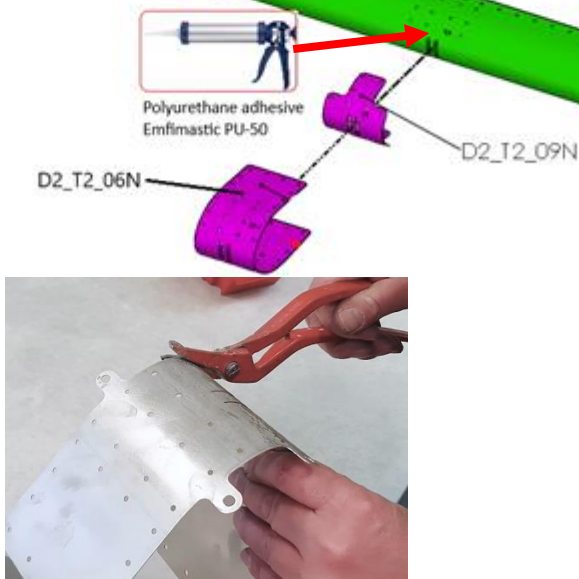
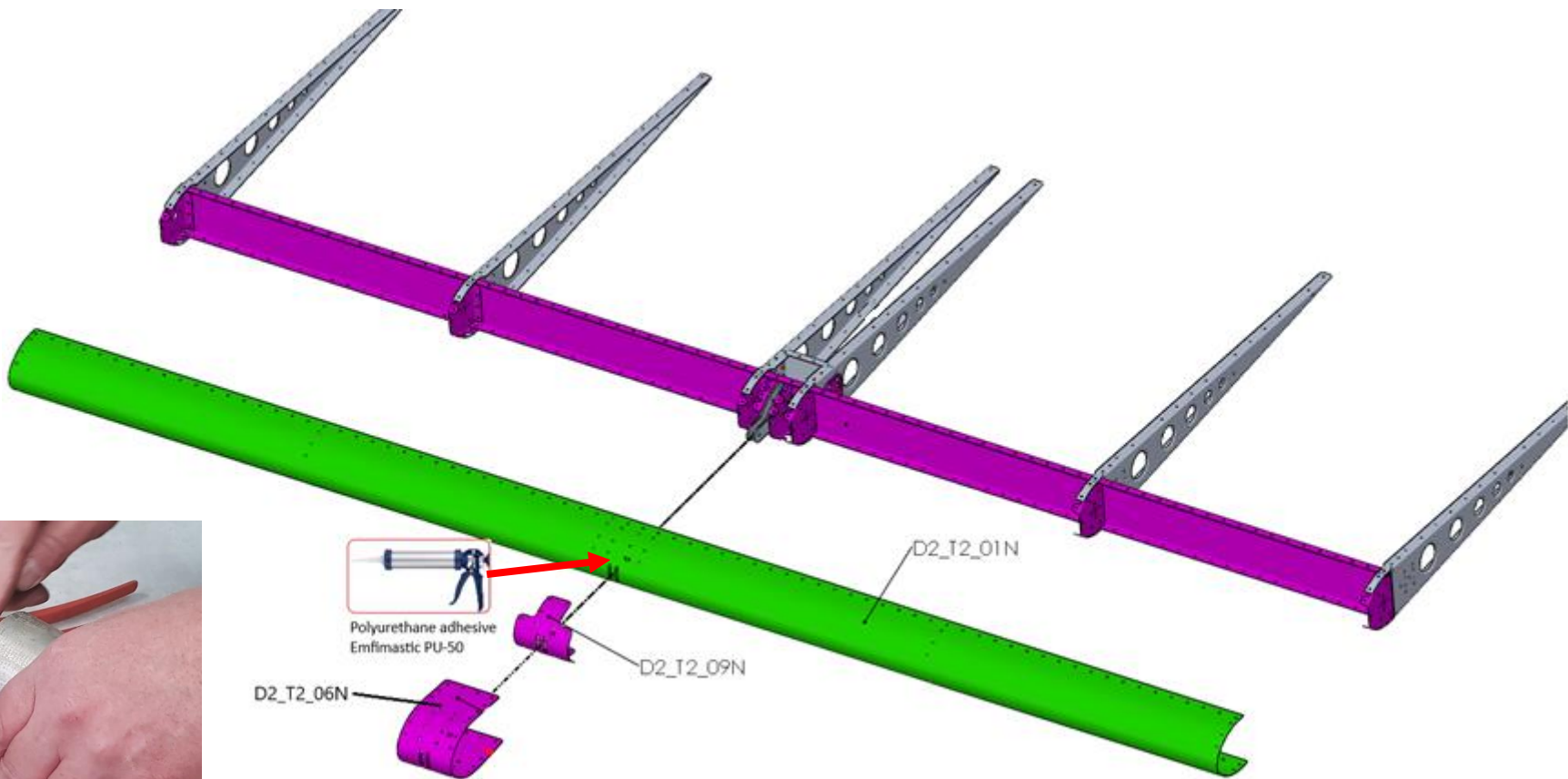


Step 14



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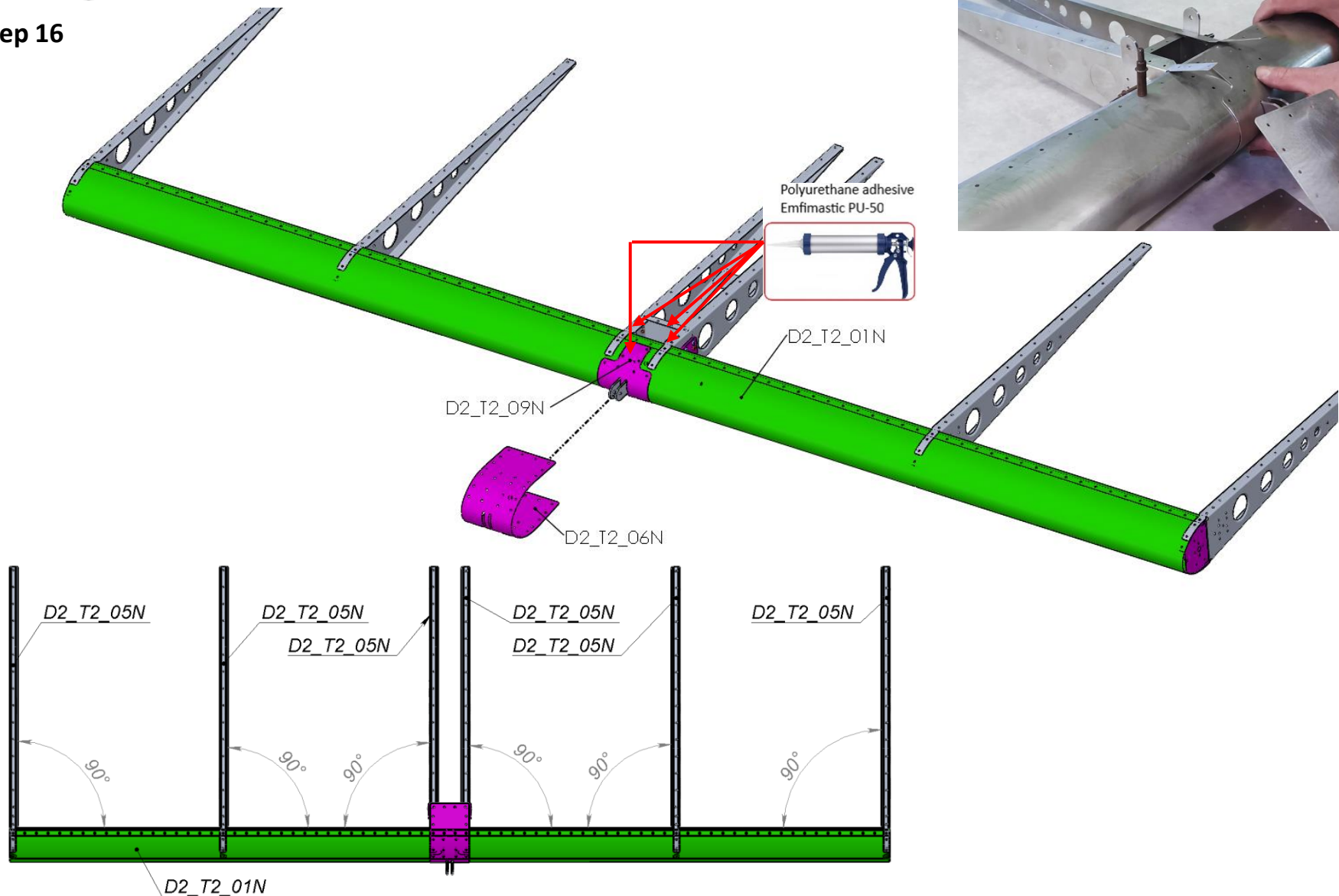
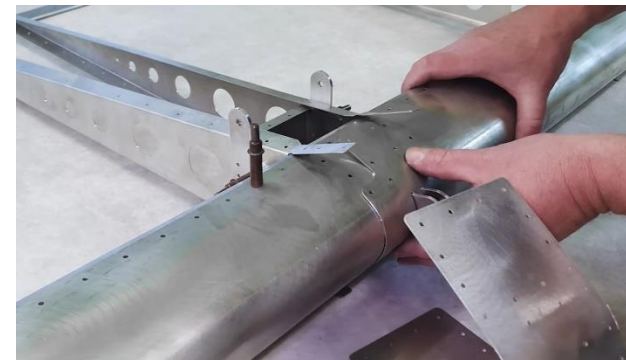


**Step 15**


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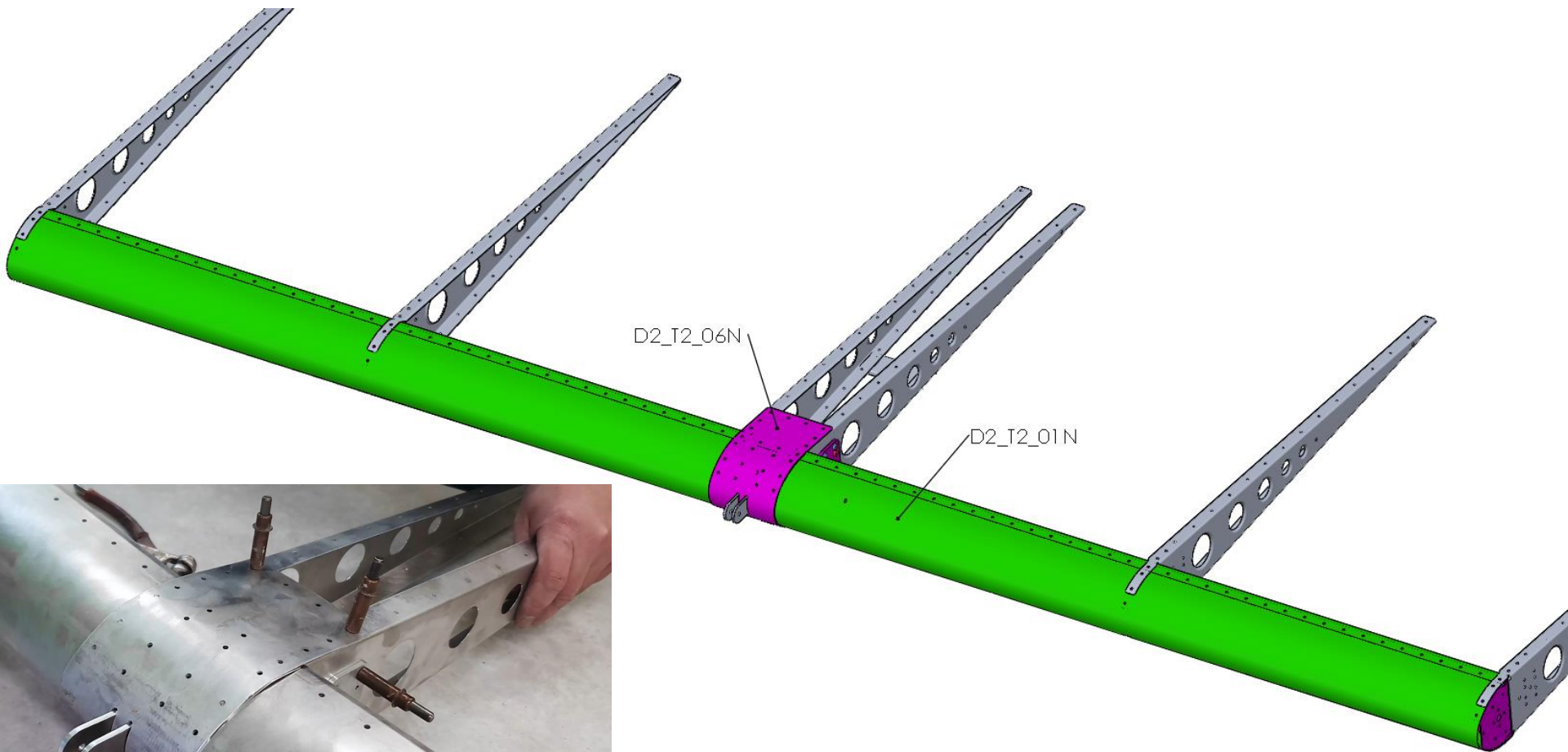
Step 16



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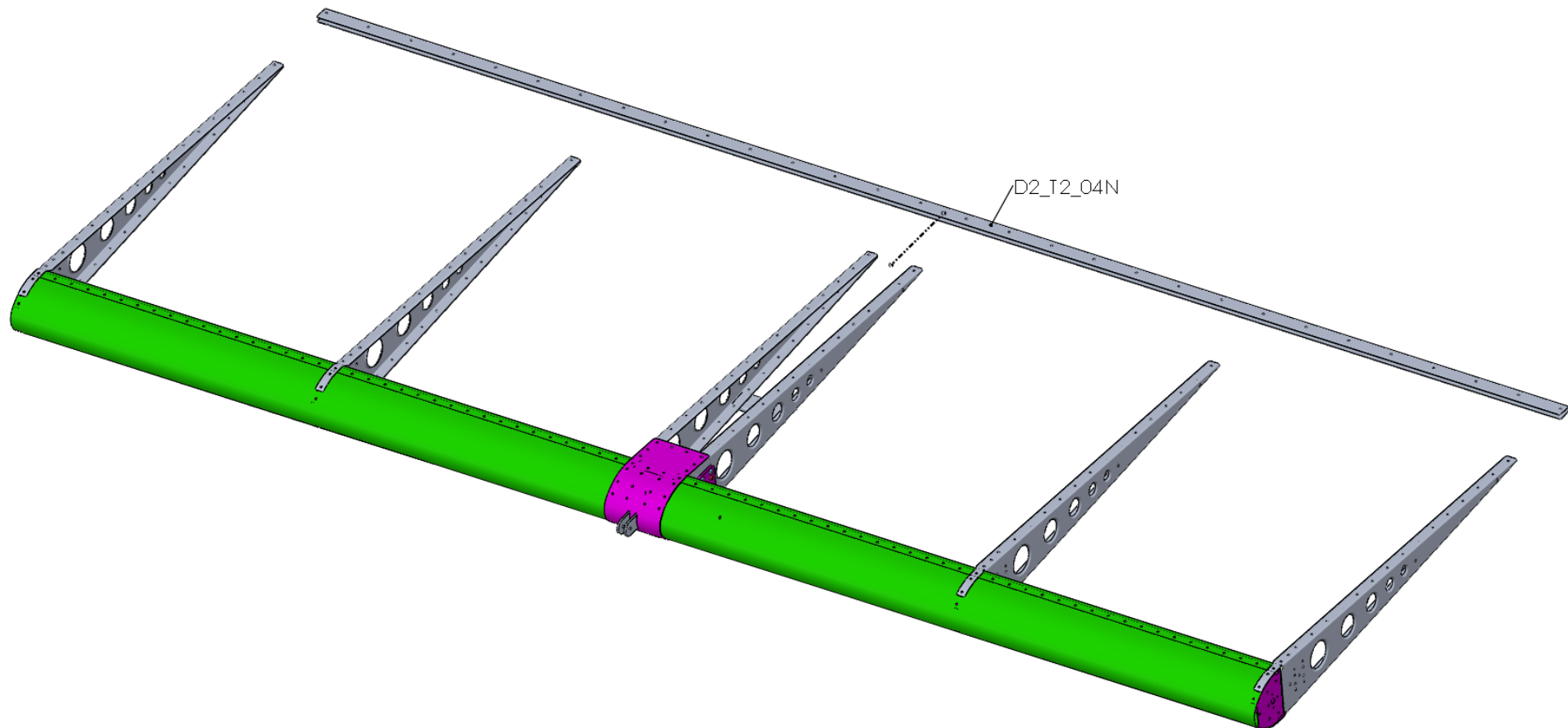


Step 17



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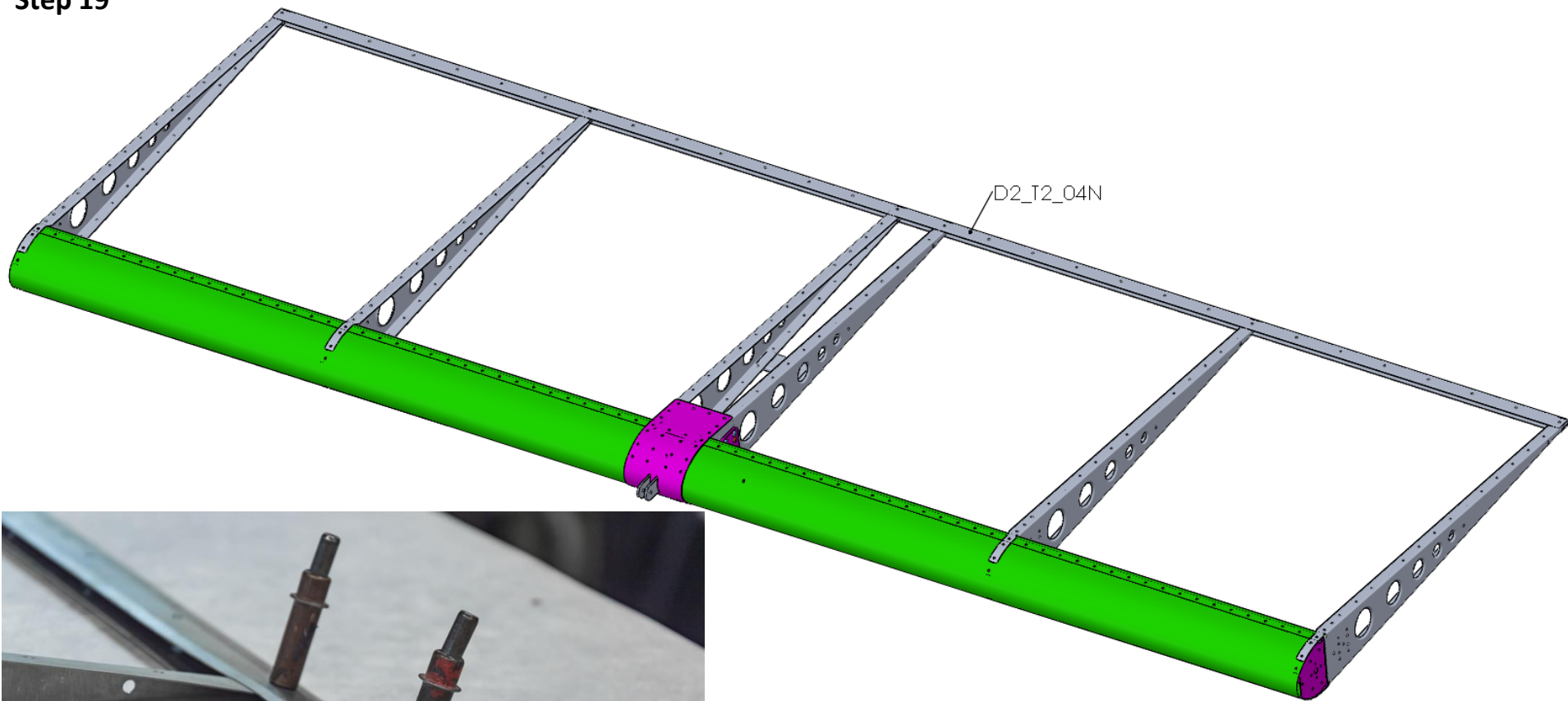
Step 18



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Step 19

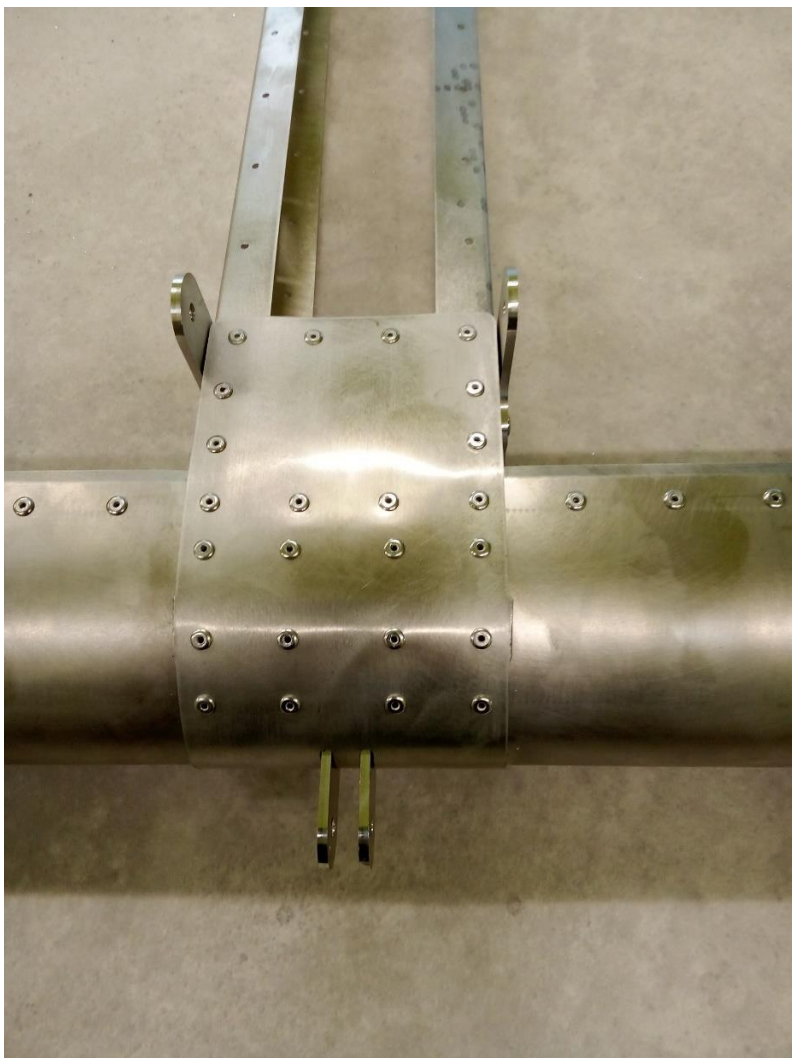


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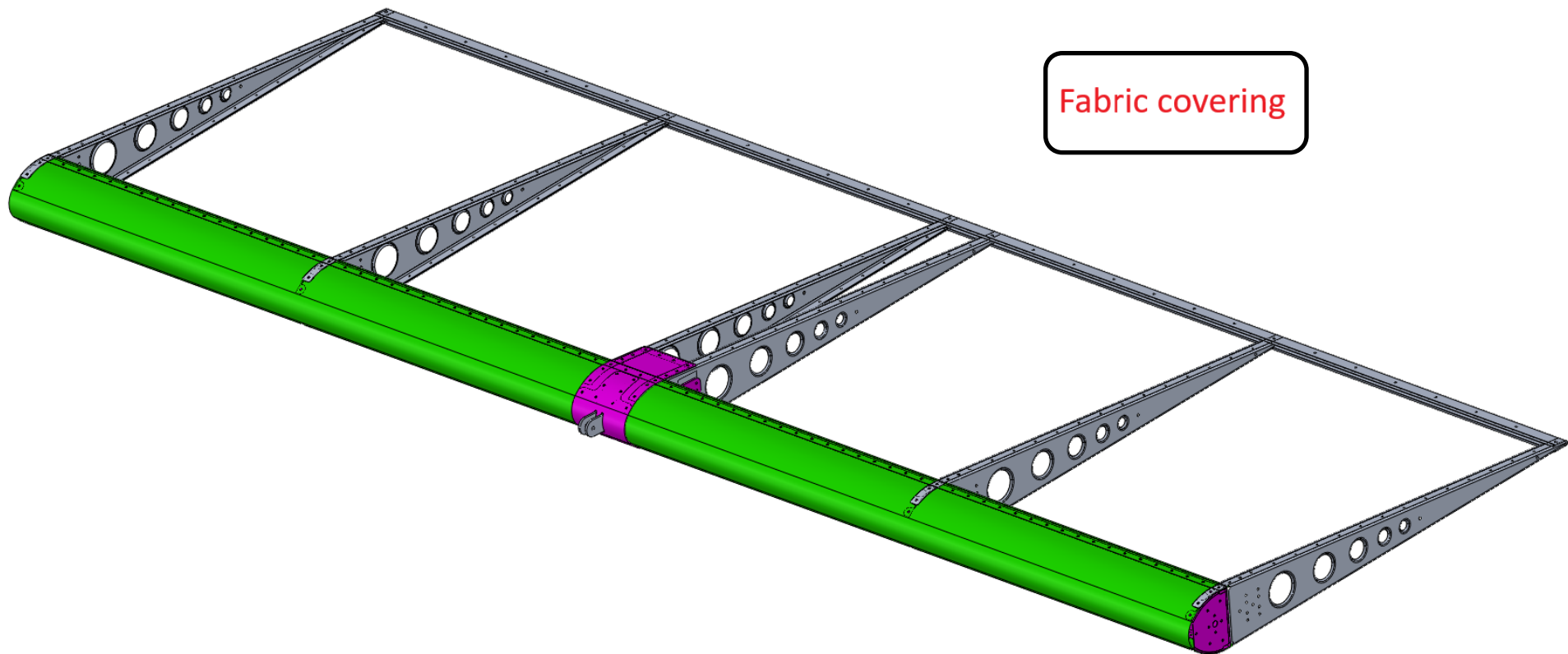
Step 20



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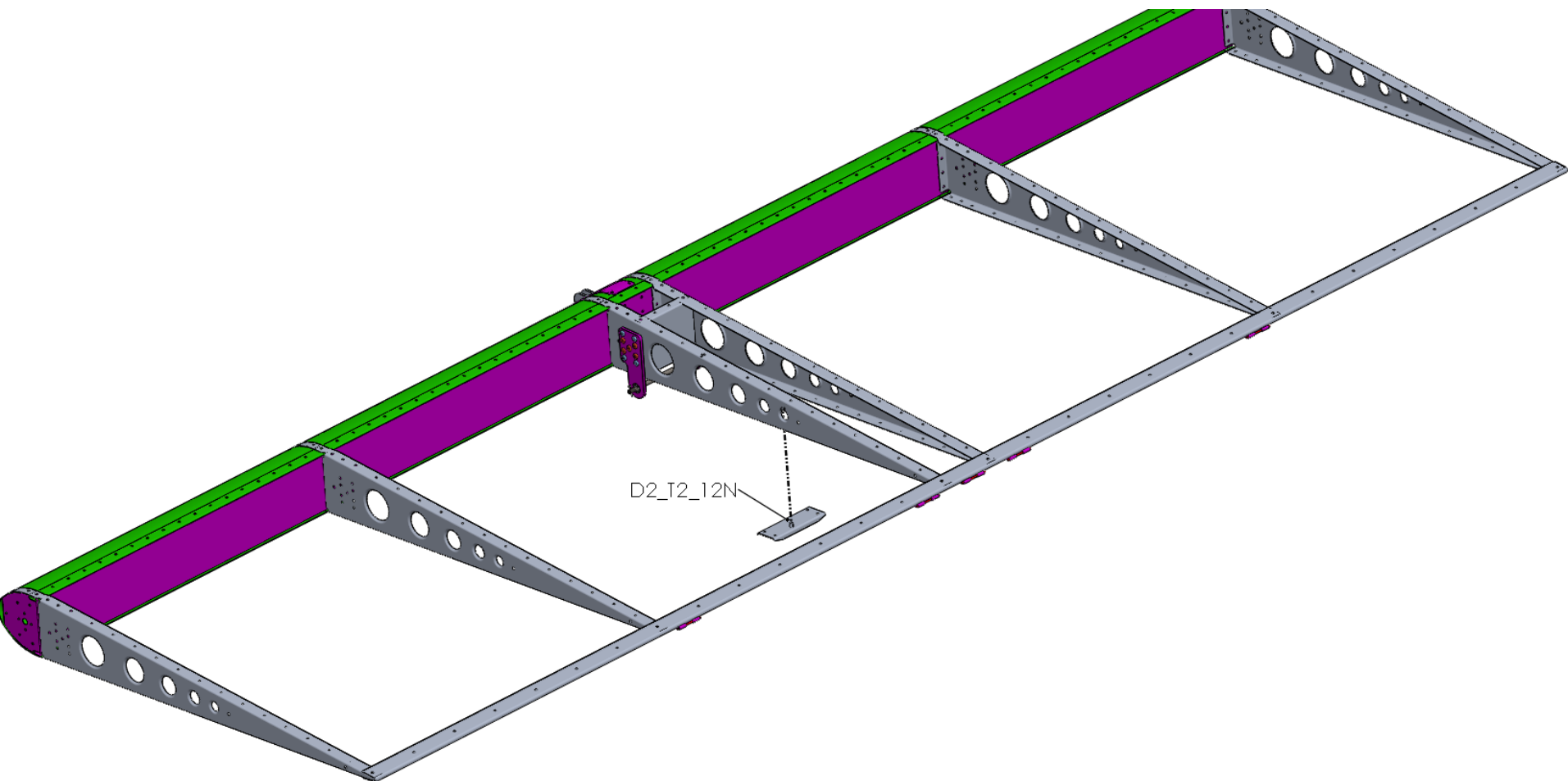
Step 21



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Step 22

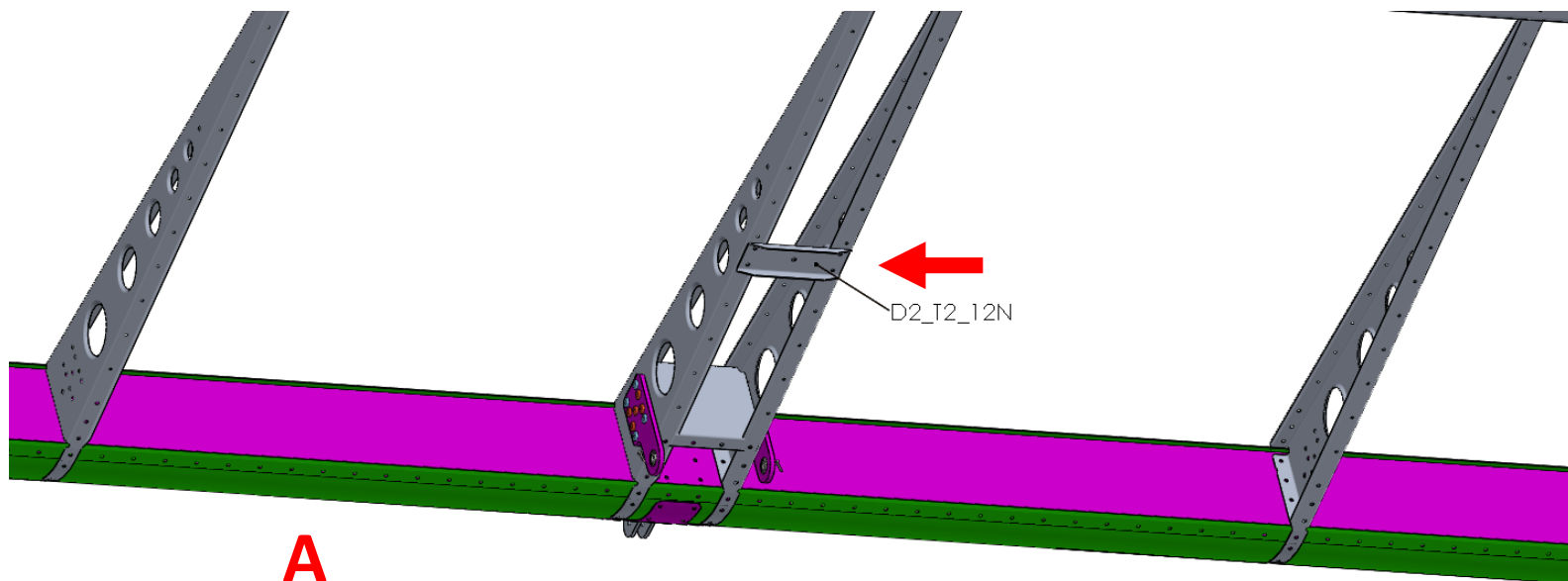


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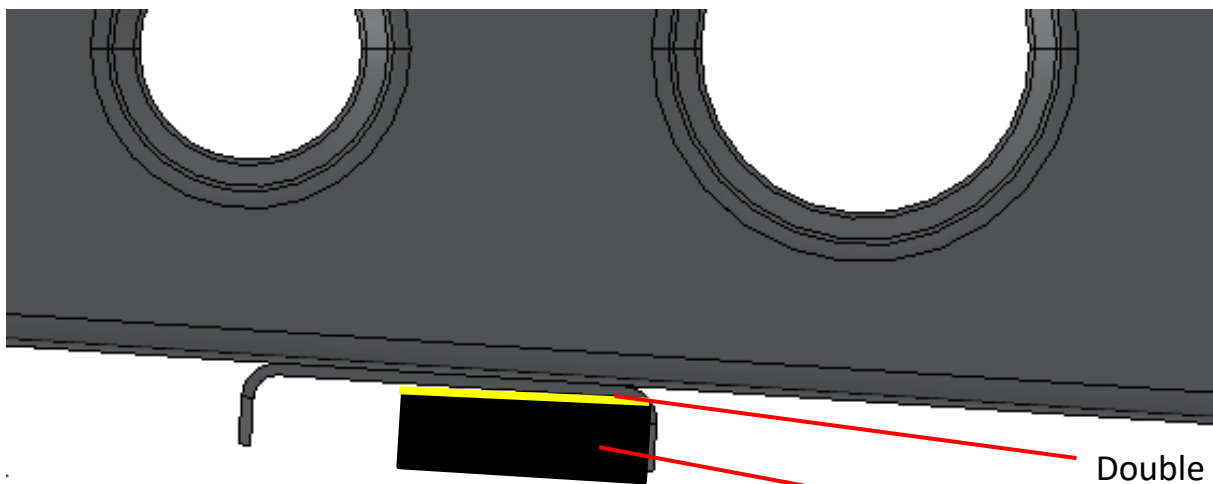




Step 23



A



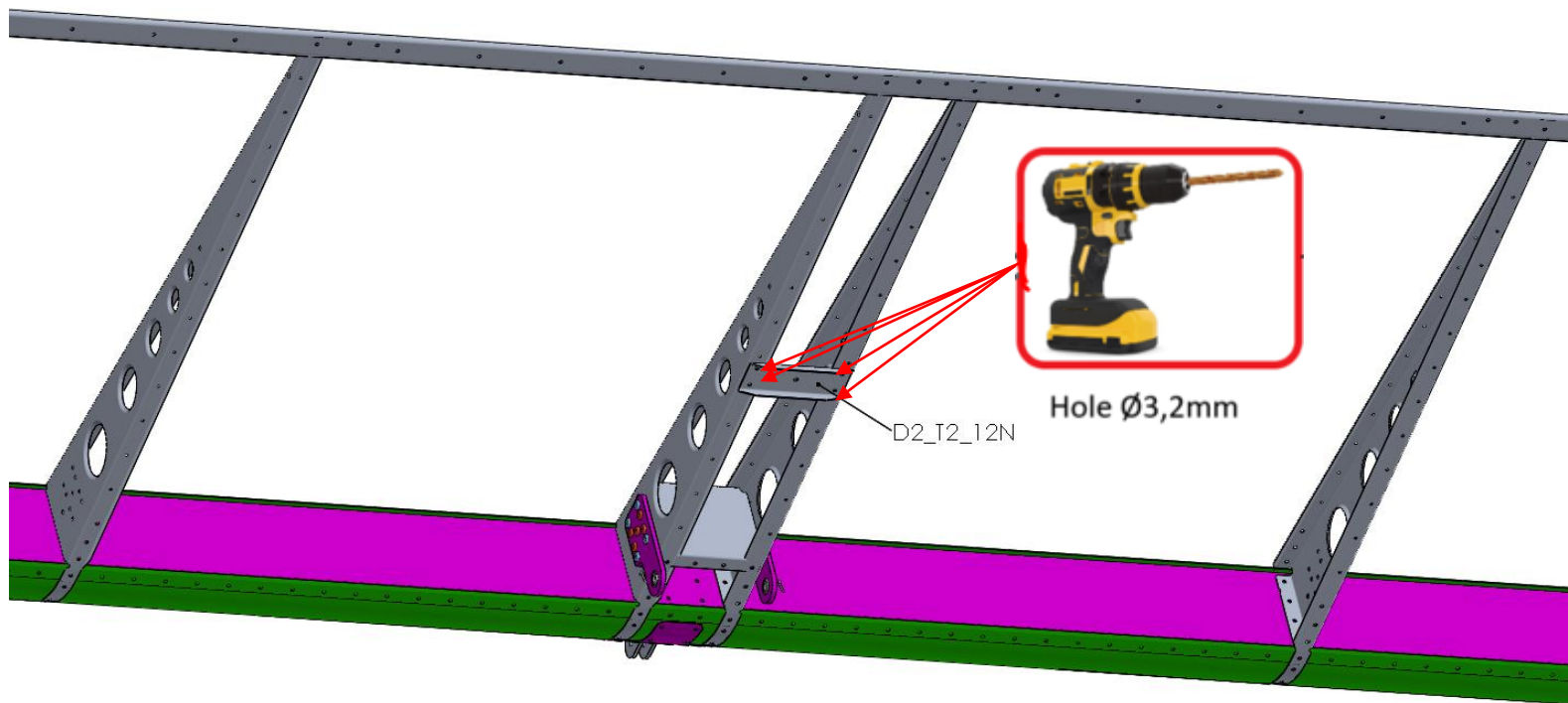
Double tape / nonstructural adhesive

D2\_T2\_13N

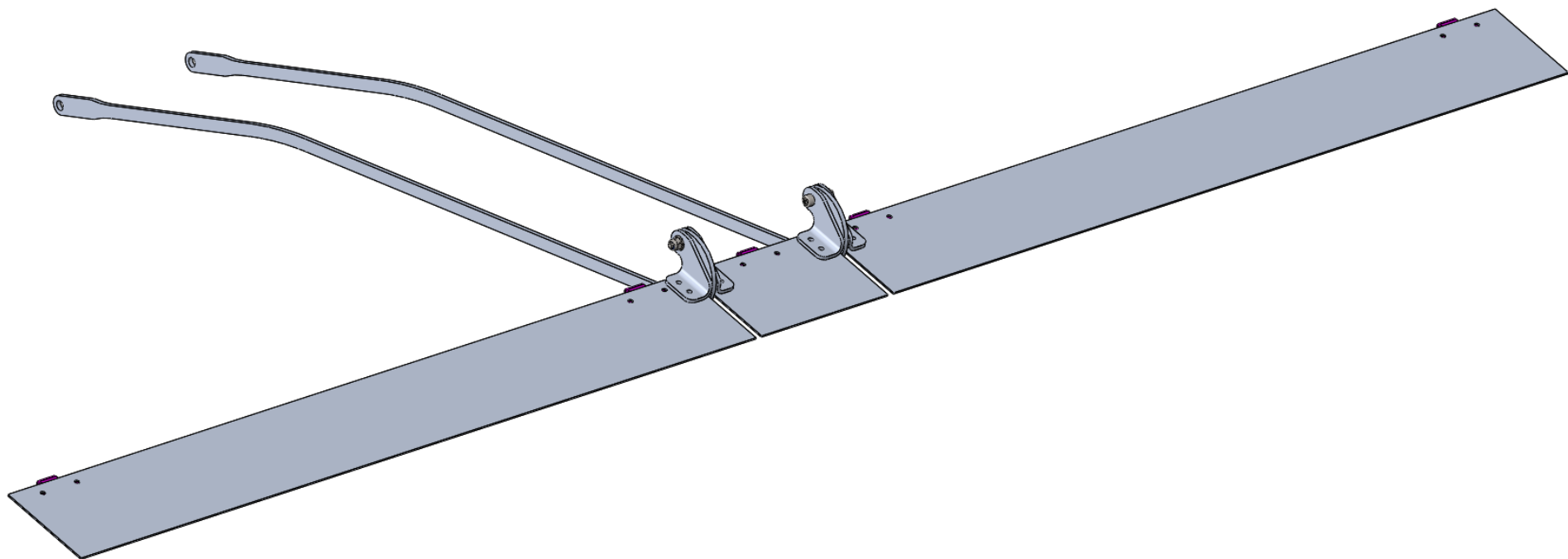
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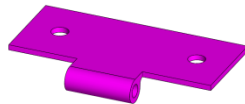


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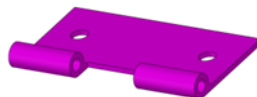
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Quantity: 5



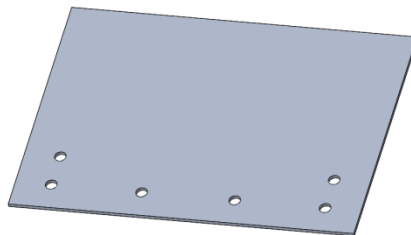
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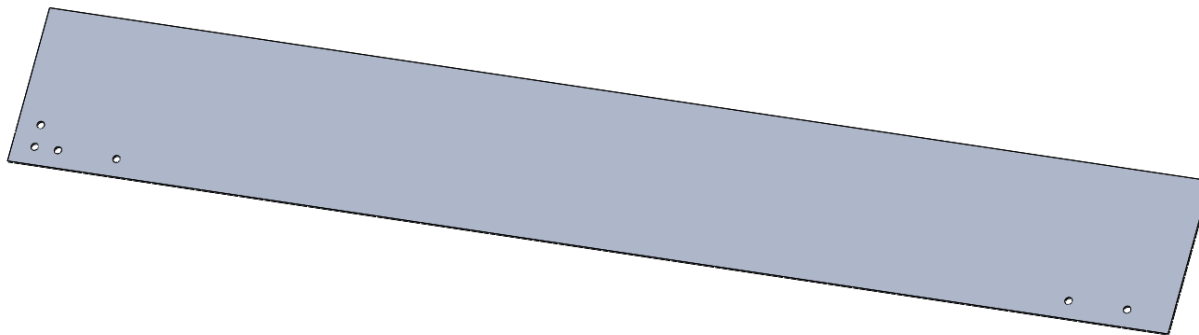
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Detail: D2\_T4\_14N

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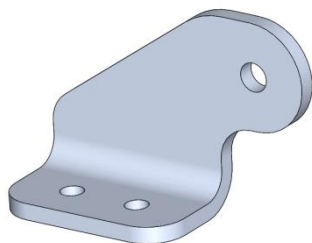


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Quantity: 2



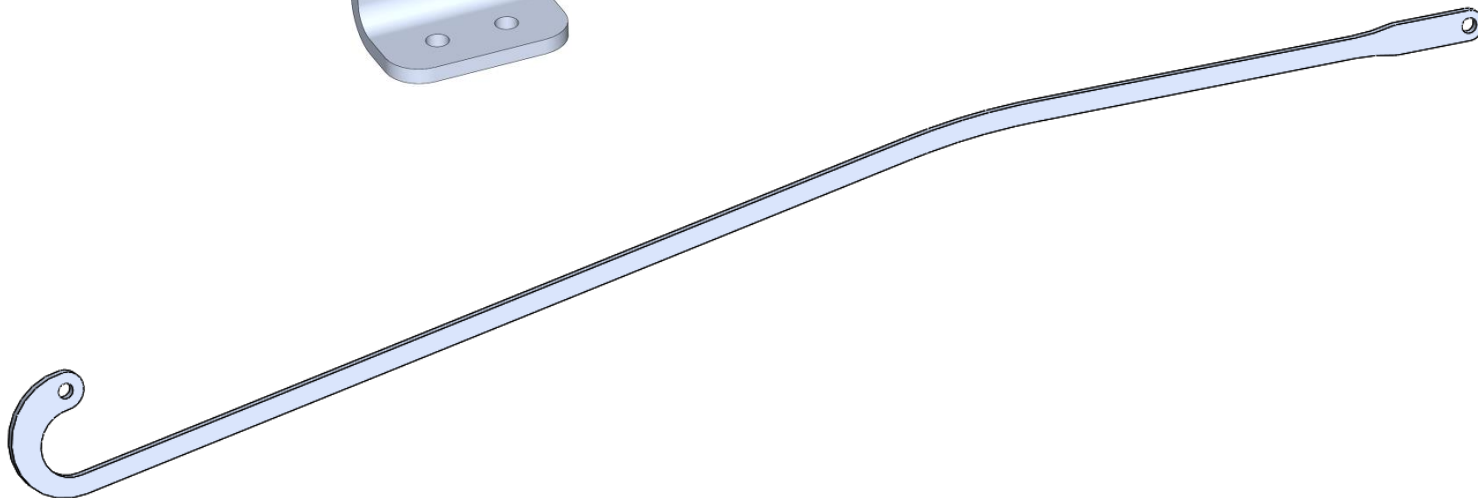
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Quantity: 2



Detail: D2\_T4\_17N

Quantity: 2



Detail: D2\_T4\_21N

Quantity: 5



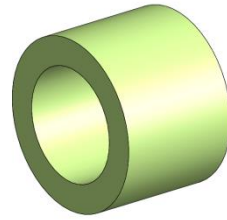
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**Trim tab**

Detail: D2\_SP\_02

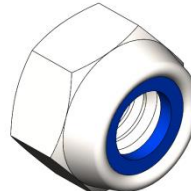
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**Trim tab**

Detail: DIN 985 M4 Nylock Nut

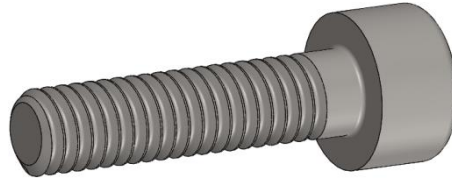
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**Trim tab**

Detail: Bolt DIN 912 M4x16

Quantity: 2



**Trim tab**

Detail: DIN 125 Washer M4

Quantity: 2



**Trim tab**

Detail: Rivet Al/St 3,2x7,9

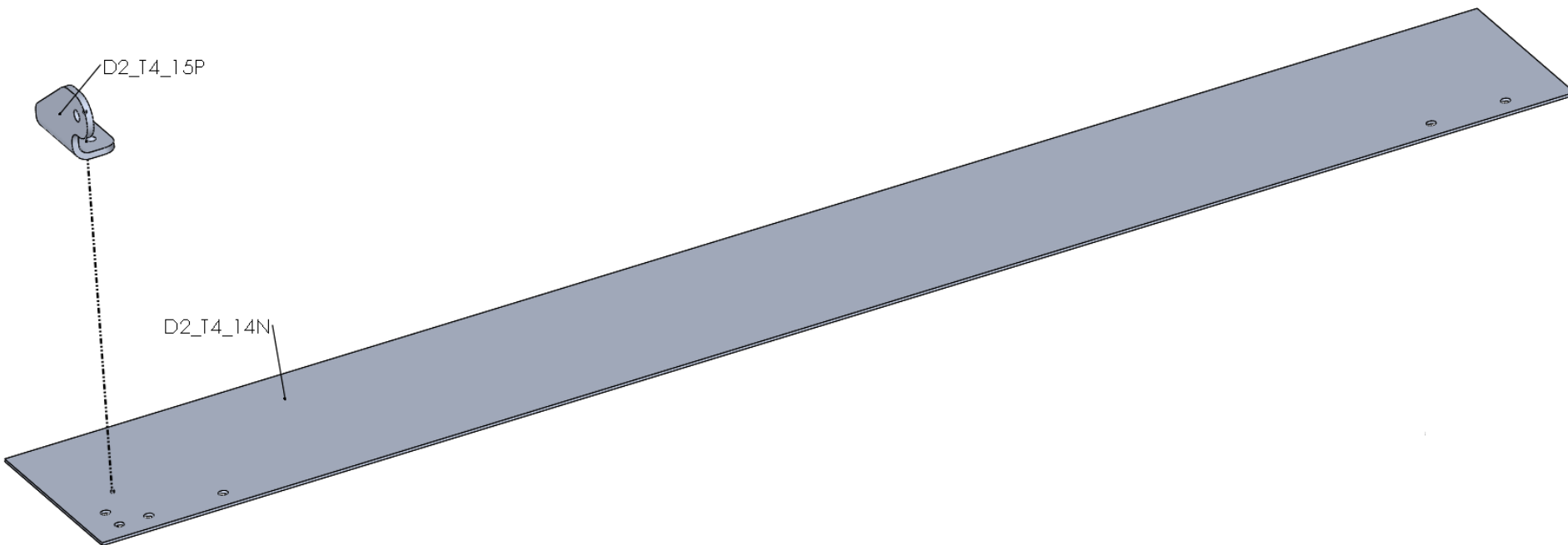
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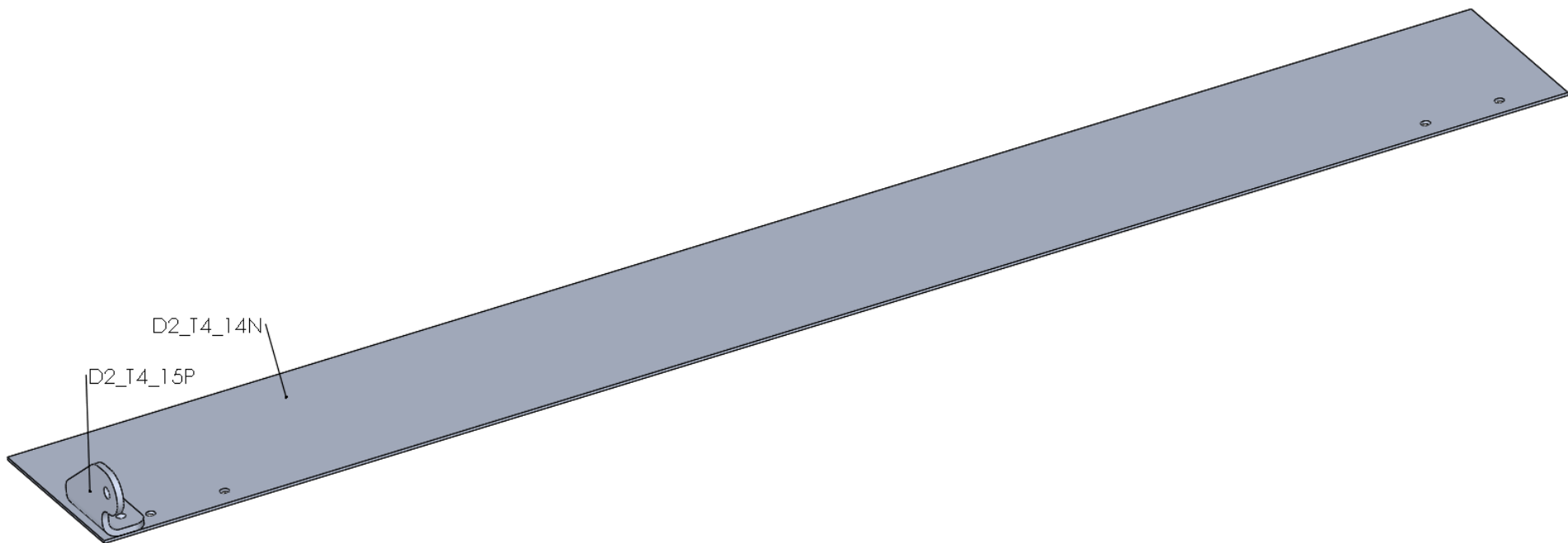
Step 1



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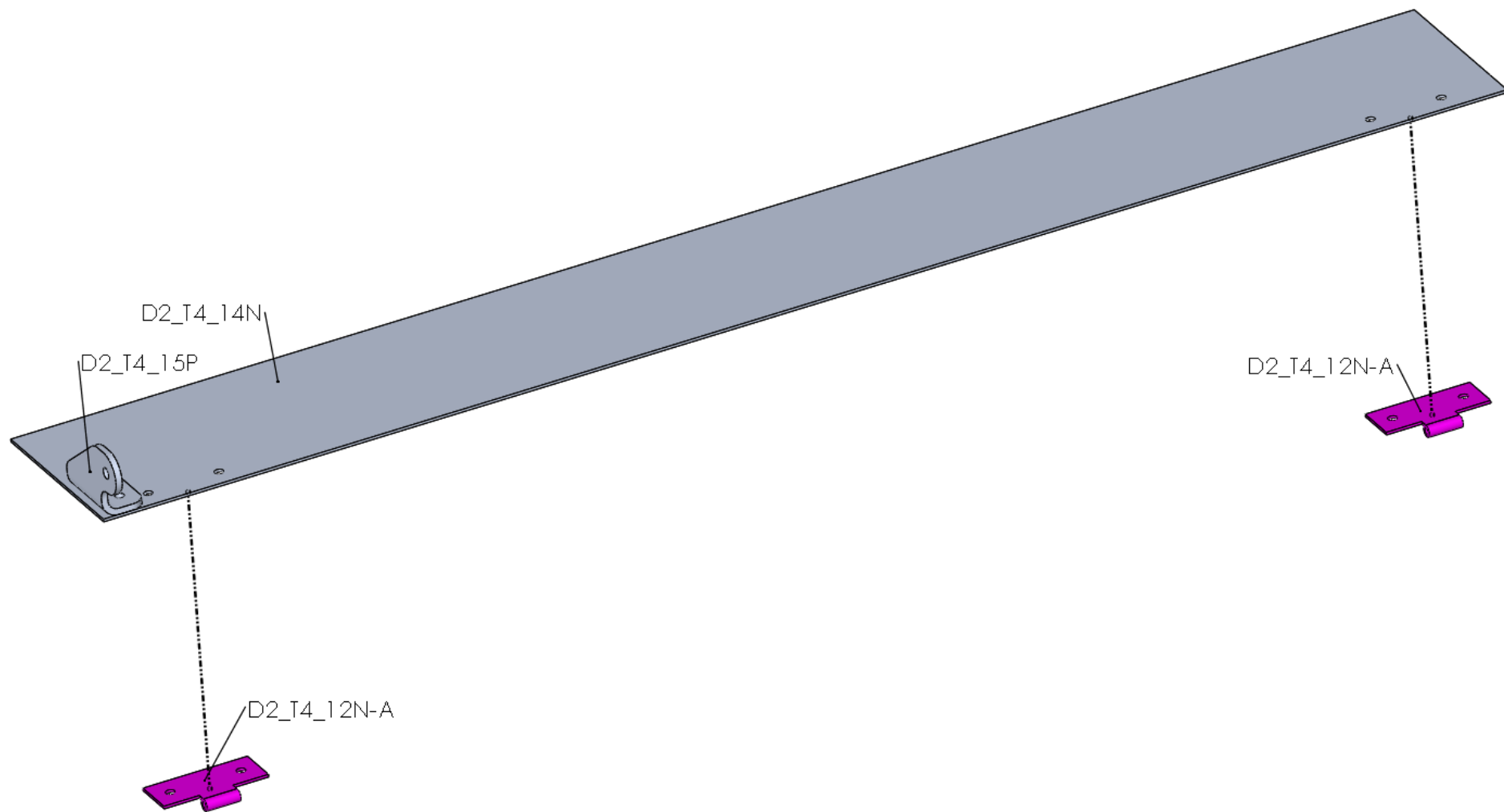


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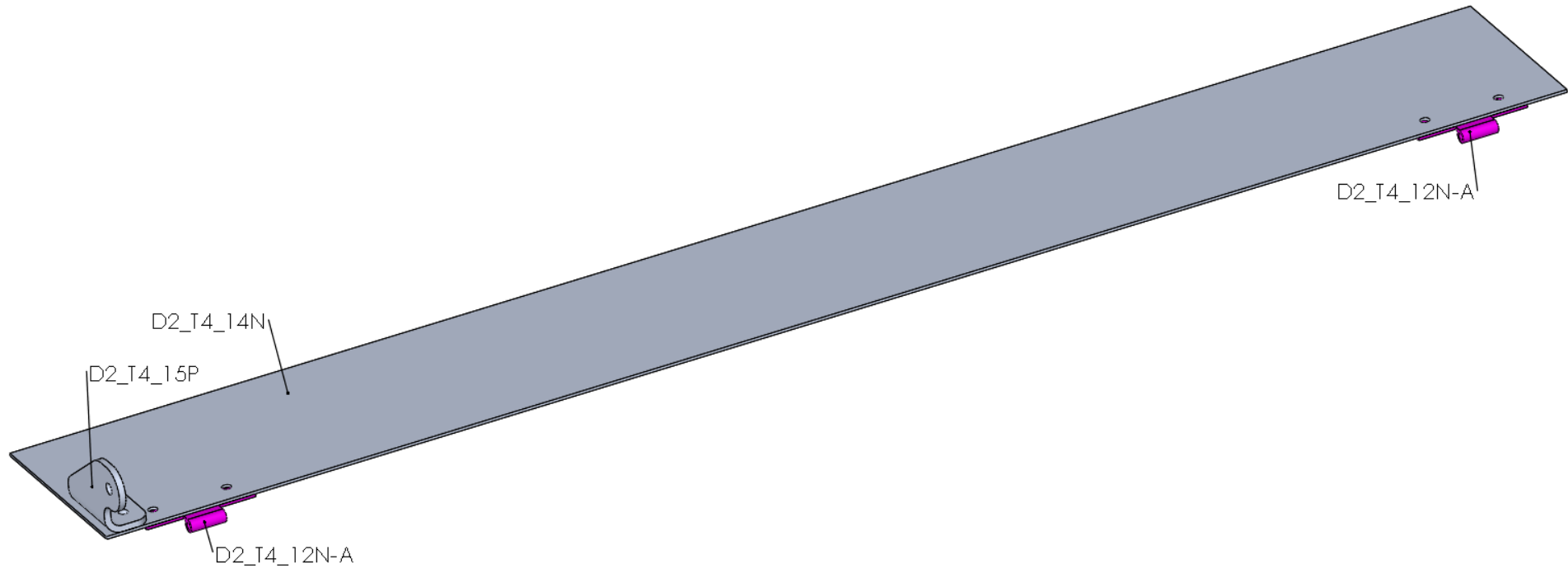
Step 3



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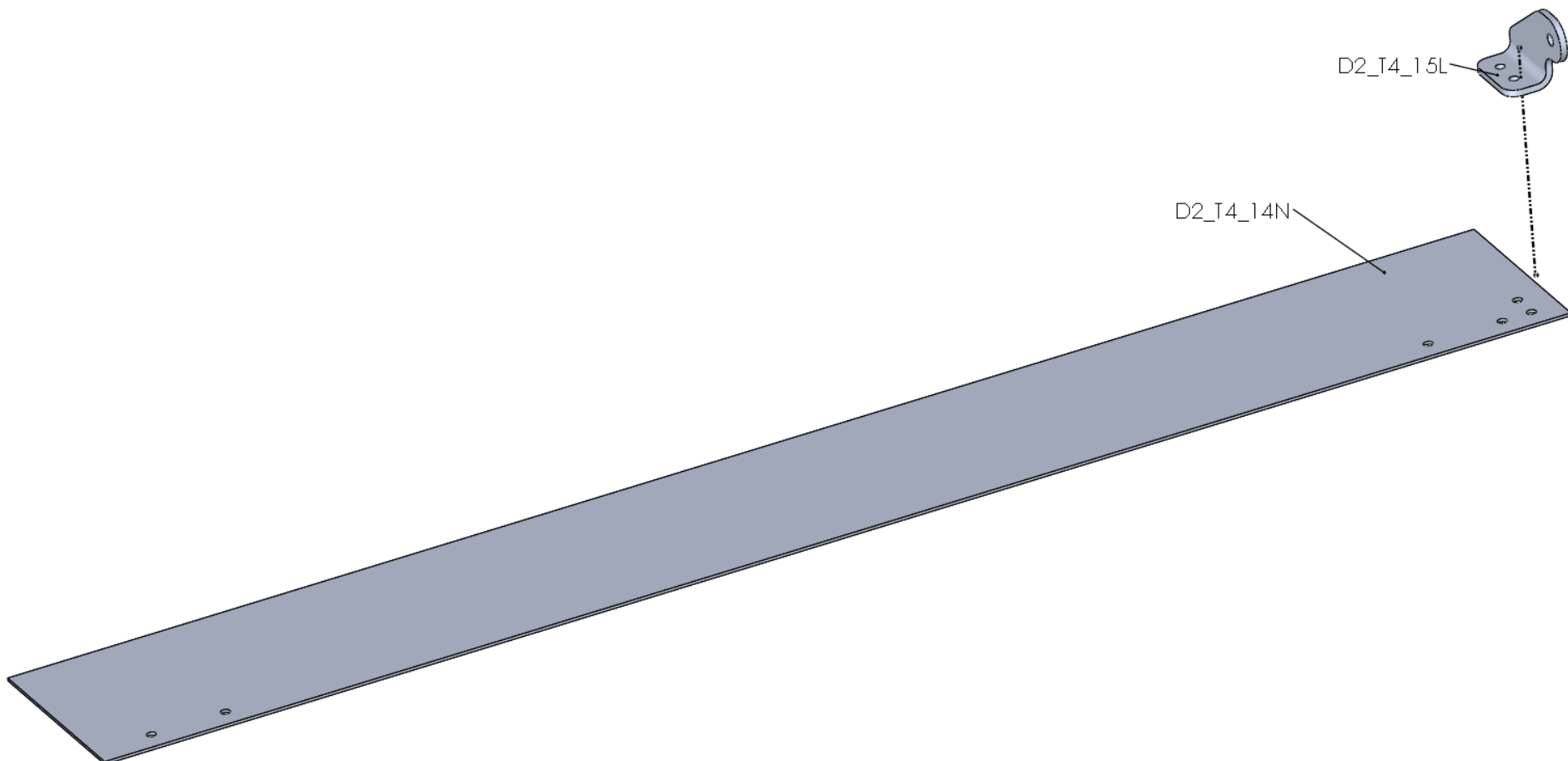
Step 4



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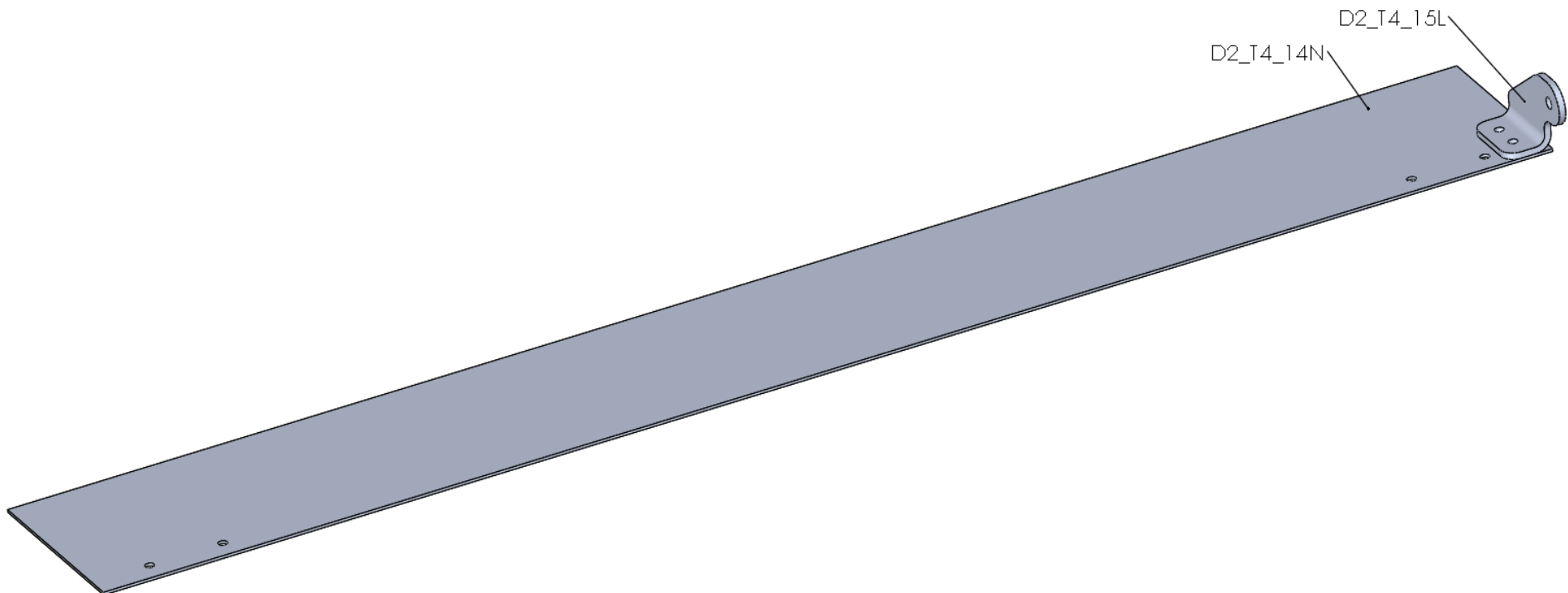
**Step 5**



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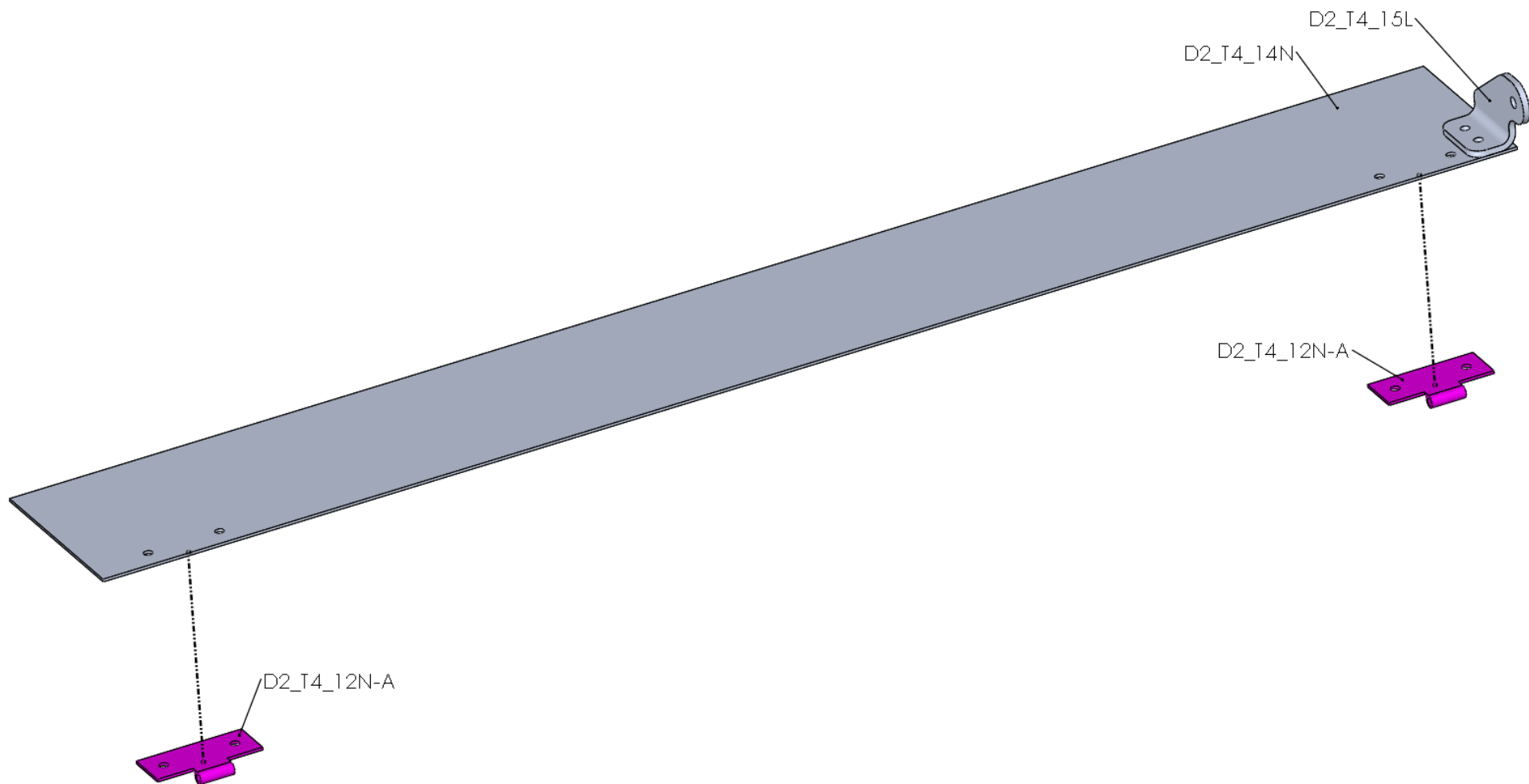
**Step 6**



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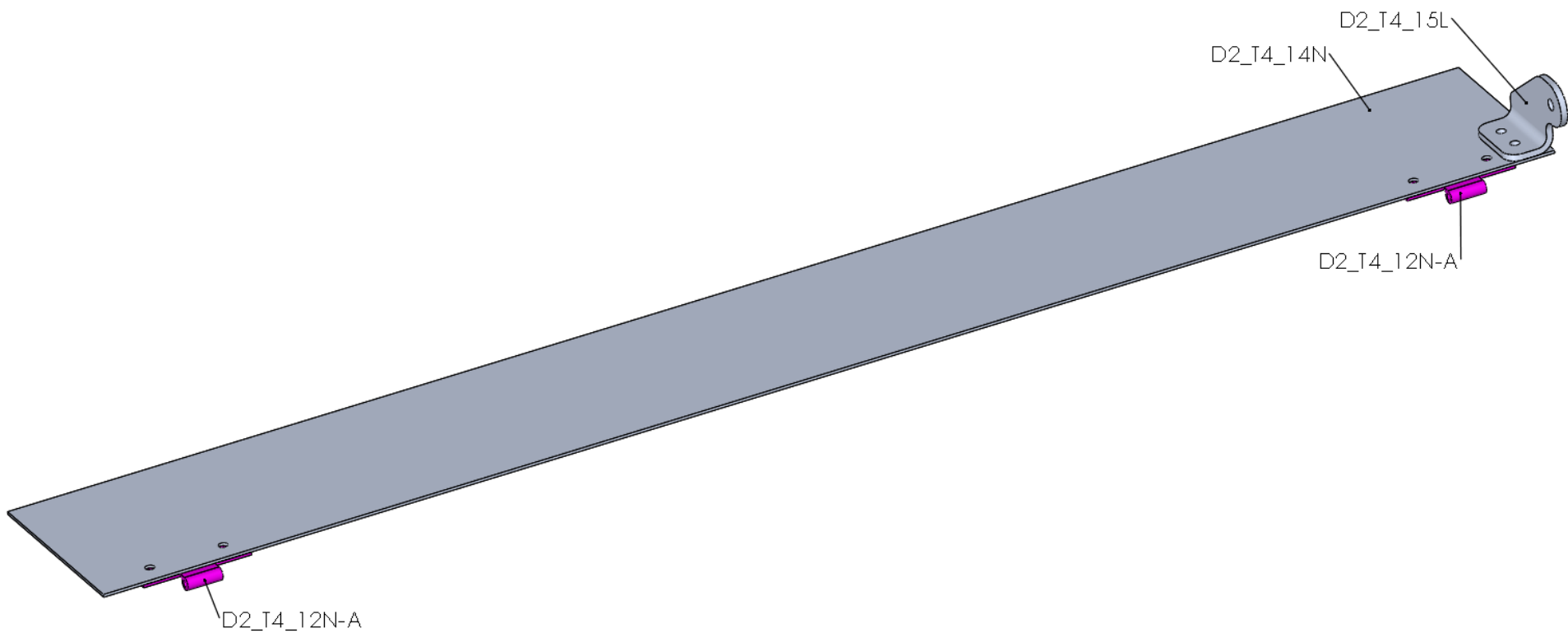
**Step 7**



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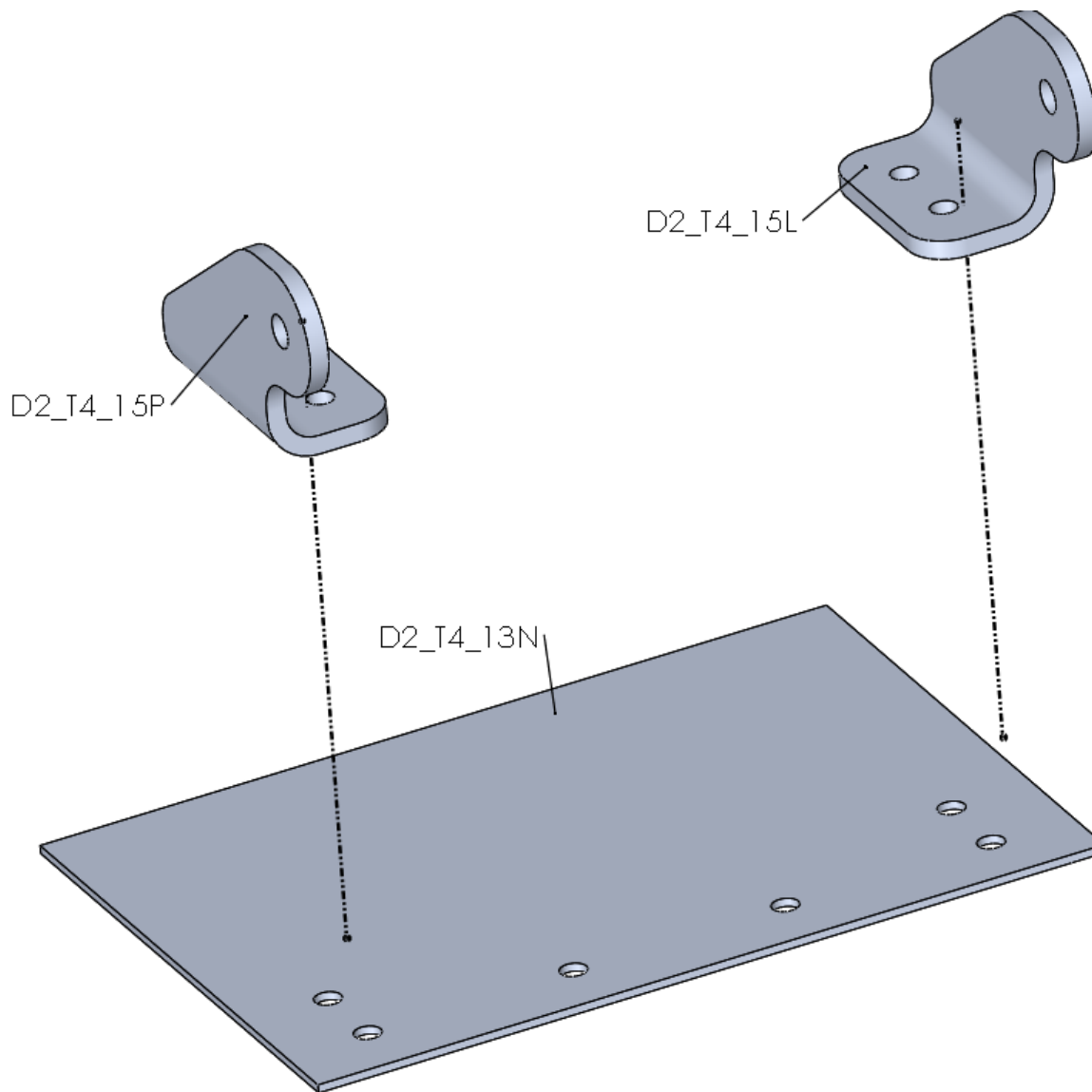
**Step 8**



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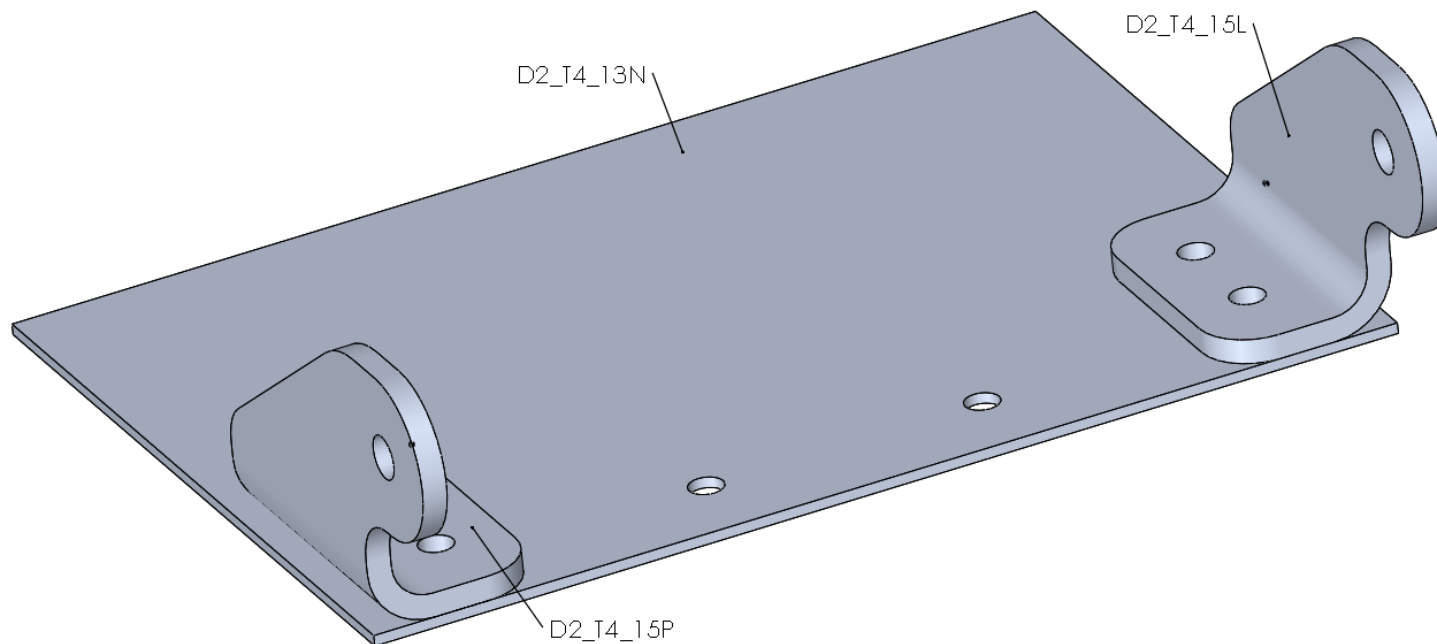
Step 9



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Step 10

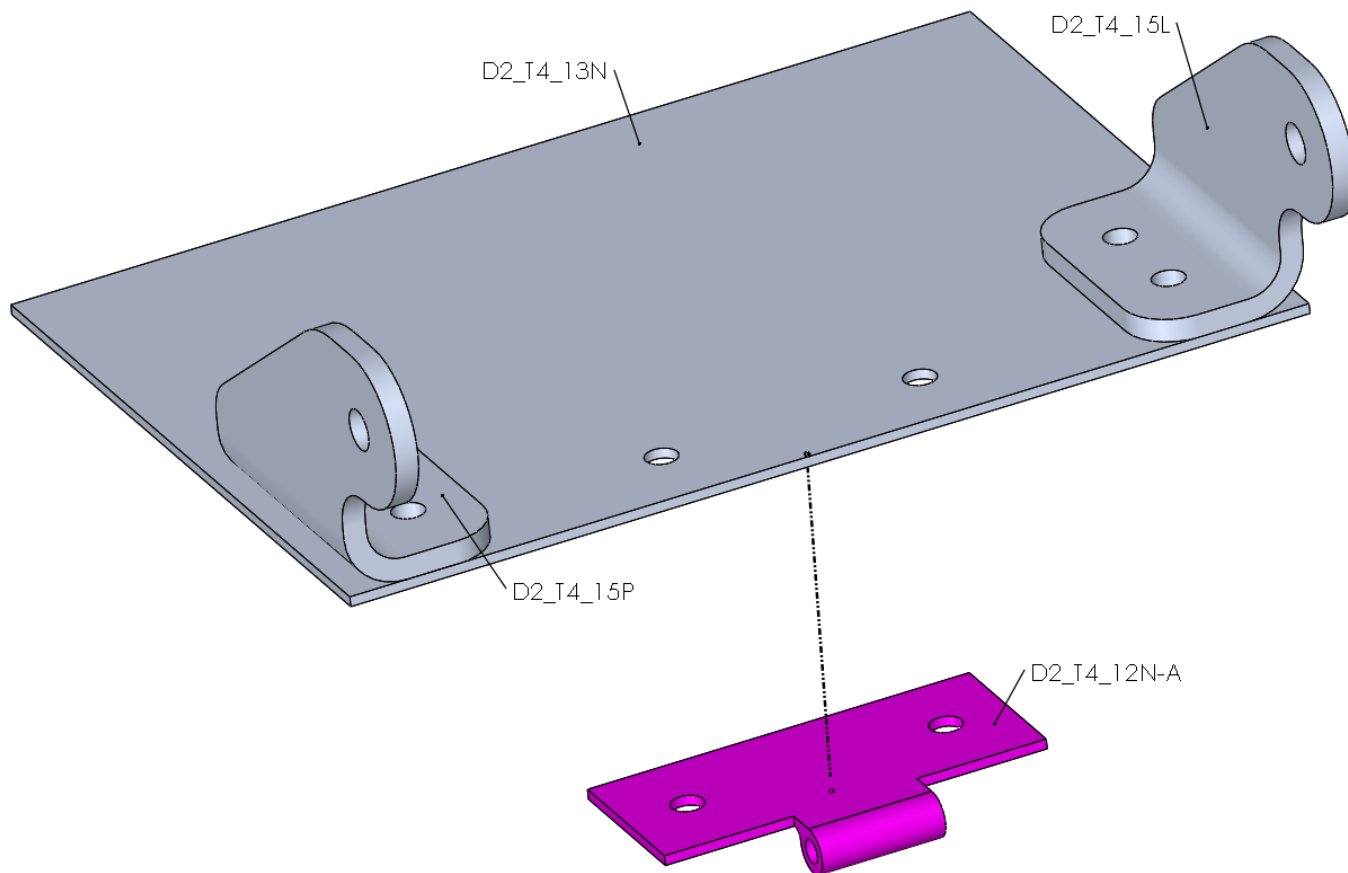


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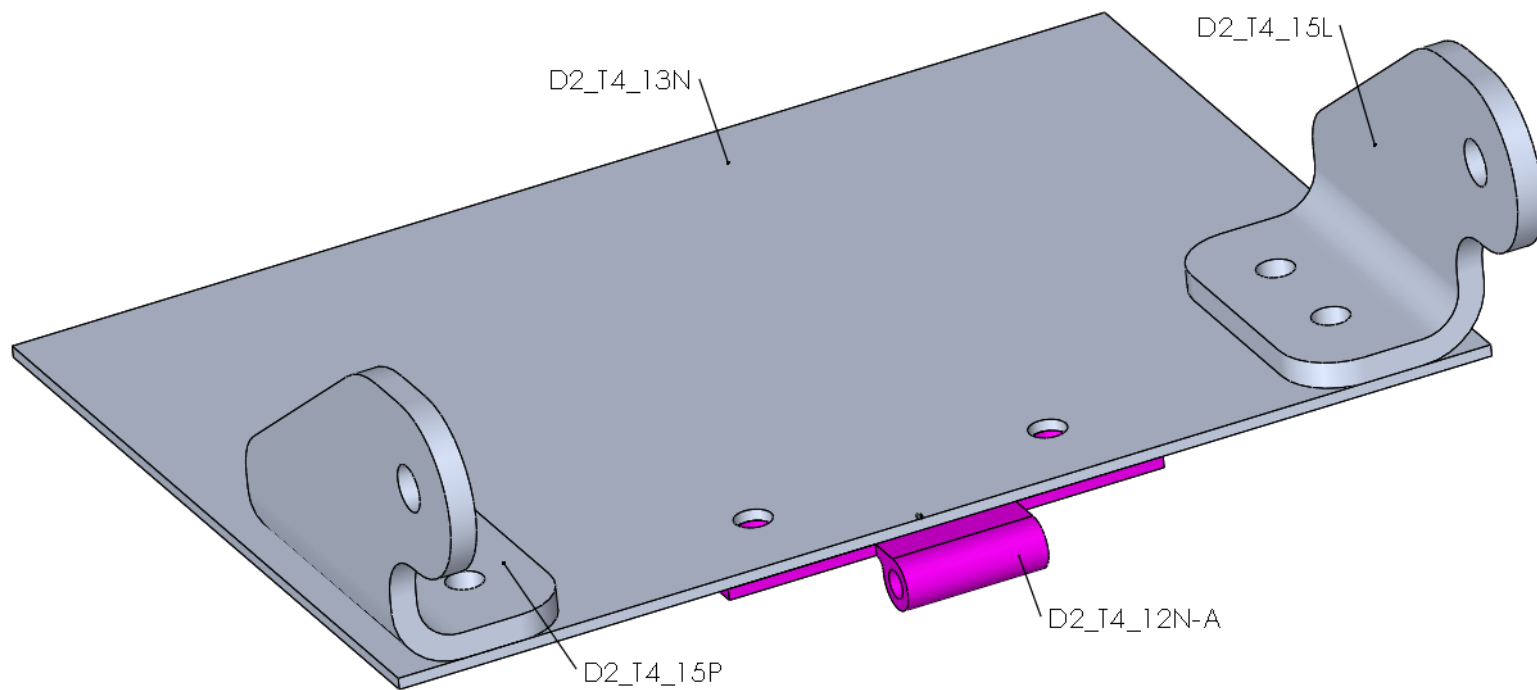
Step 11



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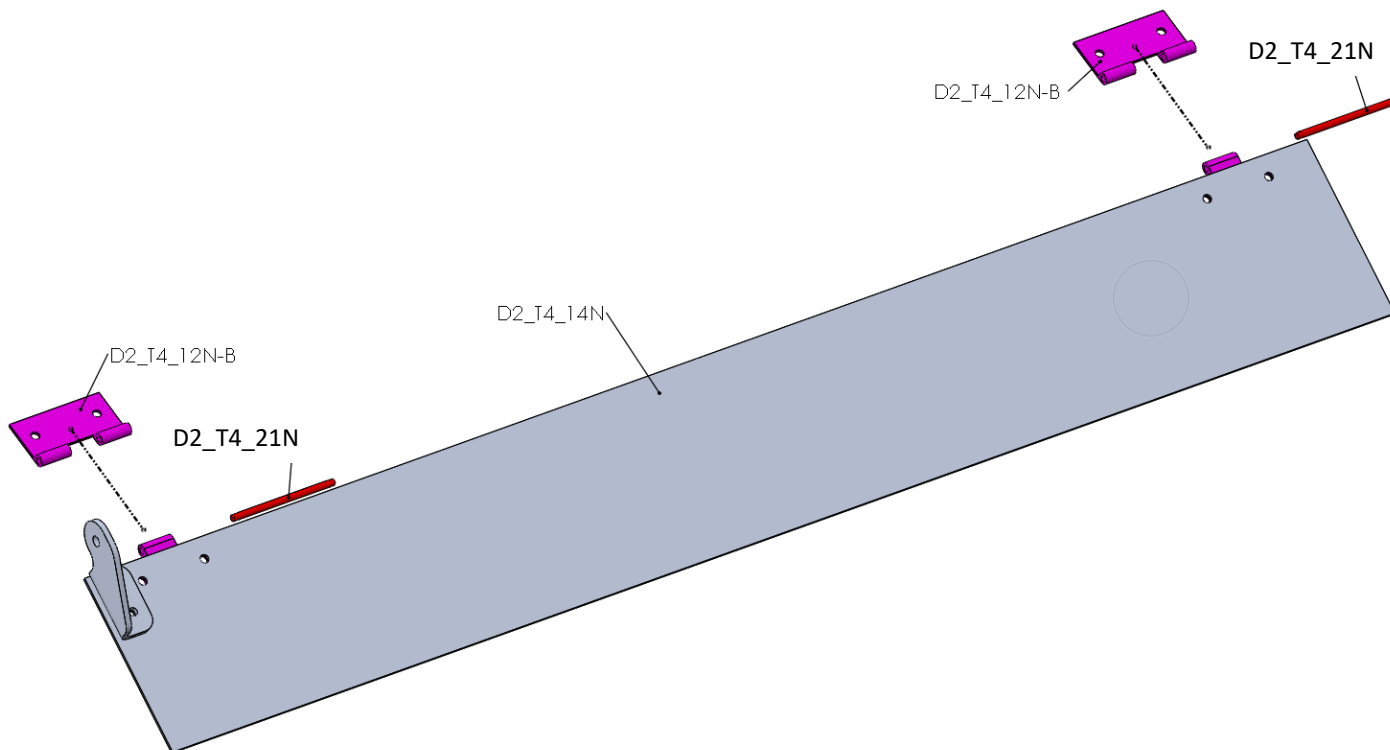
Step 12



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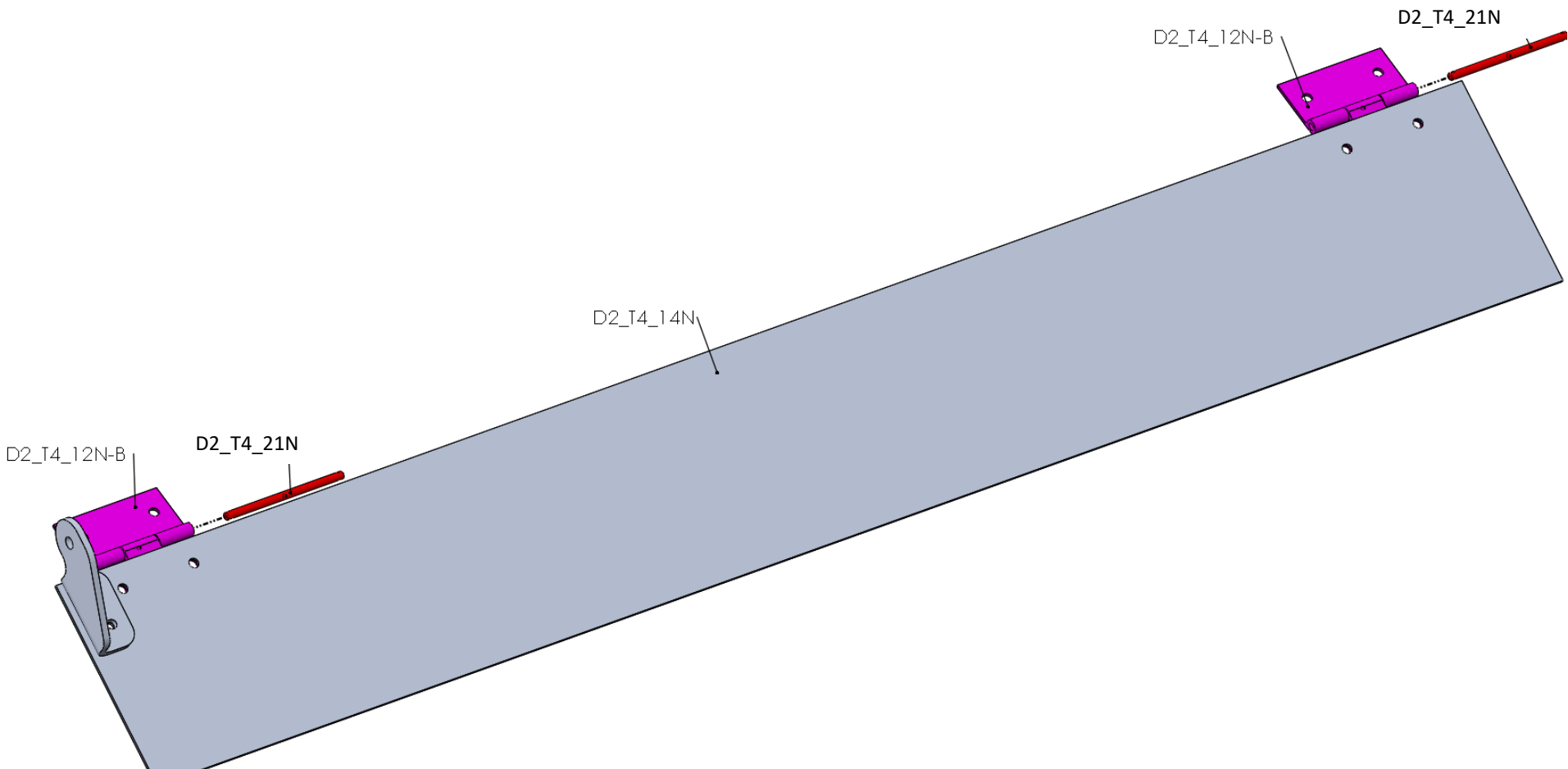
Step 13



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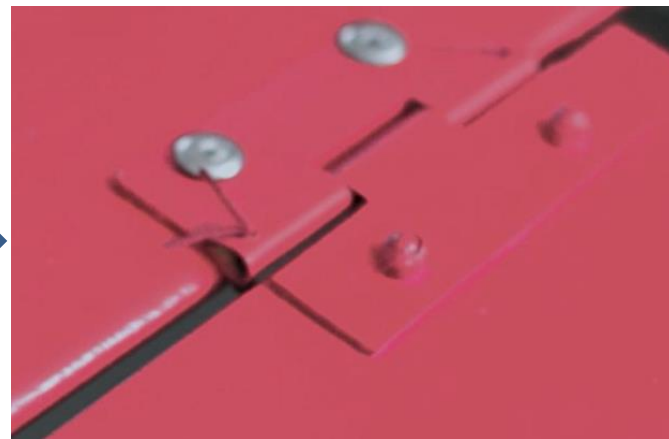
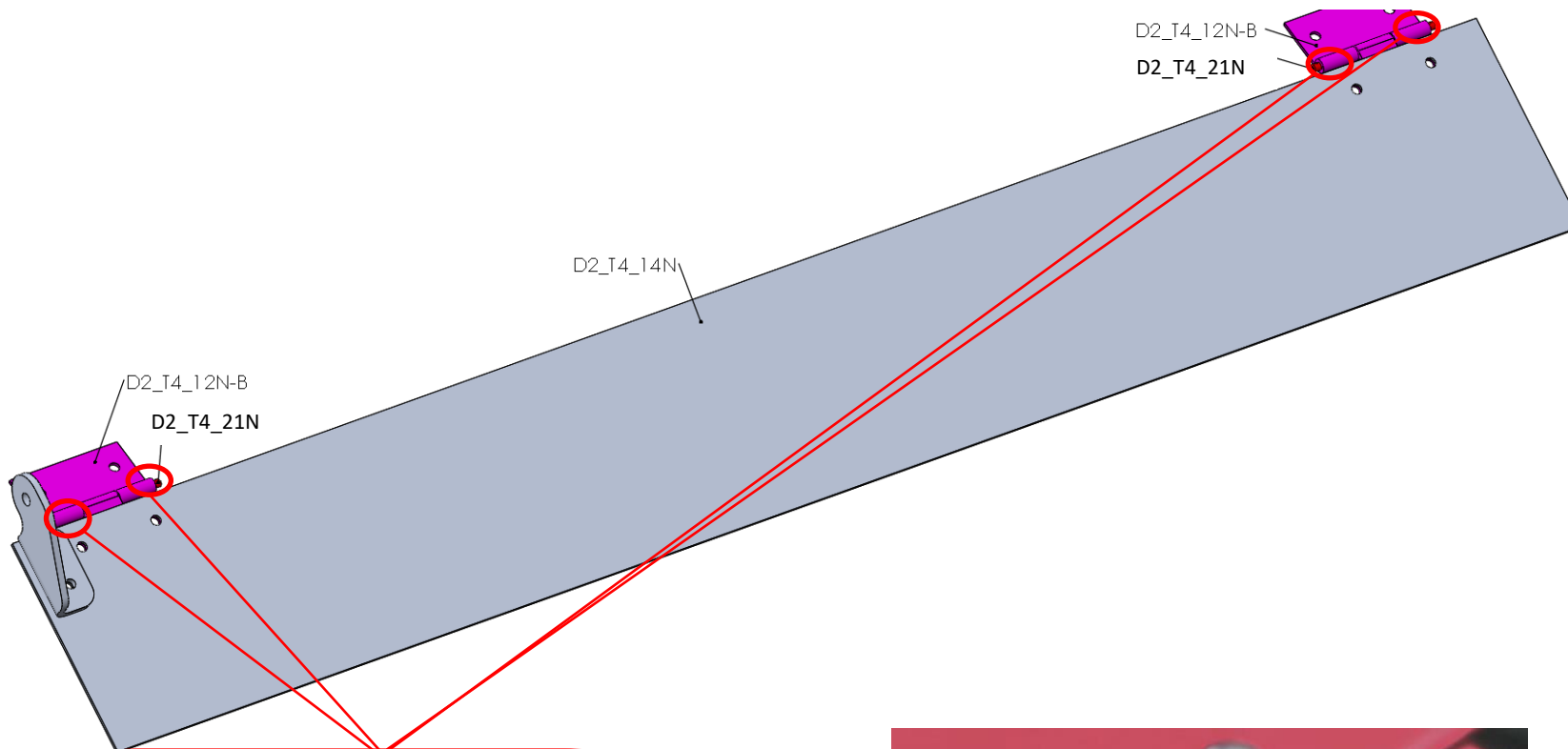
Step 14



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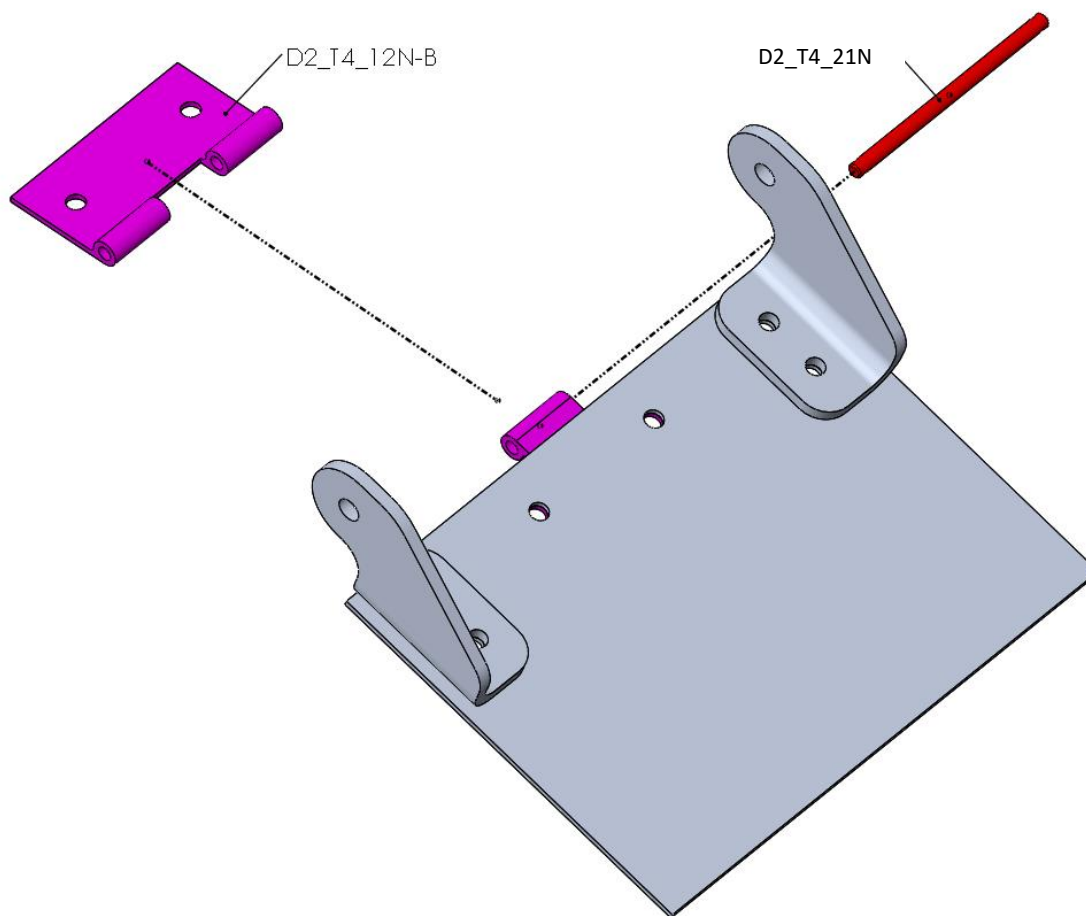
Step 15



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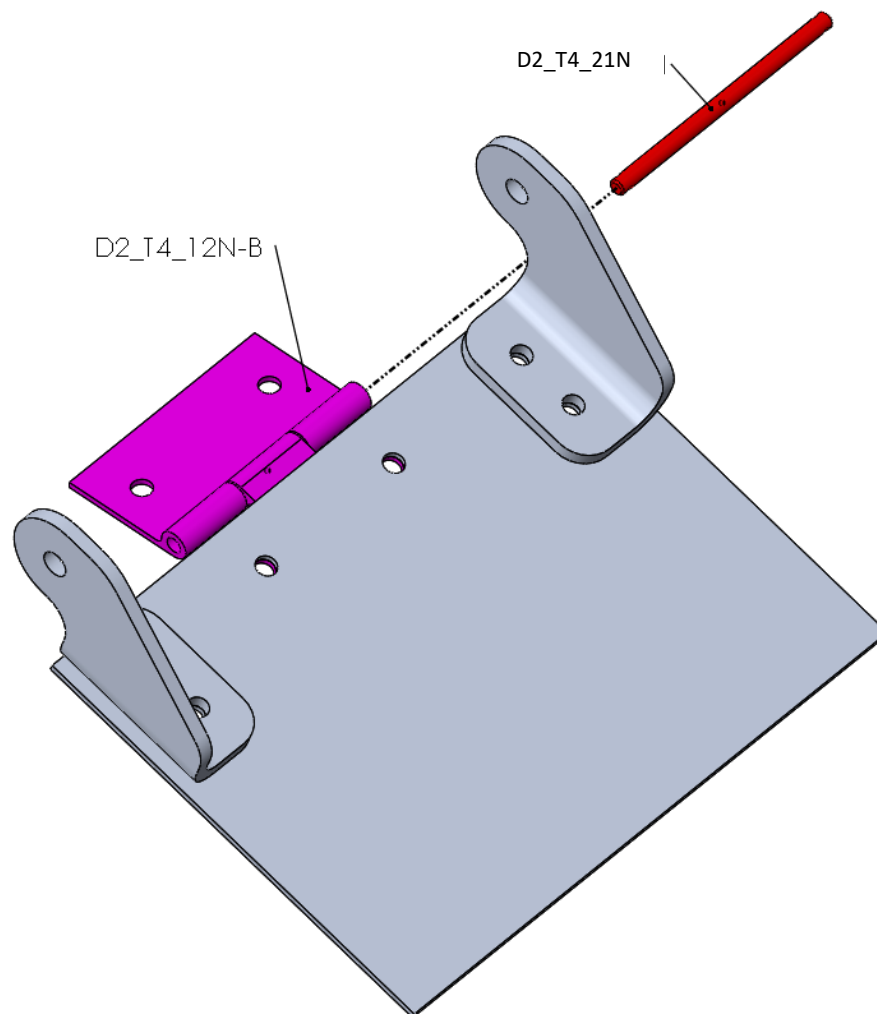
Step 16



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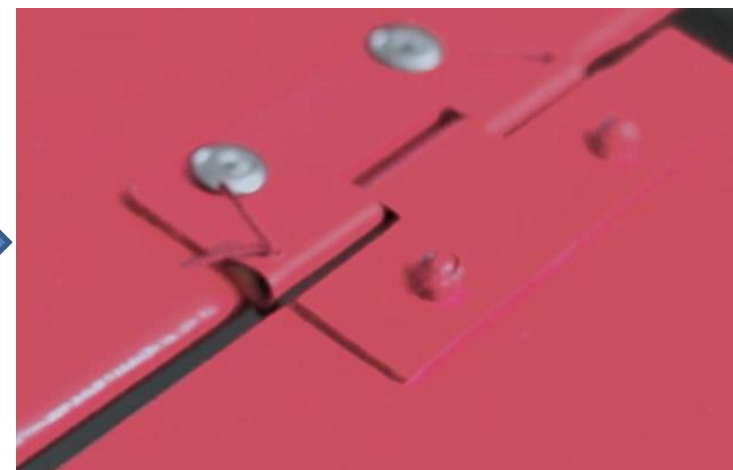
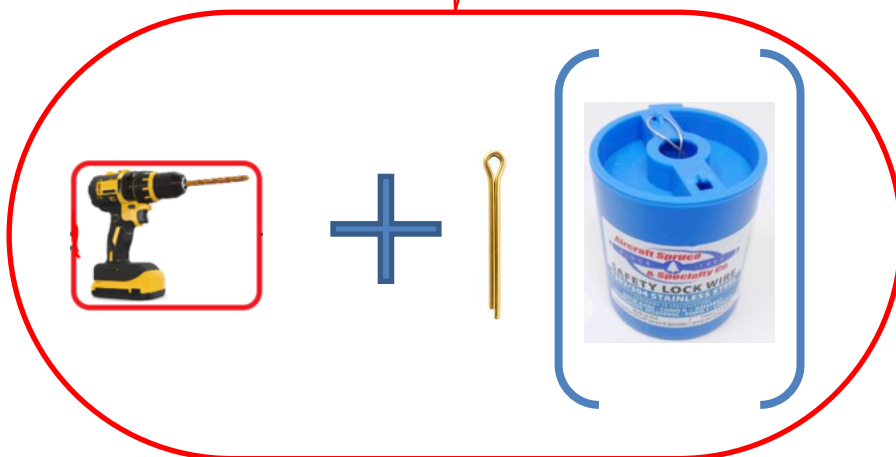
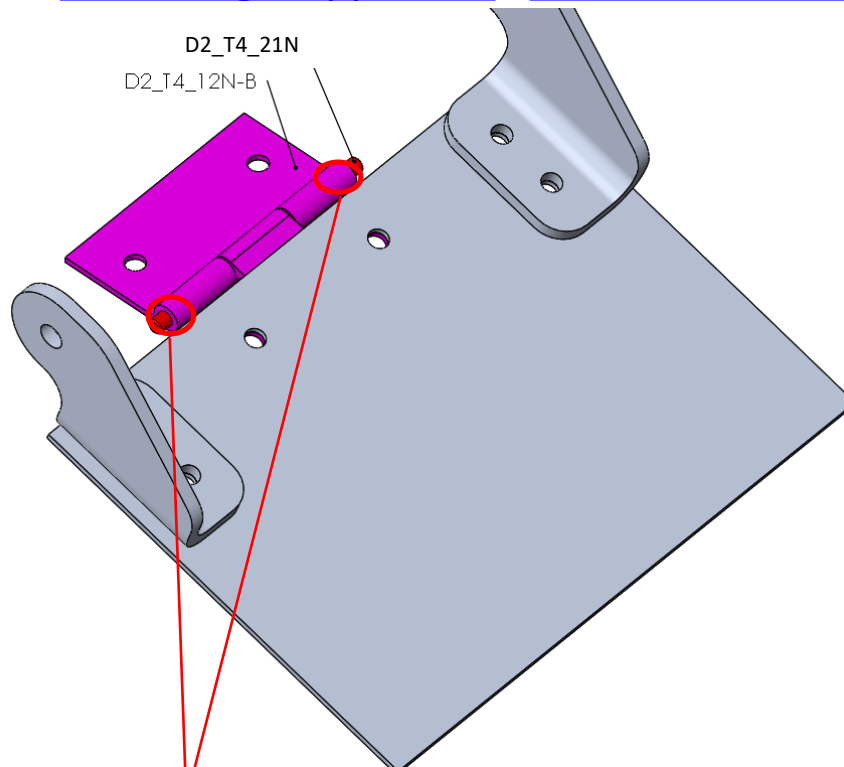
Step 17



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Step 18

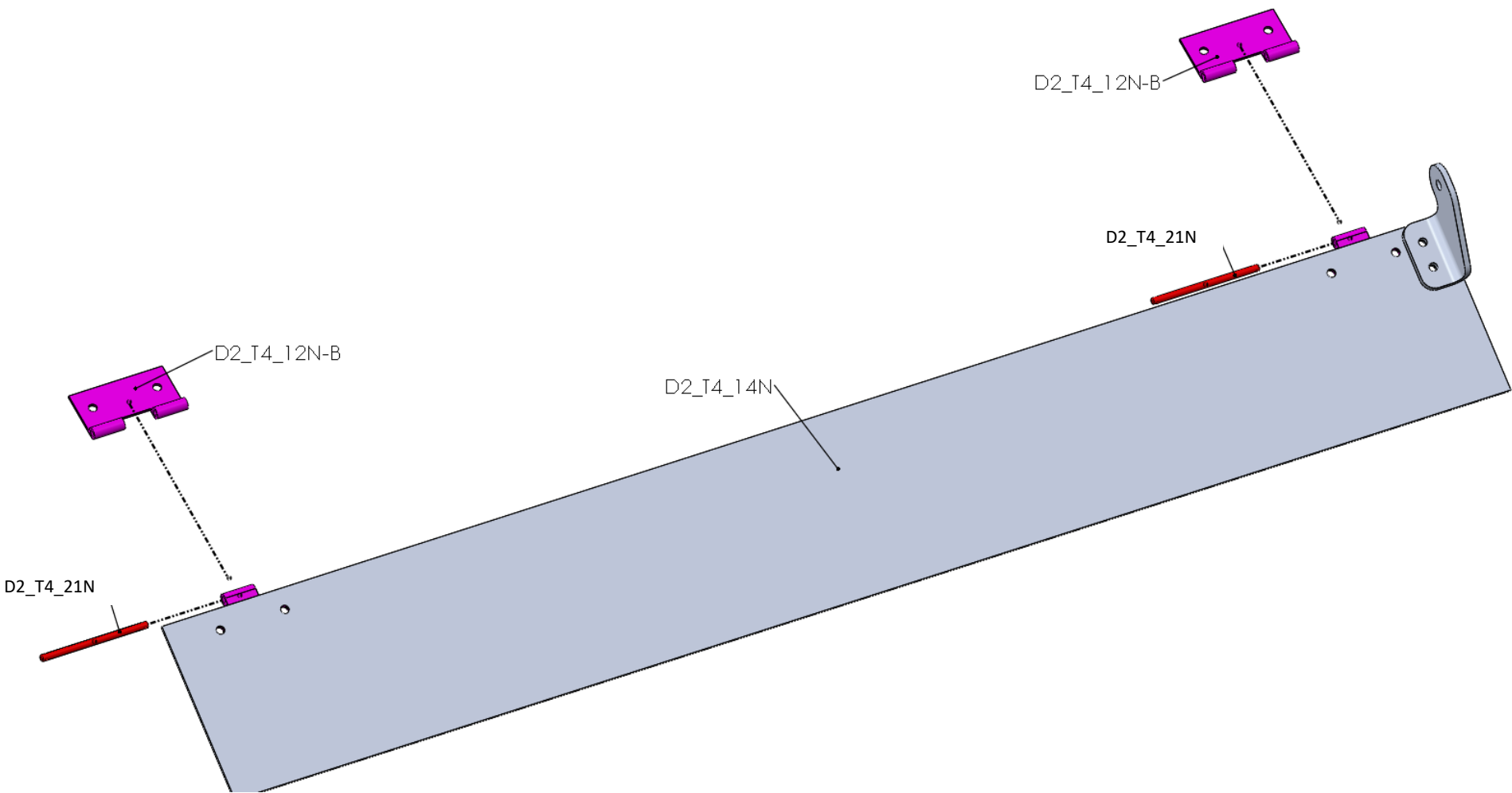


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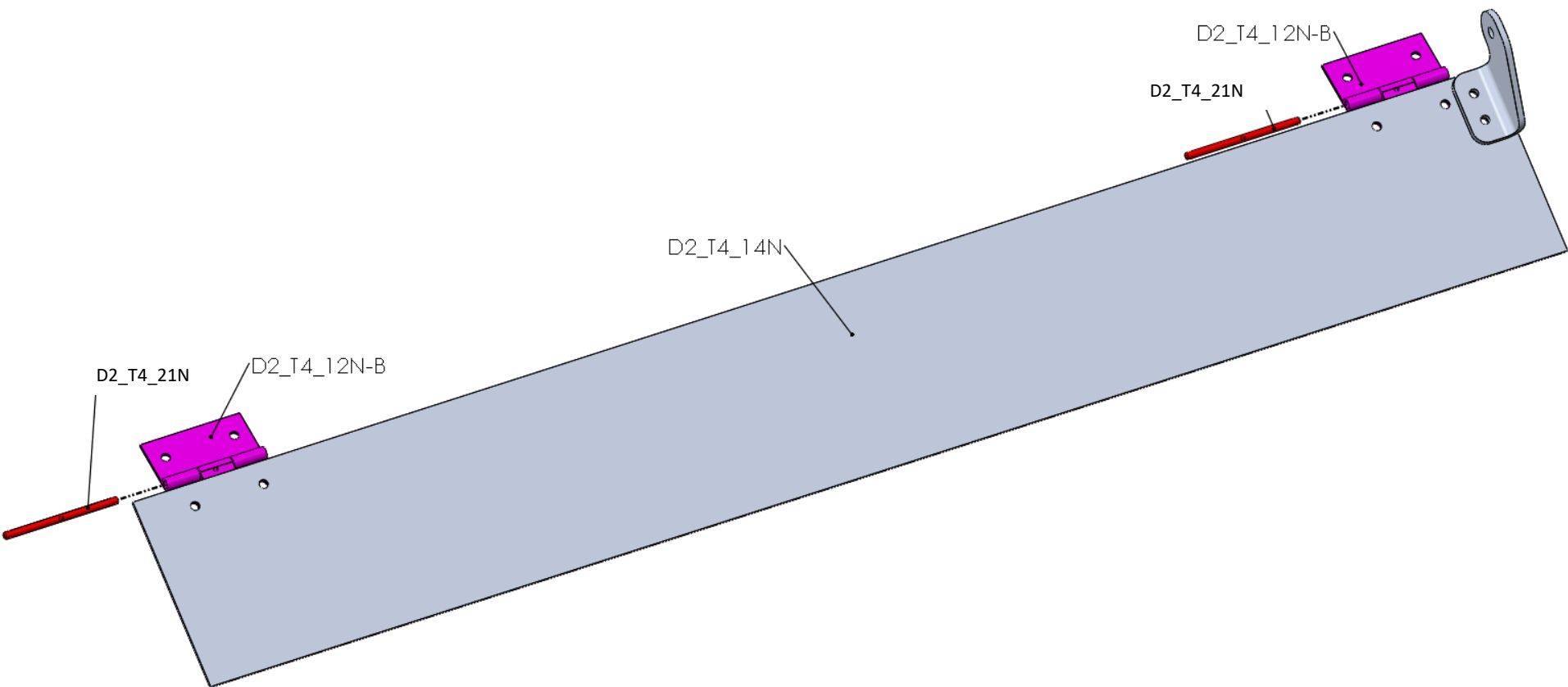
Step 19



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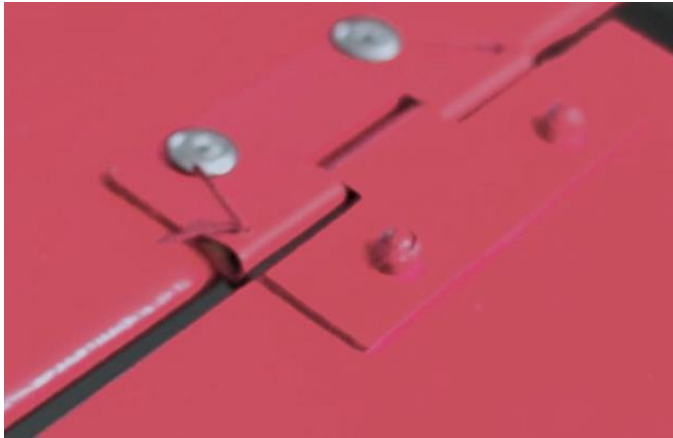
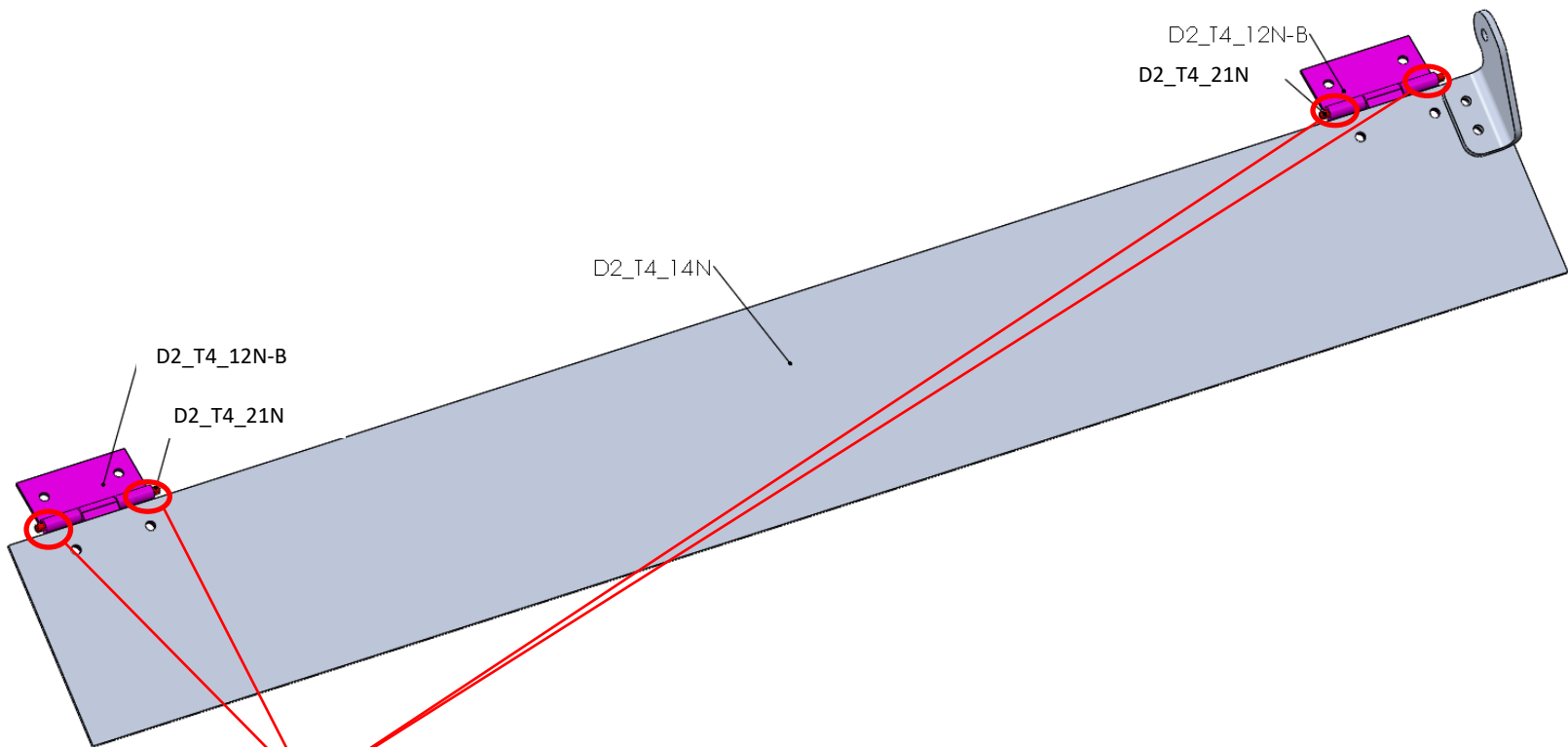
Step 20



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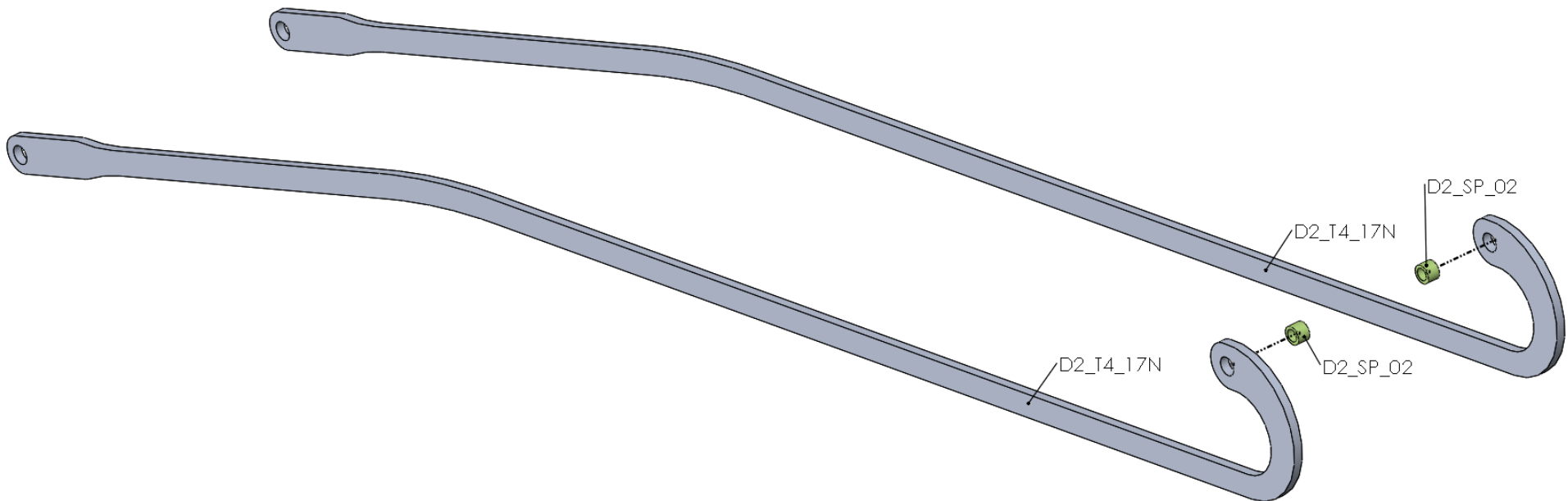
Step 21



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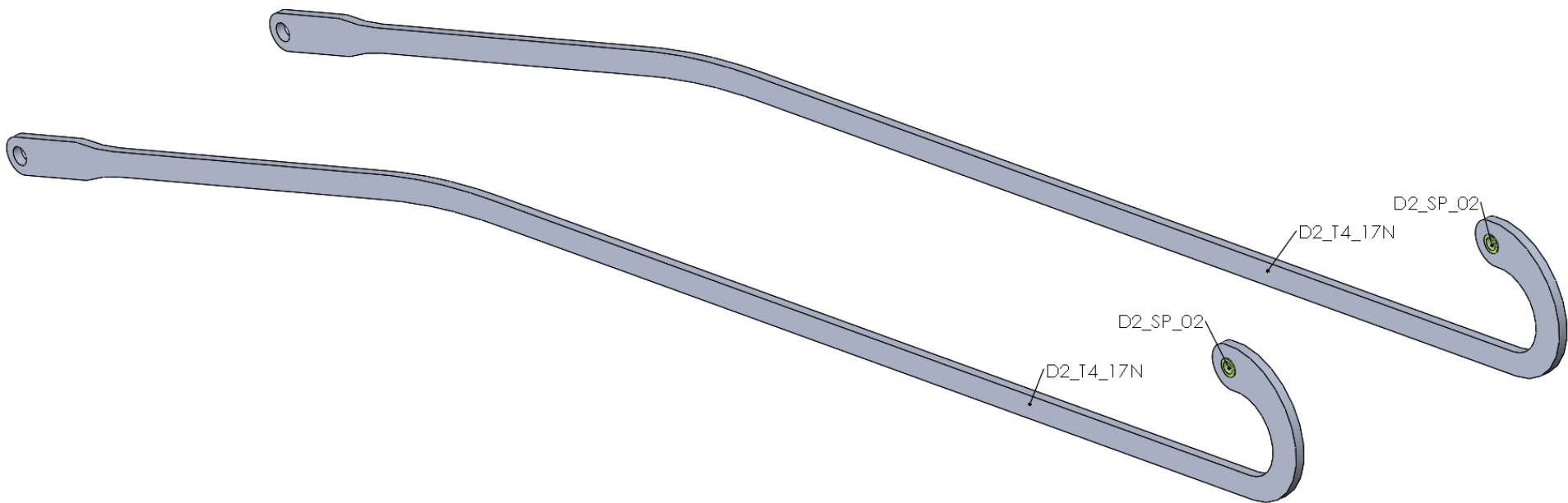
Step 22



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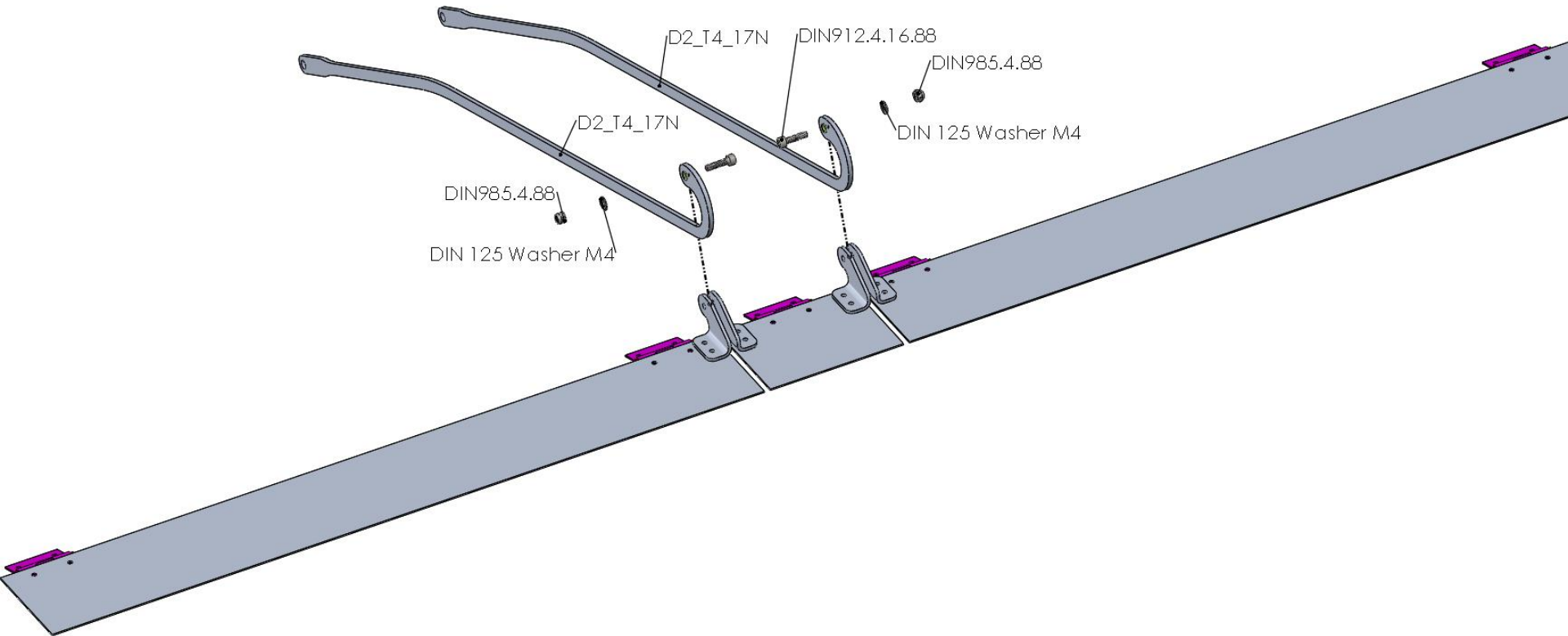
**Step 23**



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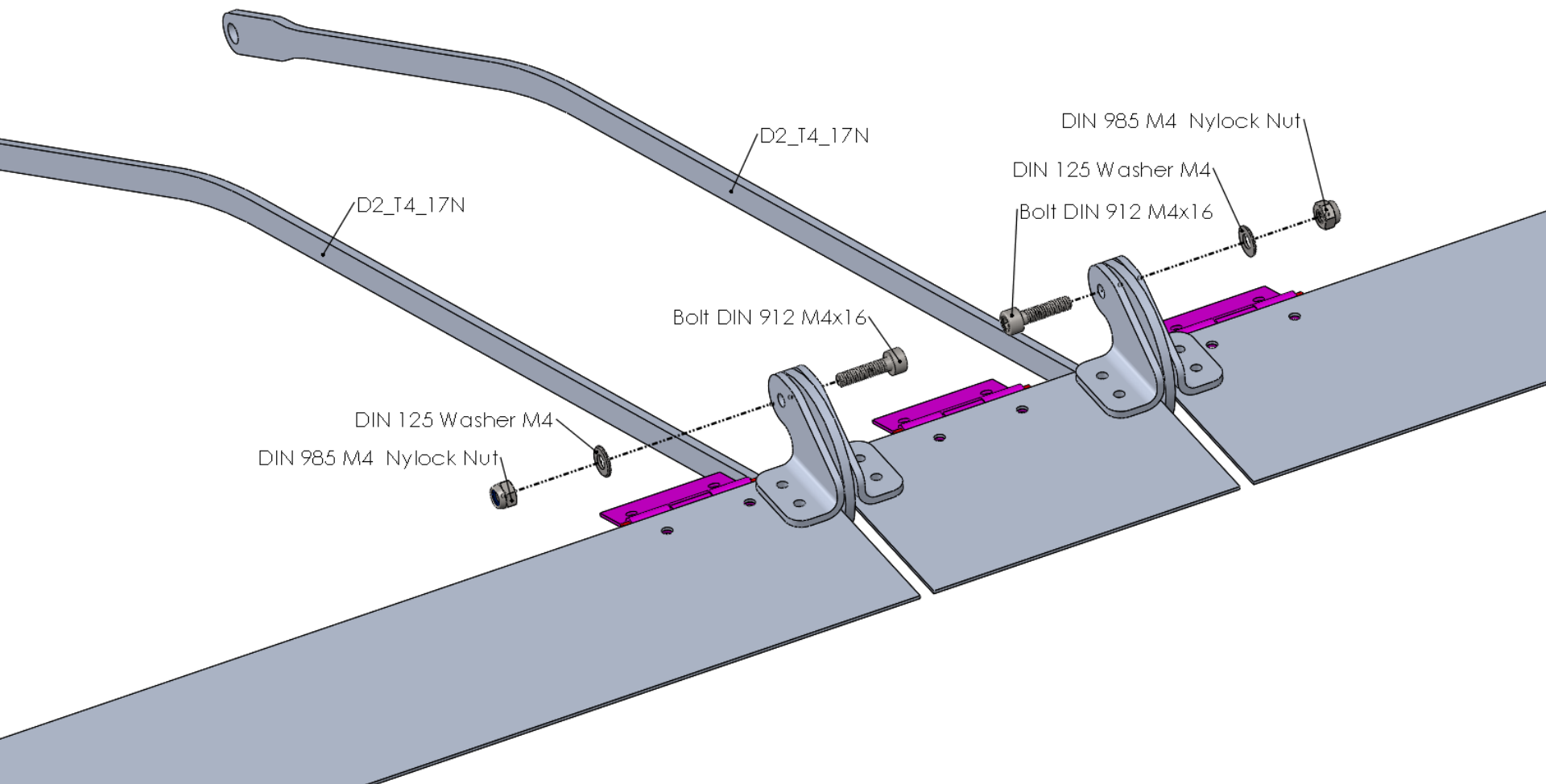
Step 24



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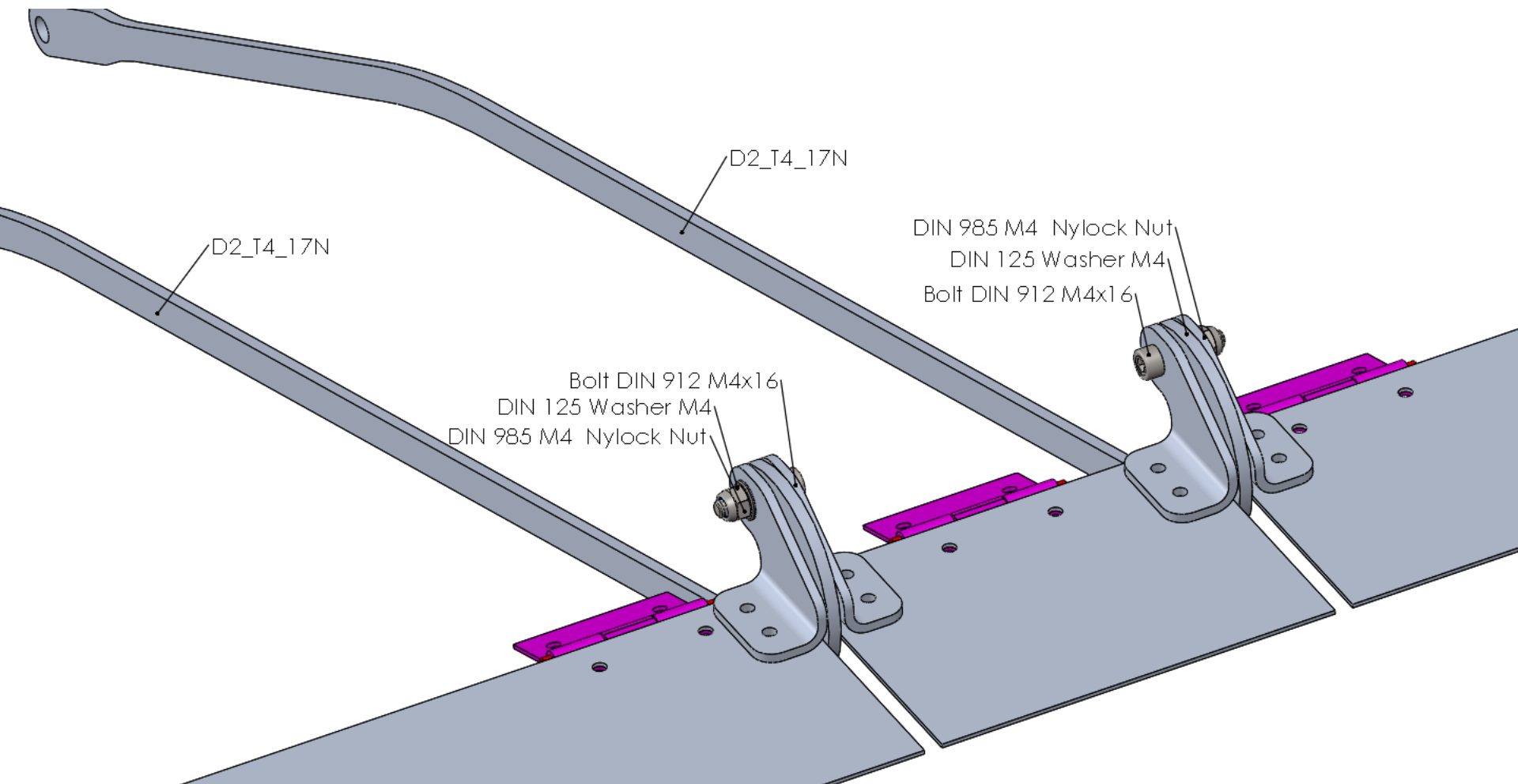
Step 25



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Step 26

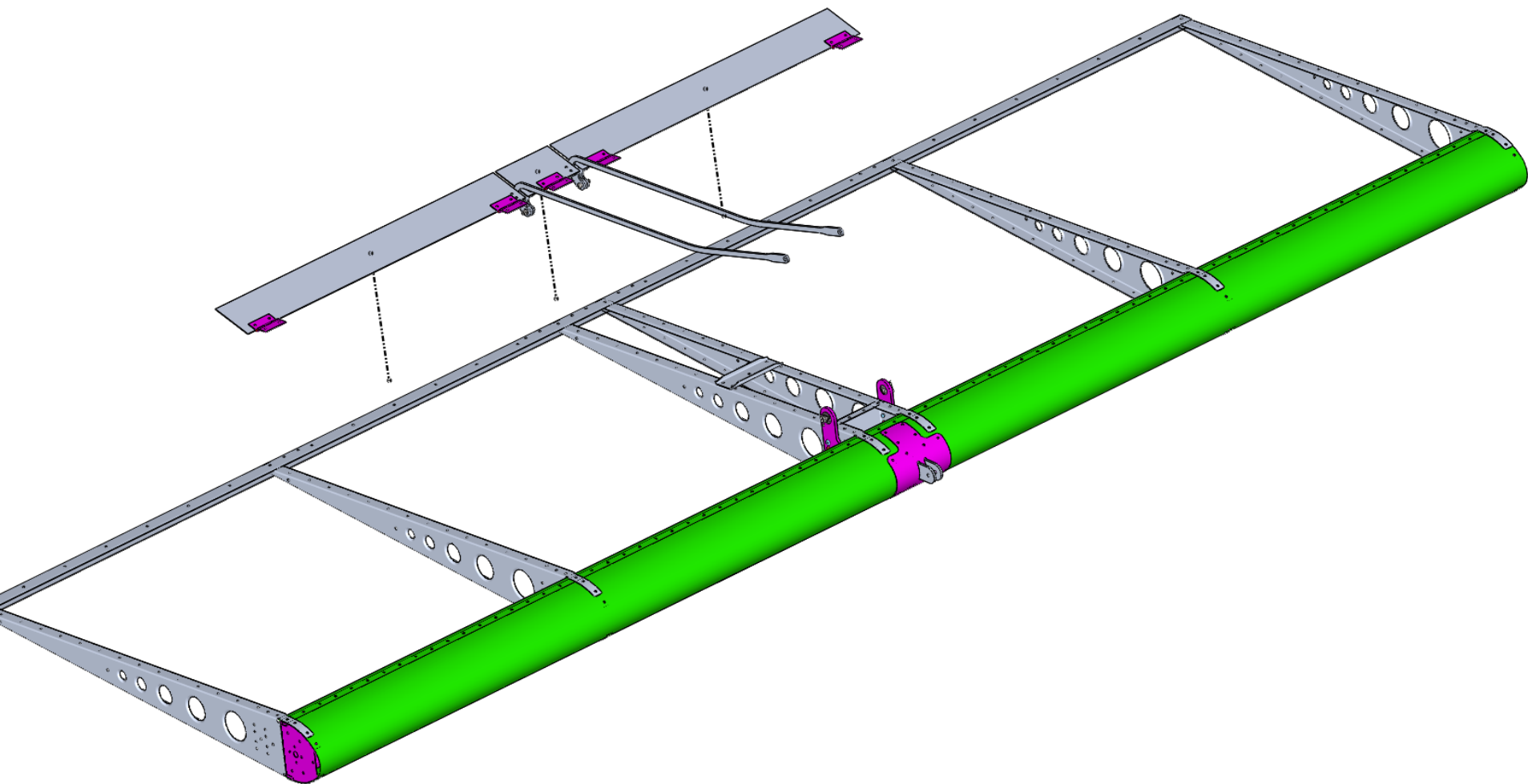


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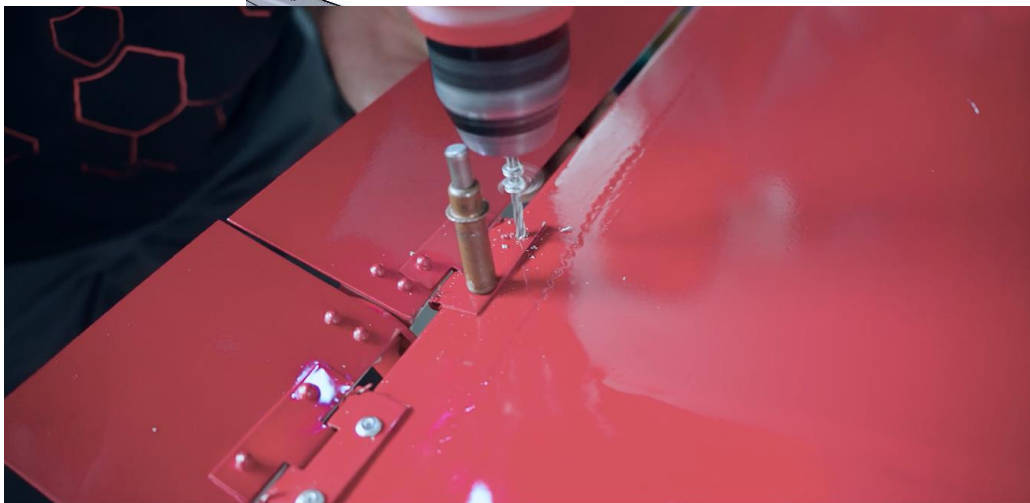
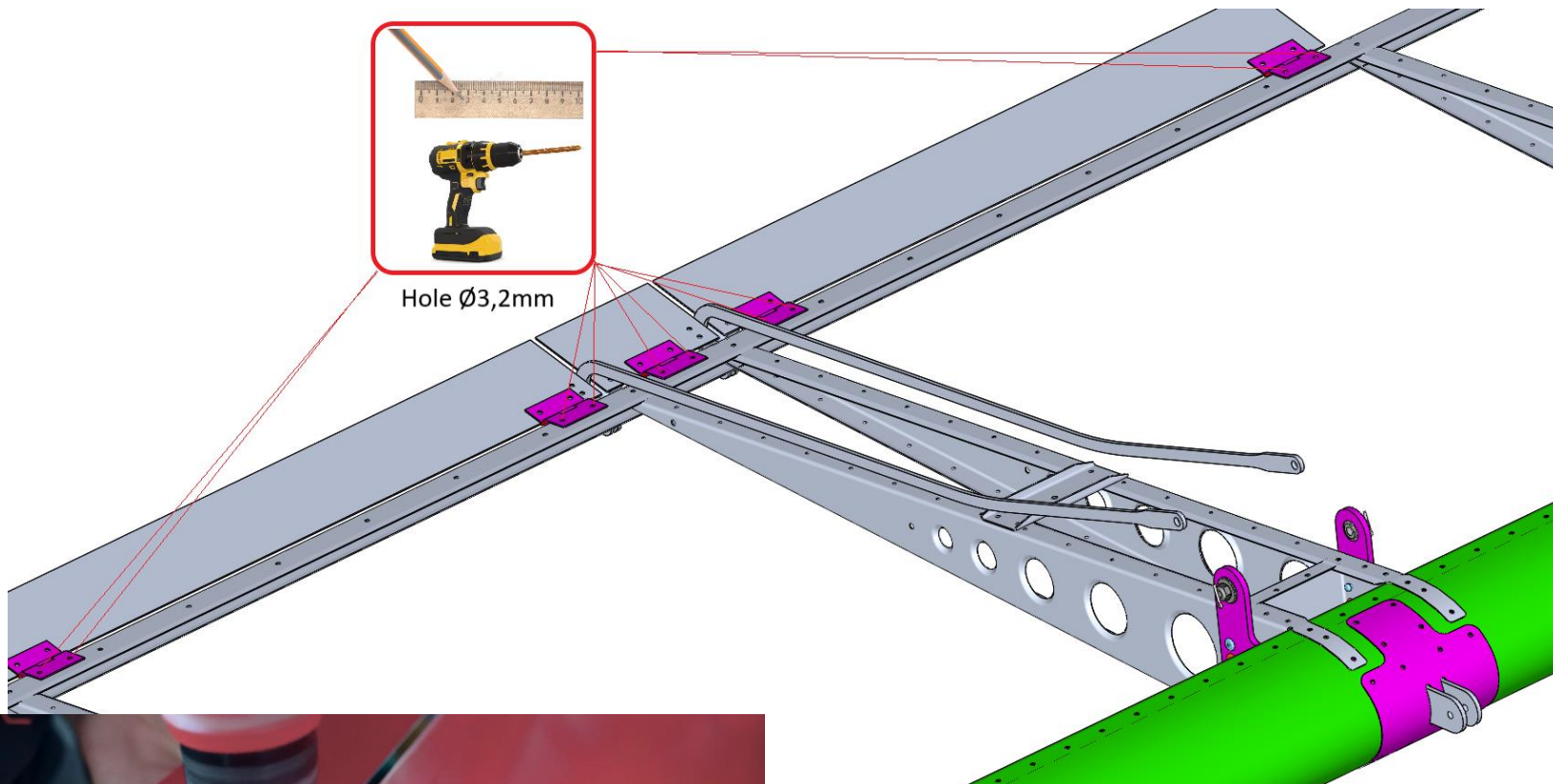
Step 1



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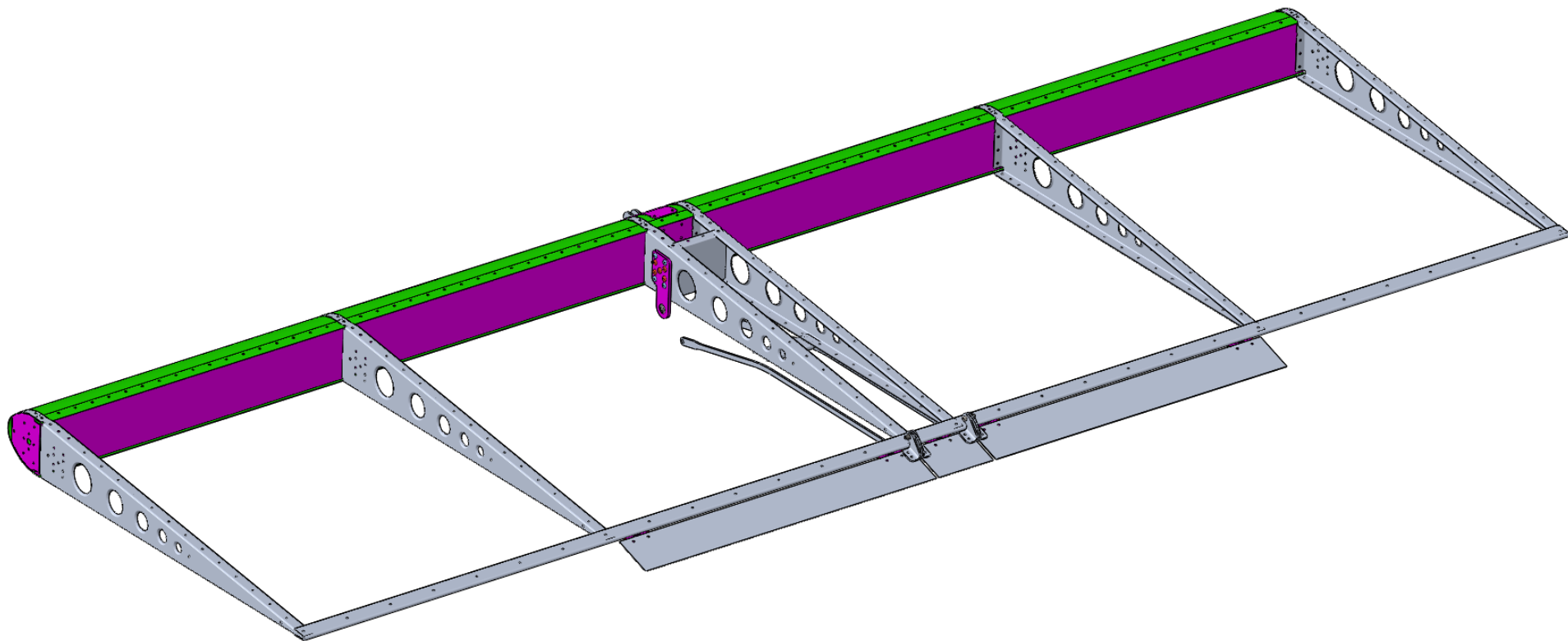
Step 2



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Step 3



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