

Title:

Wing assembly manual

Document no.:

D2_W0_00

Revision:

R02

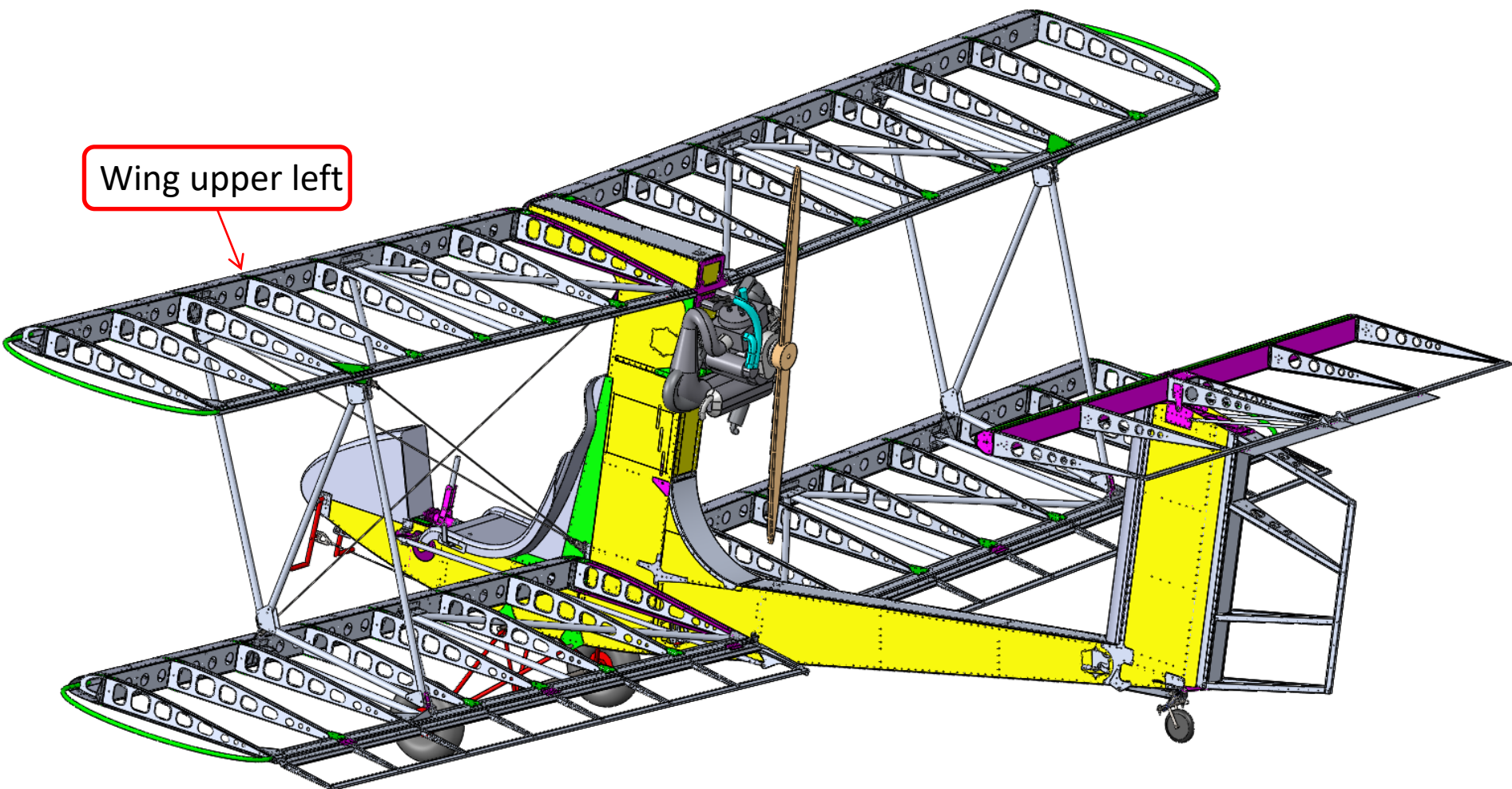
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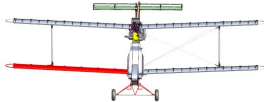
Revision	Affected pages	Short description of change
00	All	Original issue
01	02, 81, 82	Table of revision added, step 38-X - cutout corrected
02	103 – 108	Riveting of aileron hinges corrected

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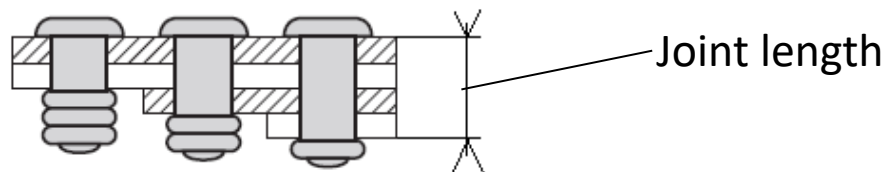


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General instructions:

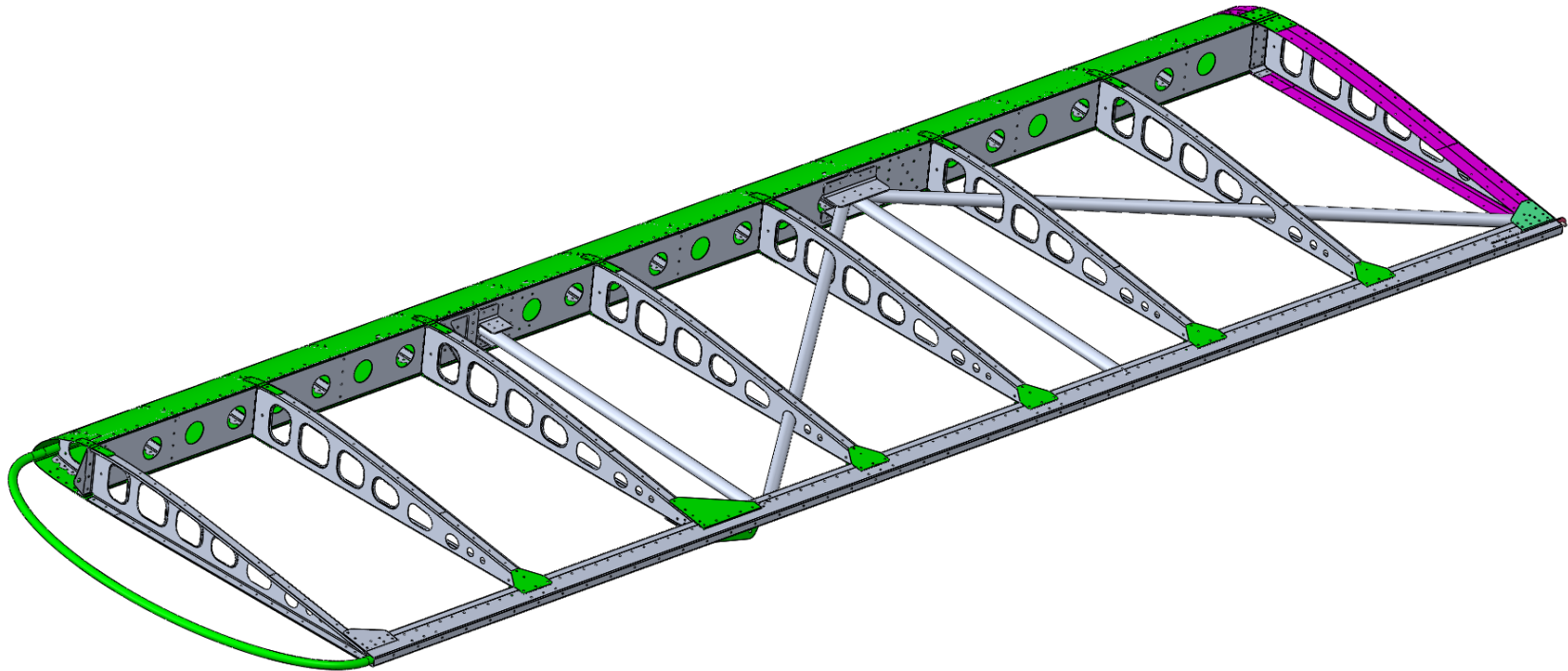
- This manual is for the upper left wing, right one is symmetrical. Specific places of construction are shown also for other wings. Follow this mark: 
- Use clecos for the preassembly, as shown in the video tutorial
- If there is no specific rivet shown or called in the assembly, use rivet AVEX 3,2x7,9 Al/St
- Use Polyurethane 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 Φ 3,2x7,9 Al/St	16910410	Al 3,2x7,9	AVEX Φ 3,2x7,9 Al/Fe	0,8mm	4,8mm
AVEX Φ 3,2x11,2 Al/St	16910414	Al 3,2x11,2	AVEX Φ 3,2x11,2 Al/Fe	4,0mm	7,9mm
AVEX Φ 4x9,5 Al/St	16910512	Al 4x9,5	AVEX Φ 4x9,5 Al/Fe	1,0mm	6,0mm
AVEX Φ 4x12,7 Al/St	16910516	Al 4x12,7	AVEX Φ 4x12,7 Al/Fe	4,0mm	9,6mm
AVINOX Φ 4x12 EST/EST PH	14514012	INOX 4x12	AVINOX Φ 4x12 EST/EST PH	3,5mm	7,0mm

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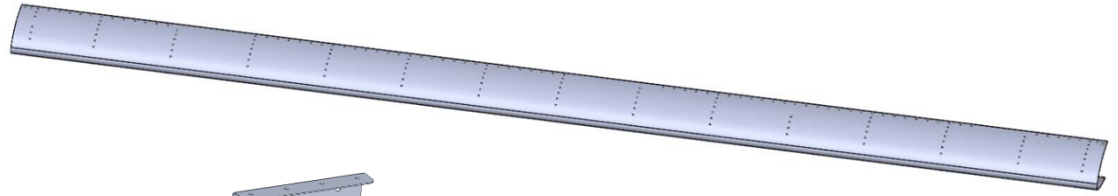
Assembly tool



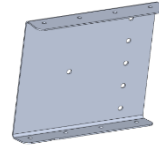
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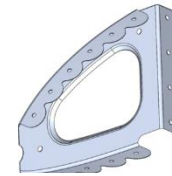
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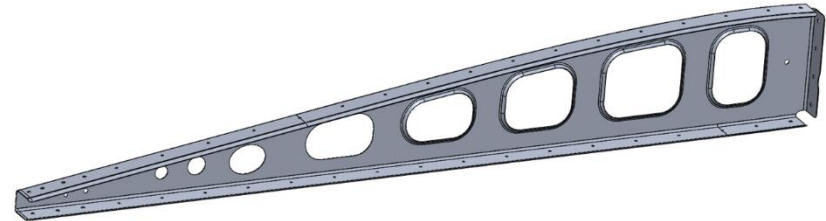
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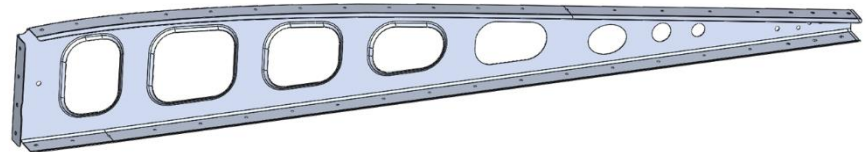
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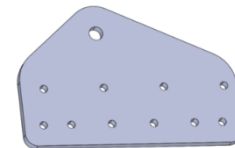
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Part number D2_W11_06P
Quantity 1



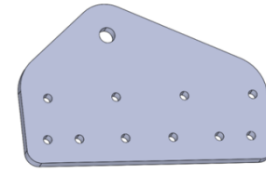
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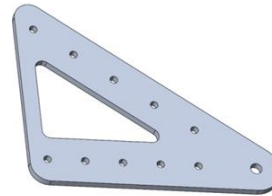
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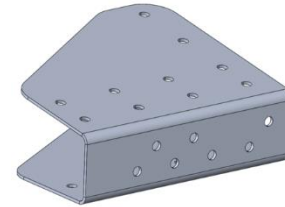
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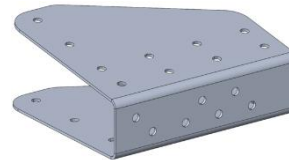
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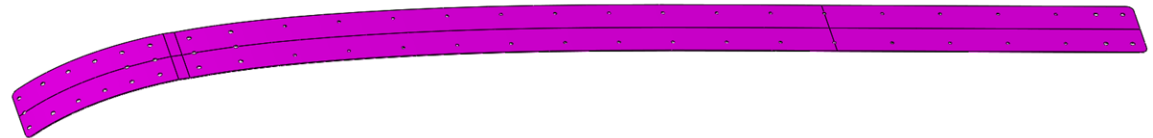
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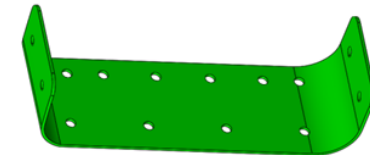
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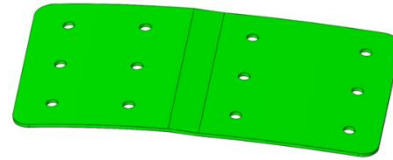
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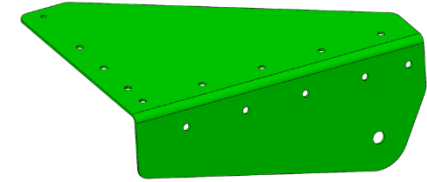
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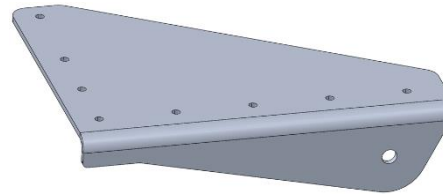
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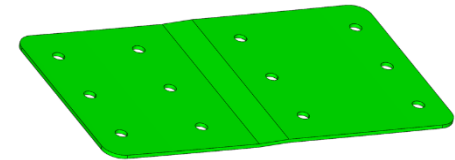
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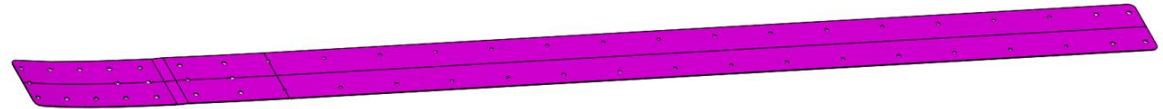
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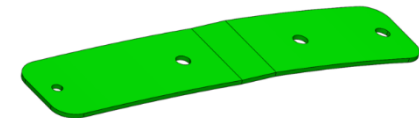
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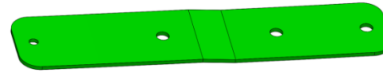
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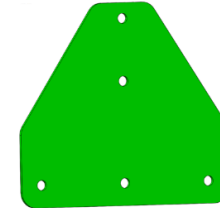
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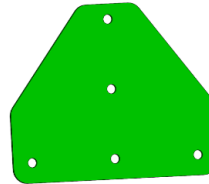
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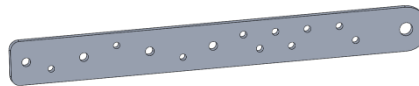
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Quantity 1



Part number D2_W21_10N
Quantity 1



Part number D2_W11_29N
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Part number D2_W11_32N
Quantity 2



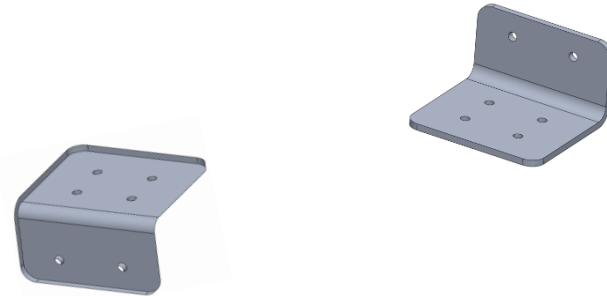
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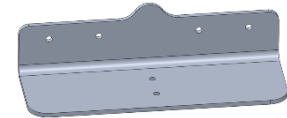


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Quantity 1



Part number D2_W11_40N
Quantity 1

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Quantity 1



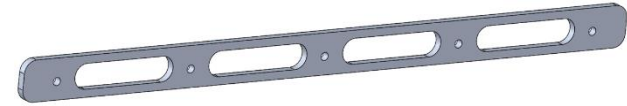
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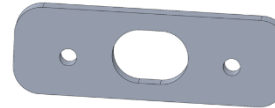
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Quantity 3



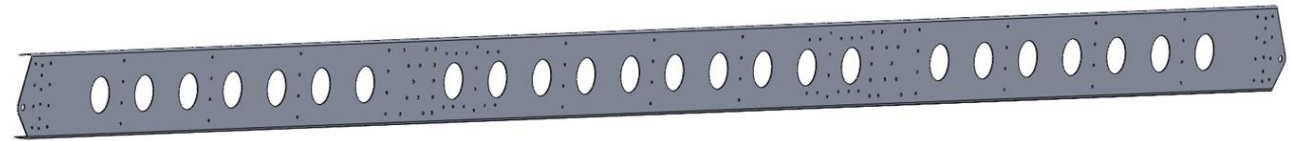
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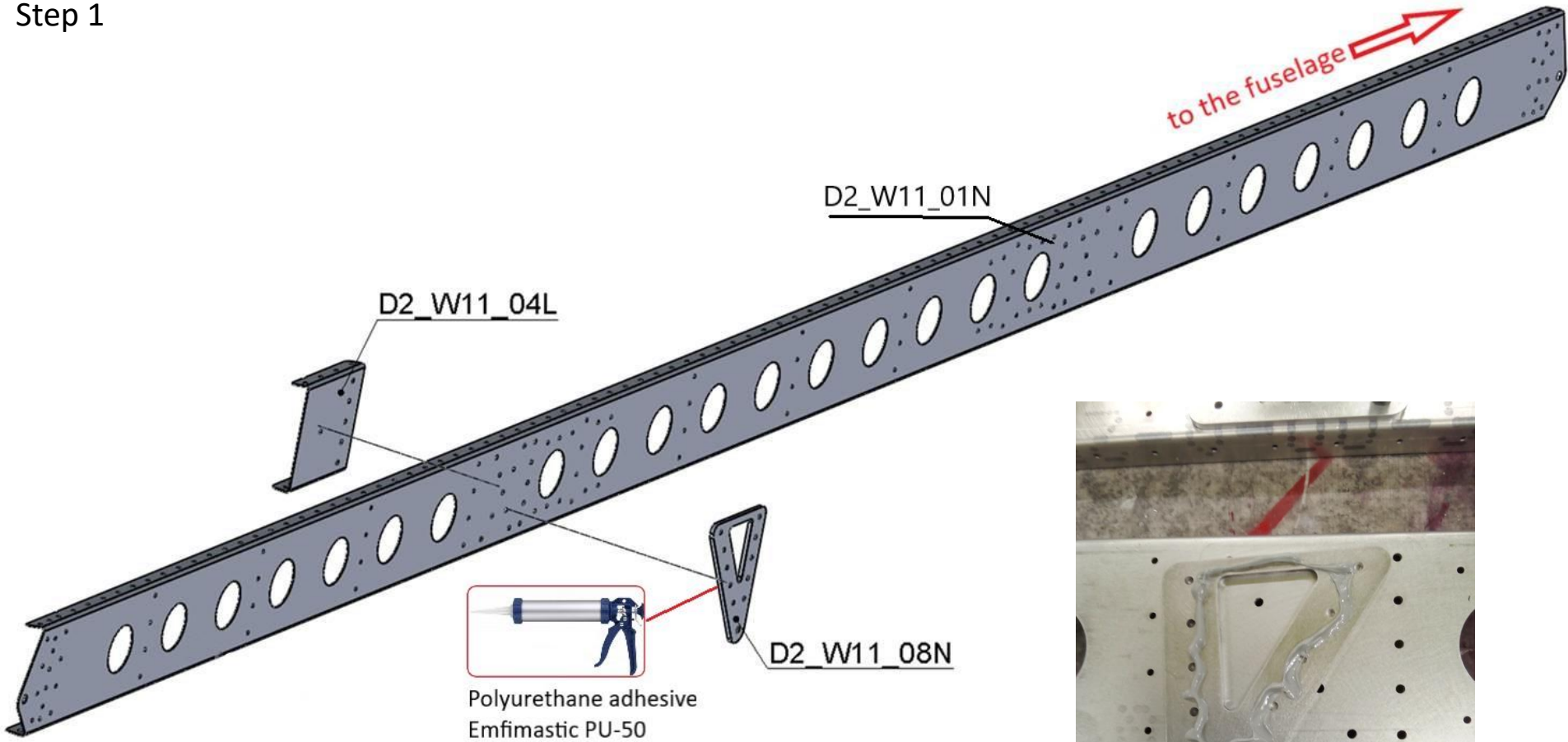


Standard parts	
Part	Quantity
Blind rivets AVEX Ø3,2x7,9 Al/St	826
Blind rivets AVEX Ø3,2x11,2 Al/St	29
Blind rivets AVEX Ø4,0x9,5 Al/St	46
Blind rivets AVEX Ø4,0x12,7 Al/St	2
Blind rivets AVINOX Ø4,0x12,0 EST/EST PH	16

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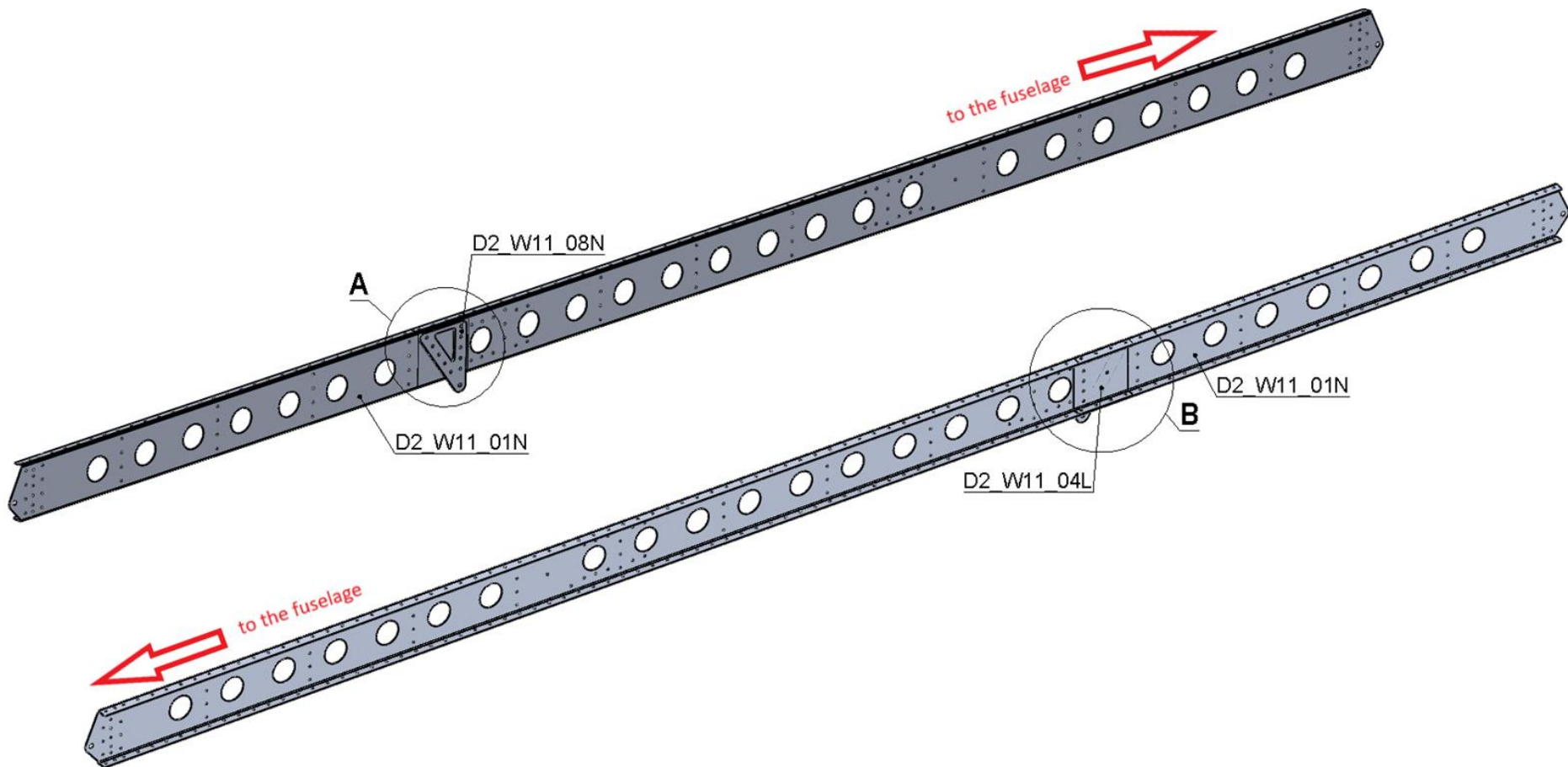
Step 1



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Step 2



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Step 2


Blind rivets
AVINOX M Ø 4,0x12,0 EST/EST PH

B

D2_W11_04L

D2_W11_01N

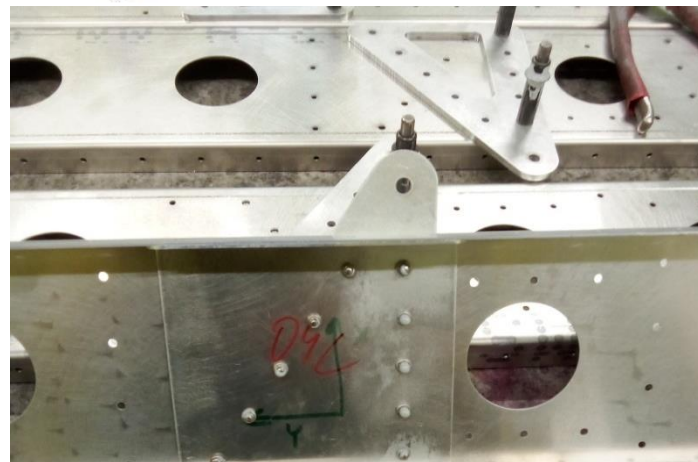
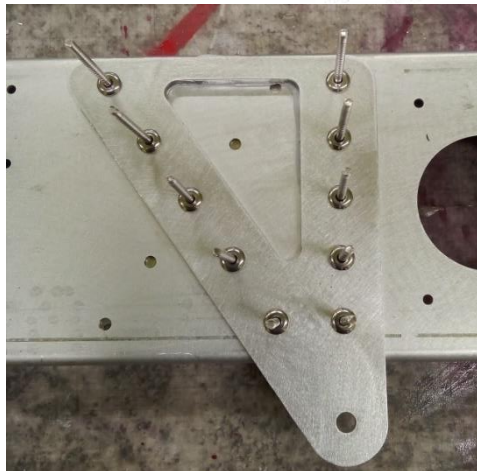
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D2_W11_01N

D2_W11_08N



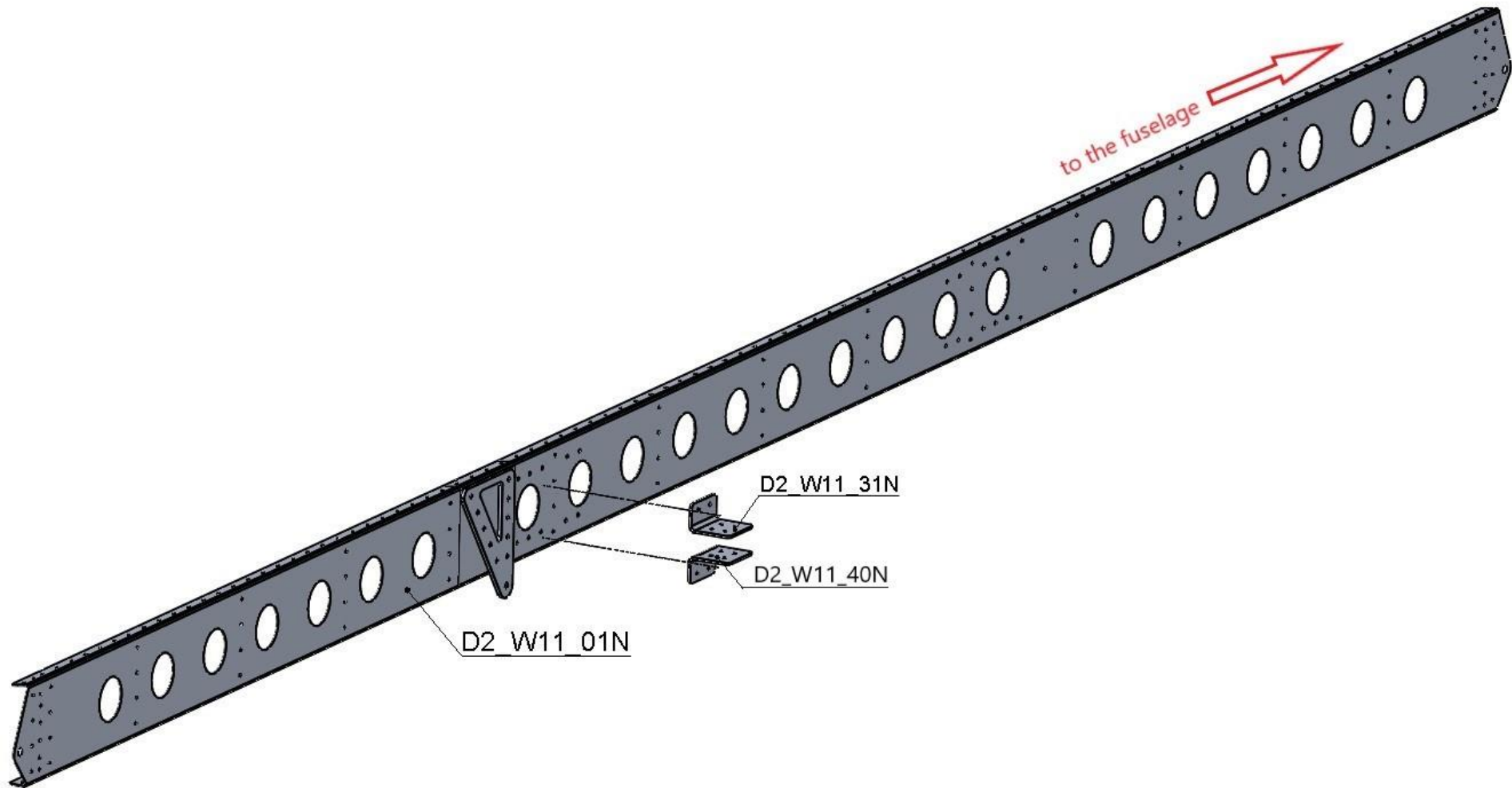
Hole Ø4mm



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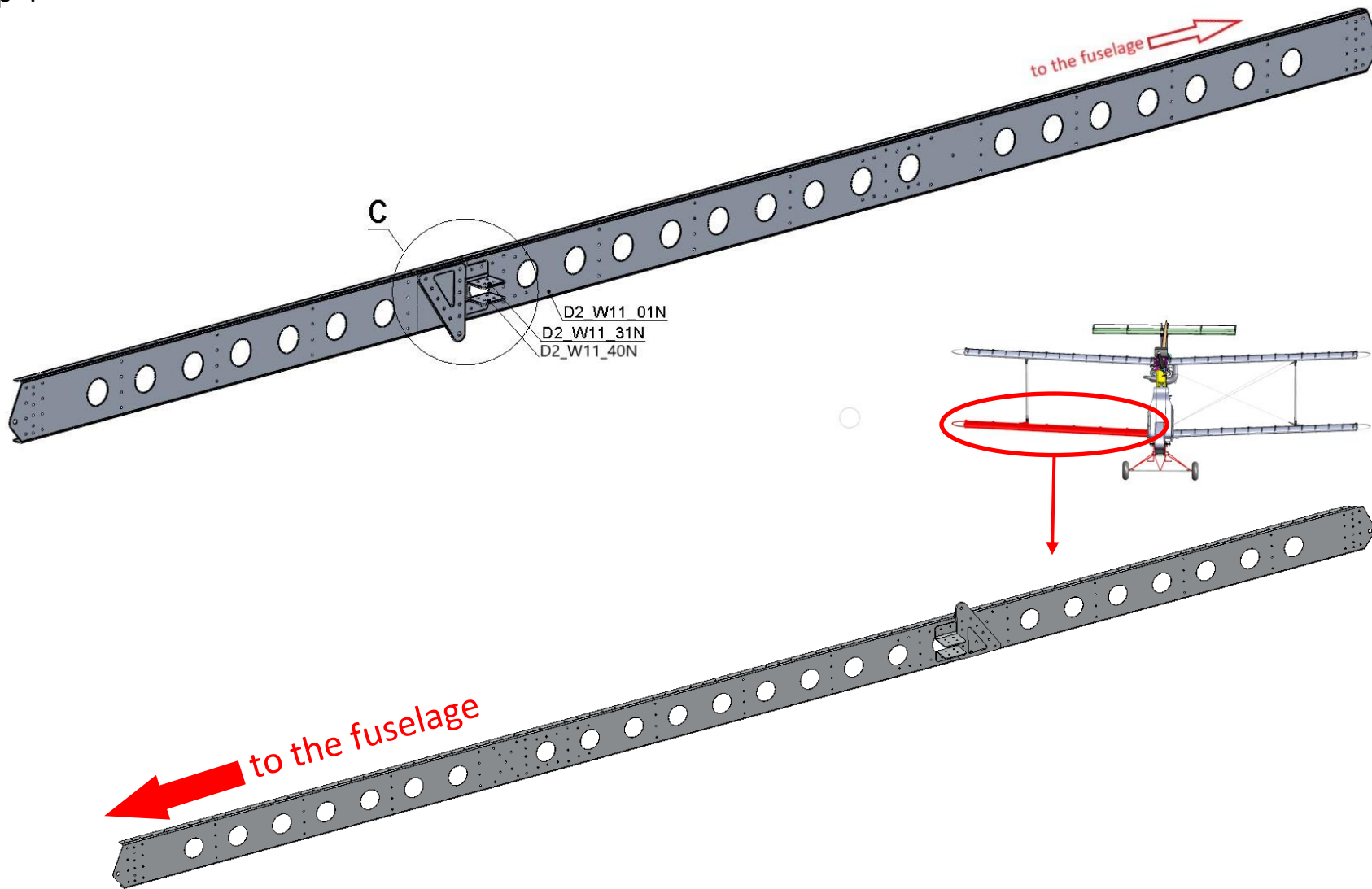
Step 3



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Step 4

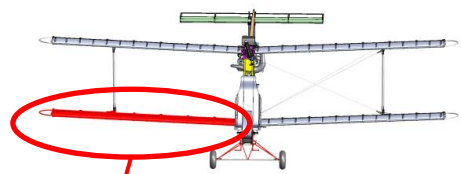
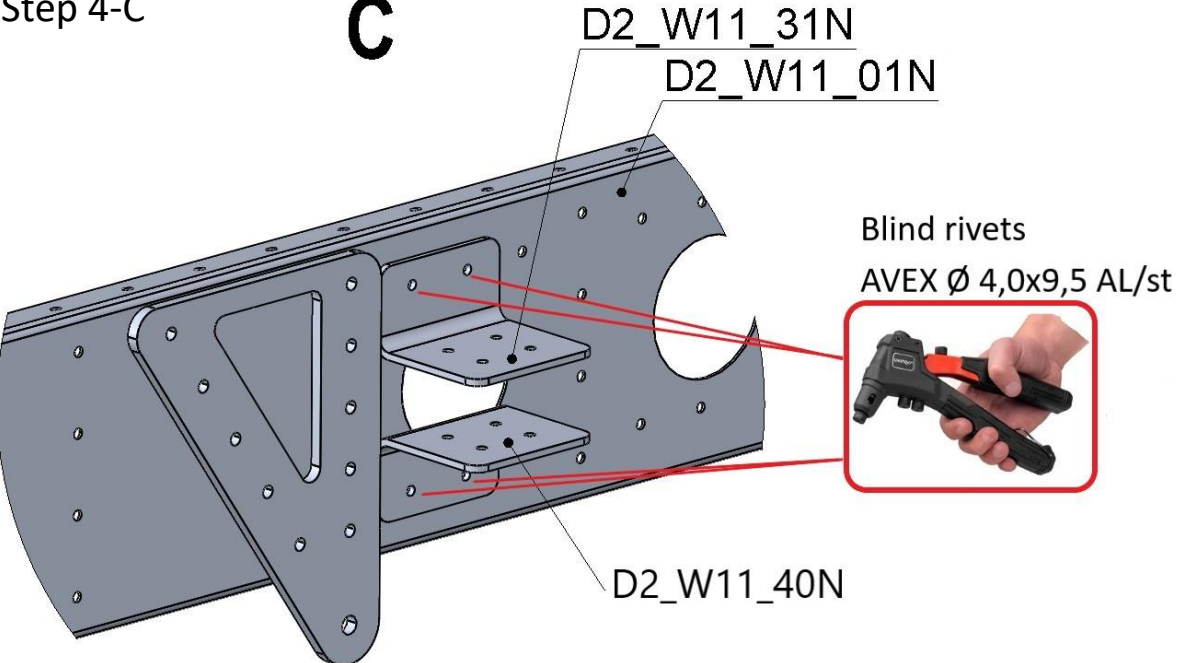


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Step 4-C

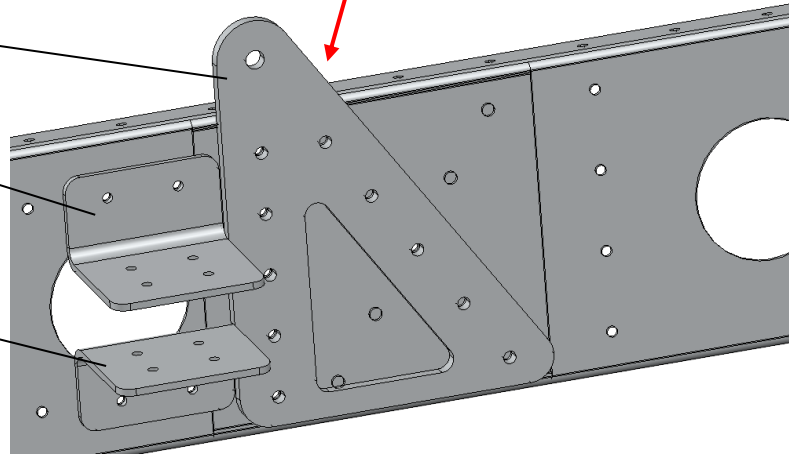
C



D2_W11_08N

D2_W11_31N

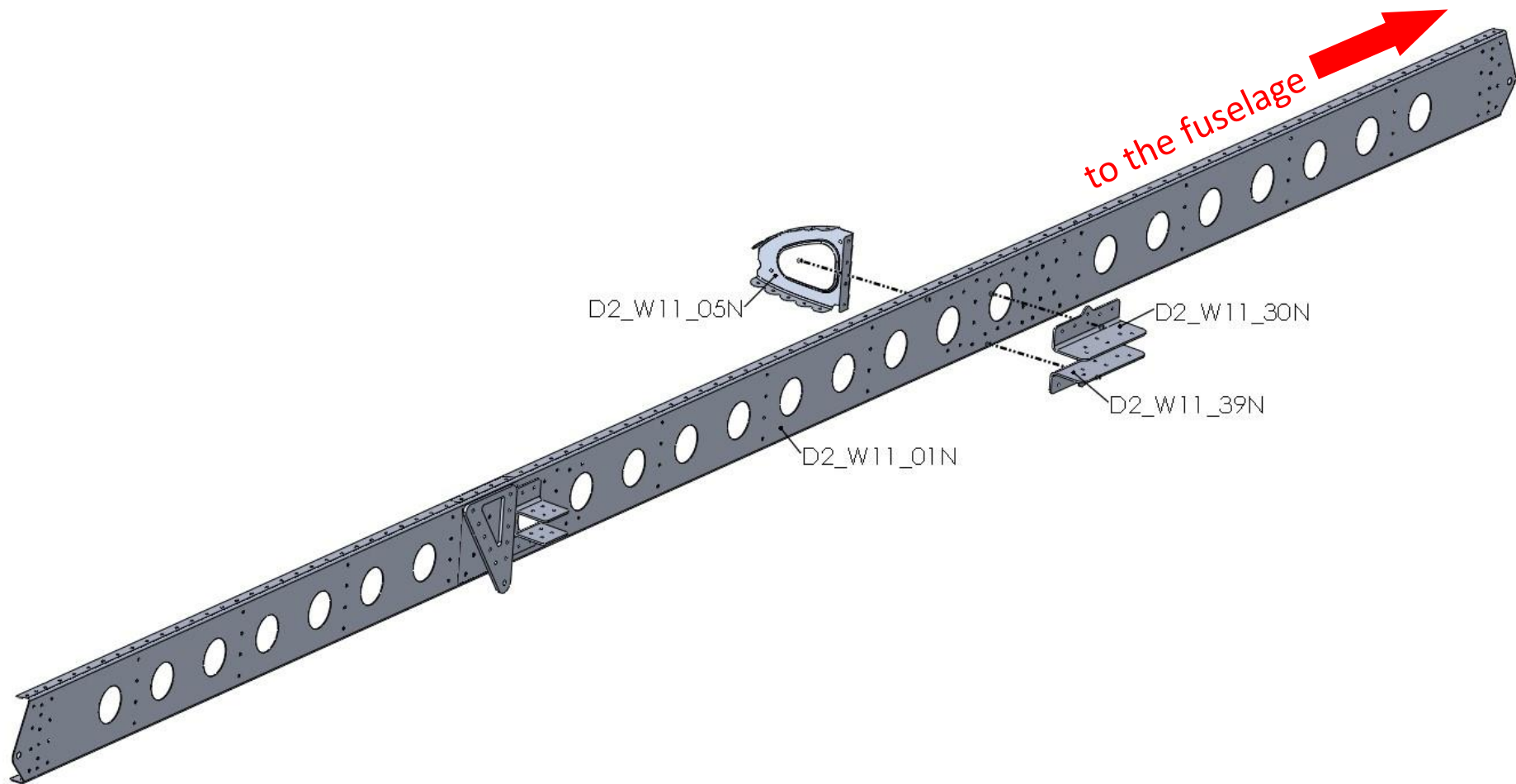
D2_W11_40N



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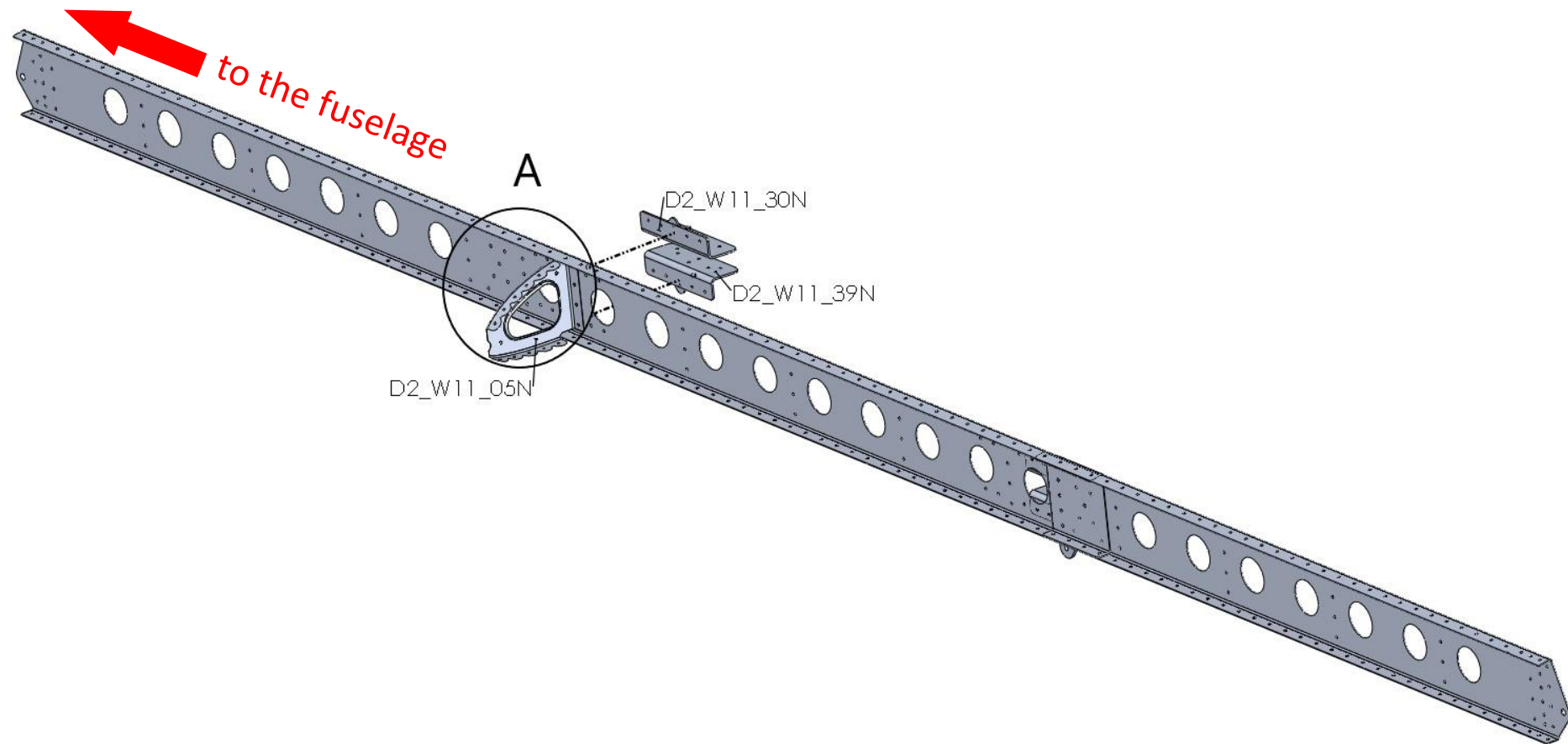
Step 5



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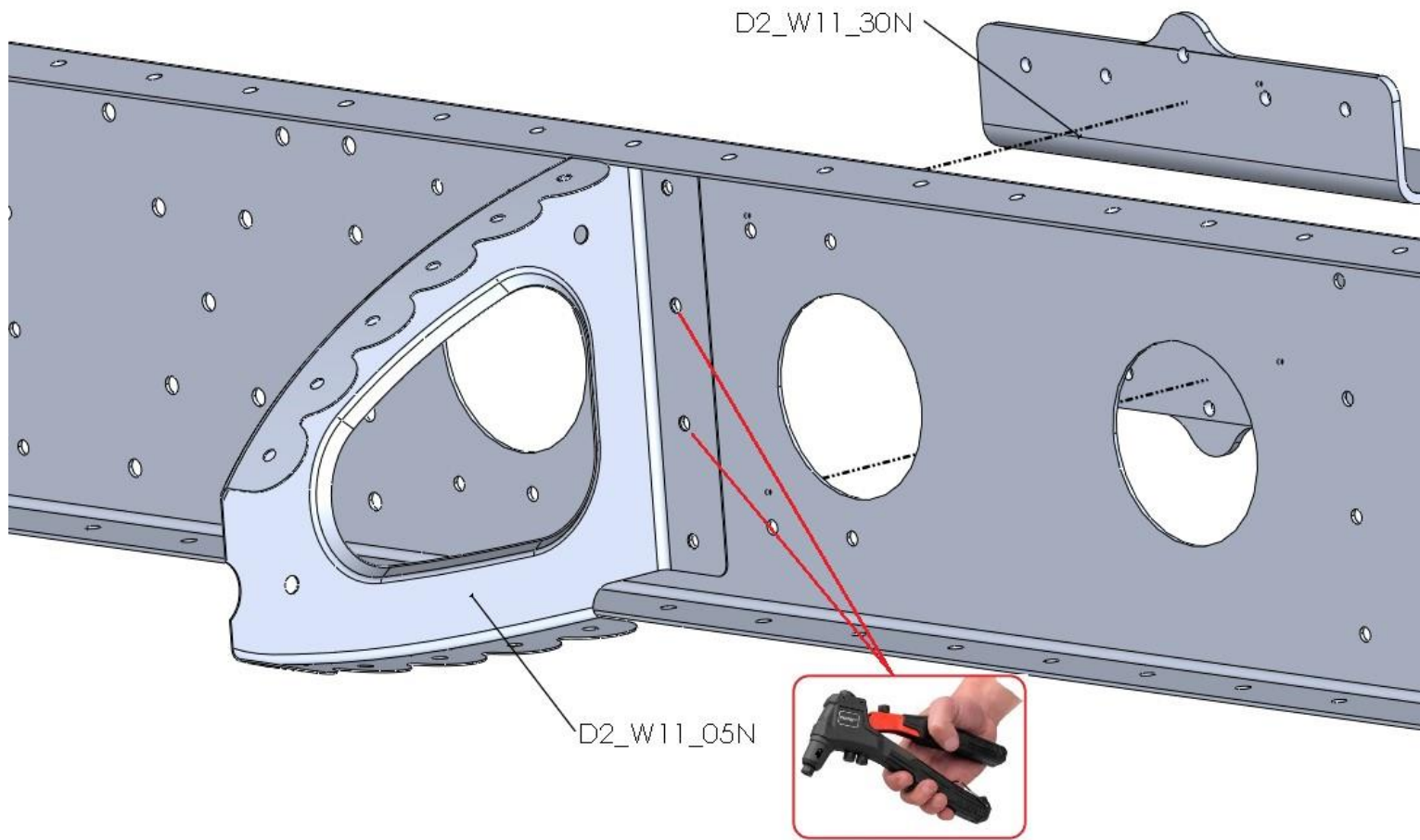


Step 6



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Step 6-A

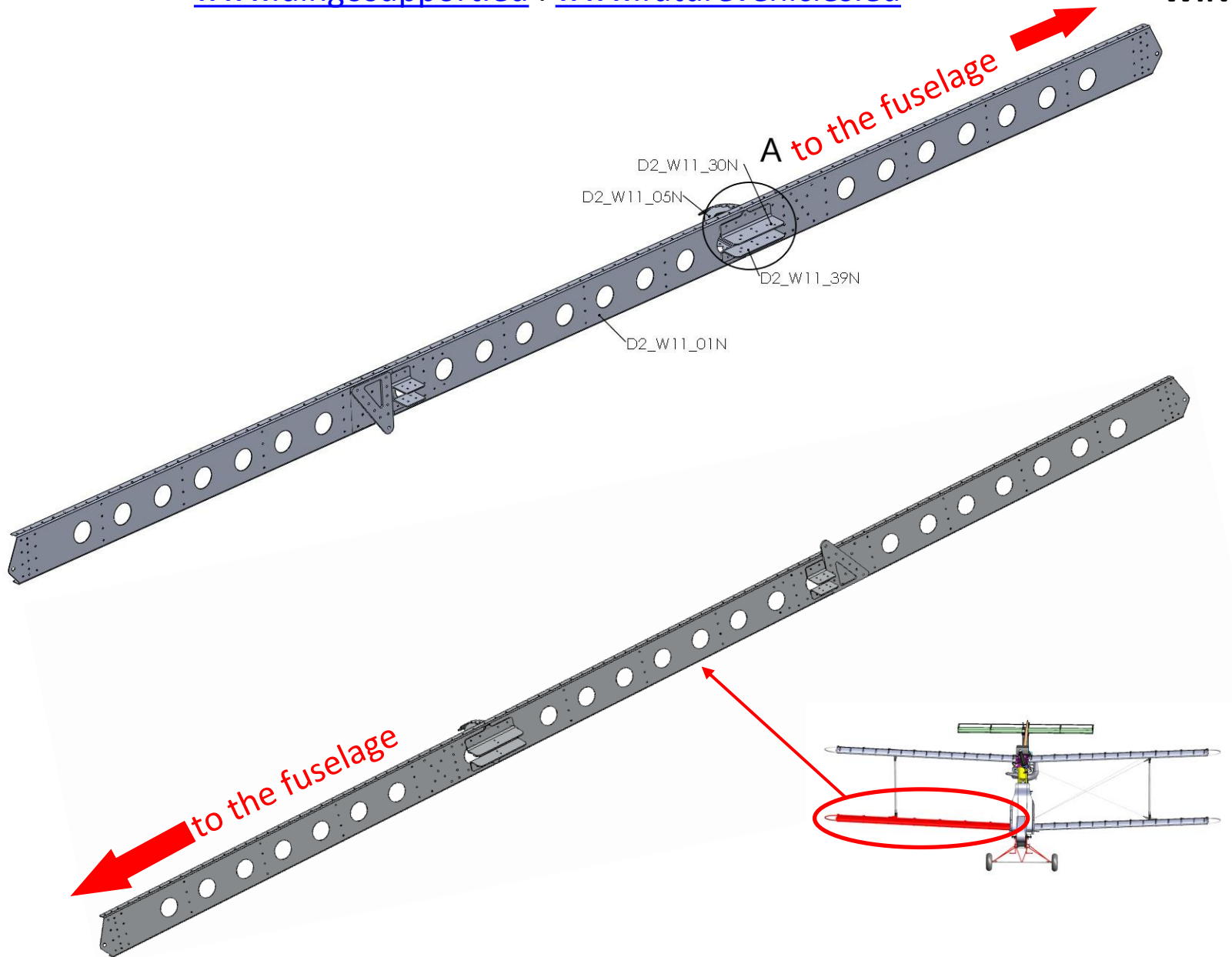


Blind rivets
AVEX Ø3,2x7,9 Al/St

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Step 7



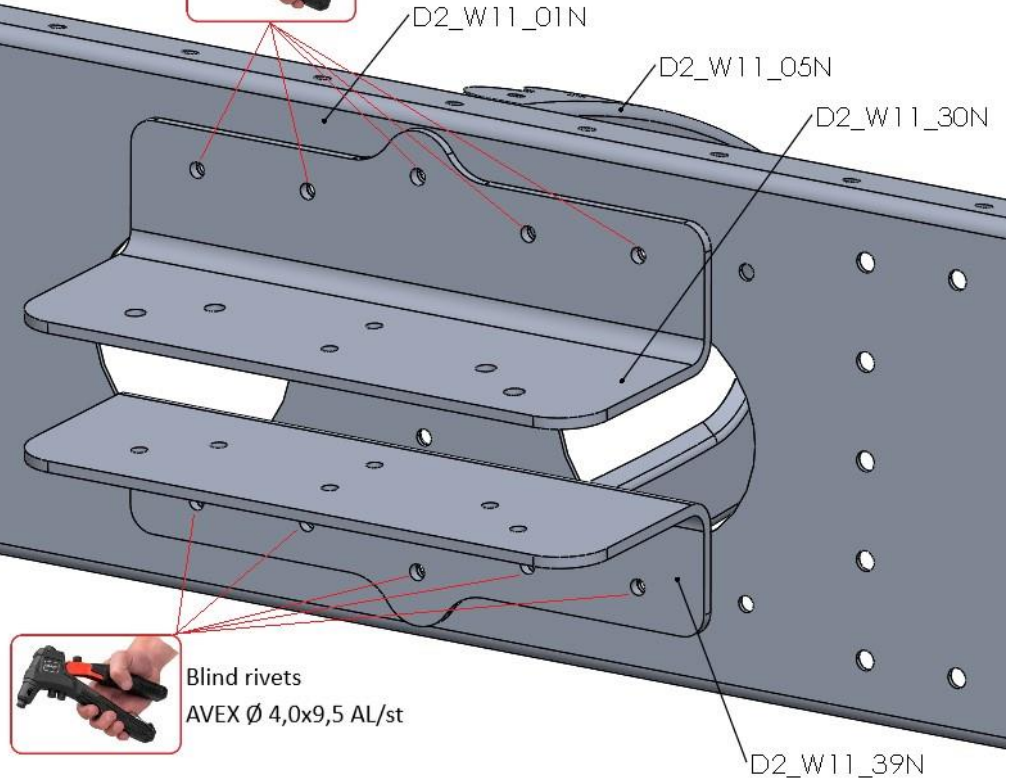
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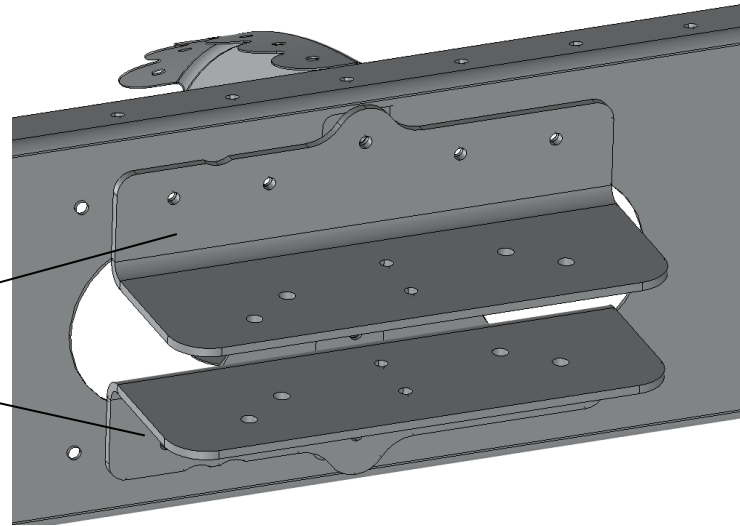
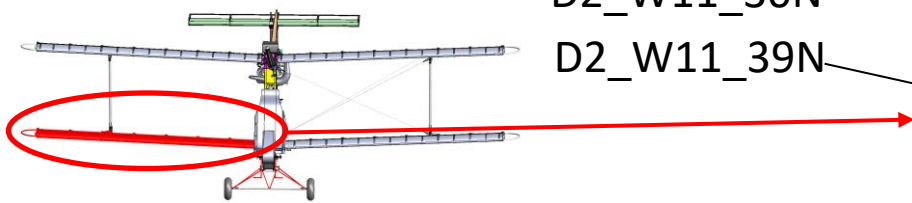
Step 7-A



Blind rivets
AVEX Ø 4,0x9,5 AL/st



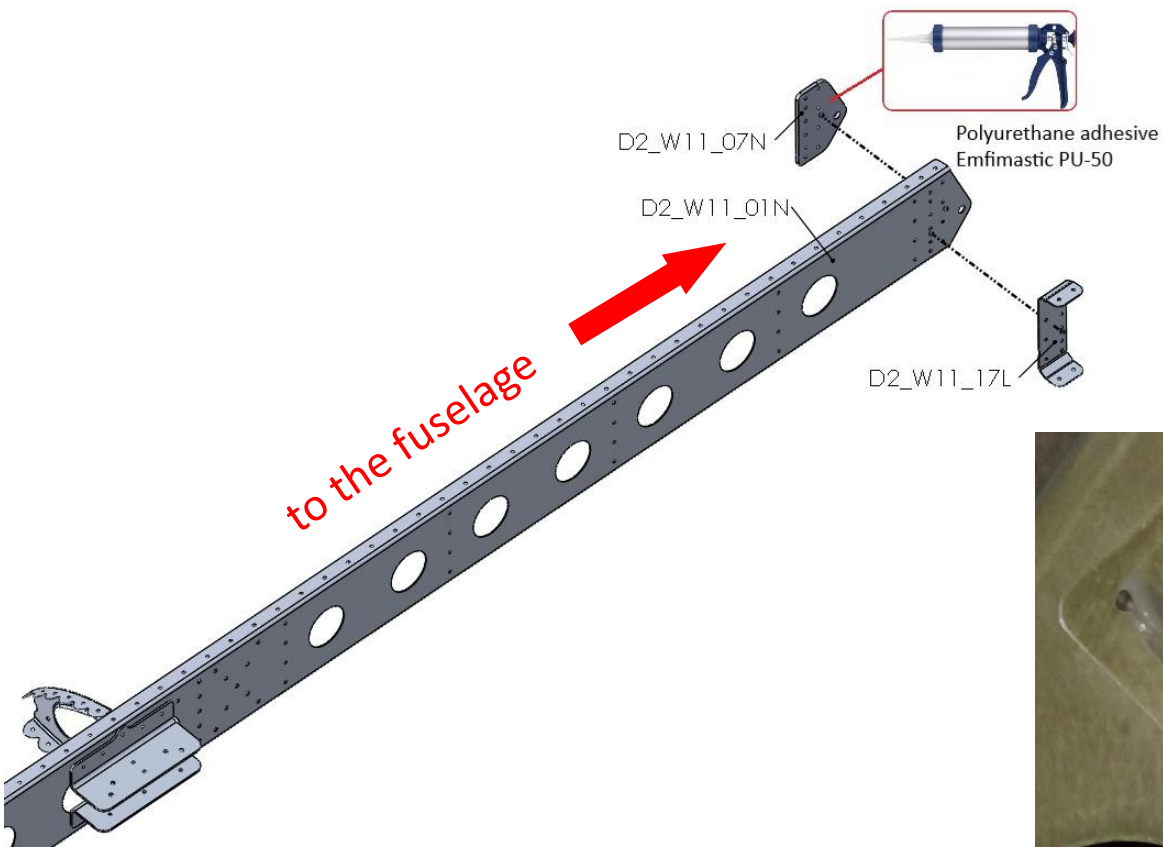
Blind rivets
AVEX Ø 4,0x9,5 AL/st



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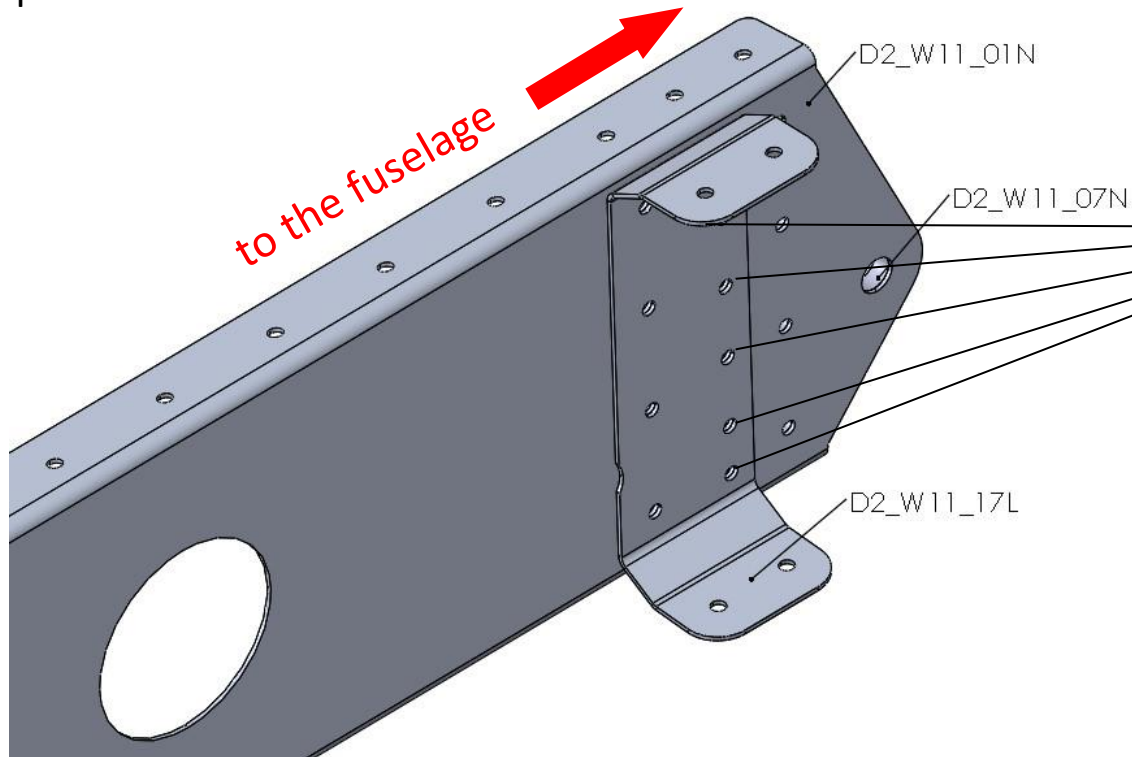
Step 8



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Step 9



Blind rivets
AVEX $\Phi 3,2 \times 11,2$ Al/St



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Step 10

to the fuselage

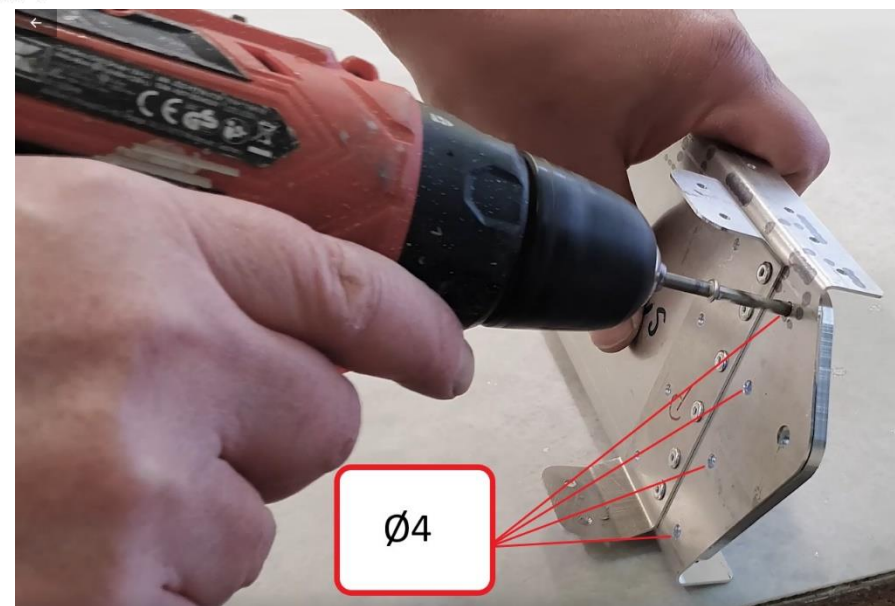
D2_W11_01N

D2_W11_07N



Hole Ø4mm

D2_W11_17L

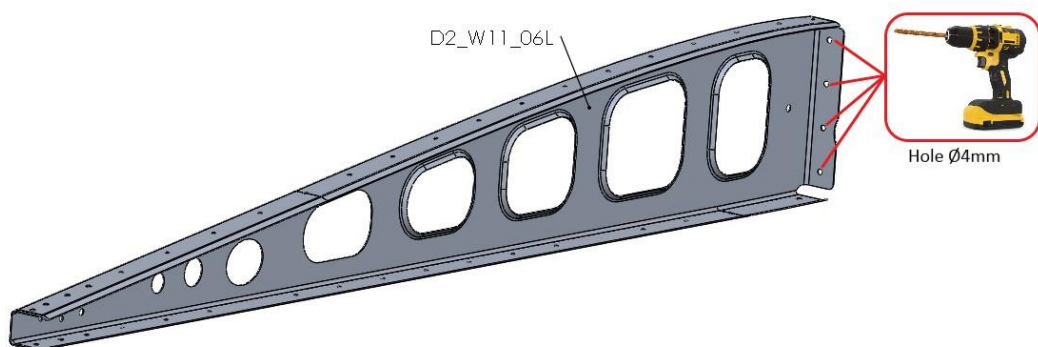
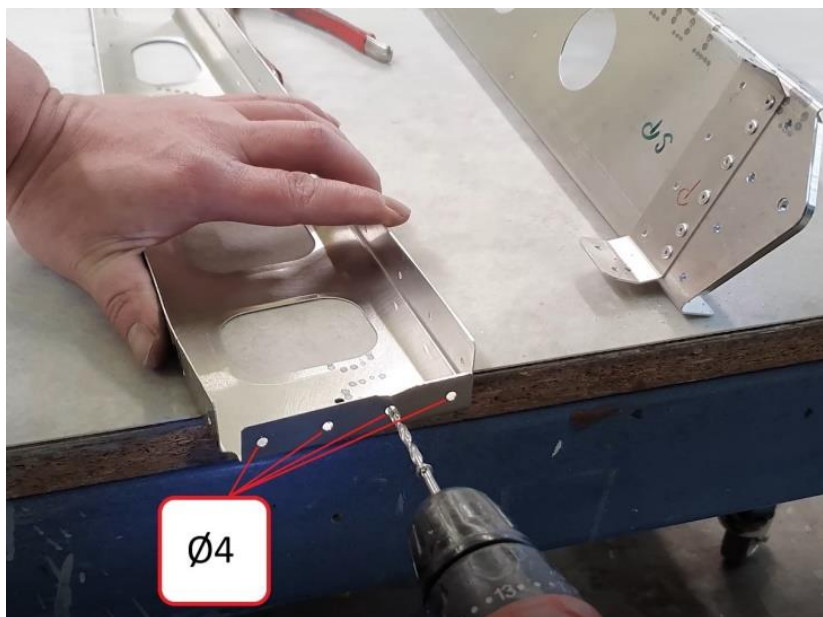
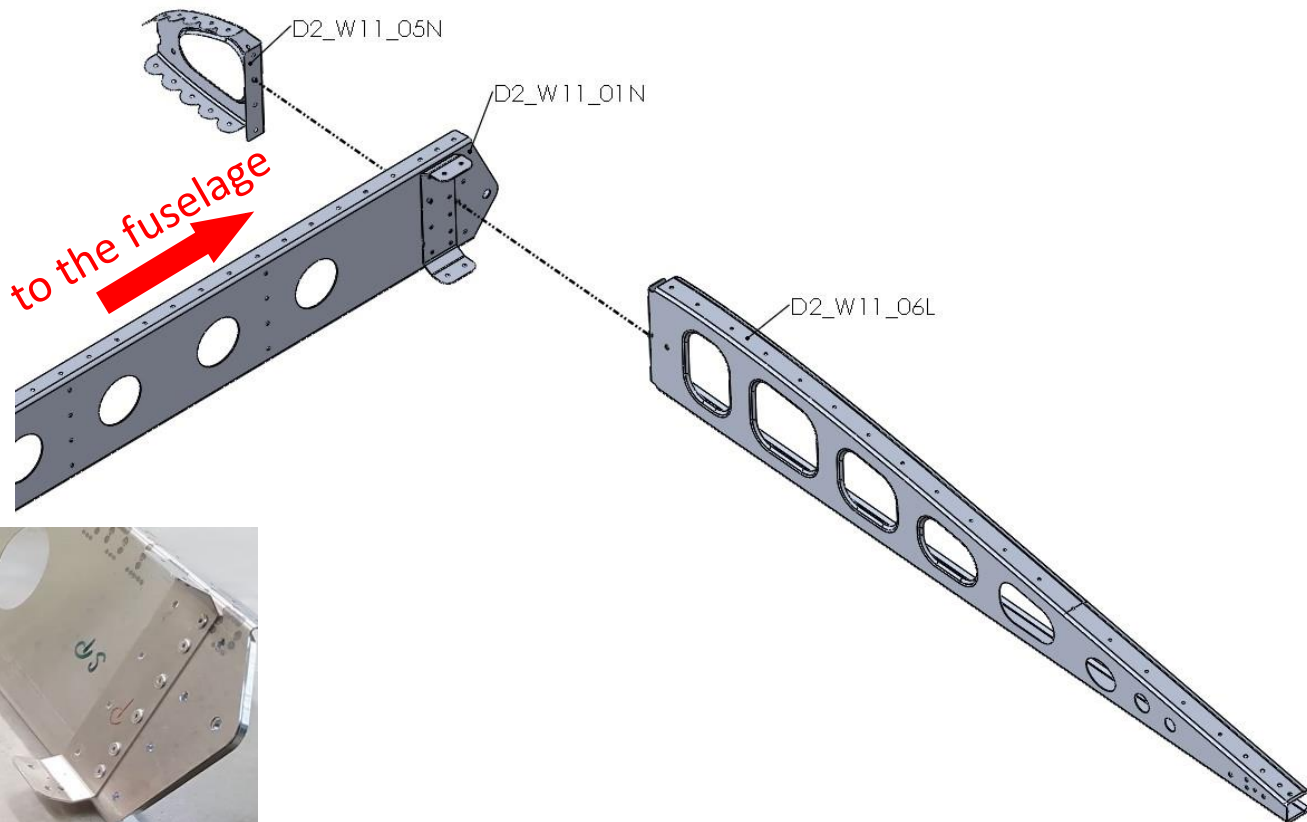


Ø4

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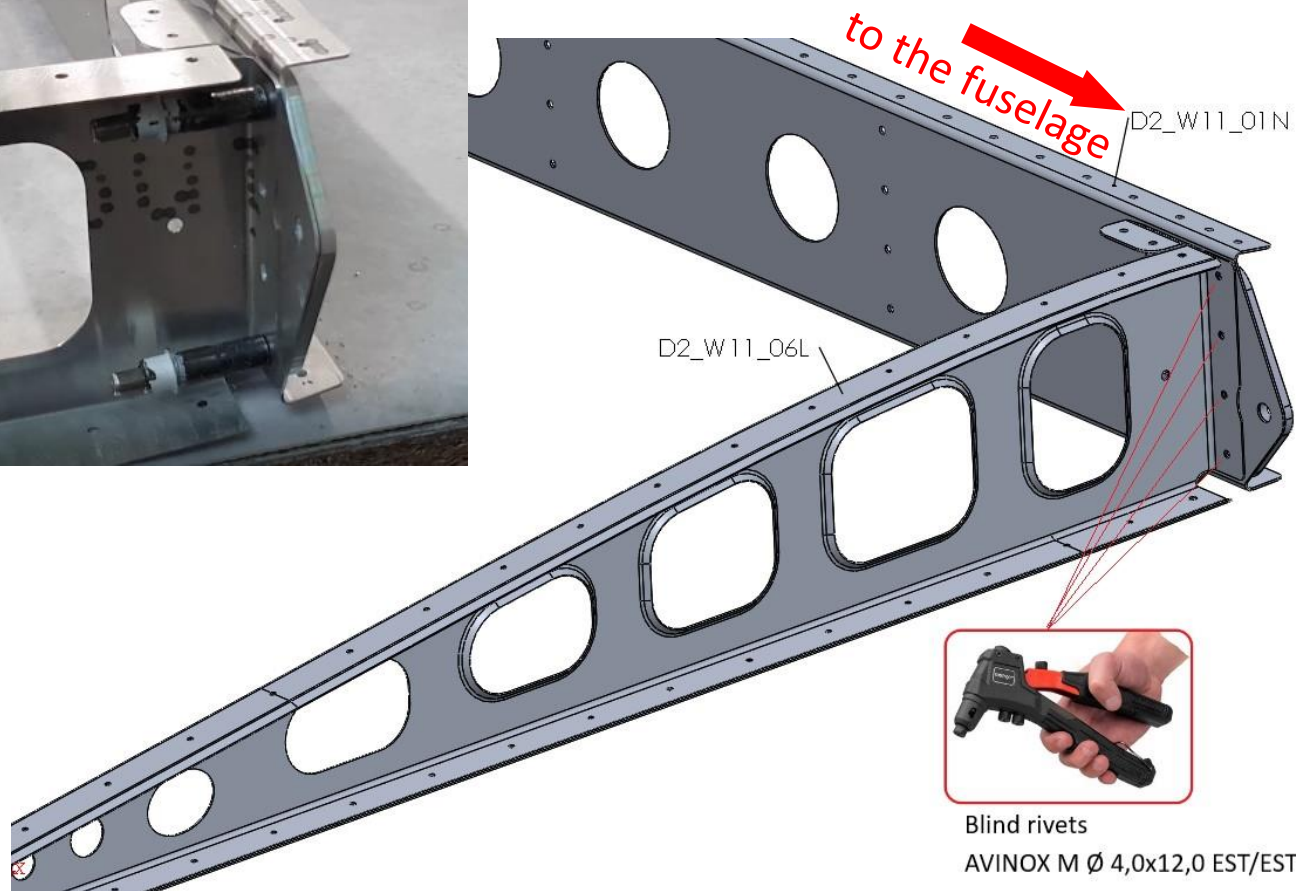
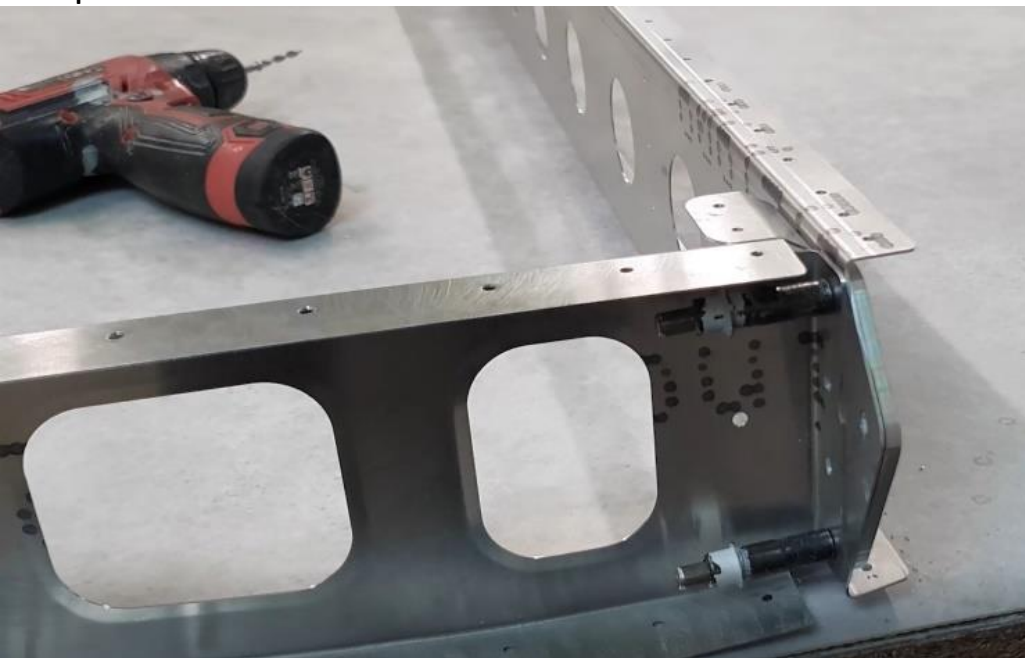


Step 11



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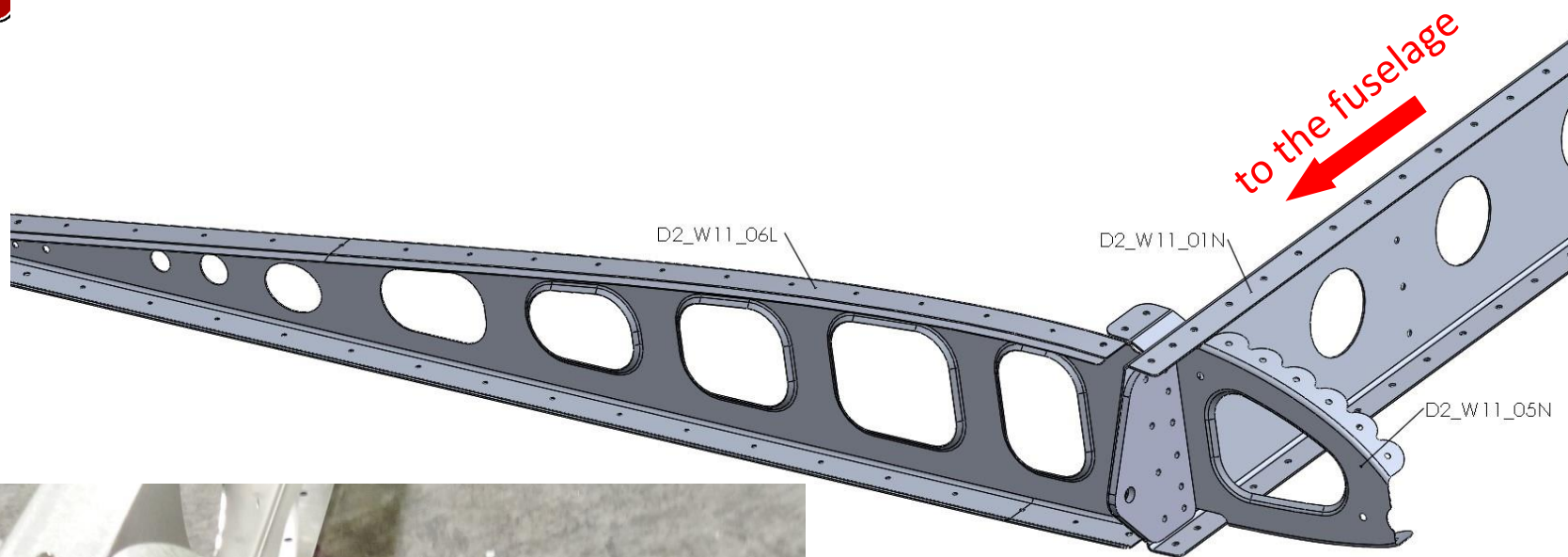
Step 12



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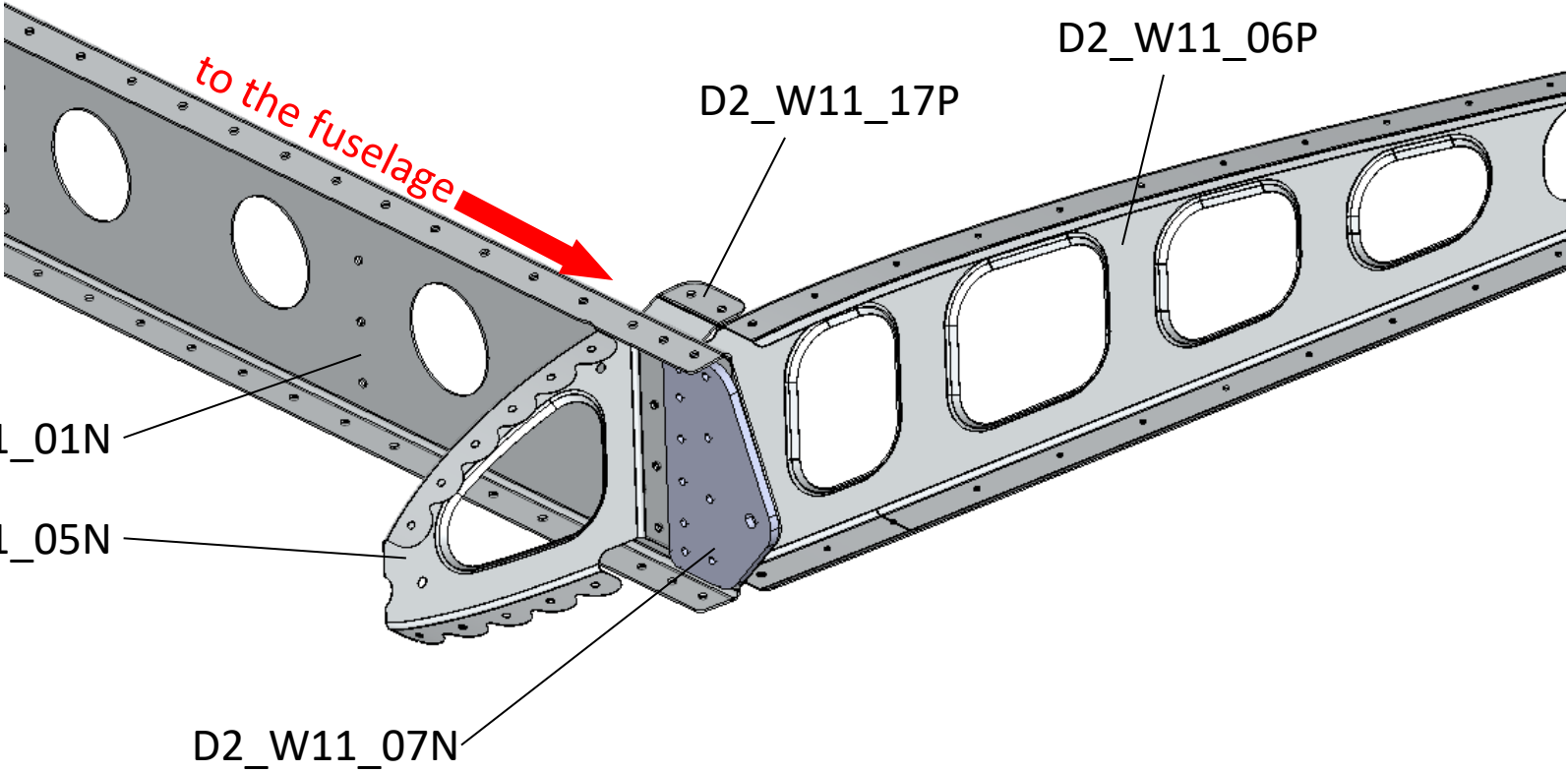
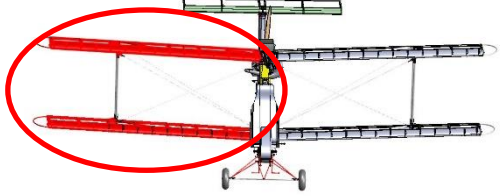
Step 13



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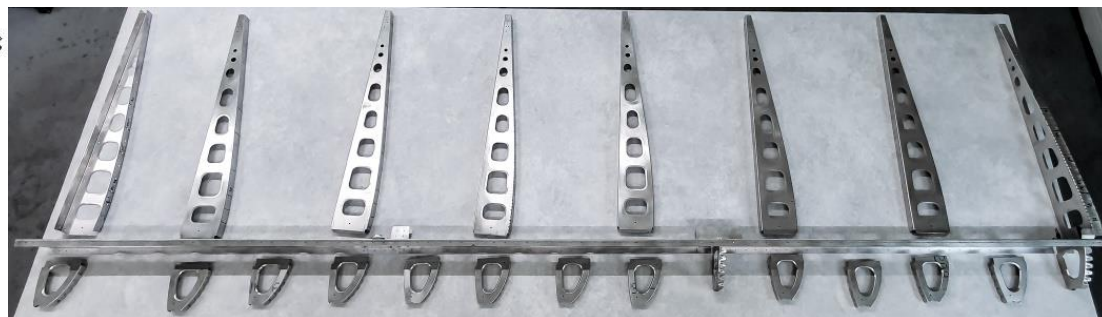
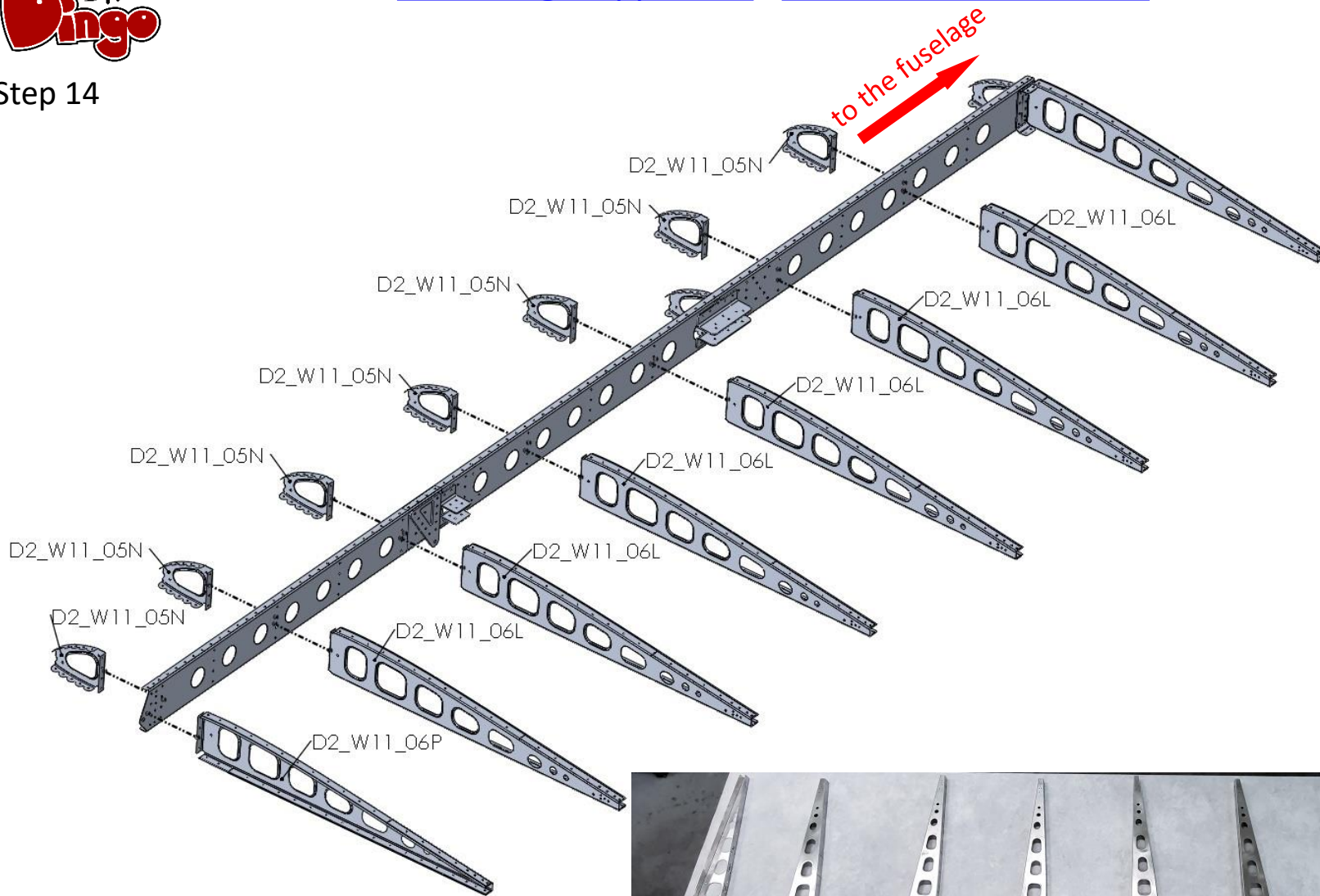
Step 13P



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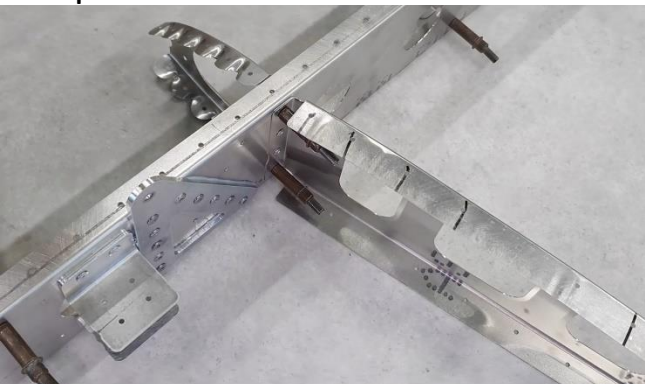
Step 14



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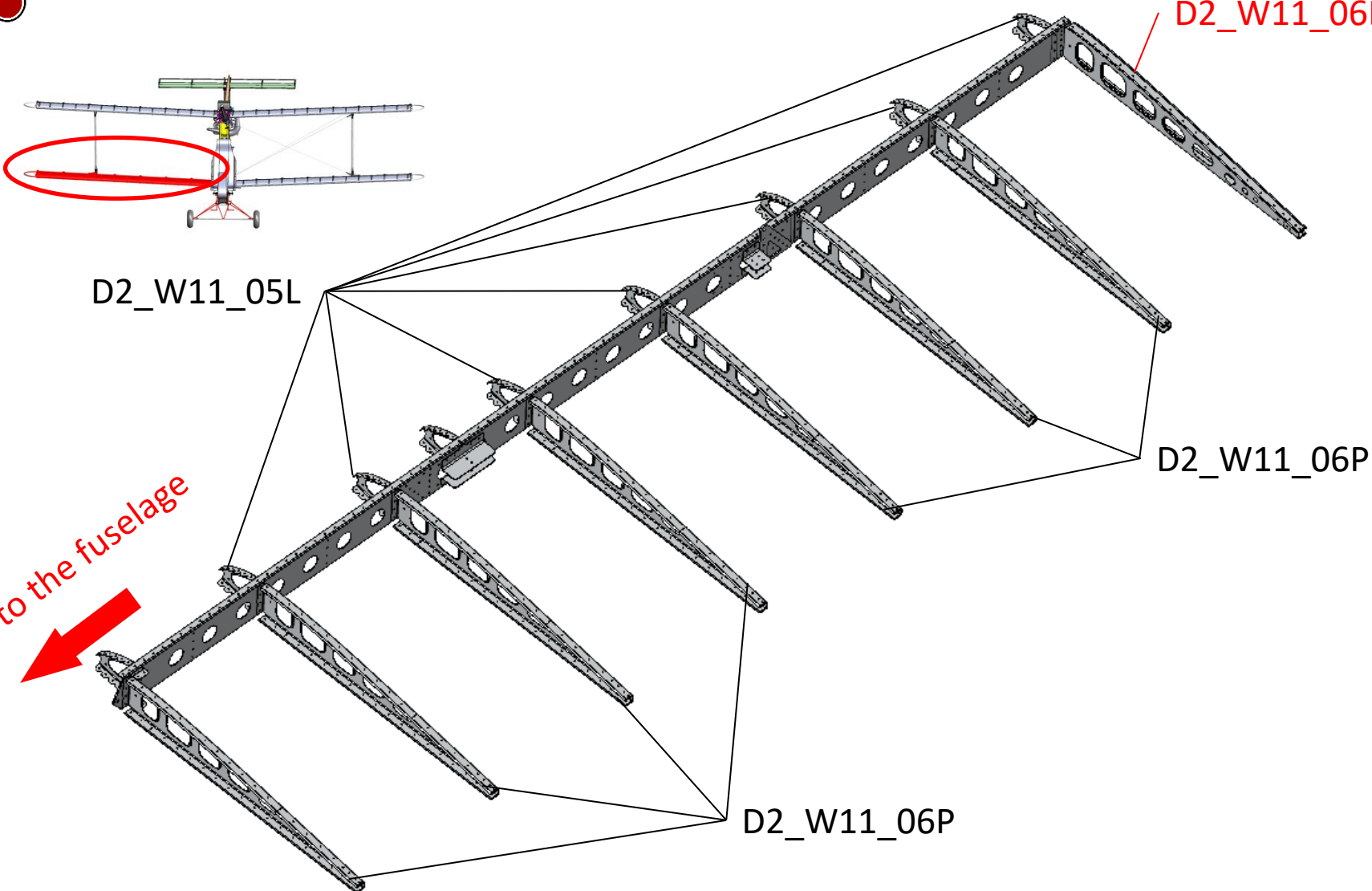
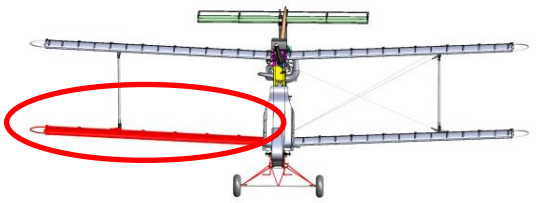
Step 15



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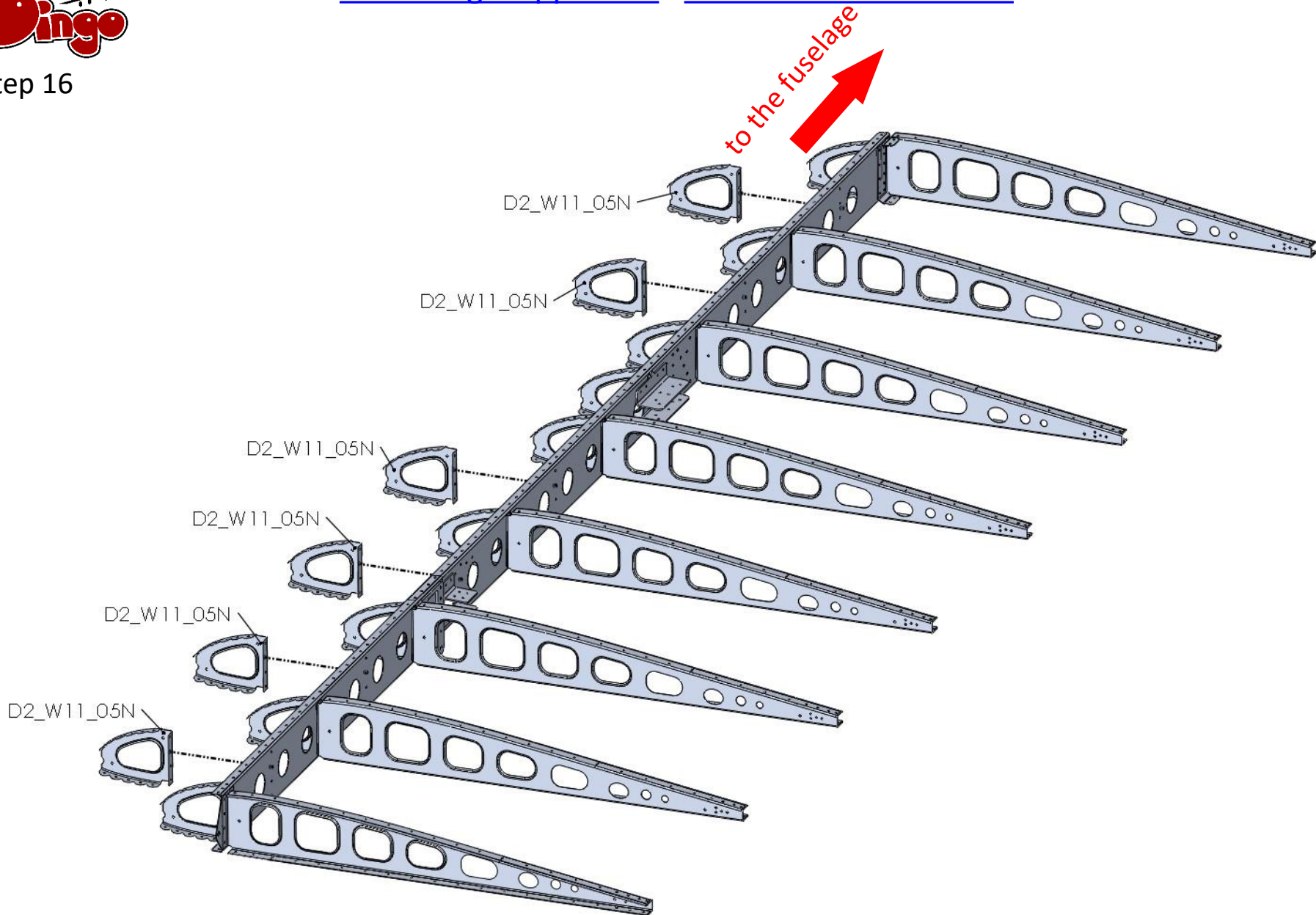
Step 15P



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Step 16

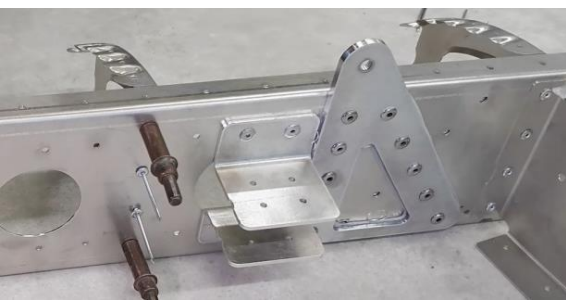
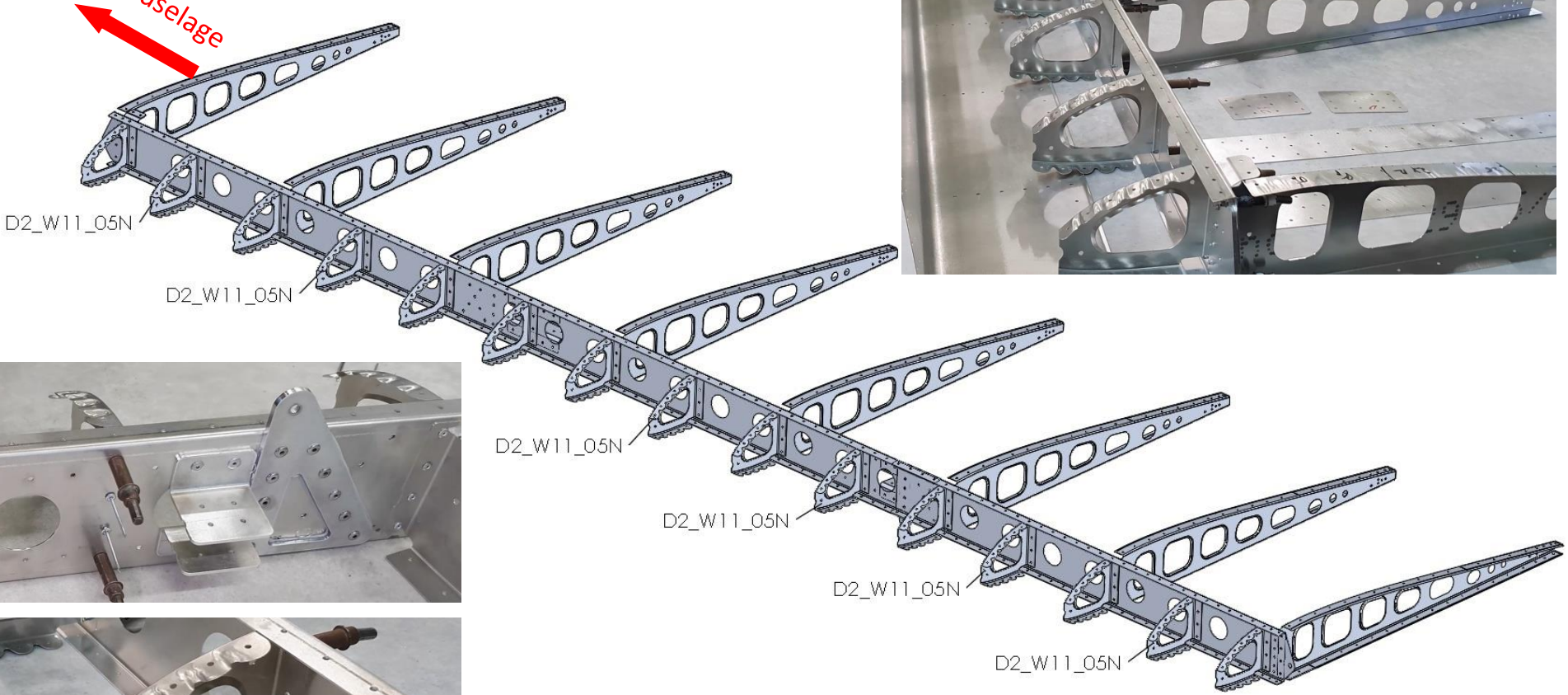


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Wing assembly manual	D2_W0_00	Rev. 02	35	108



Step 17

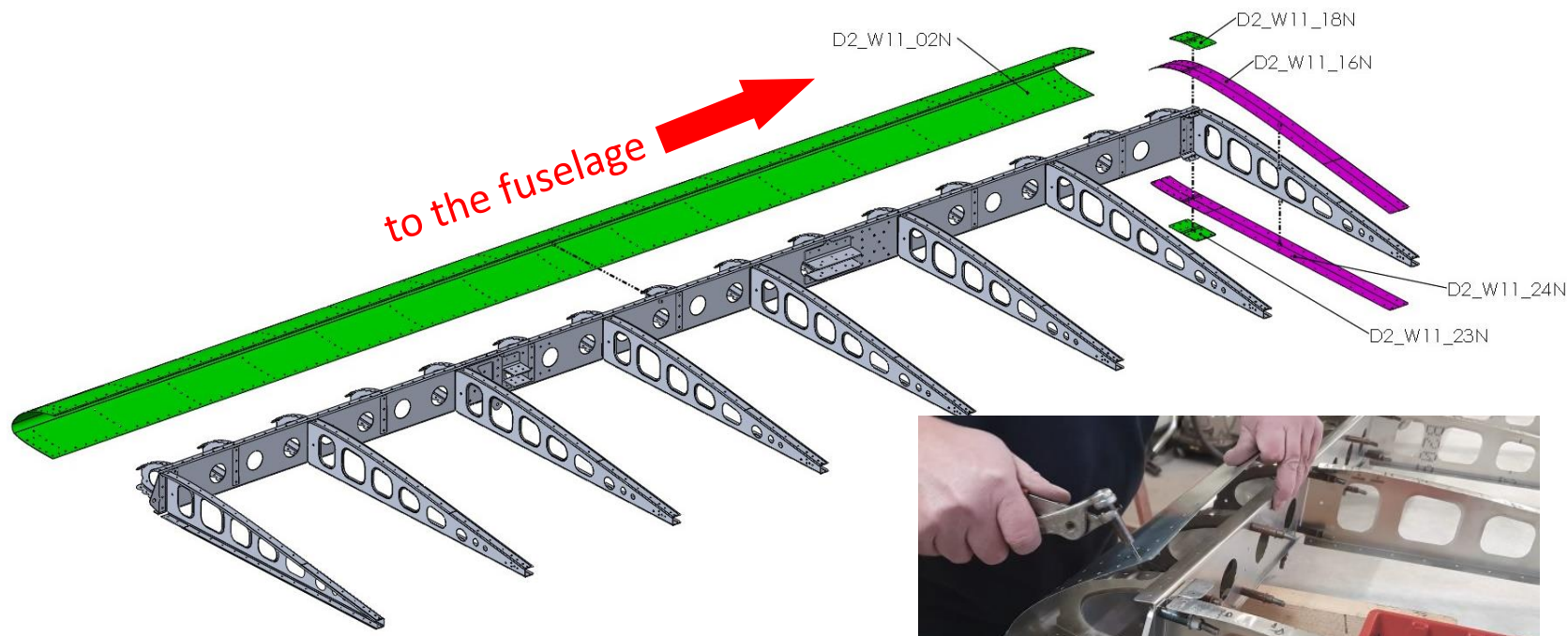
to the fuselage



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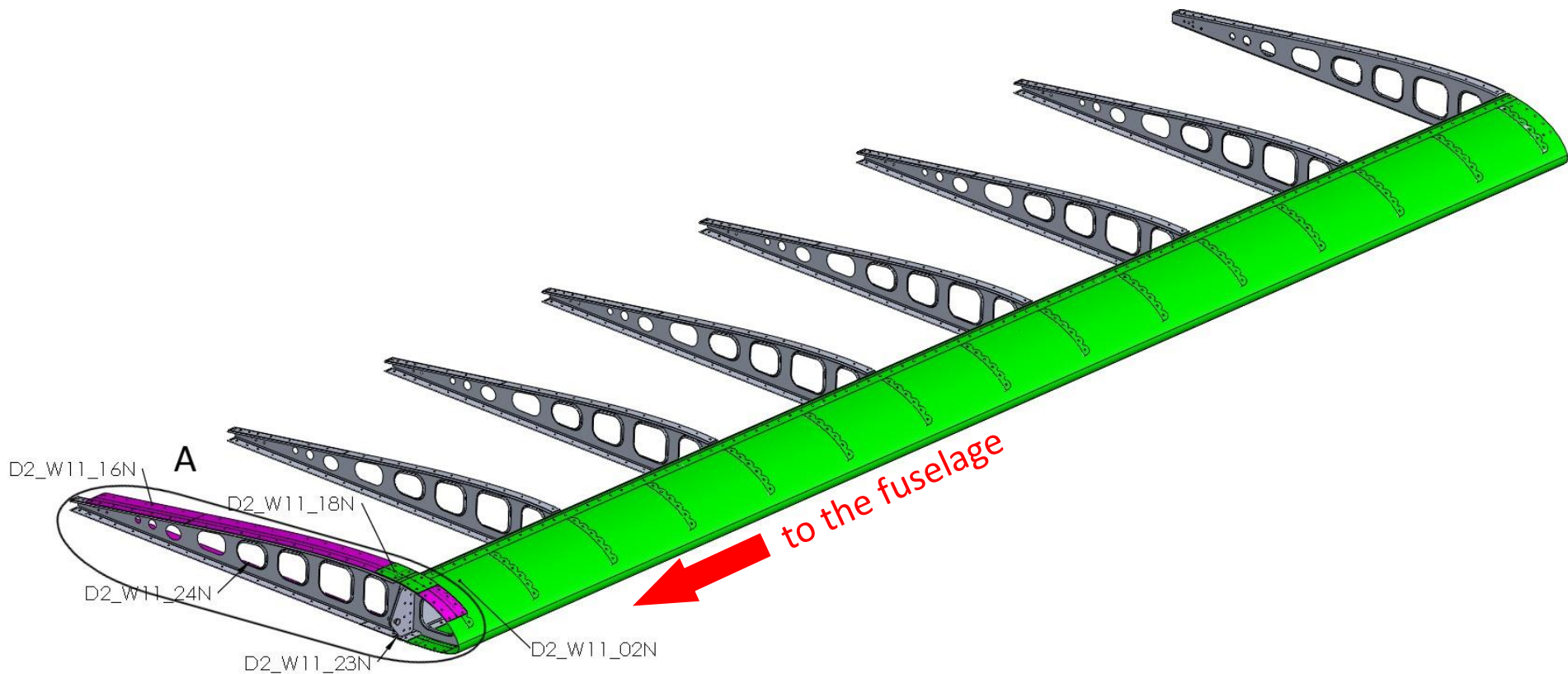
Step 18



Title	Document no.	Revision	Page	Pages
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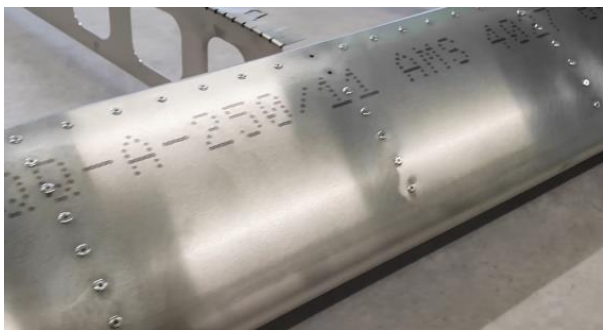
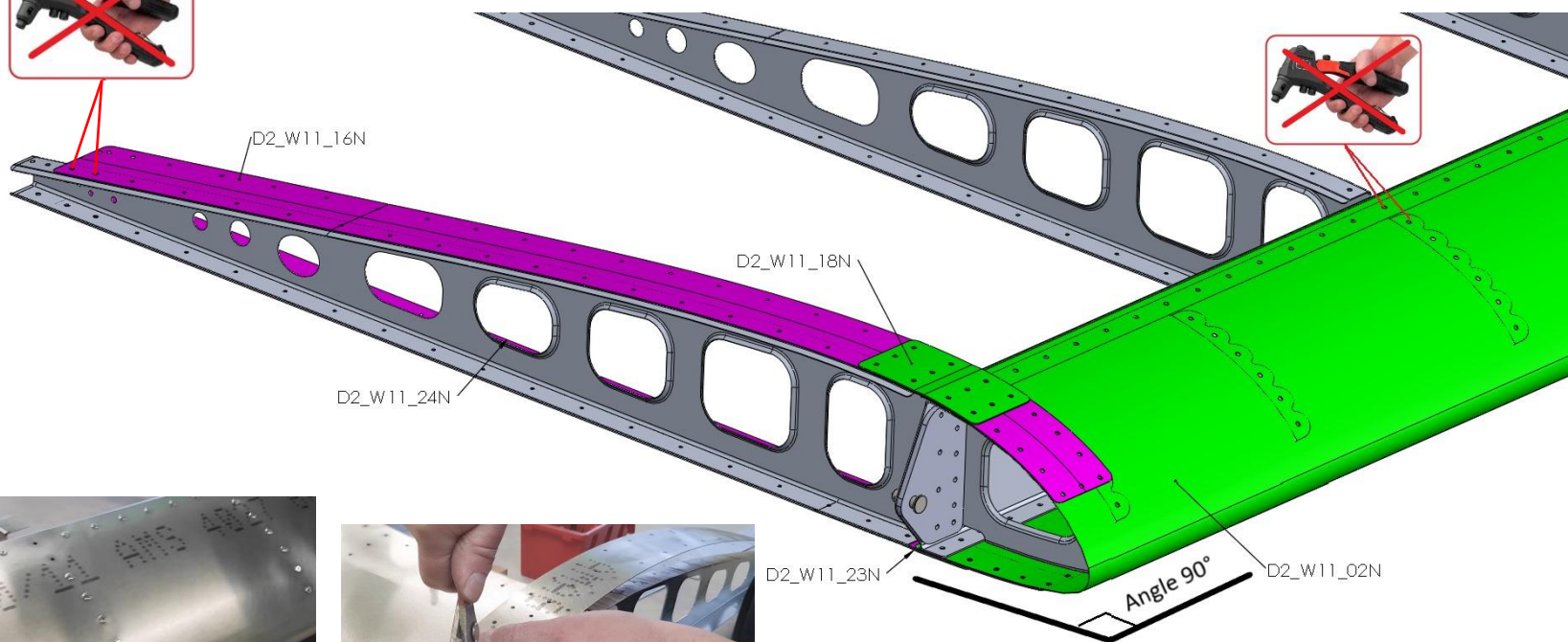
Step 19



Title	Document no.	Revision	Page	Pages
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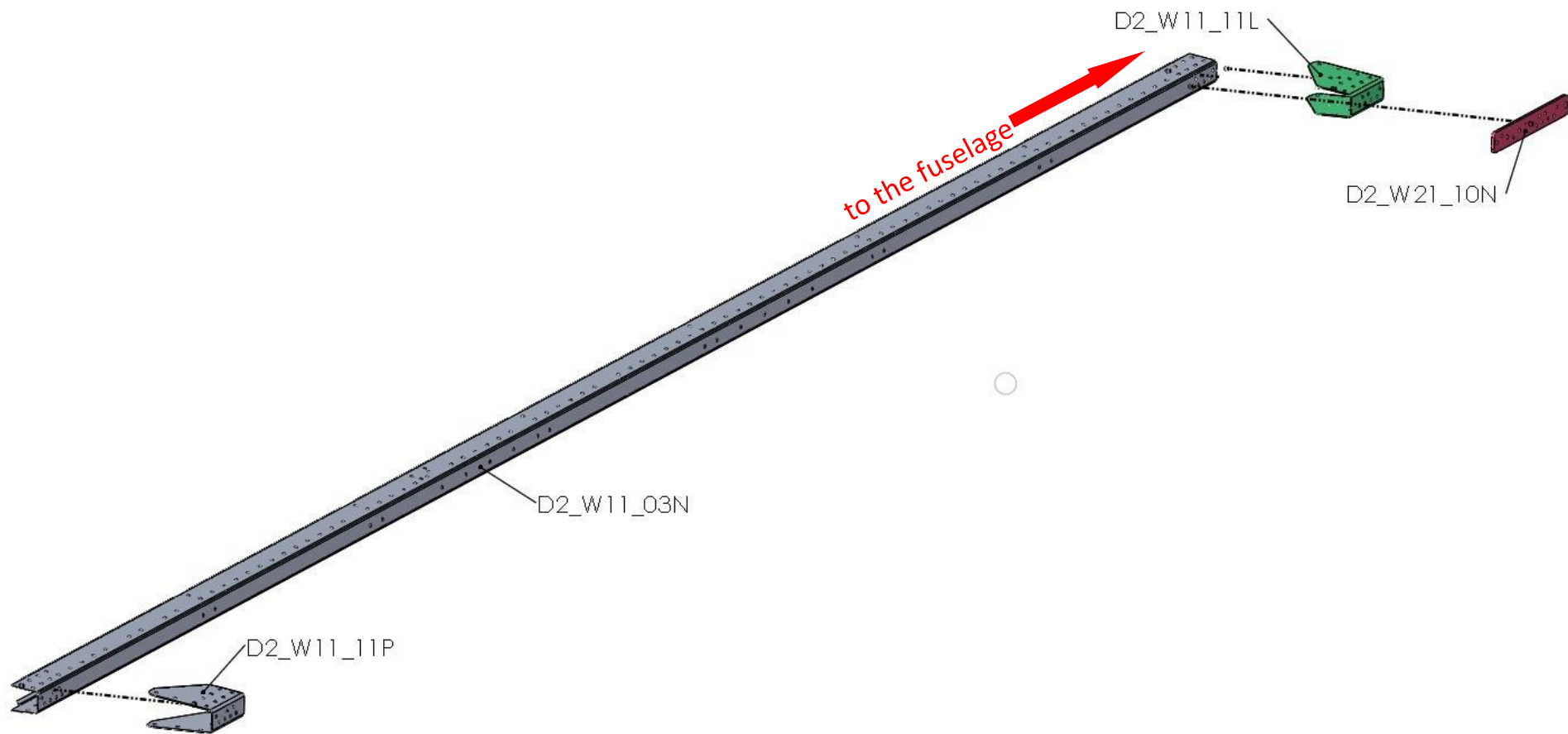
Step 19-A



Title	Document no.	Revision	Page	Pages
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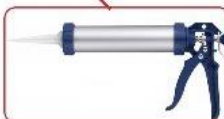
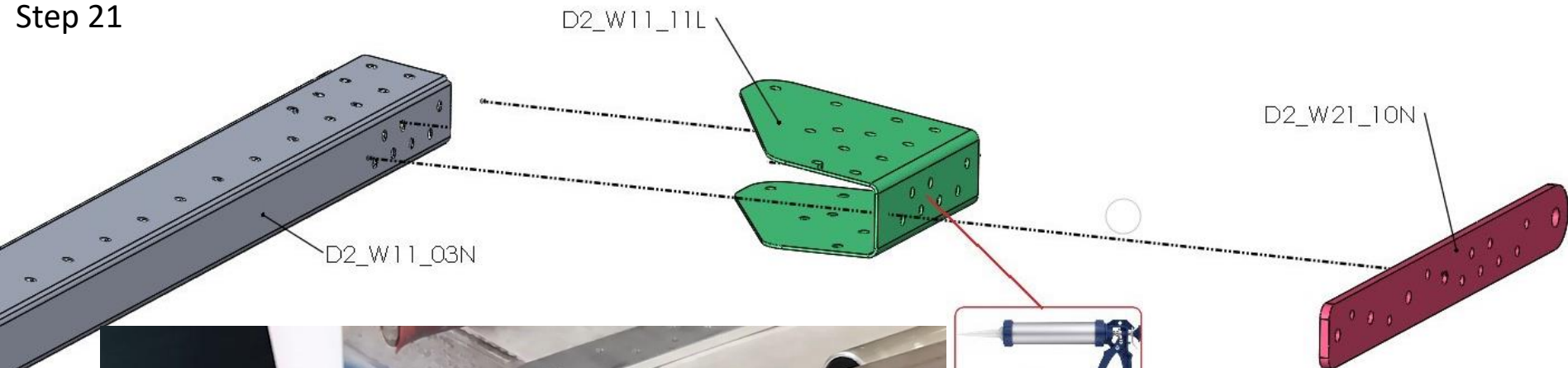
Step 20



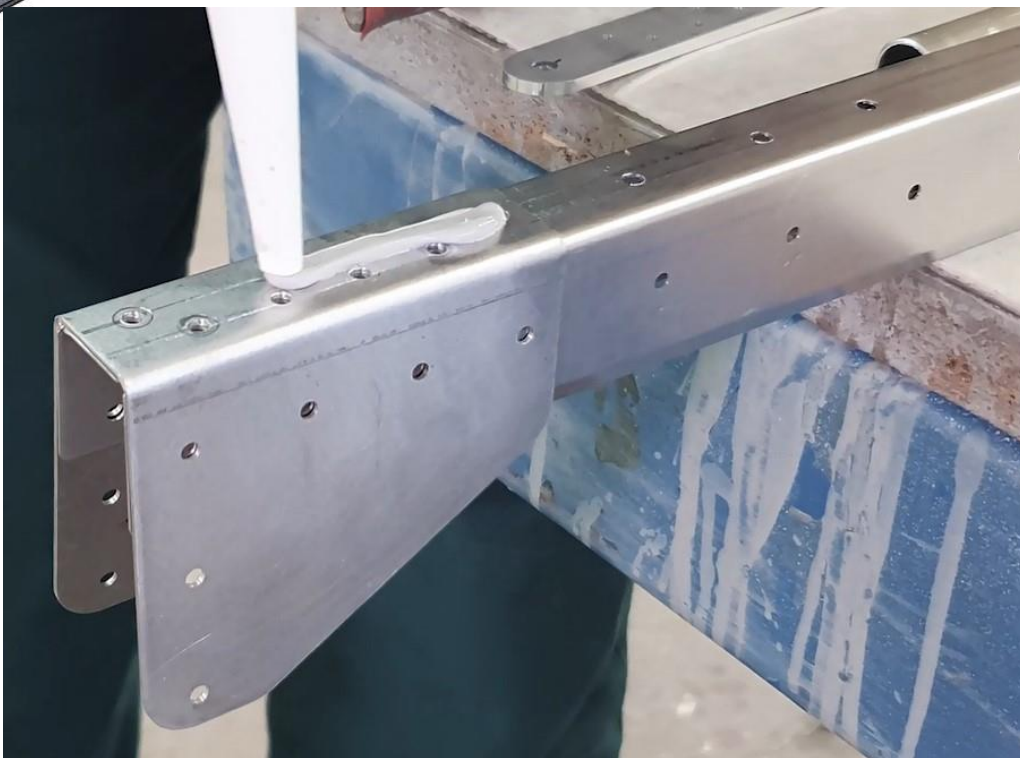
Title	Document no.	Revision	Page	Pages
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Step 21



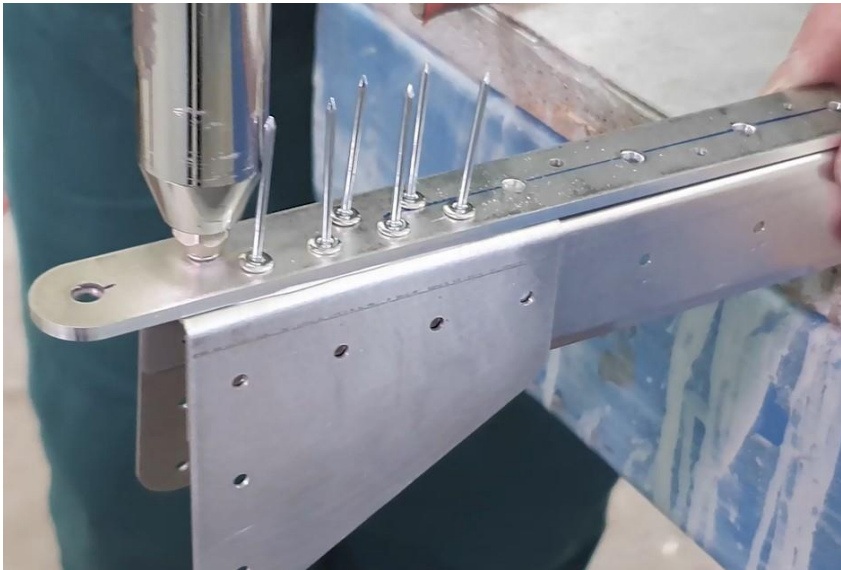
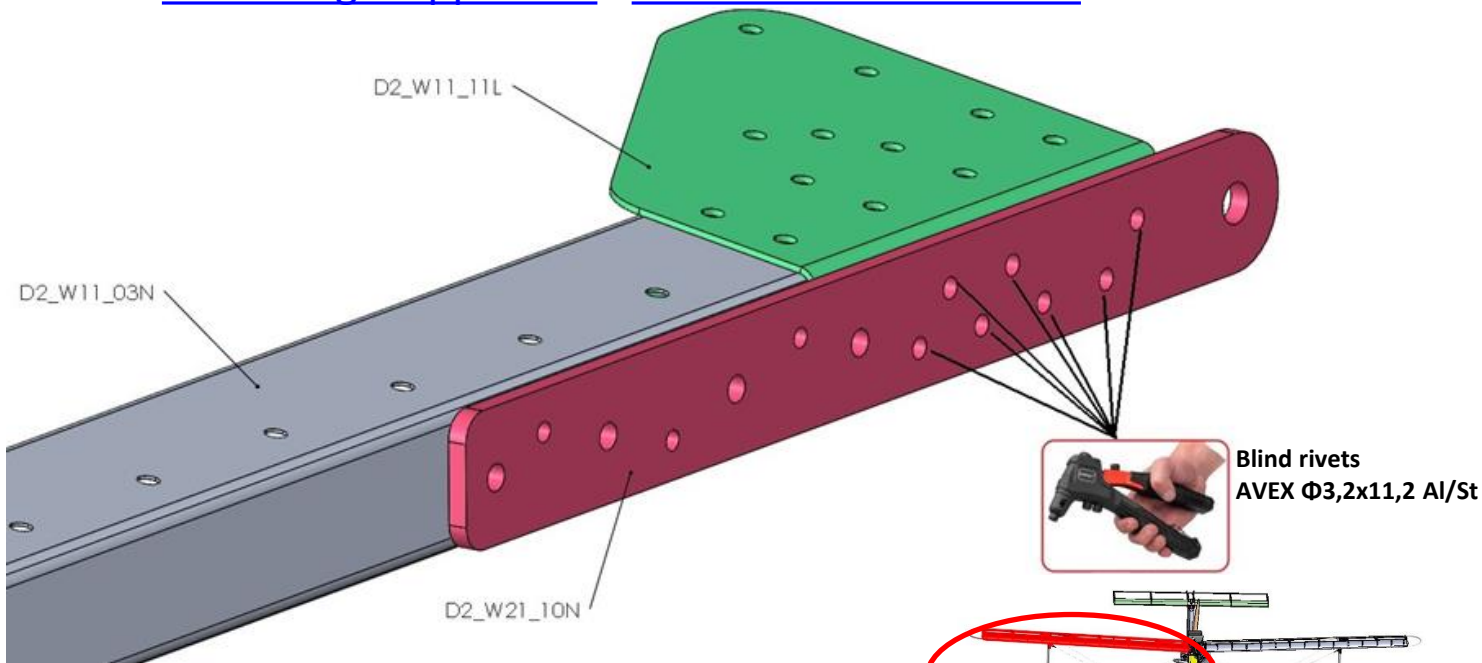
Polyurethane adhesive
Emfimastic PU-50



Title	Document no.	Revision	Page	Pages
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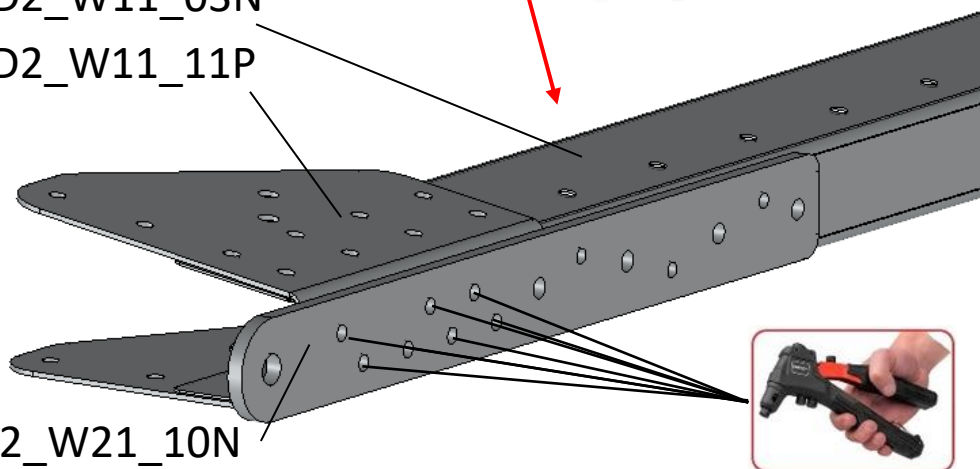


Step 22



D2_W11_03N
D2_W11_11P

D2_W21_10N

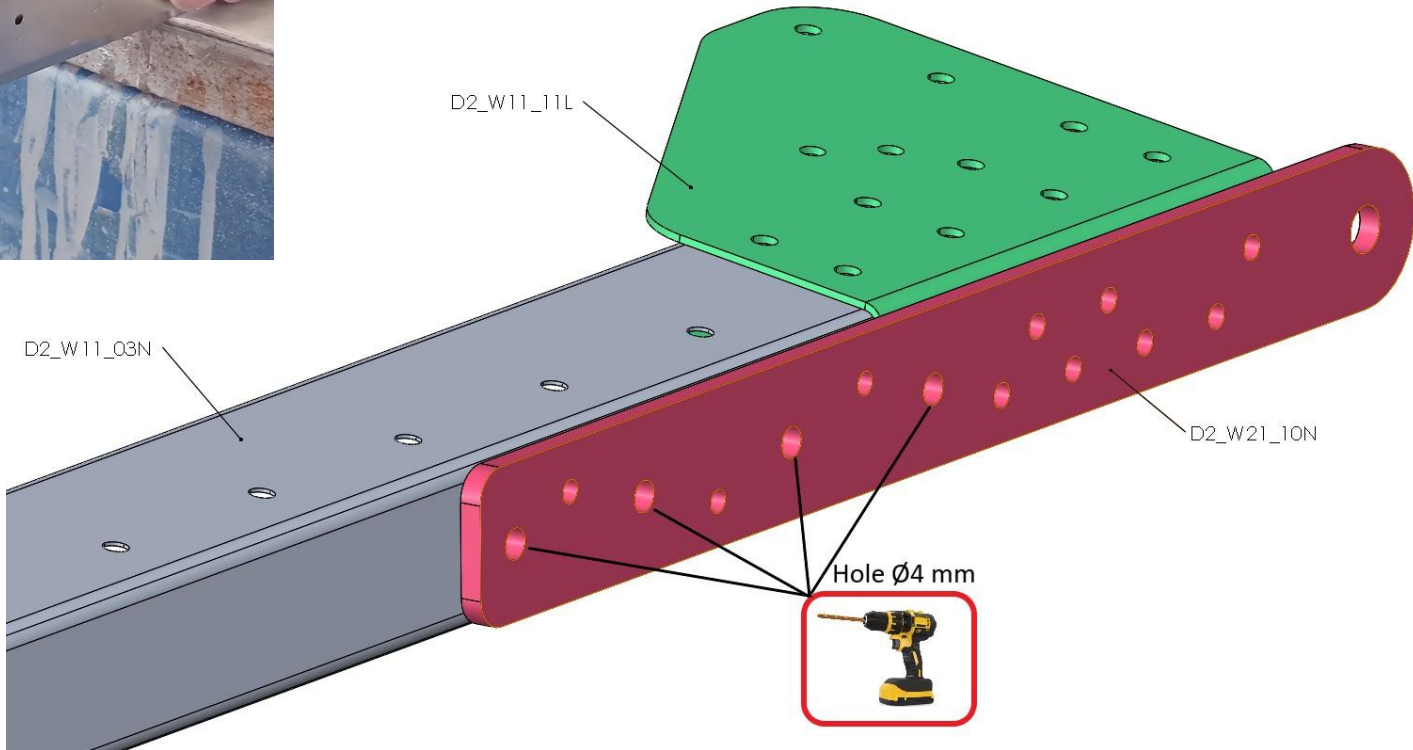
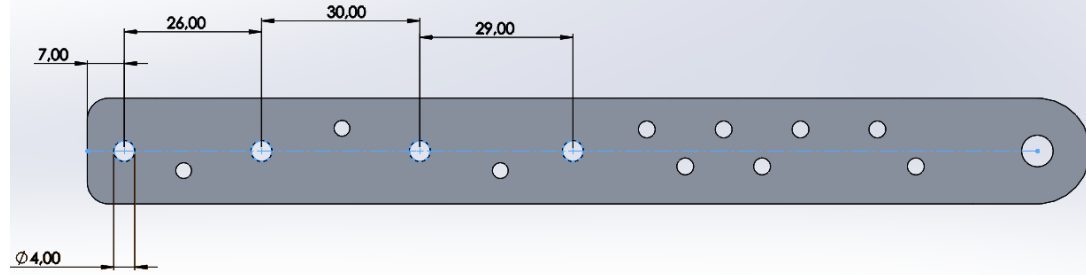


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Blind rivets
AVEX Ø3,2x11,2 Al/St



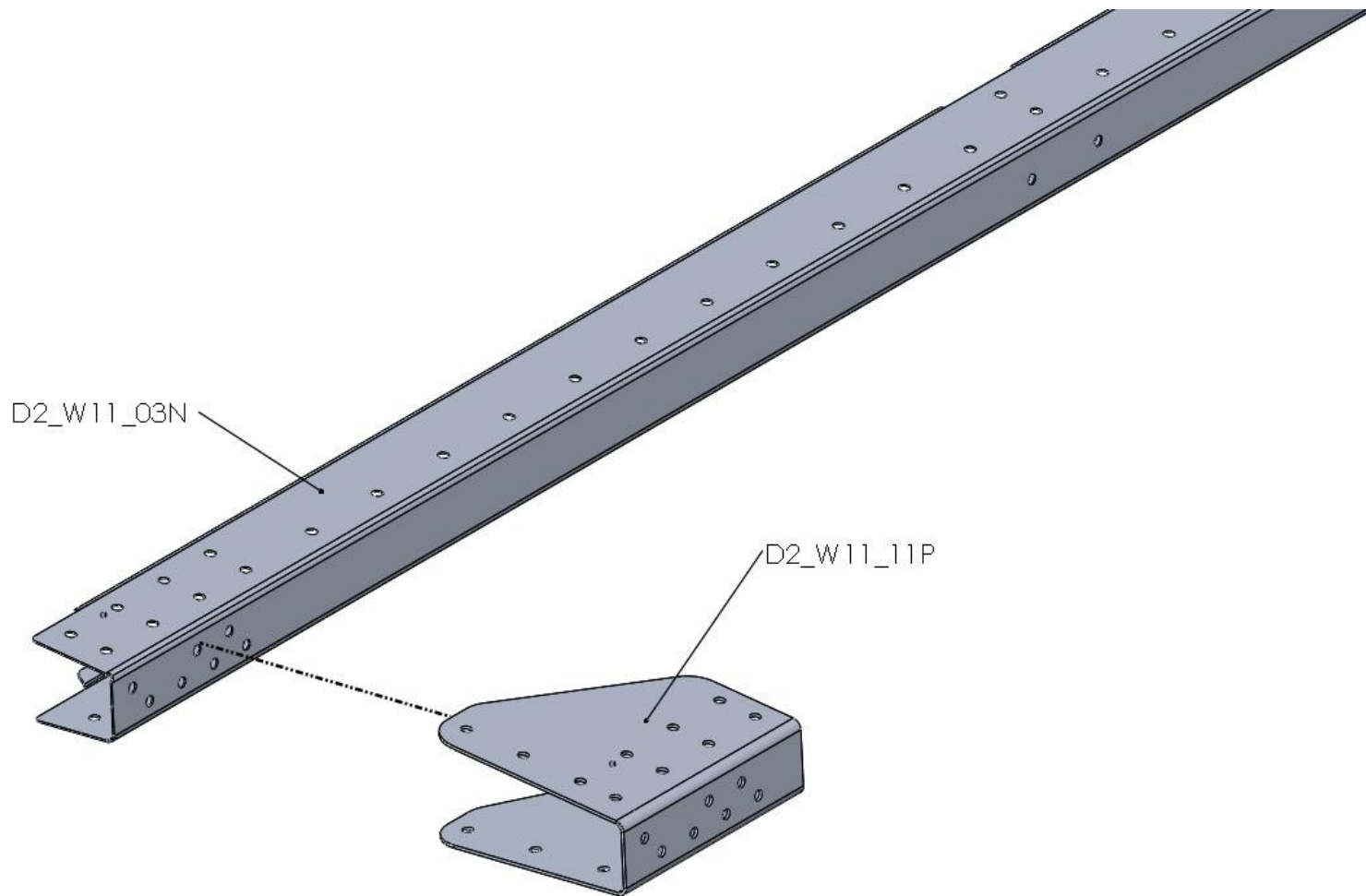
Step 23



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	43	108



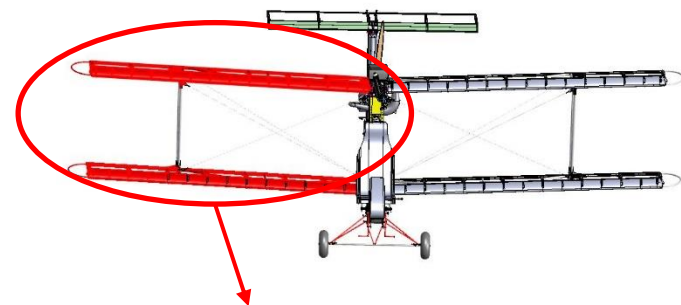
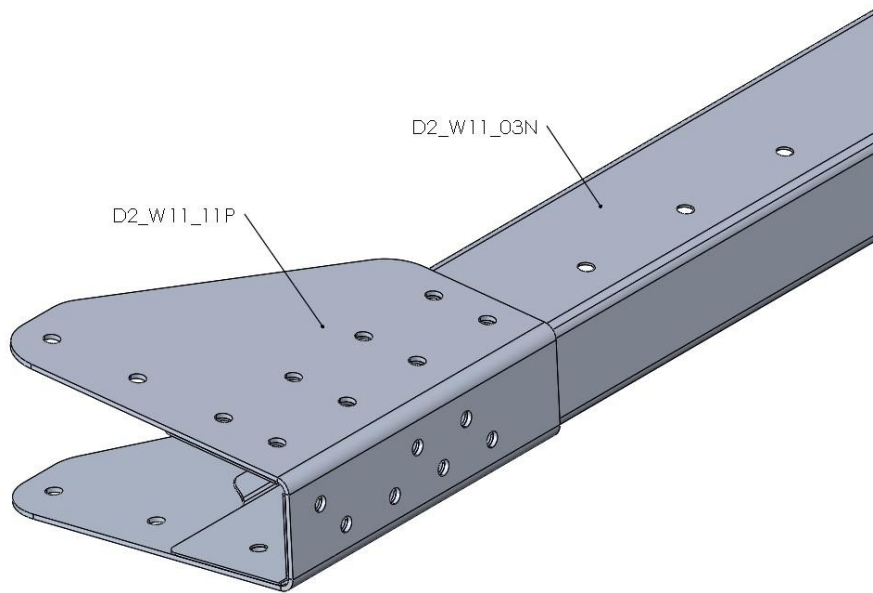
Step 24



Title	Document no.	Revision	Page	Pages
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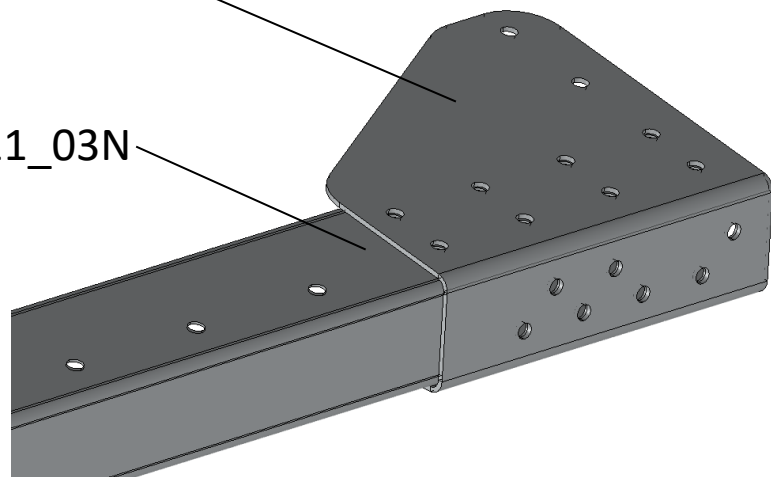


Step 25



D2_W11_11L

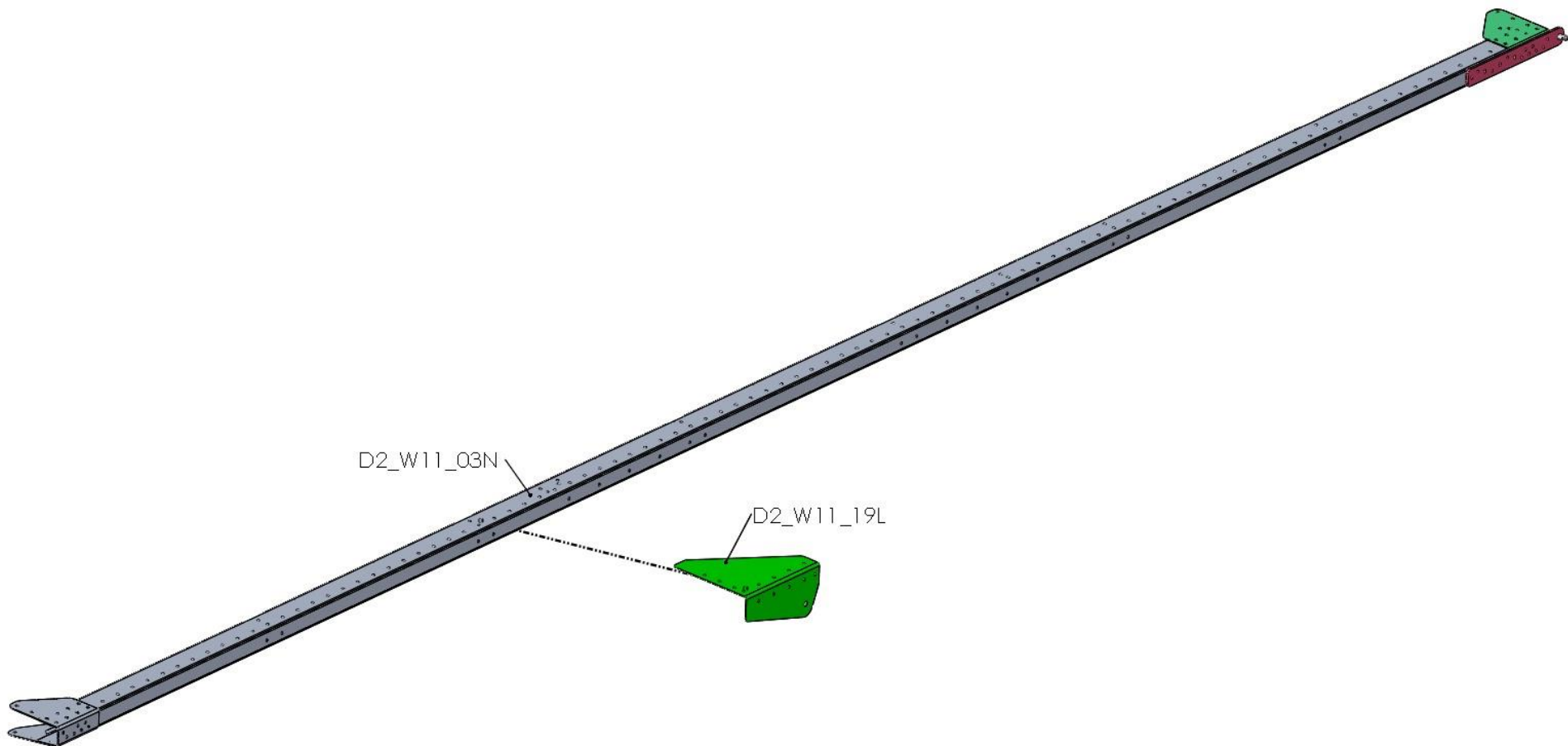
D2_W11_03N



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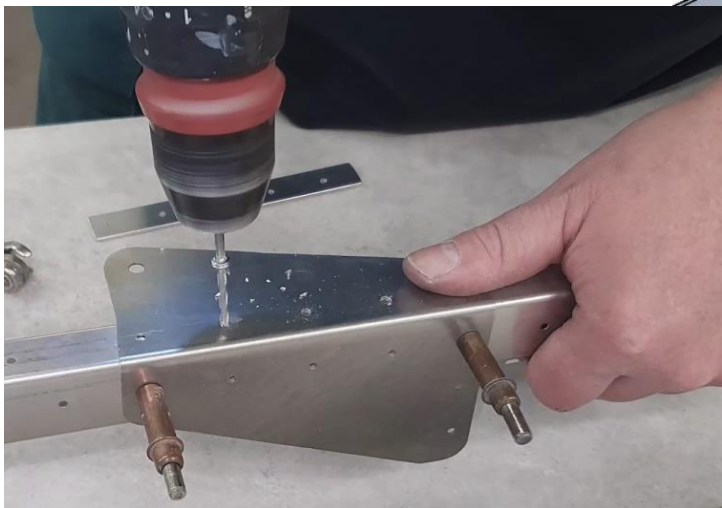
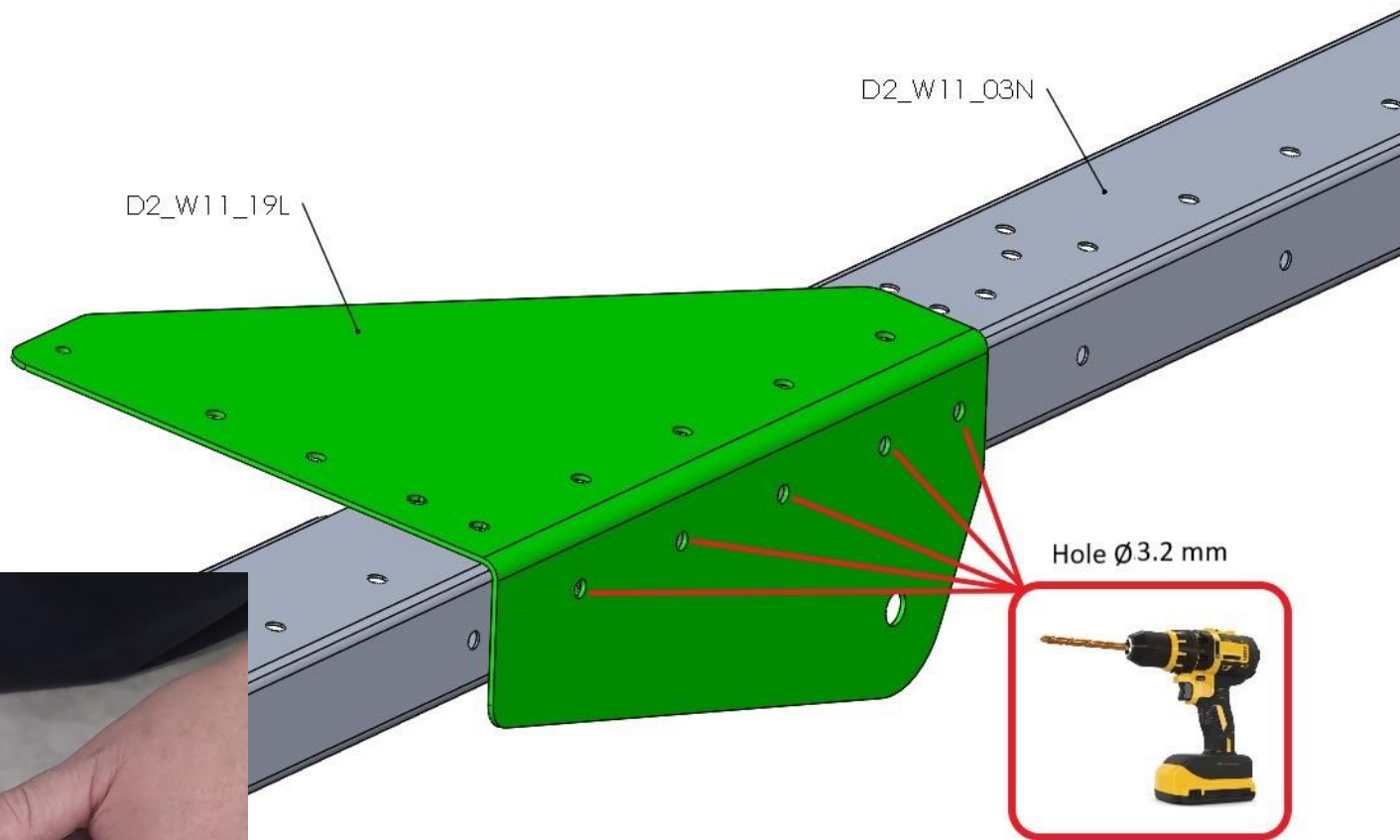
Step 26



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	46	108



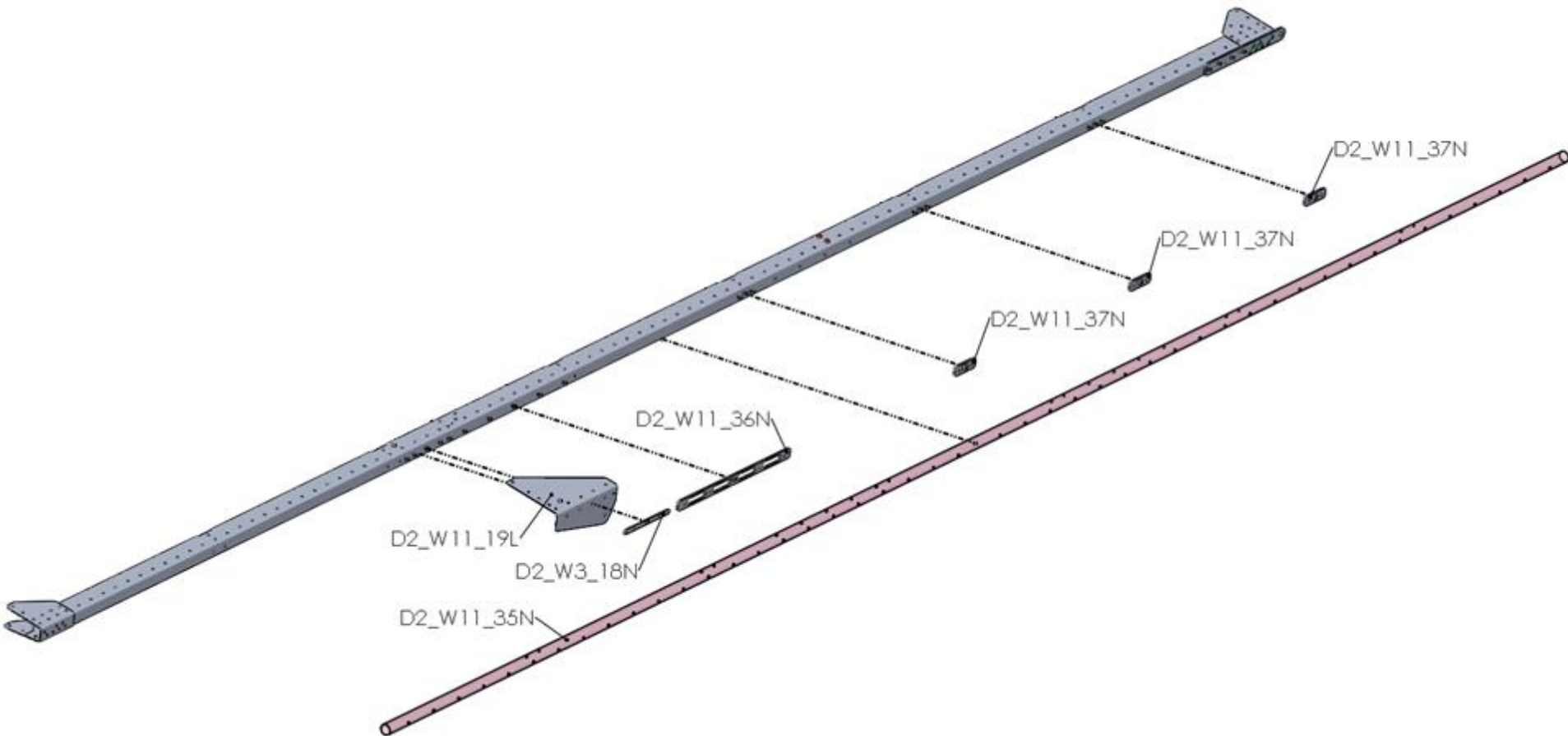
Step 27



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	47	108



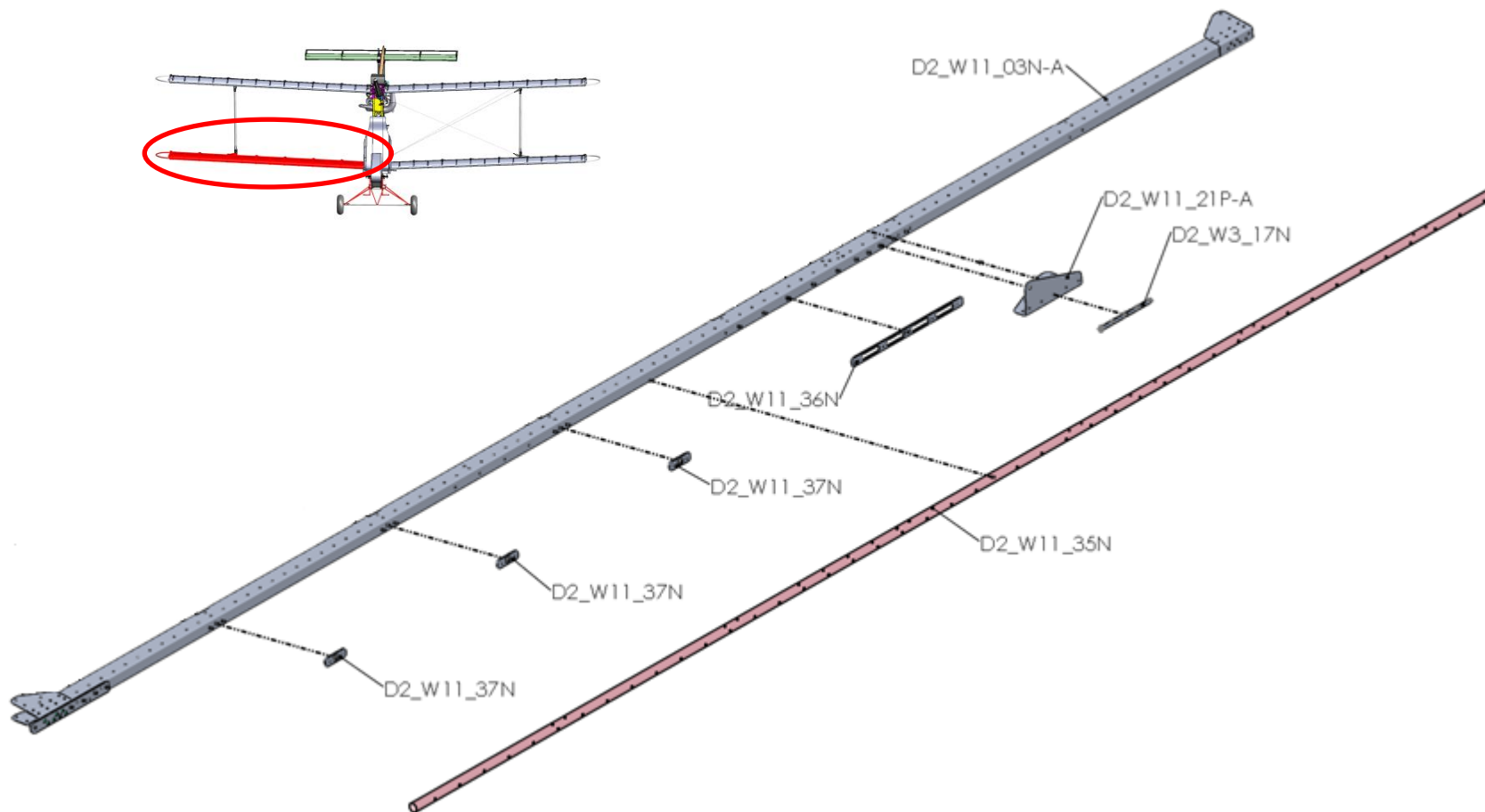
Step 28



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	48	108



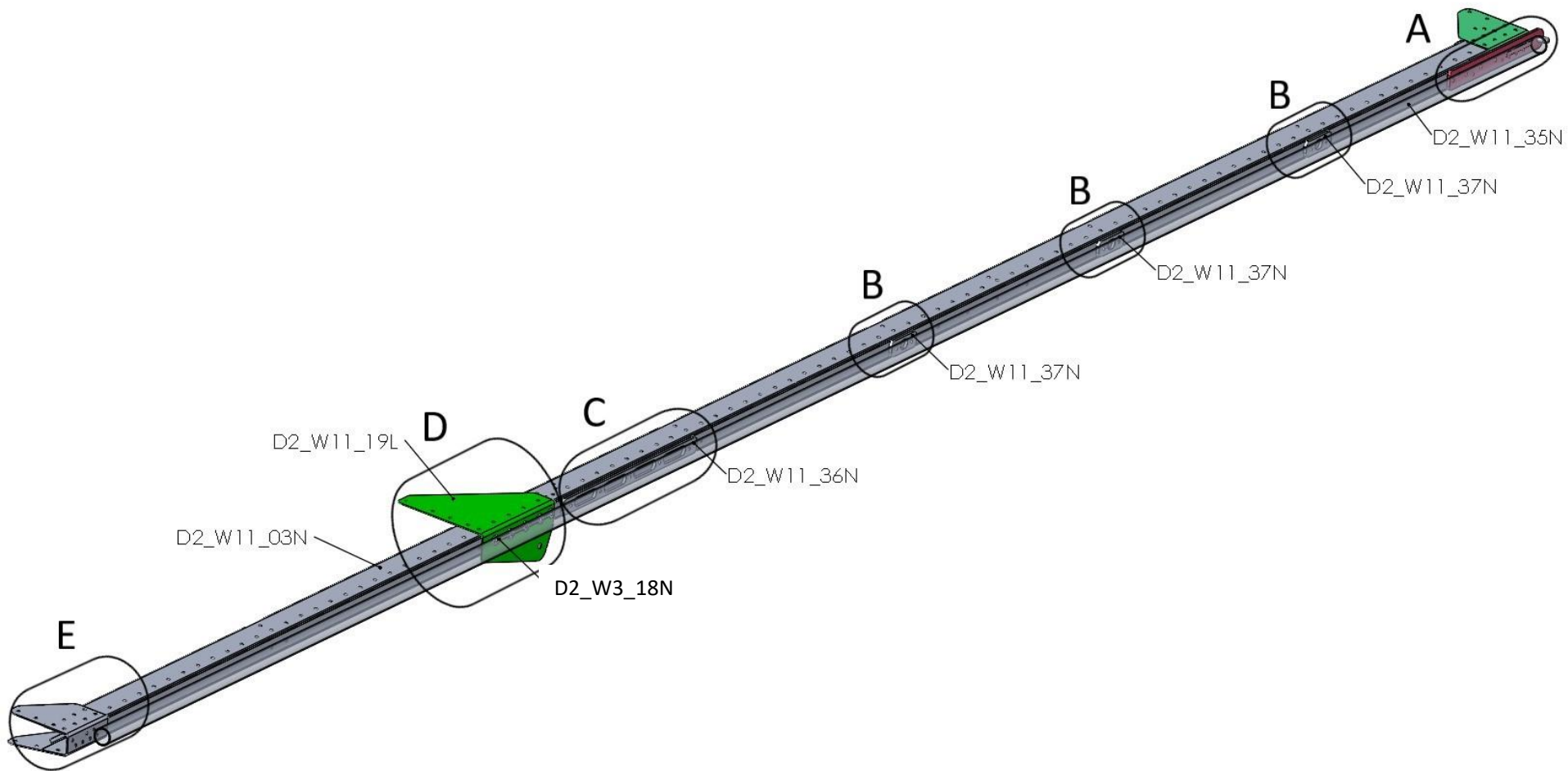
Step 28P



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	49	108



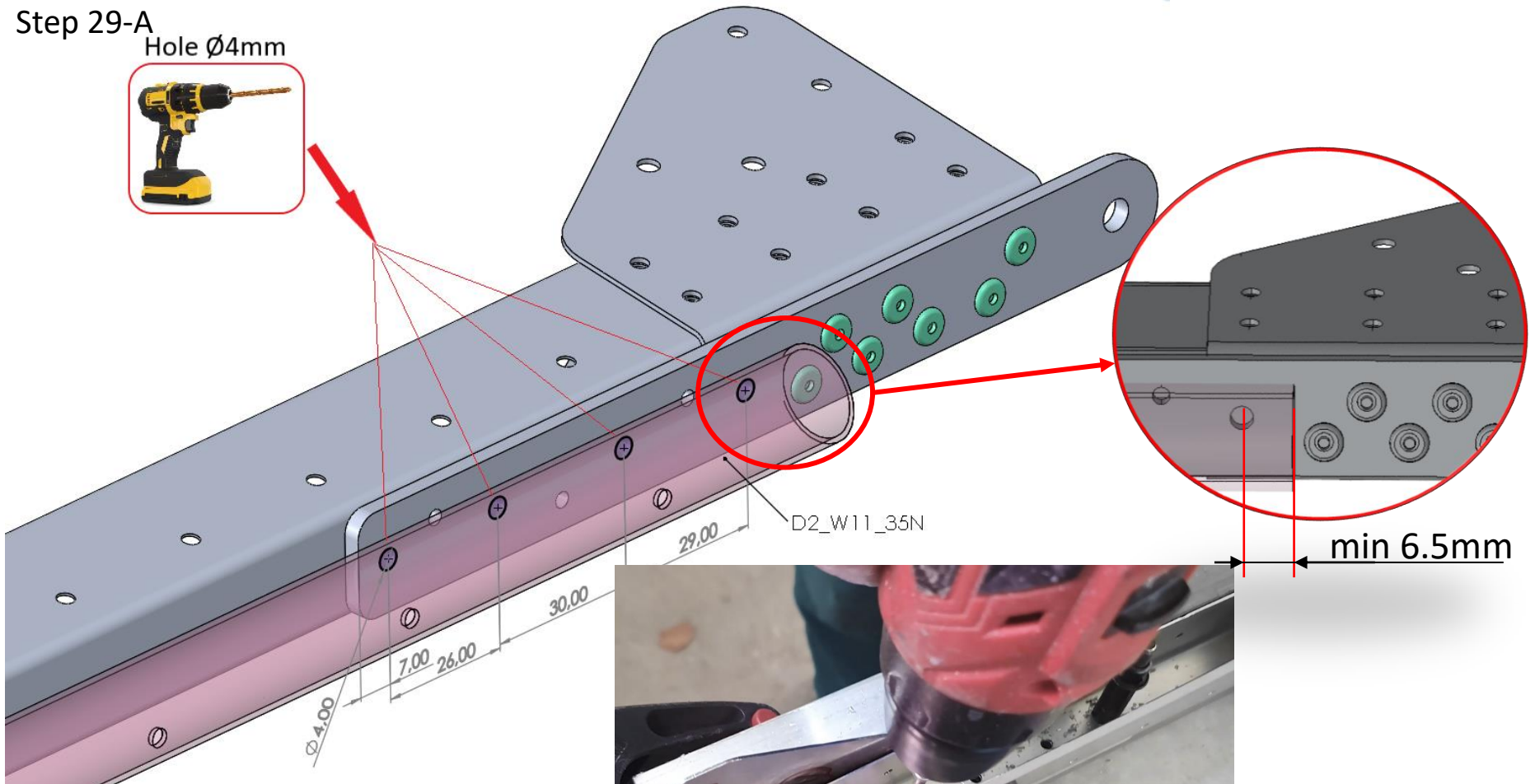
Step 29



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	50	108

Step 29-A

Hole $\varnothing 4\text{mm}$

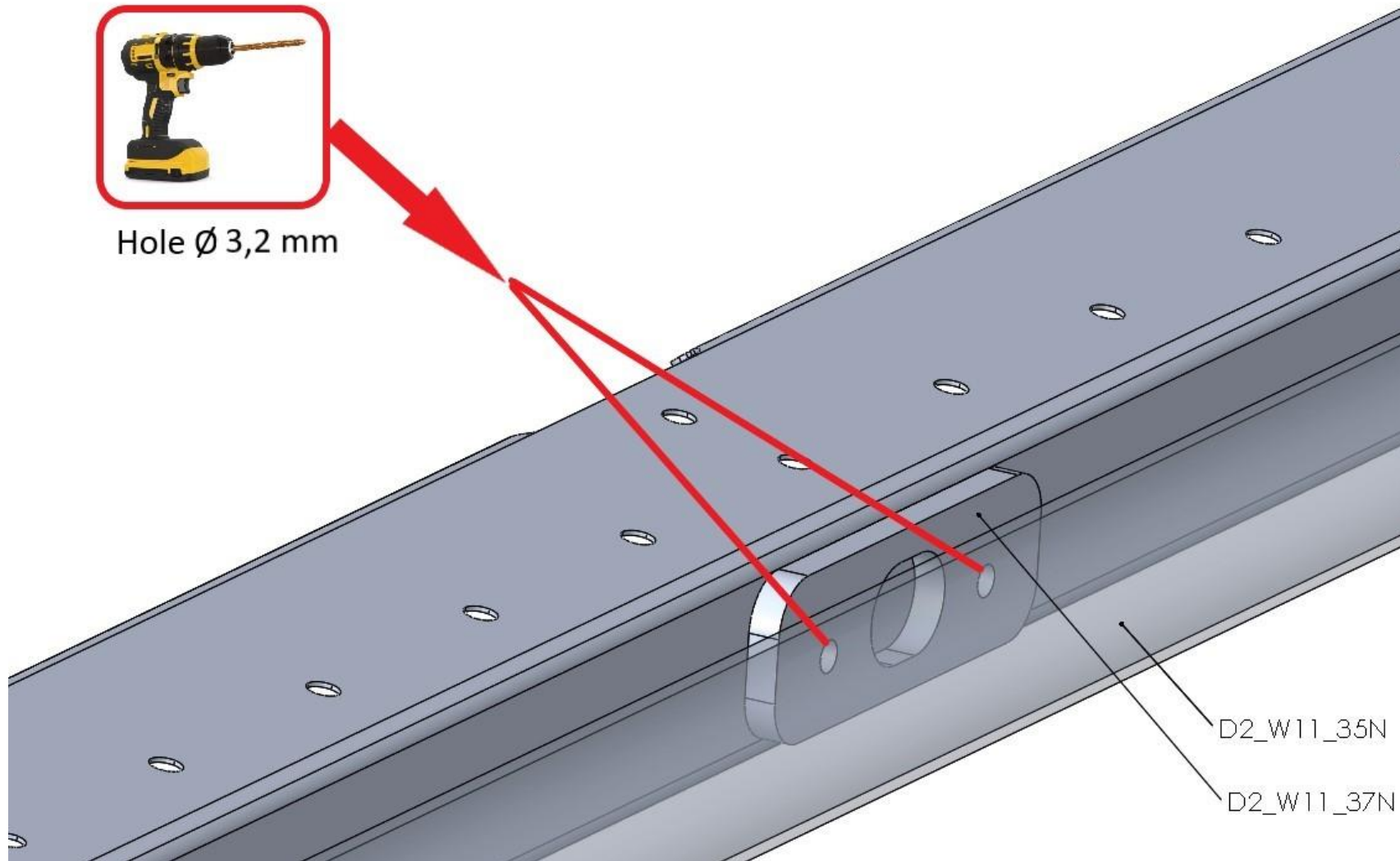


Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	51	108

Step 29-B



Hole \varnothing 3,2 mm



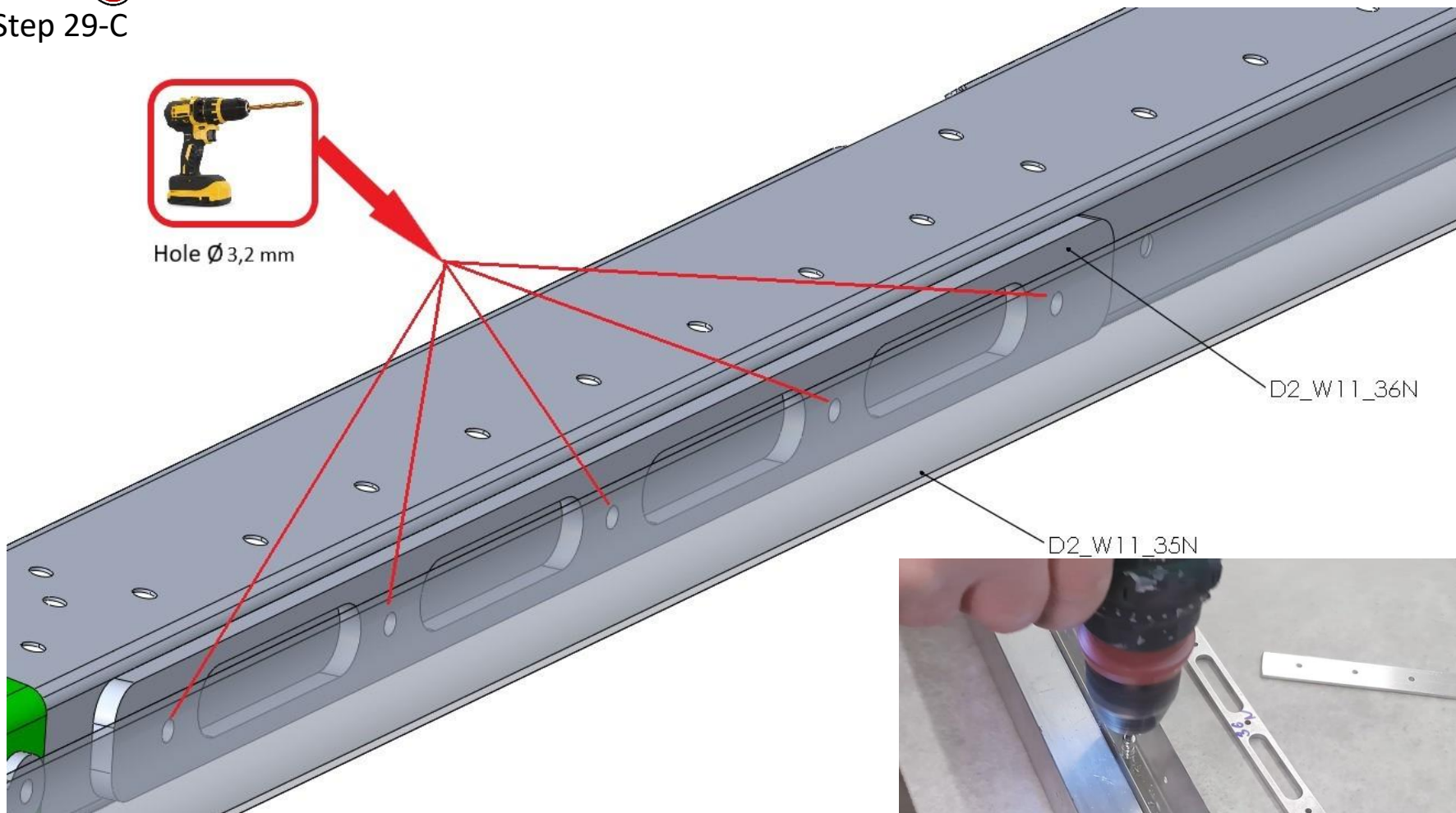
Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	52	108



Step 29-C



Hole \varnothing 3,2 mm



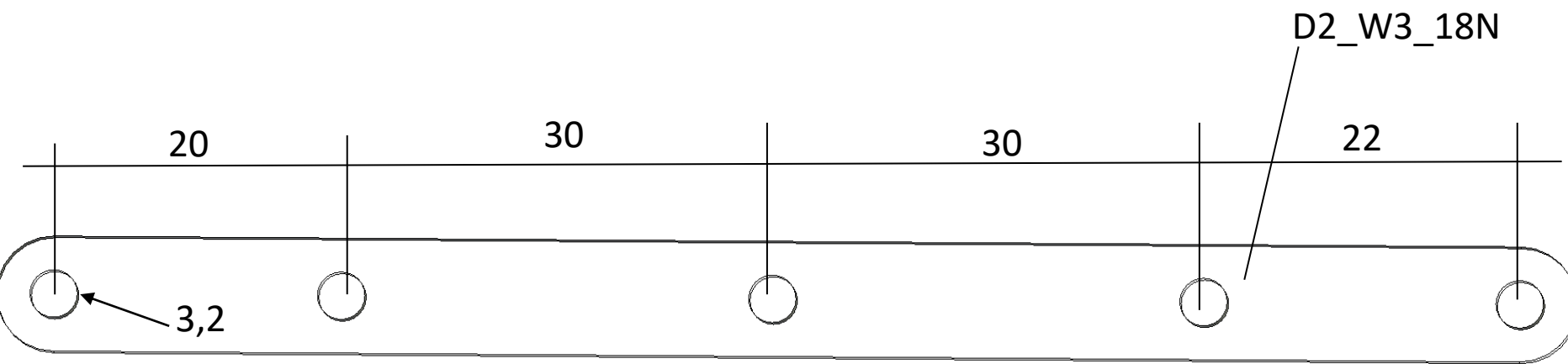
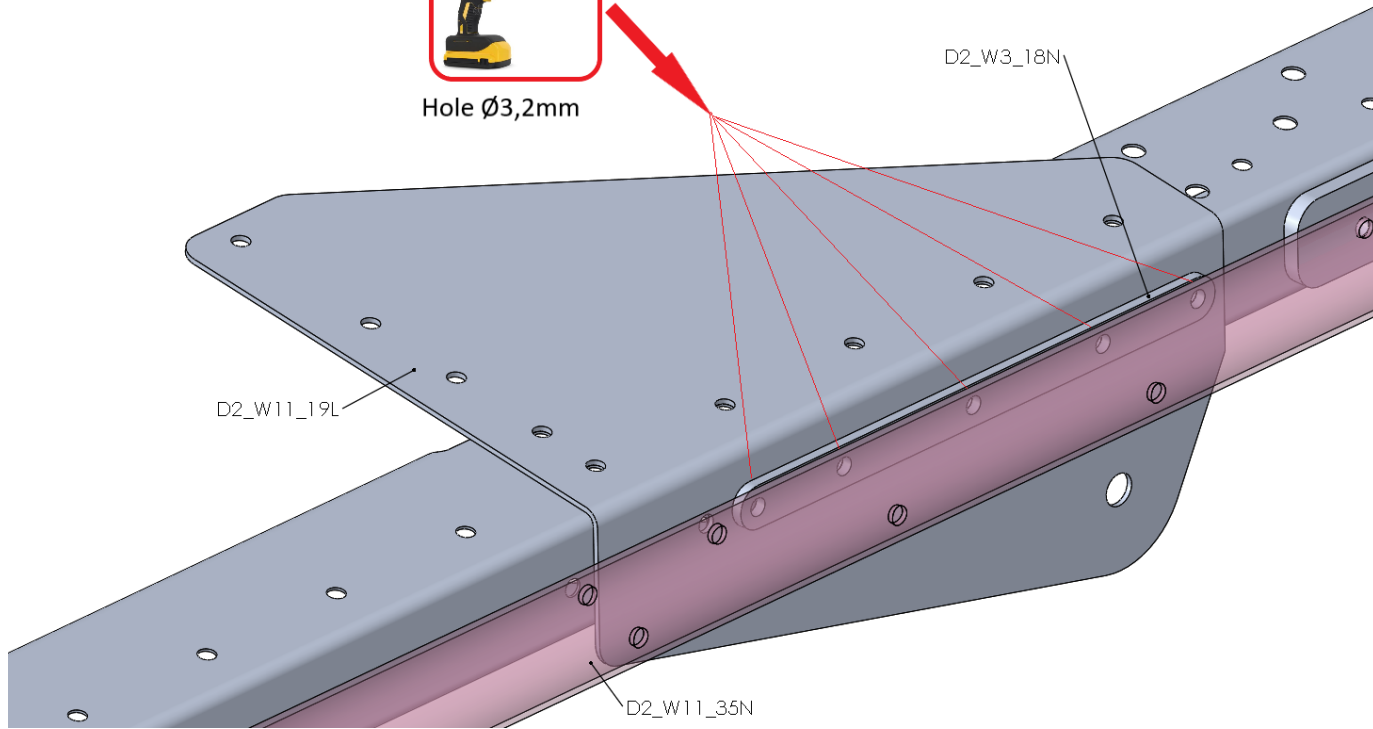
Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	53	108



Step 29-D



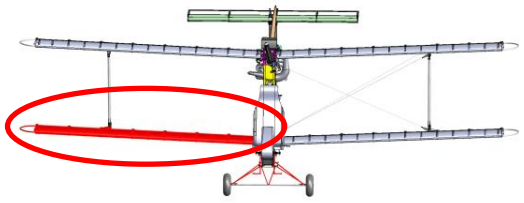
Hole $\varnothing 3,2\text{mm}$



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	54	108



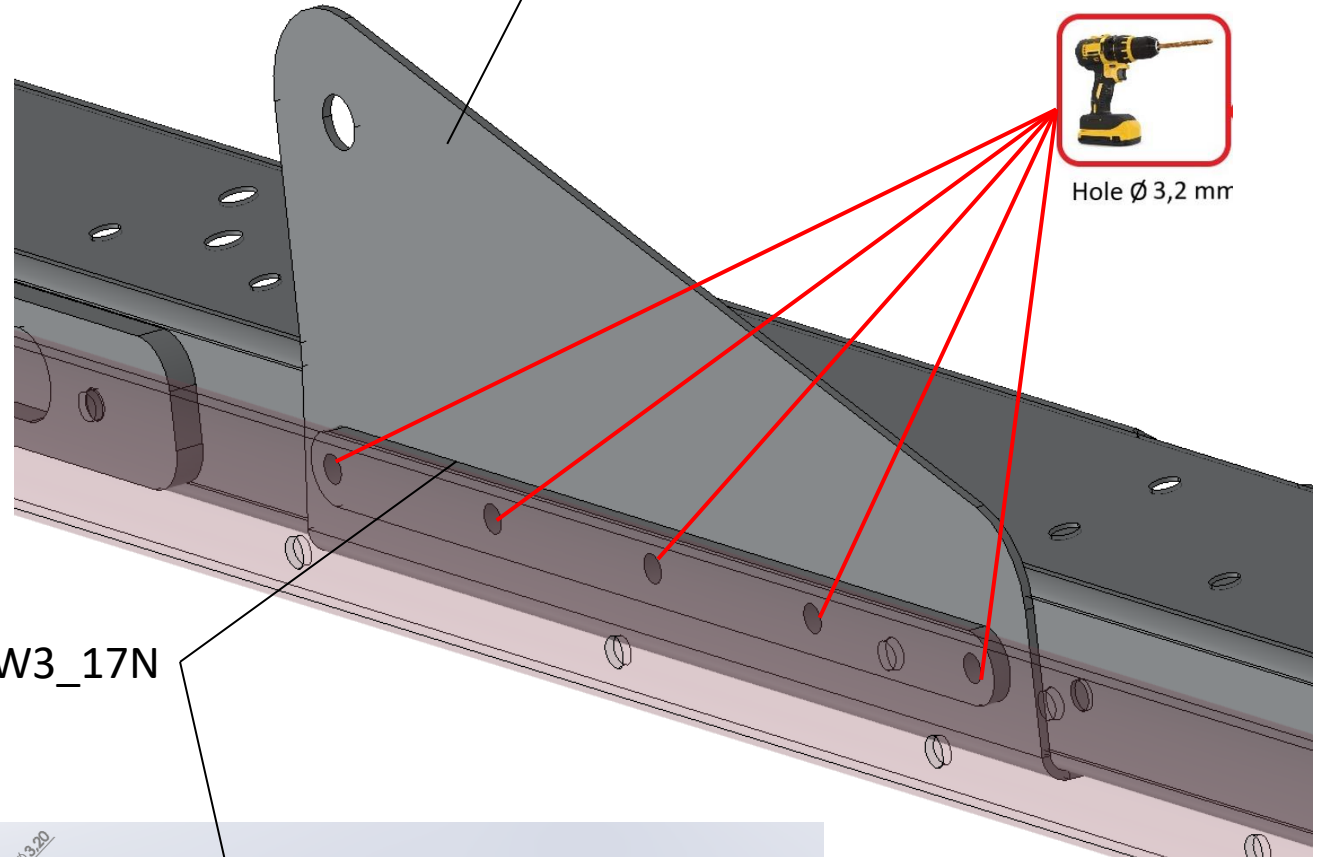
Step 29P-D



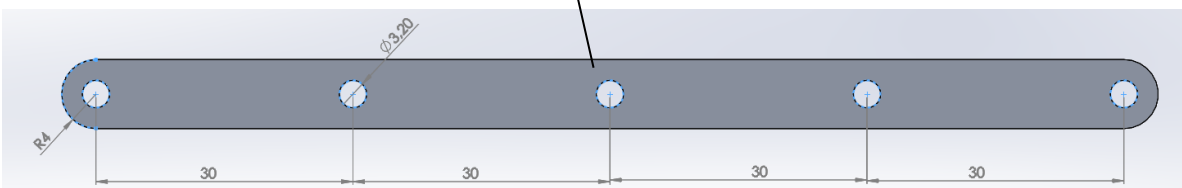
D2_W11_21P



Hole \varnothing 3,2 mm



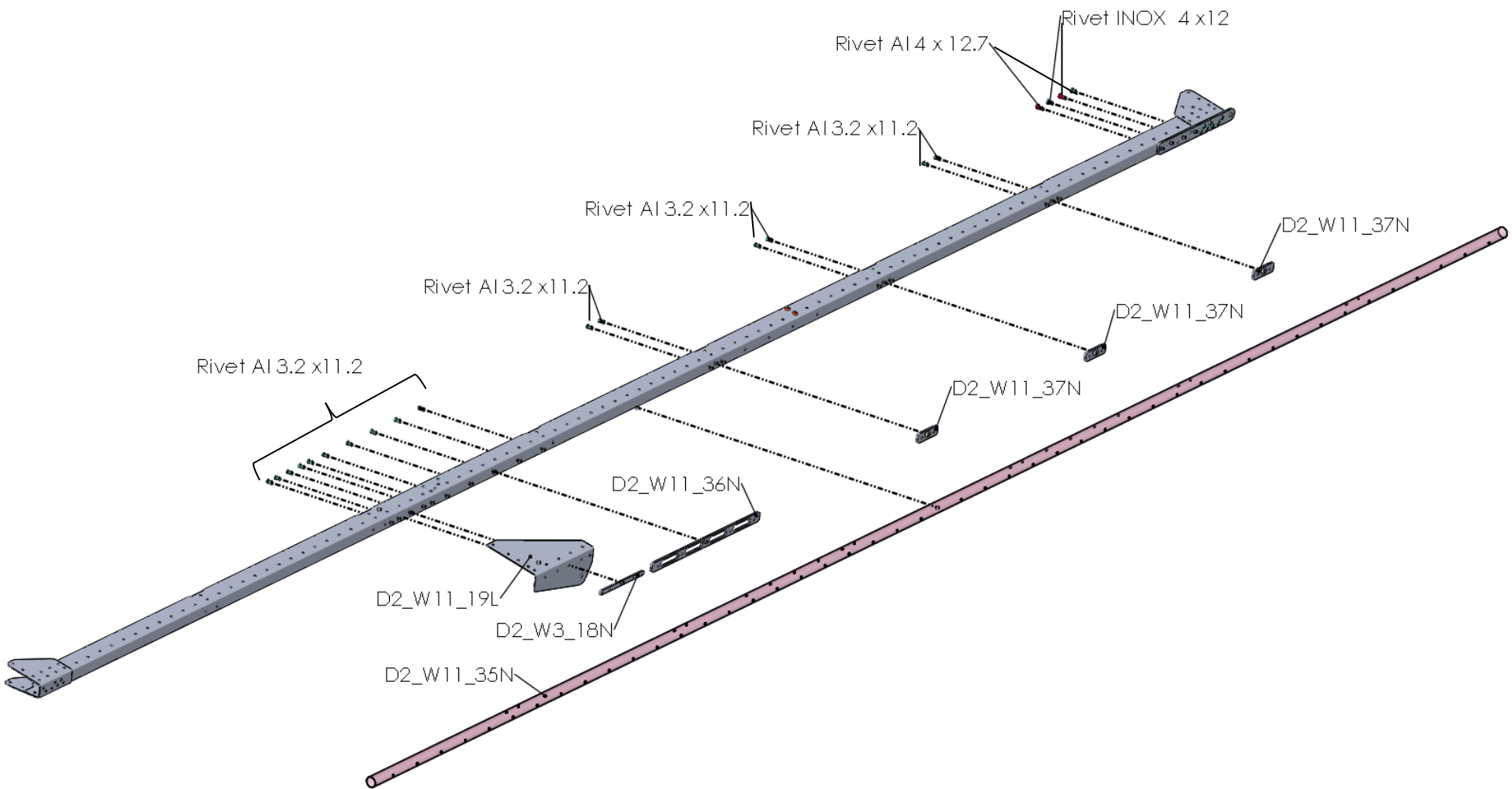
D2_W3_17N



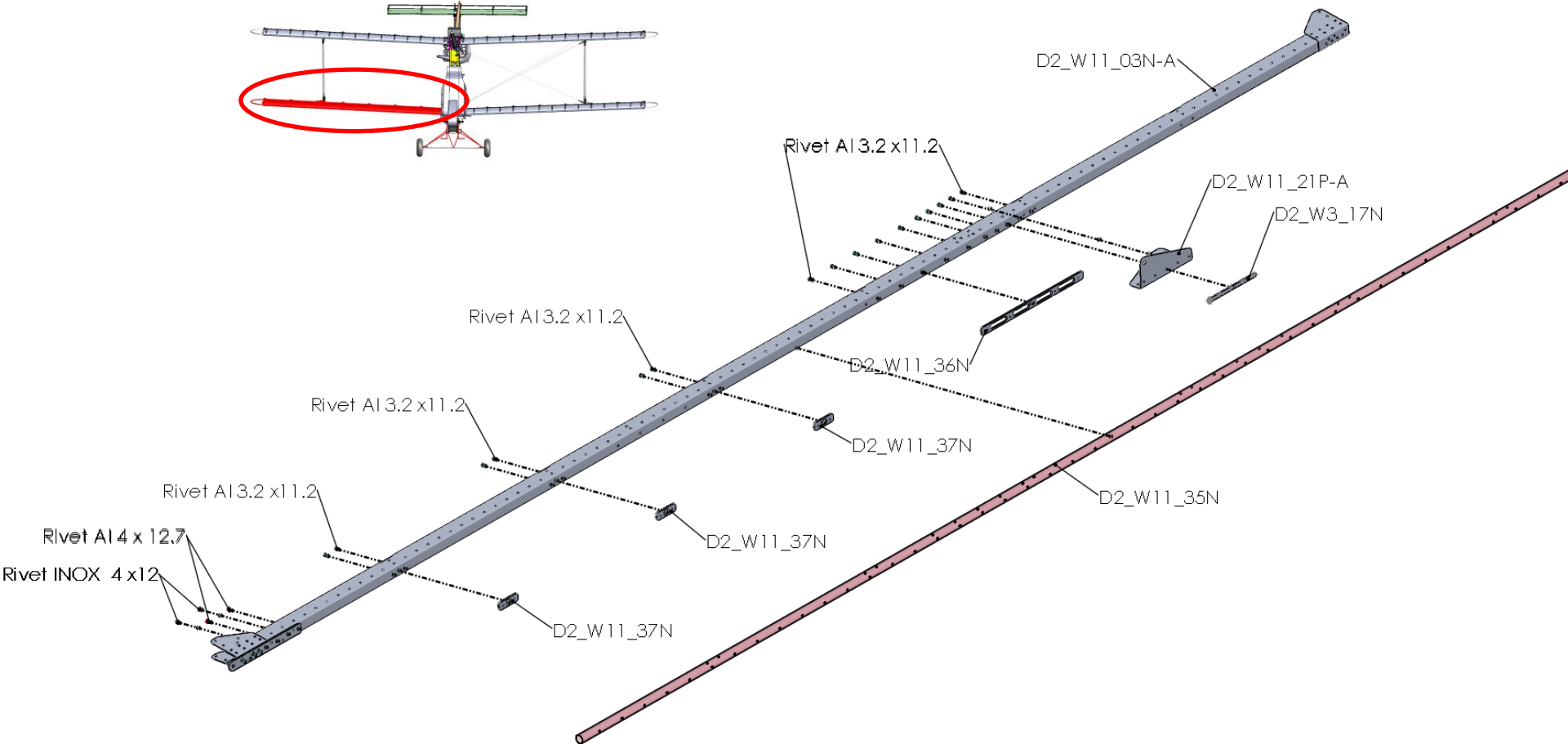
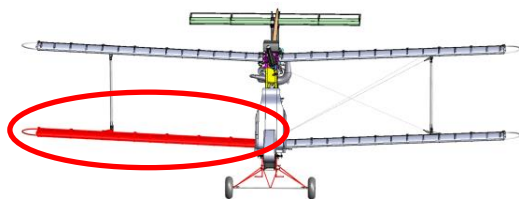
Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	55	108



Step 30



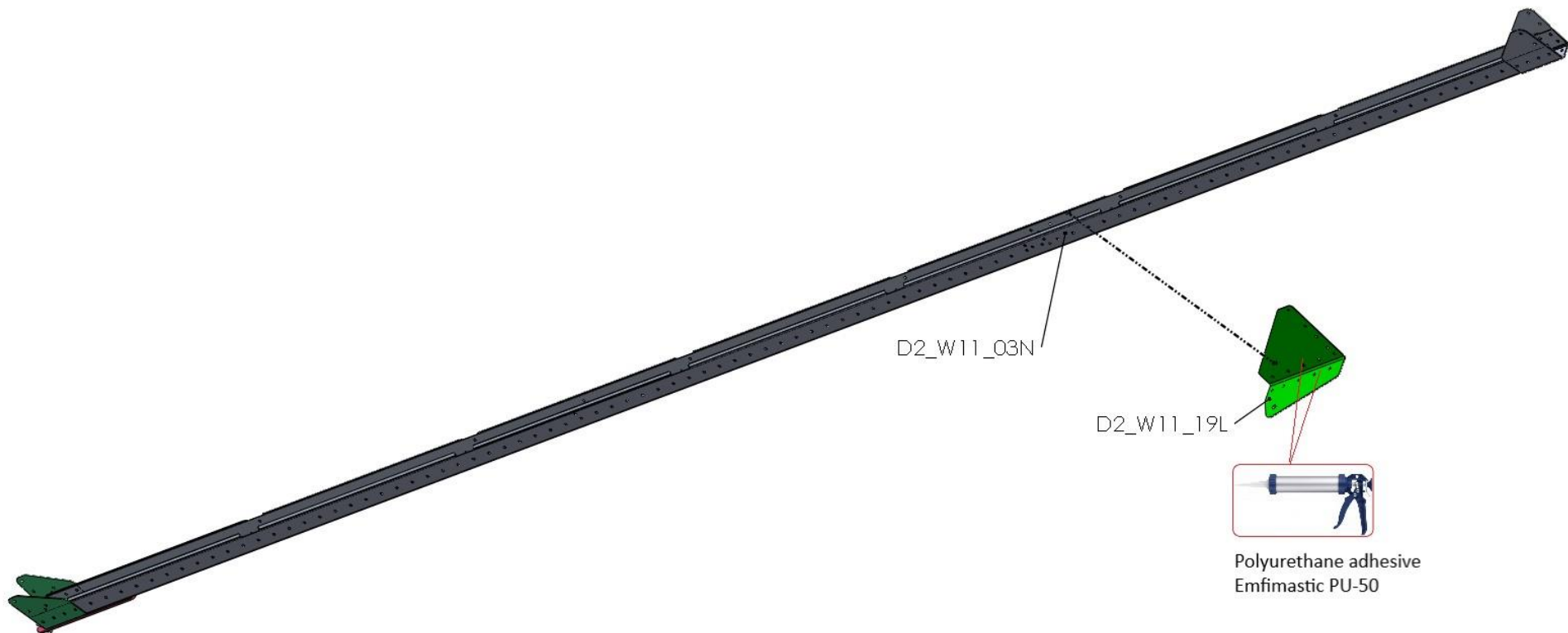
Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	56	108

Step 30P


Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	57	108



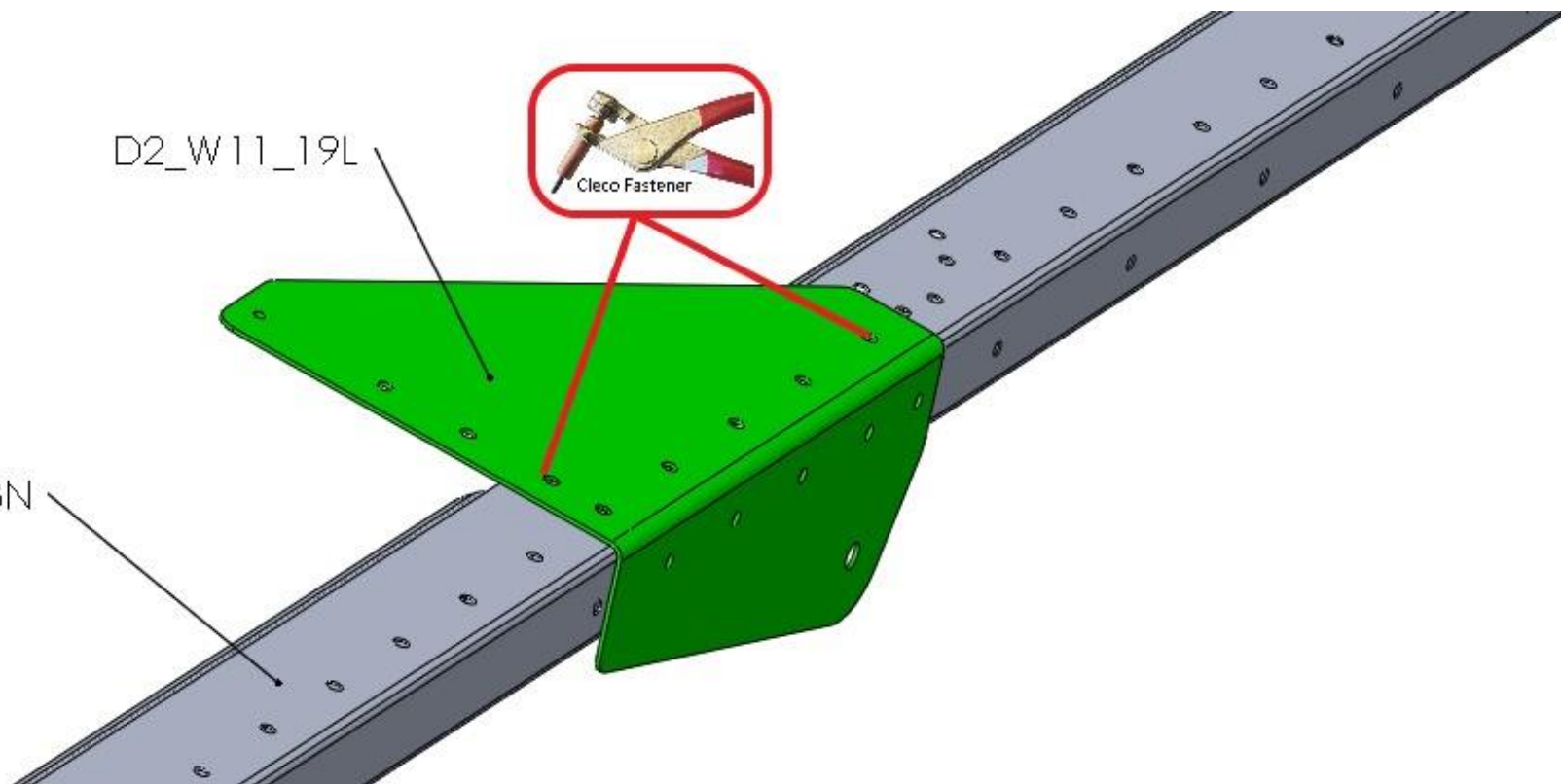
Step 31



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	58	108



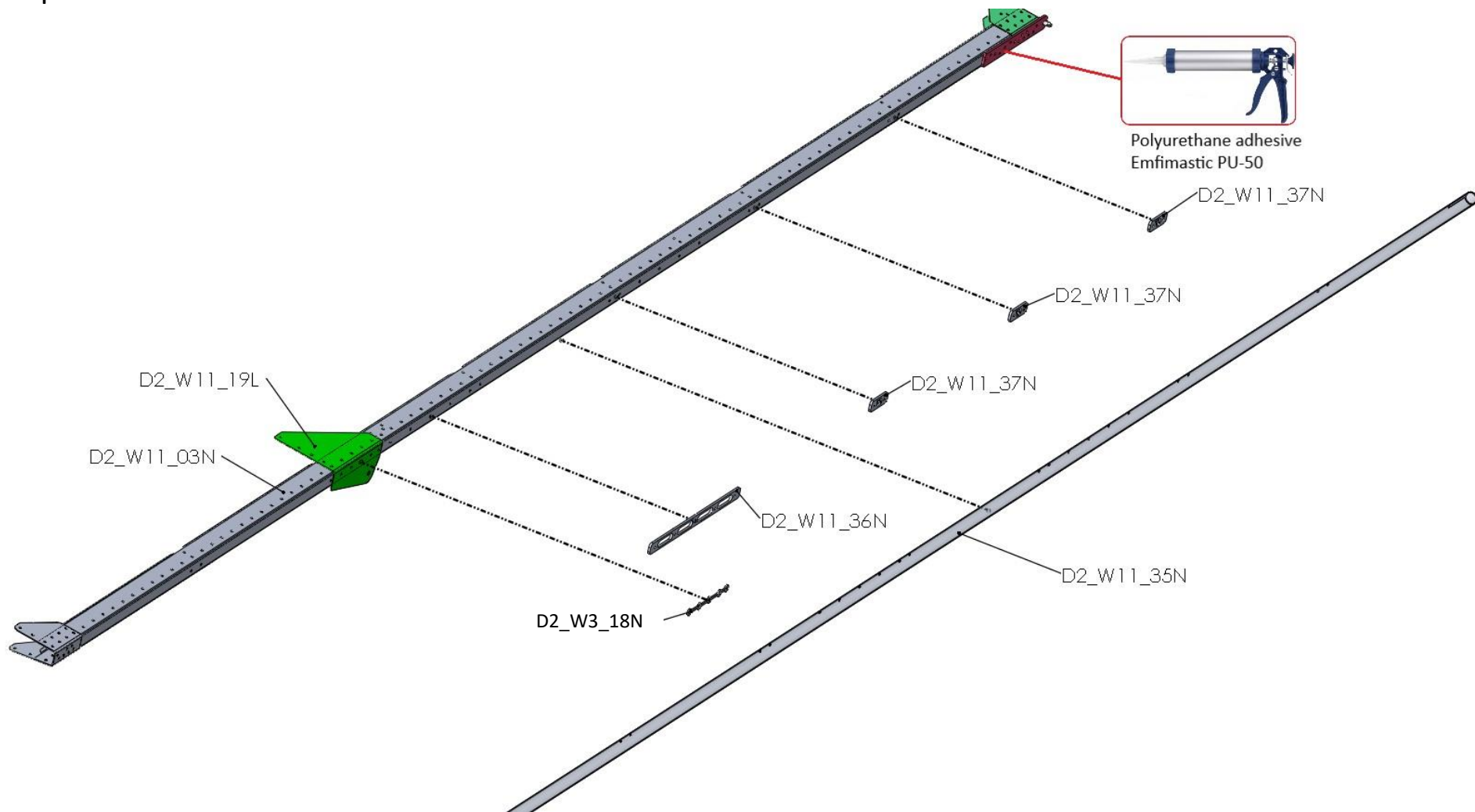
Step 32



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	59	108



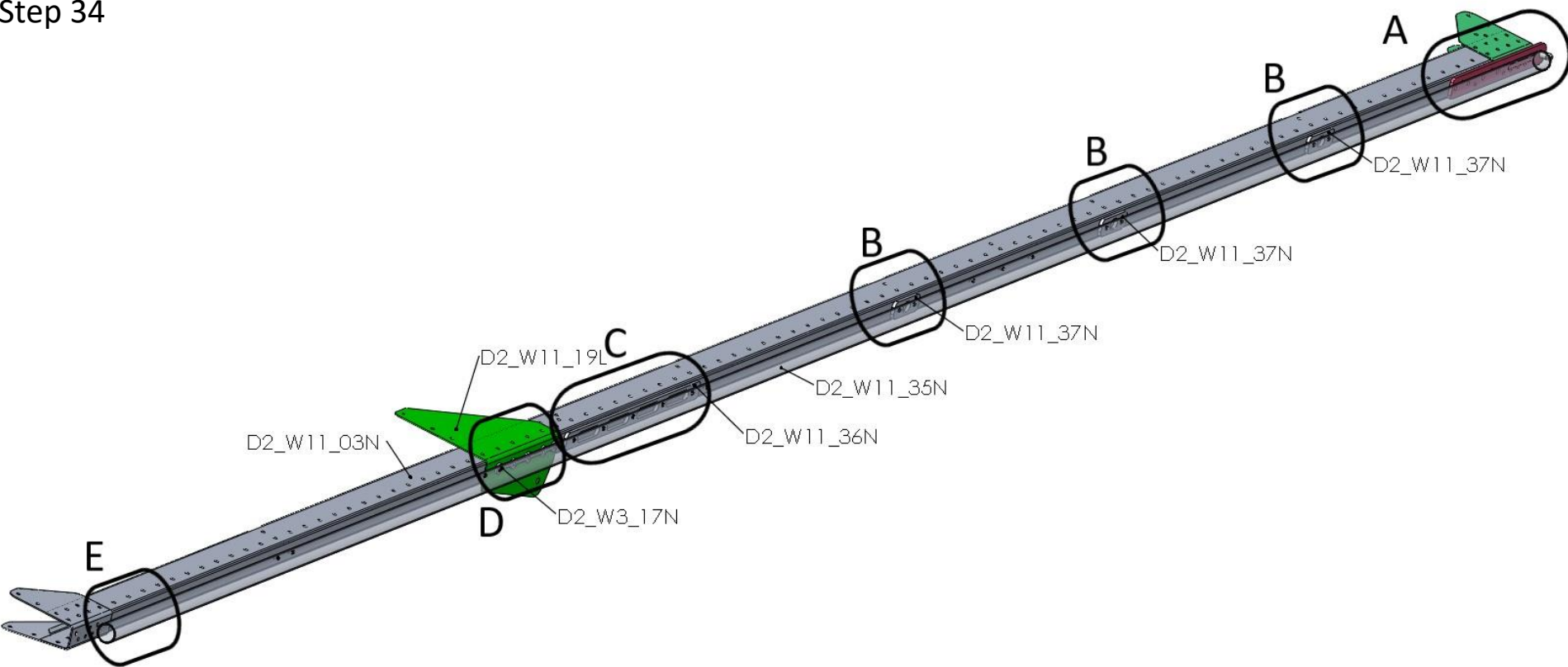
Step 33



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Wing assembly manual	D2_W0_00	Rev. 02	60	108

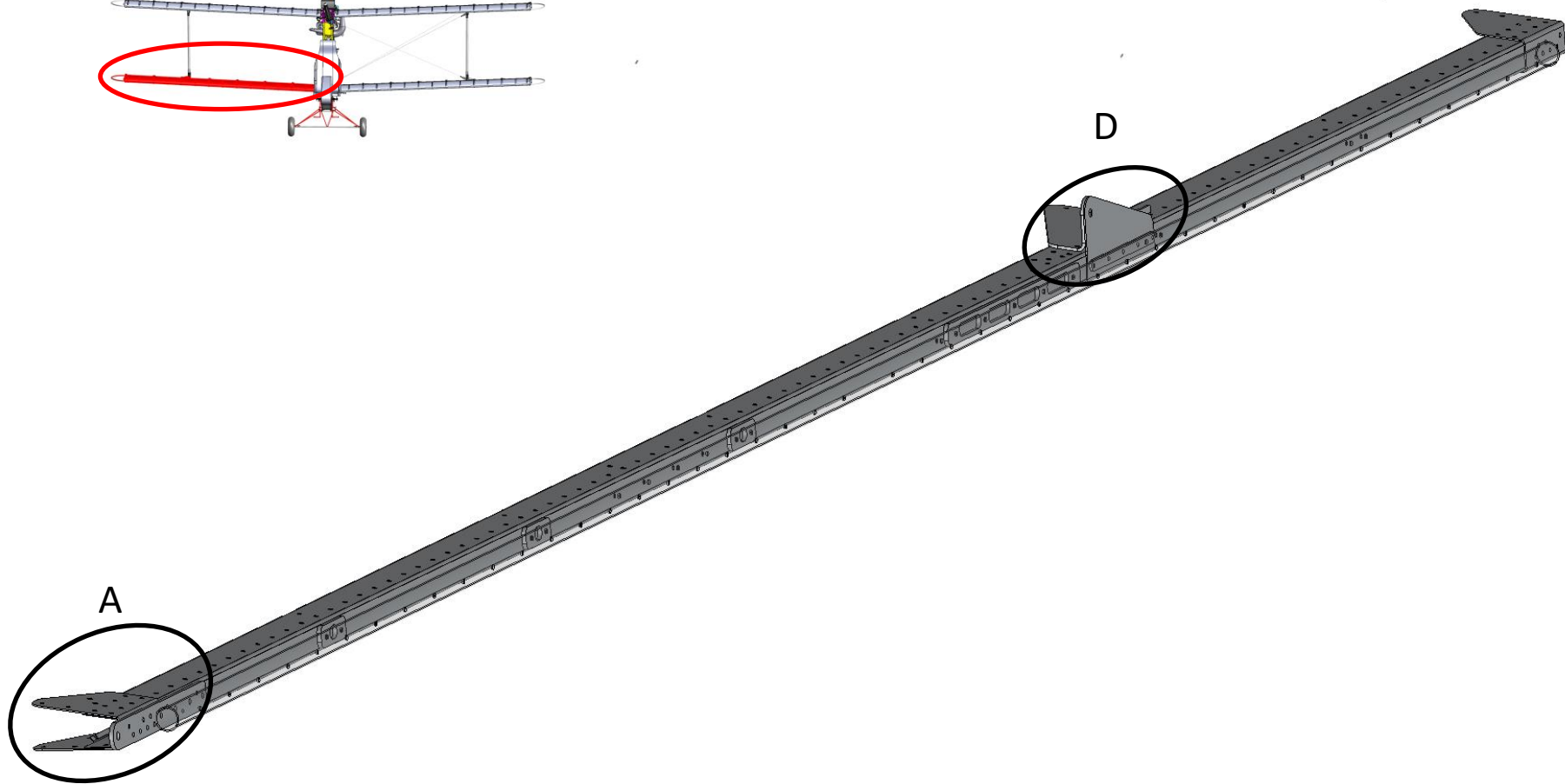
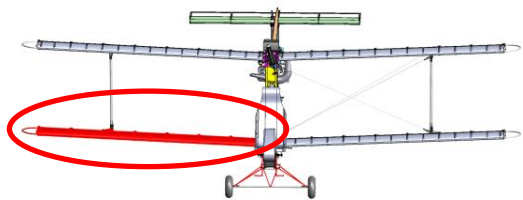


Step 34



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	61	108

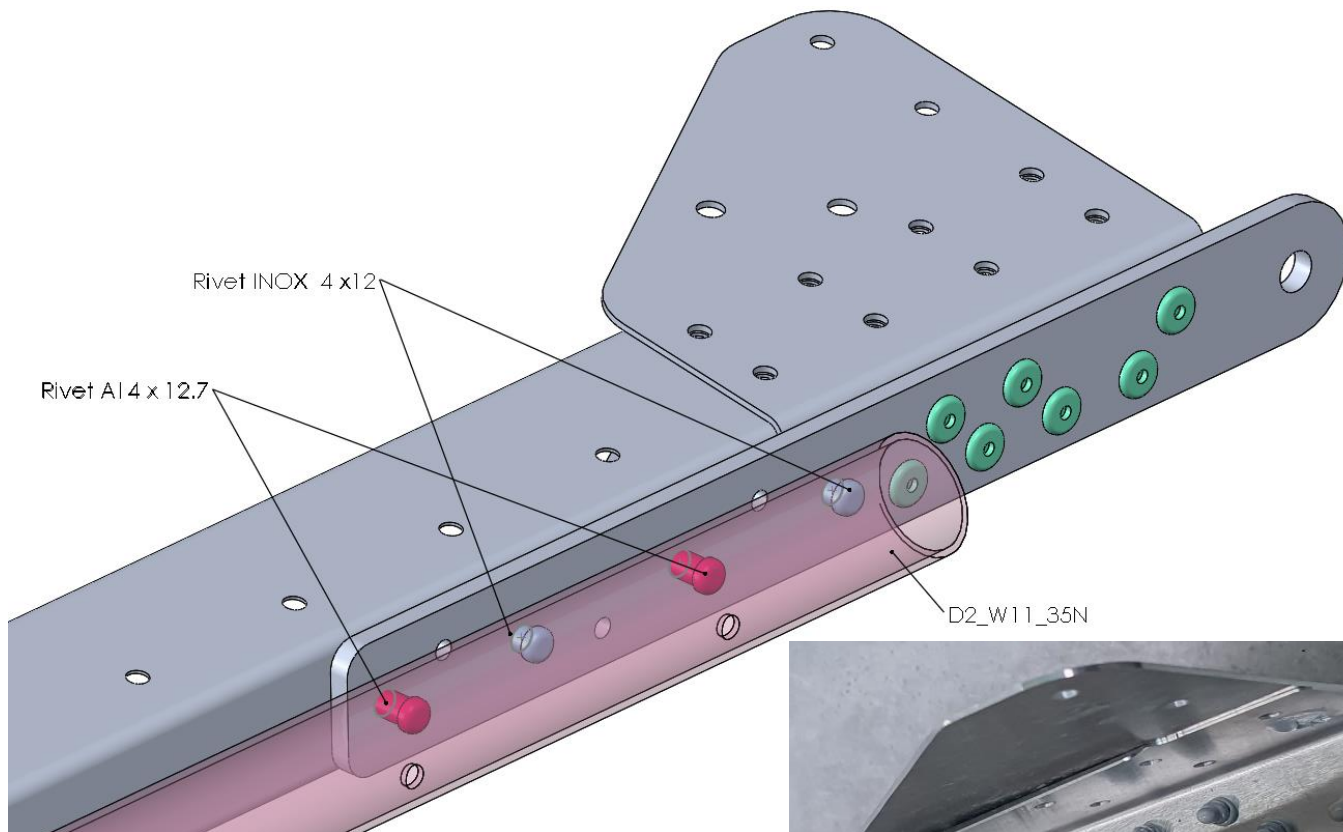
Step 34P



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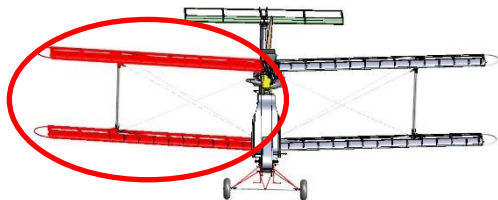
Step 34-A



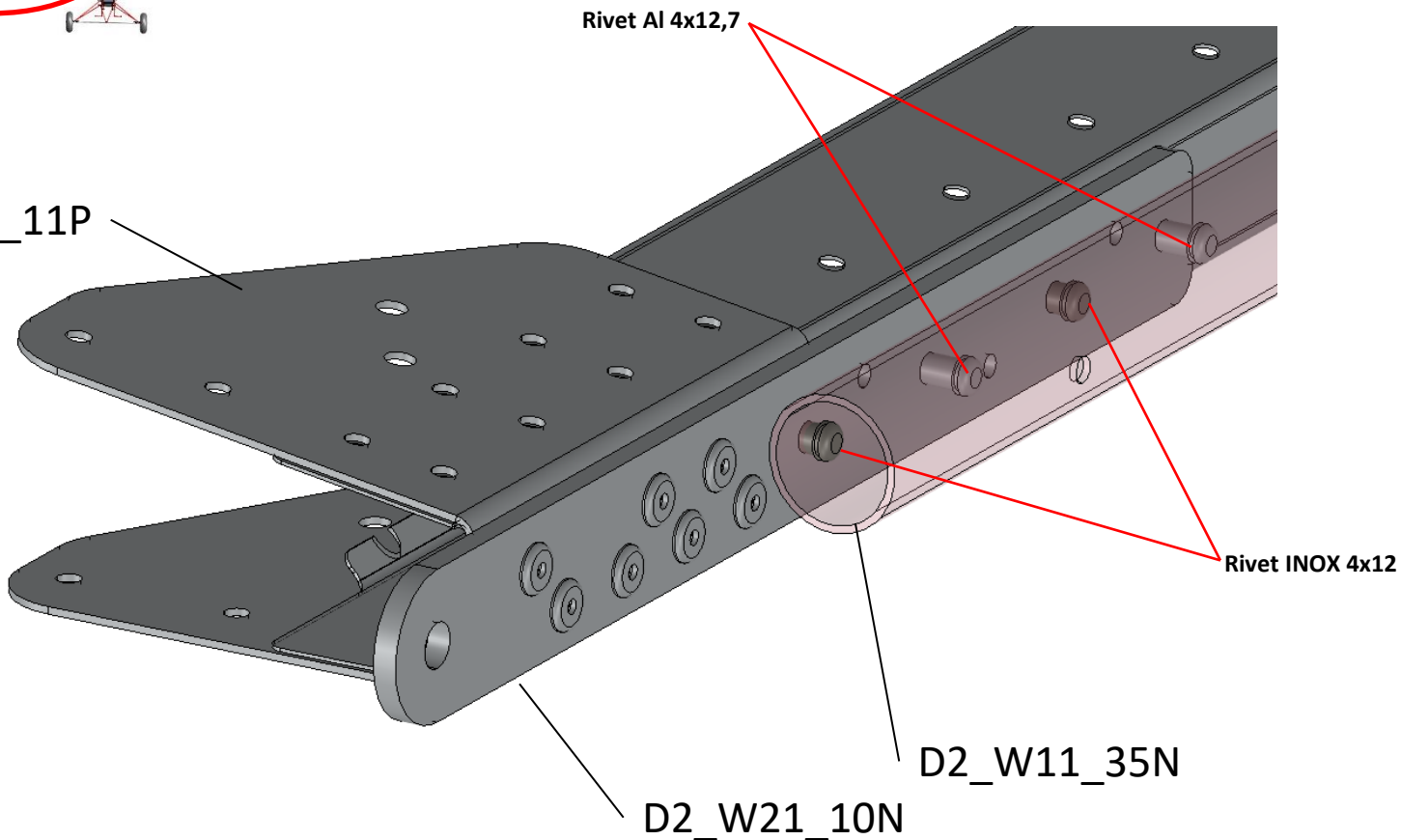
Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	63	108



Step 34P-A



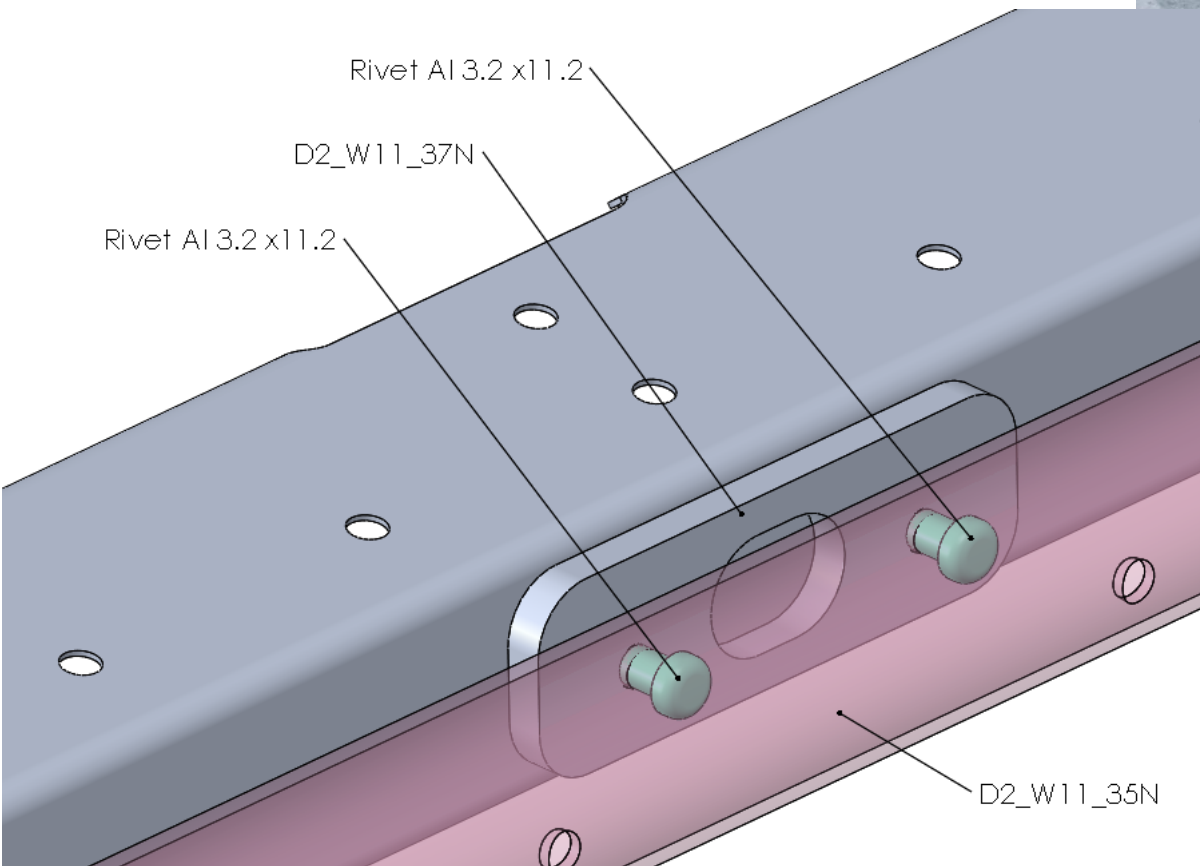
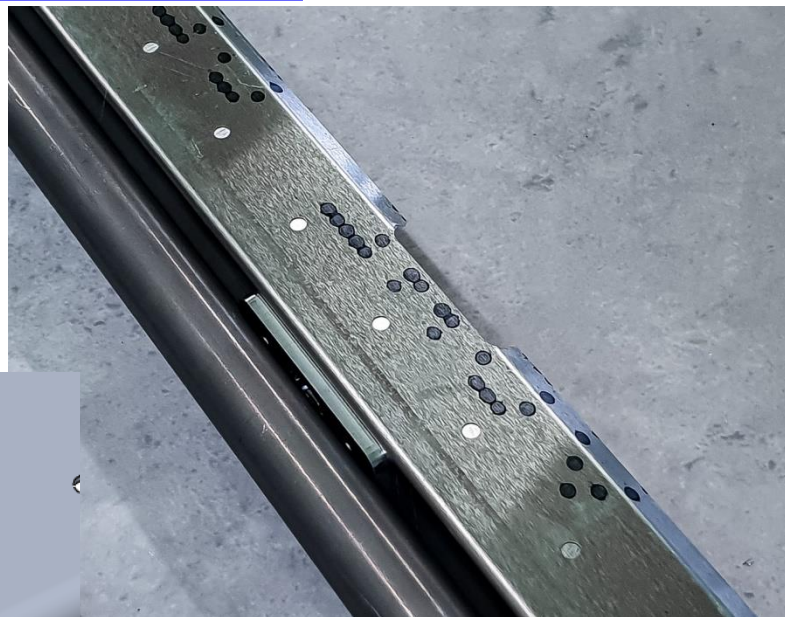
D2_W11_11P



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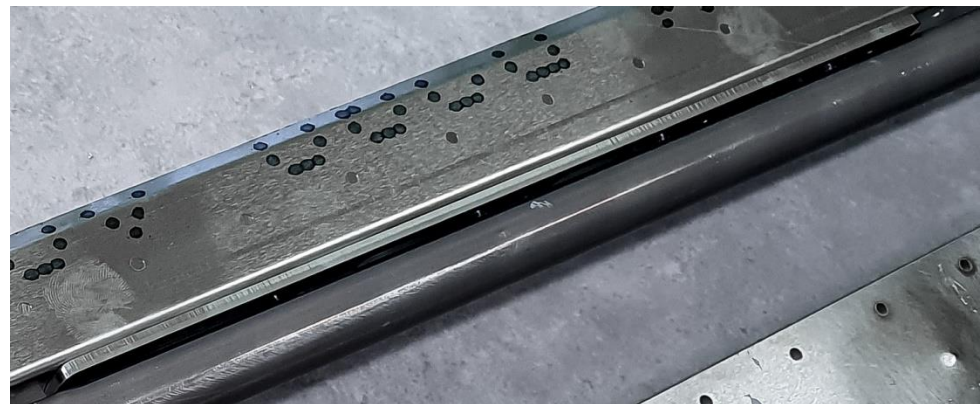
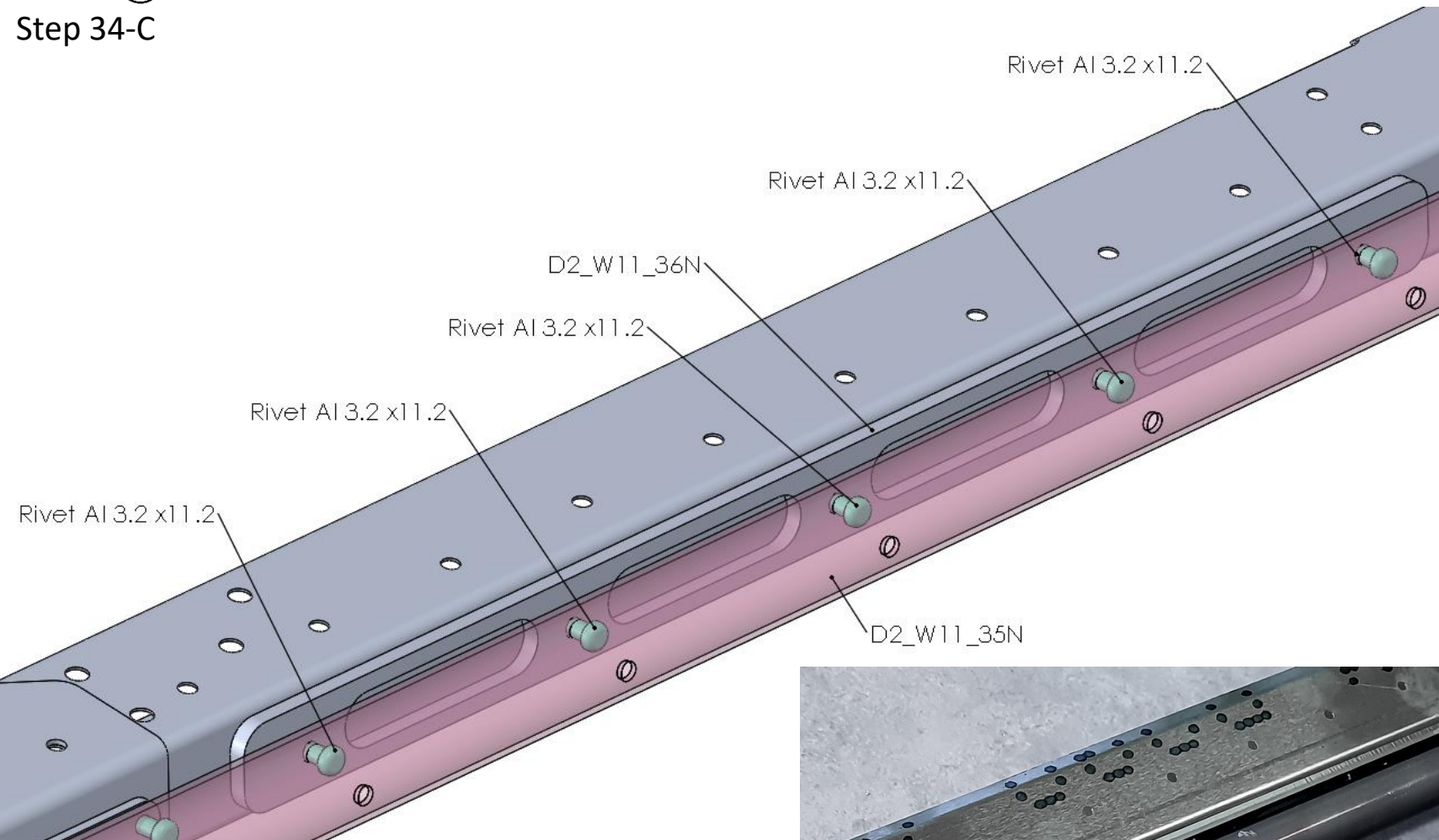
Step 34-B



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Wing assembly manual	D2_W0_00	Rev. 02	65	108



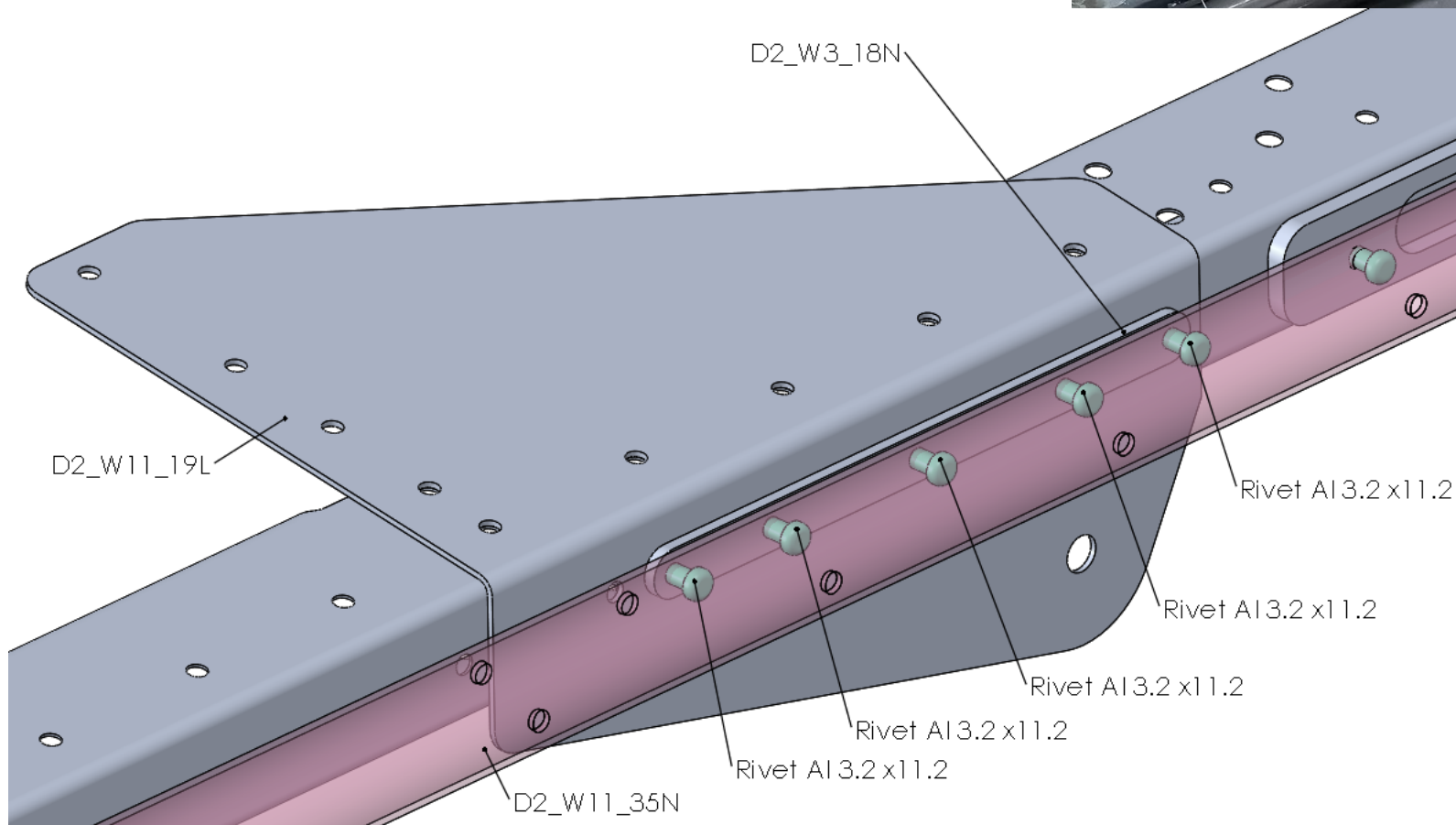
Step 34-C



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	66	108



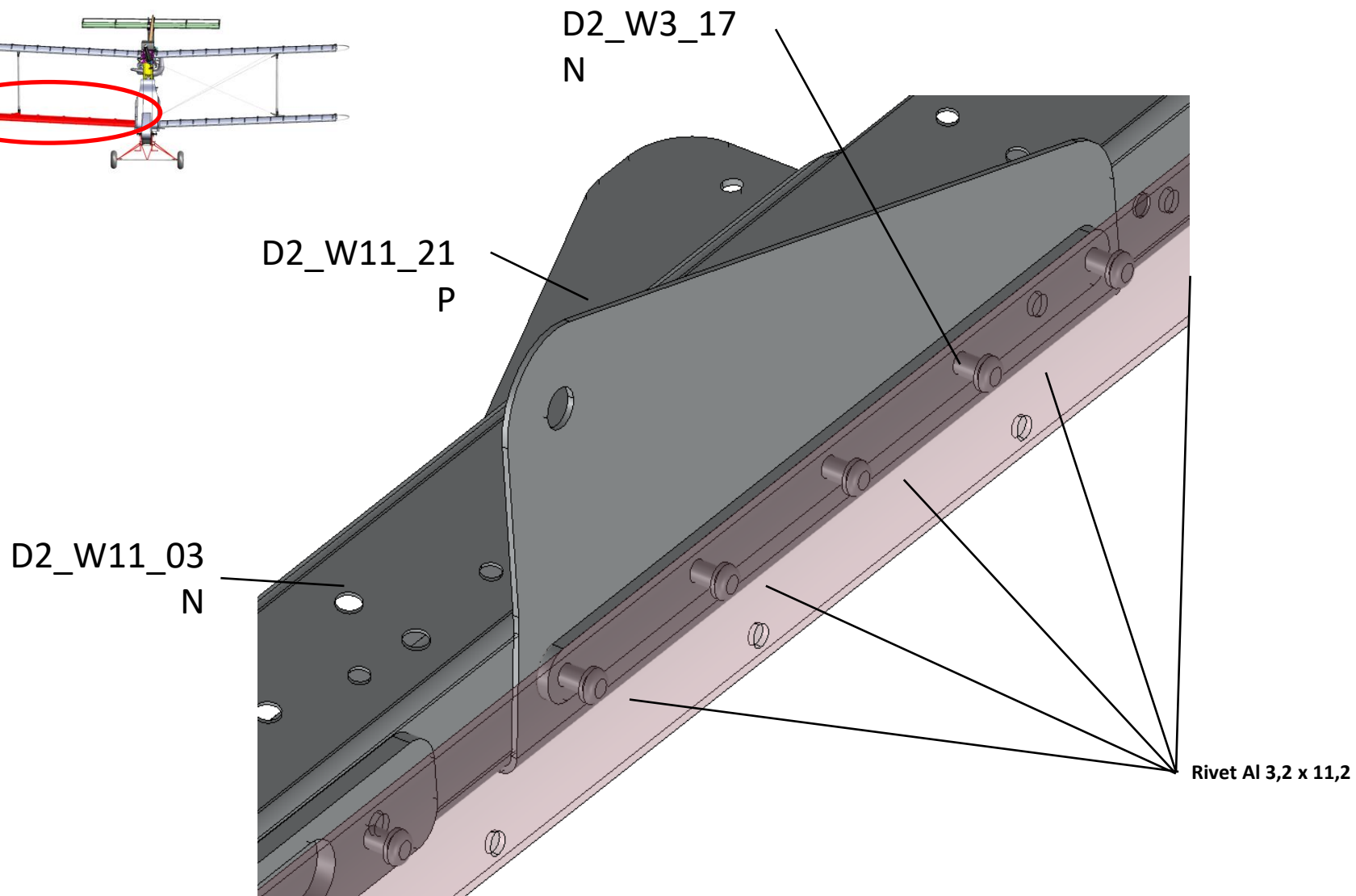
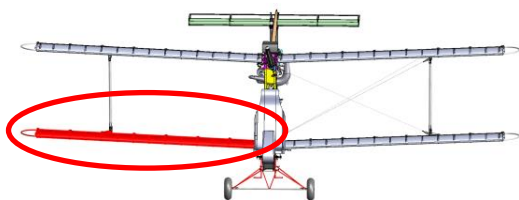
Step 34-D



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	67	108



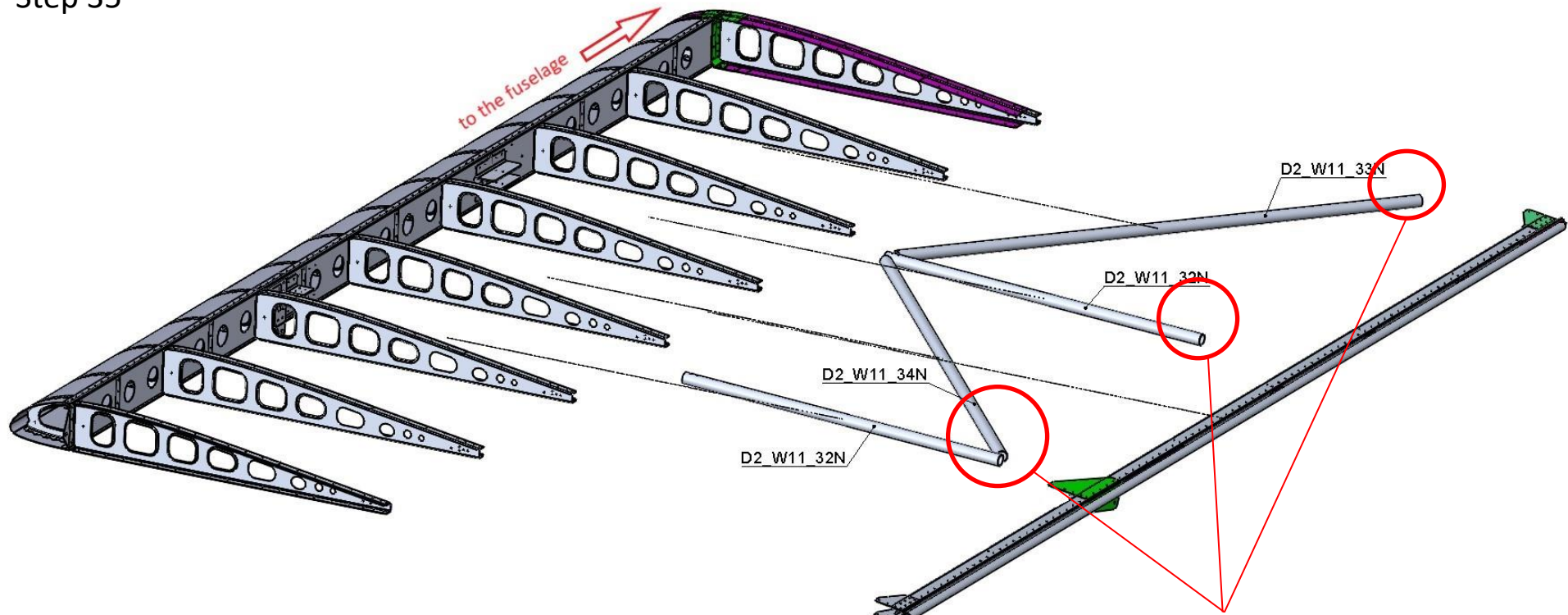
Step 34P-D



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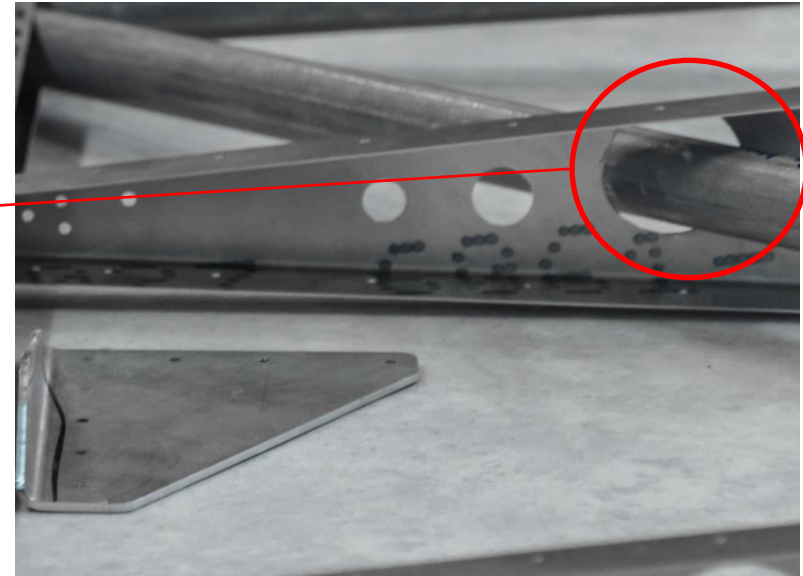
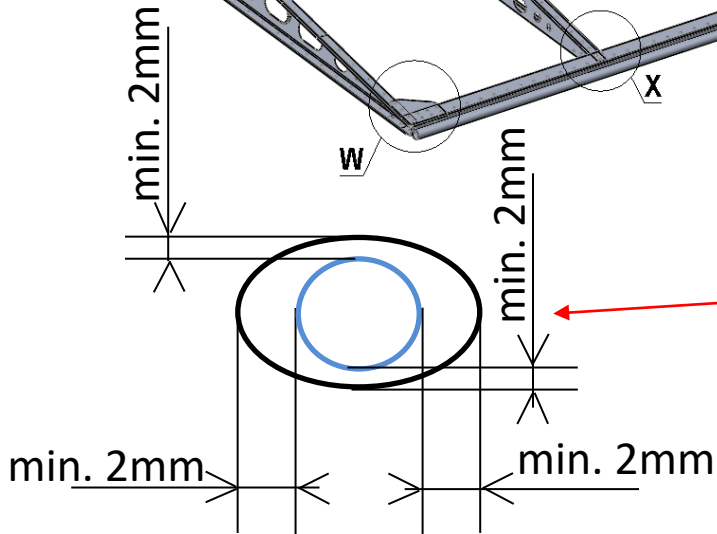
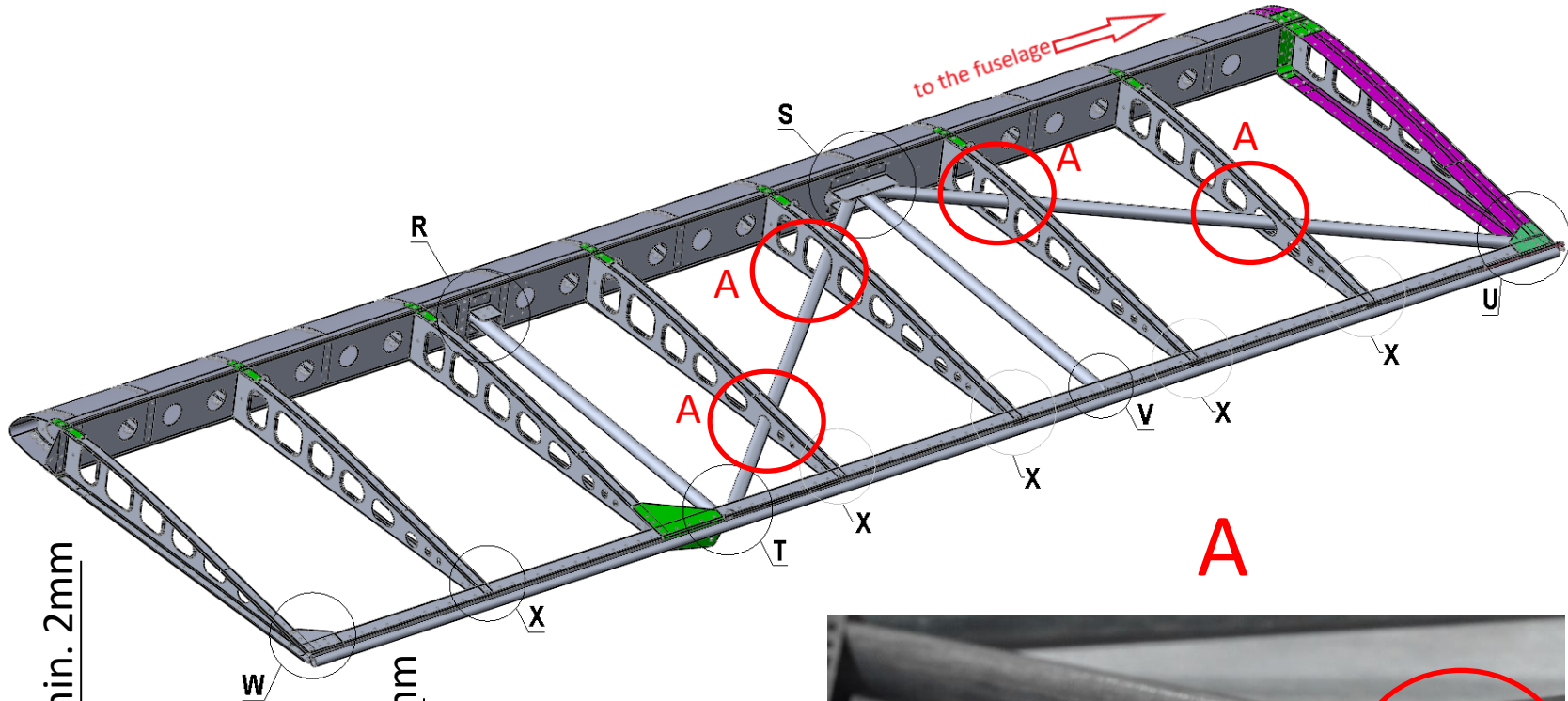
Step 35



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Wing assembly manual	D2_W0_00	Rev. 02	69	108



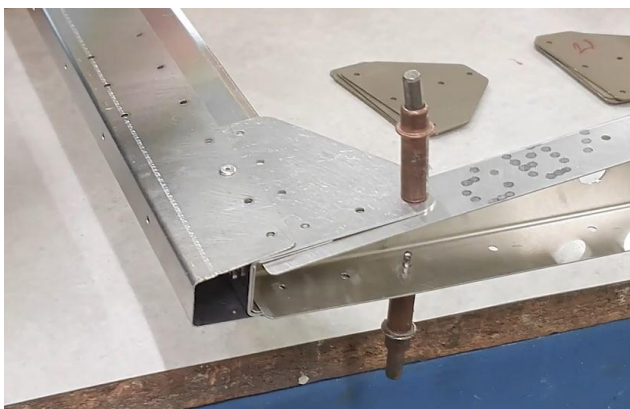
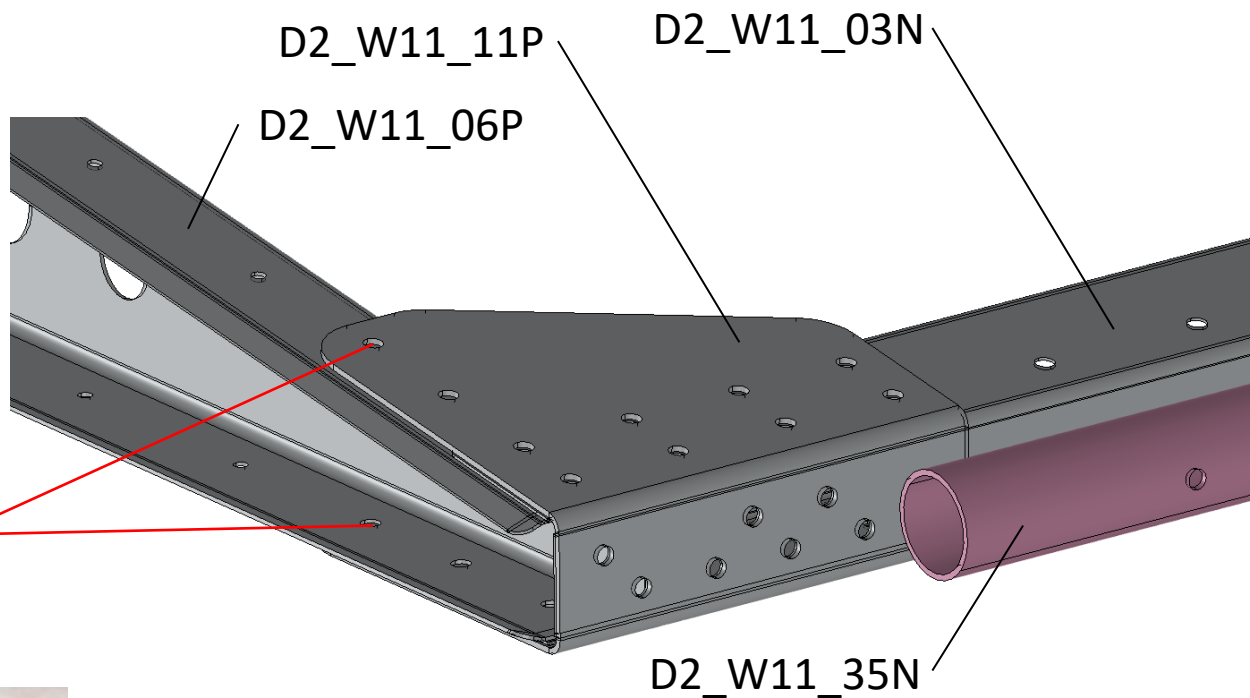
Step 36



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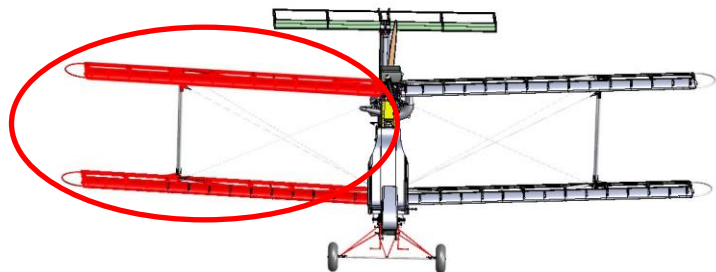
Step 36-W



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Step 36P-W



D2_W11_03N

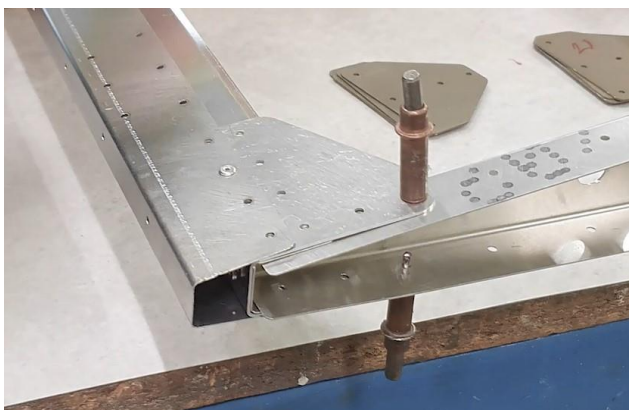
D2_W11_11P

D2_W11_06P

D2_W11_35N



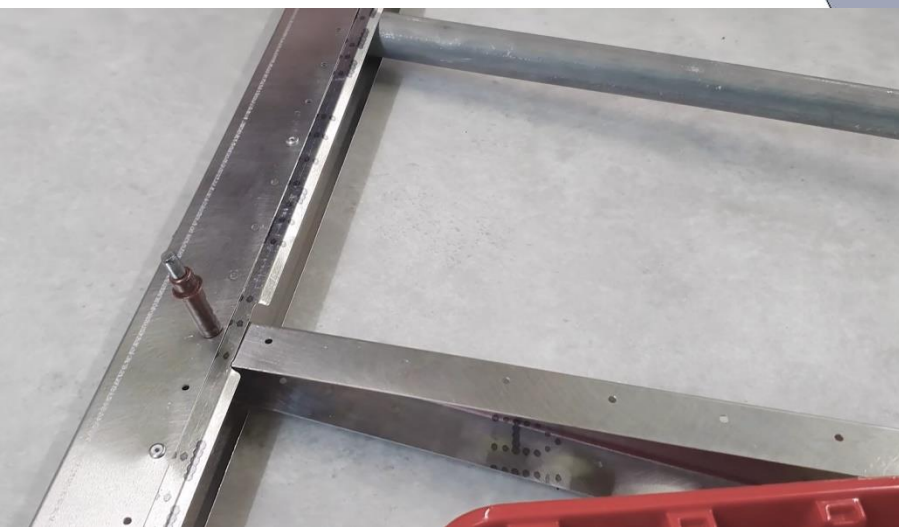
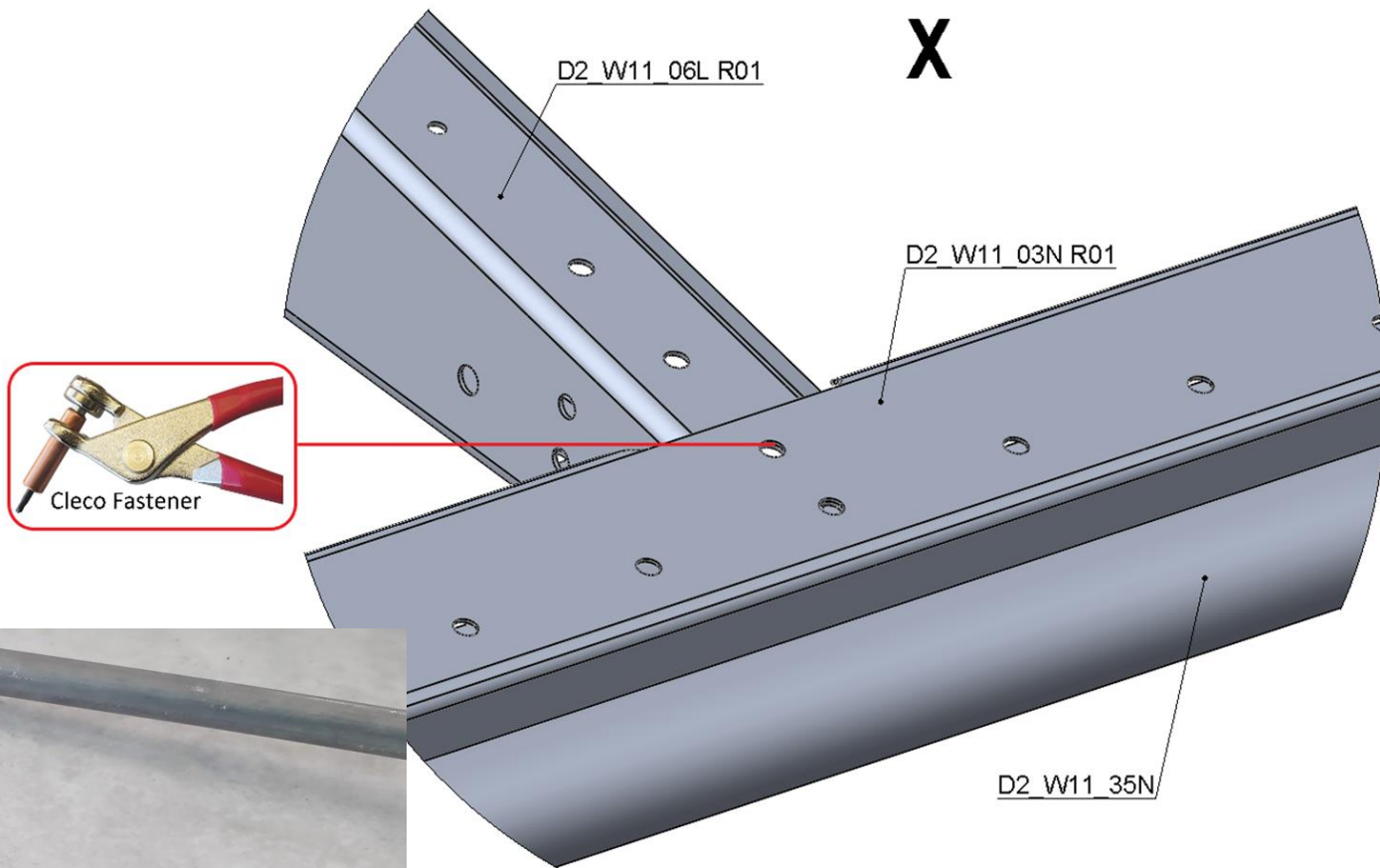
Cleco Fastener



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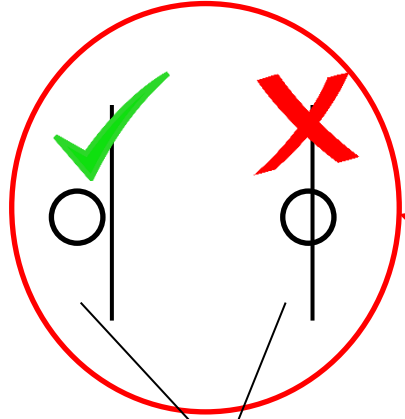
Step 36-X



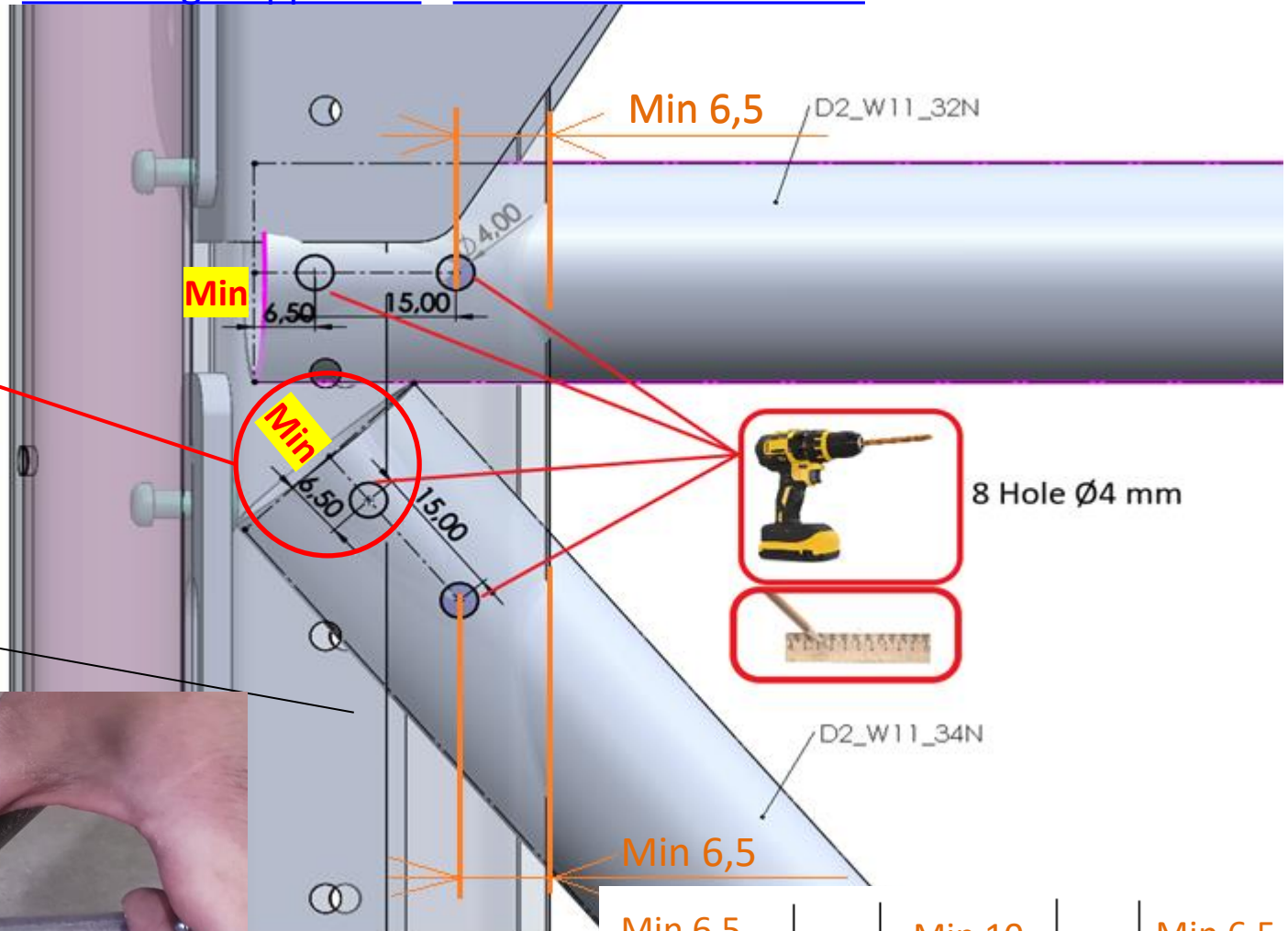
Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	73	108



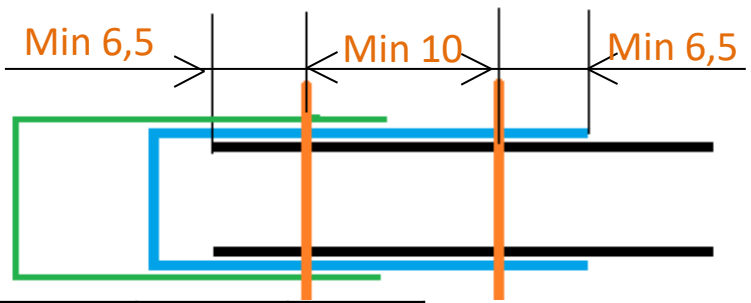
Step 36-T



D2_W11_29N



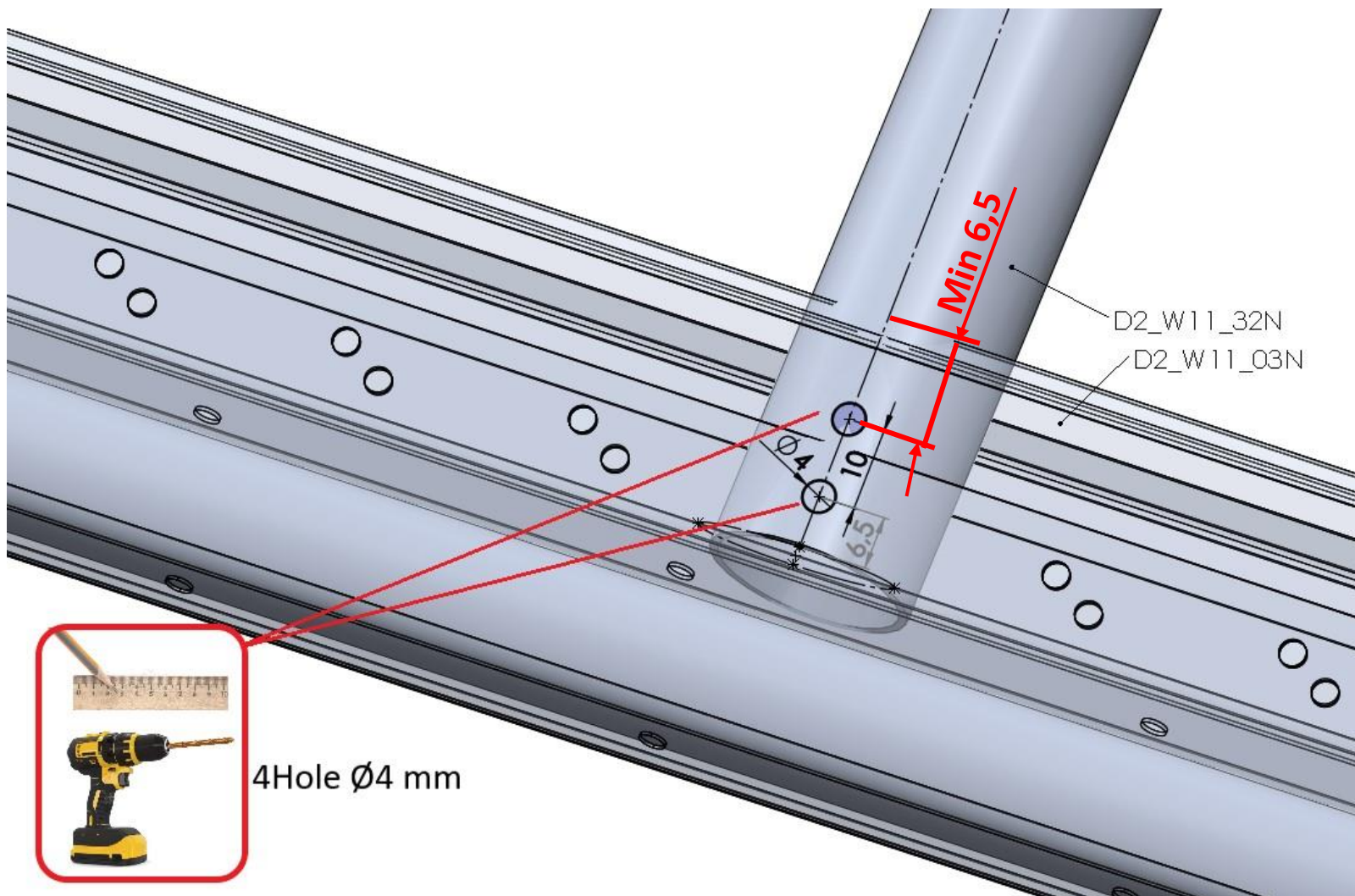
8 Hole Ø4 mm



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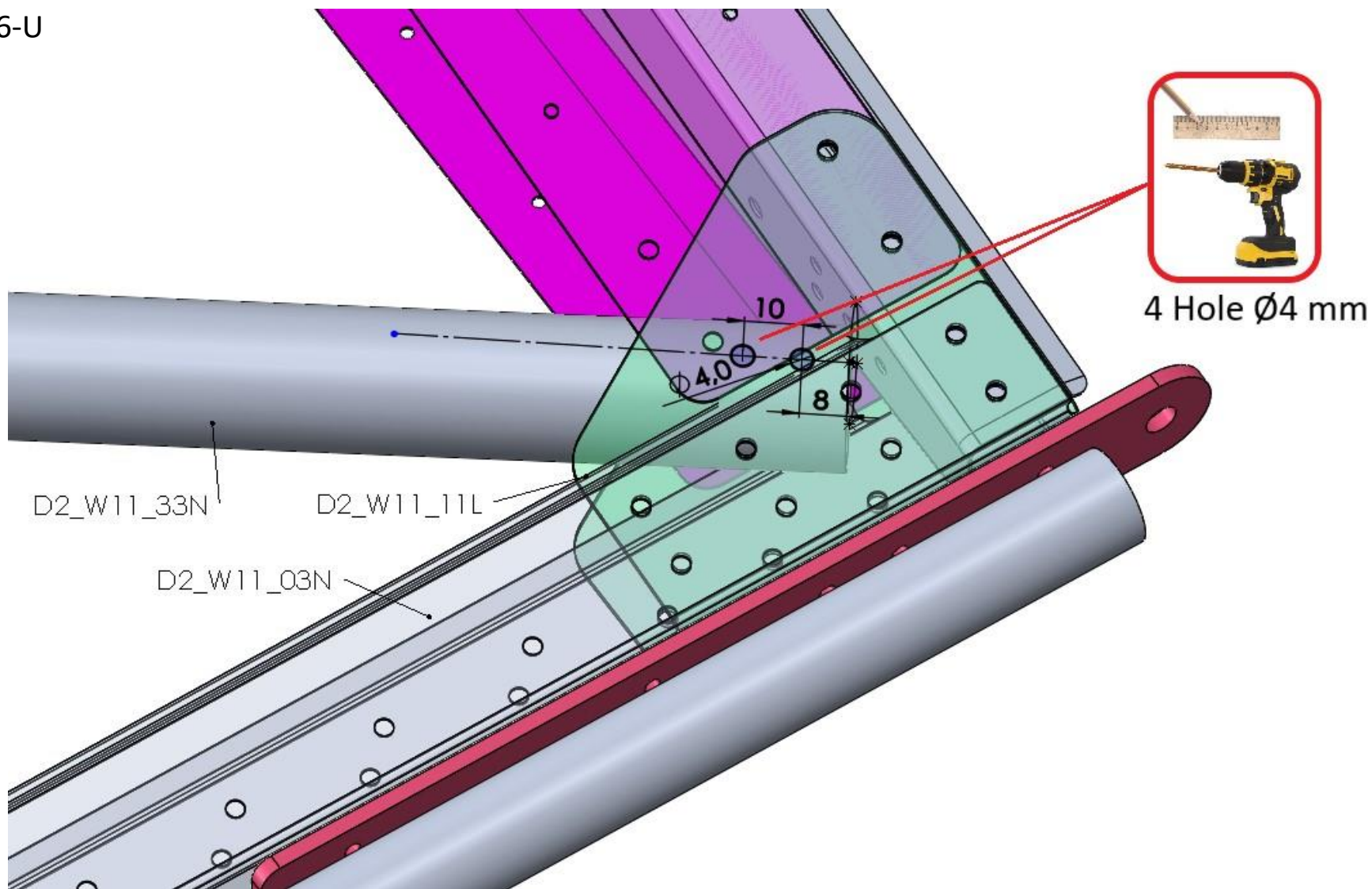
Step 36-V



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Step 36-U

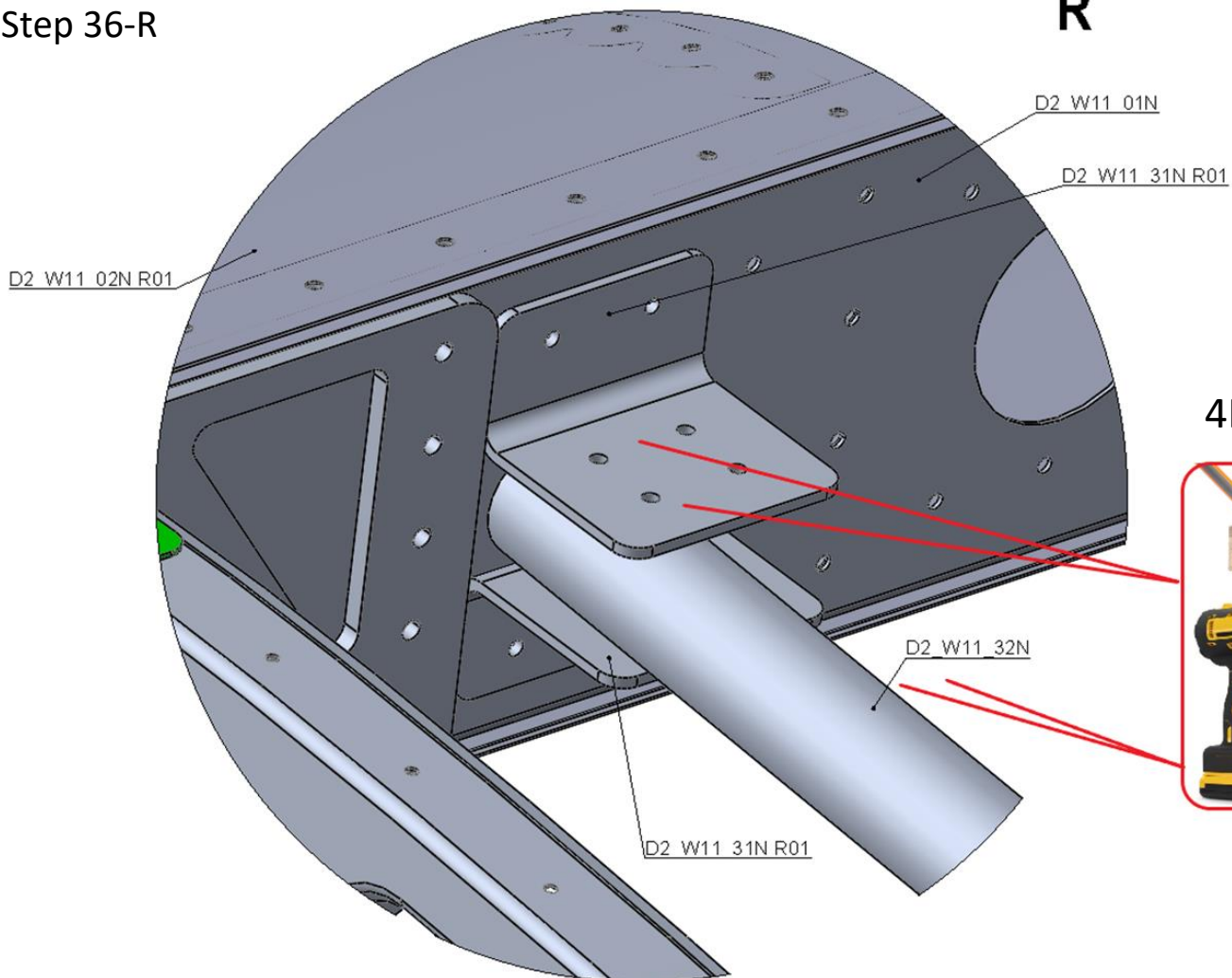


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Step 36-R

R



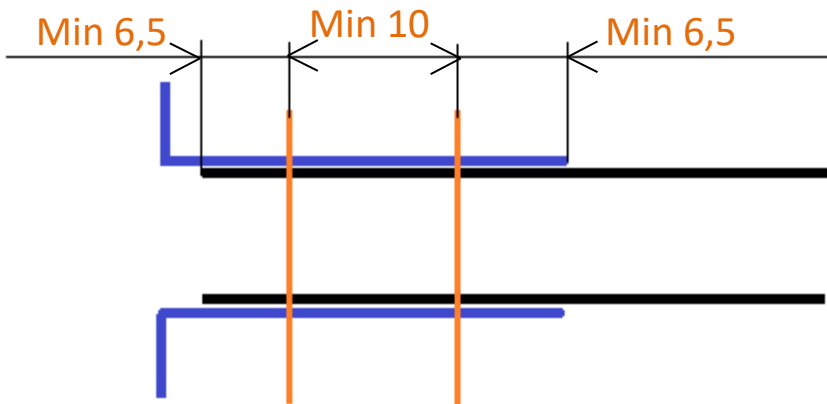
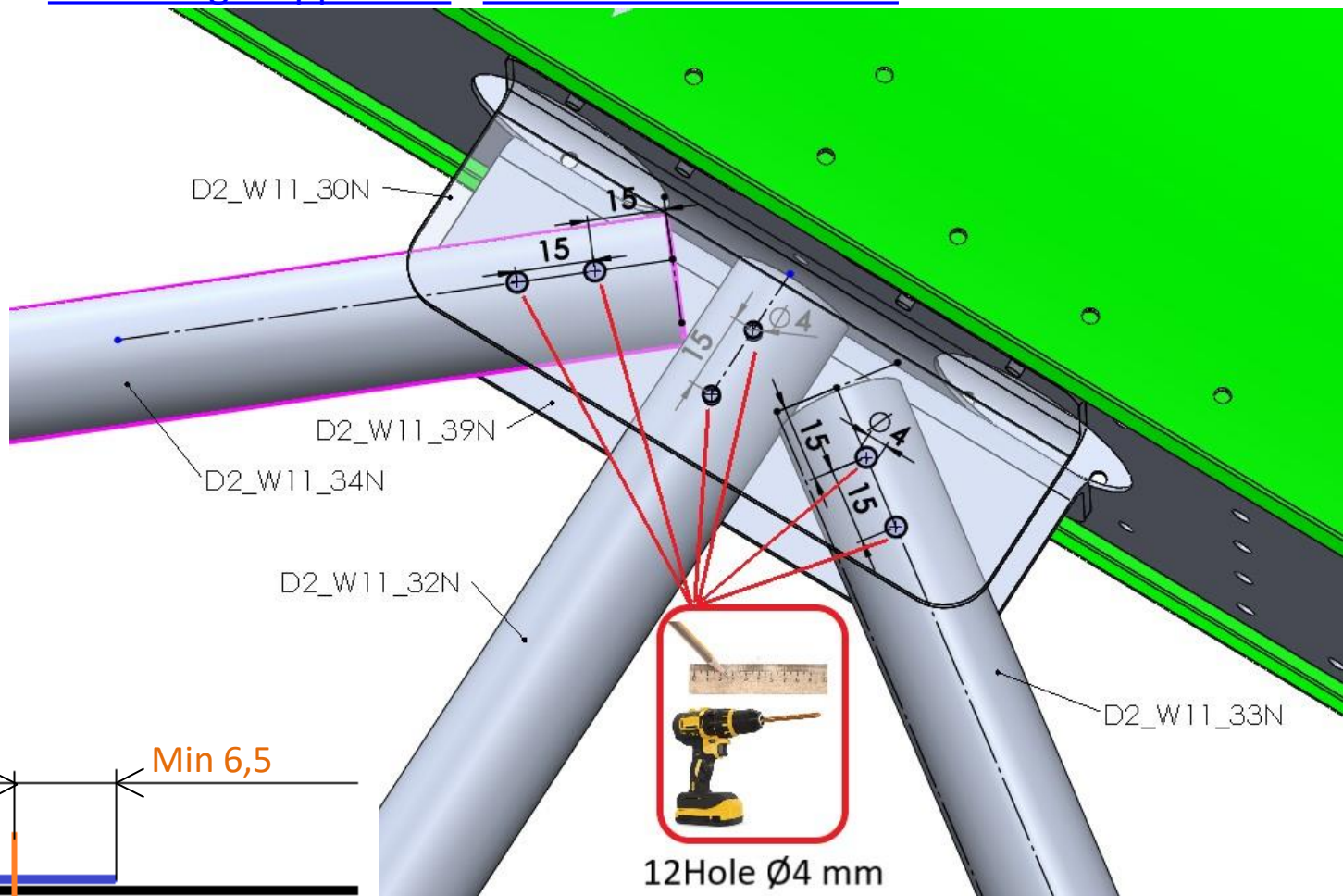
4Hole Ø4 mm



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Wing assembly manual	D2_W0_00	Rev. 02	77	108

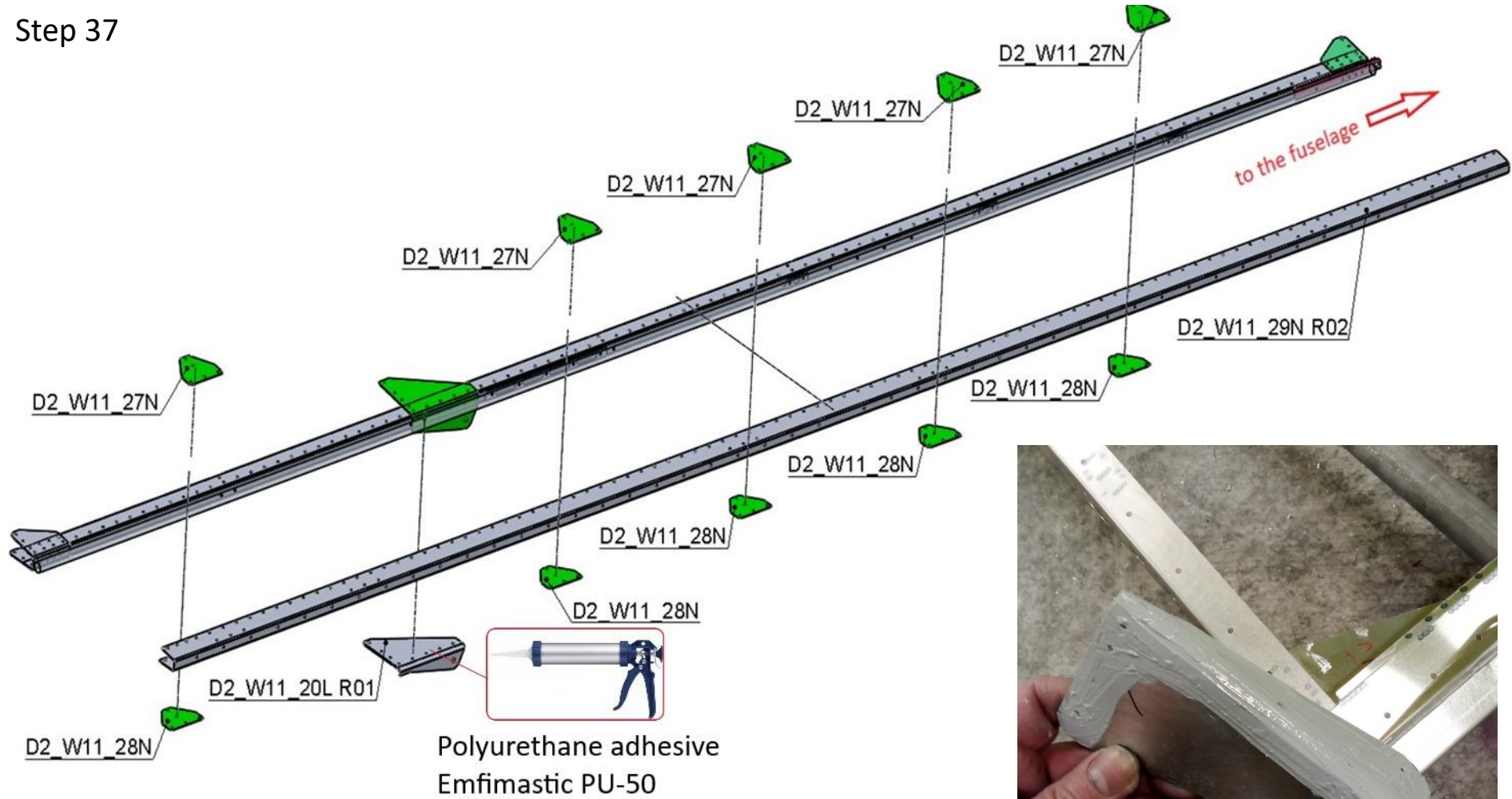


Step 36-S



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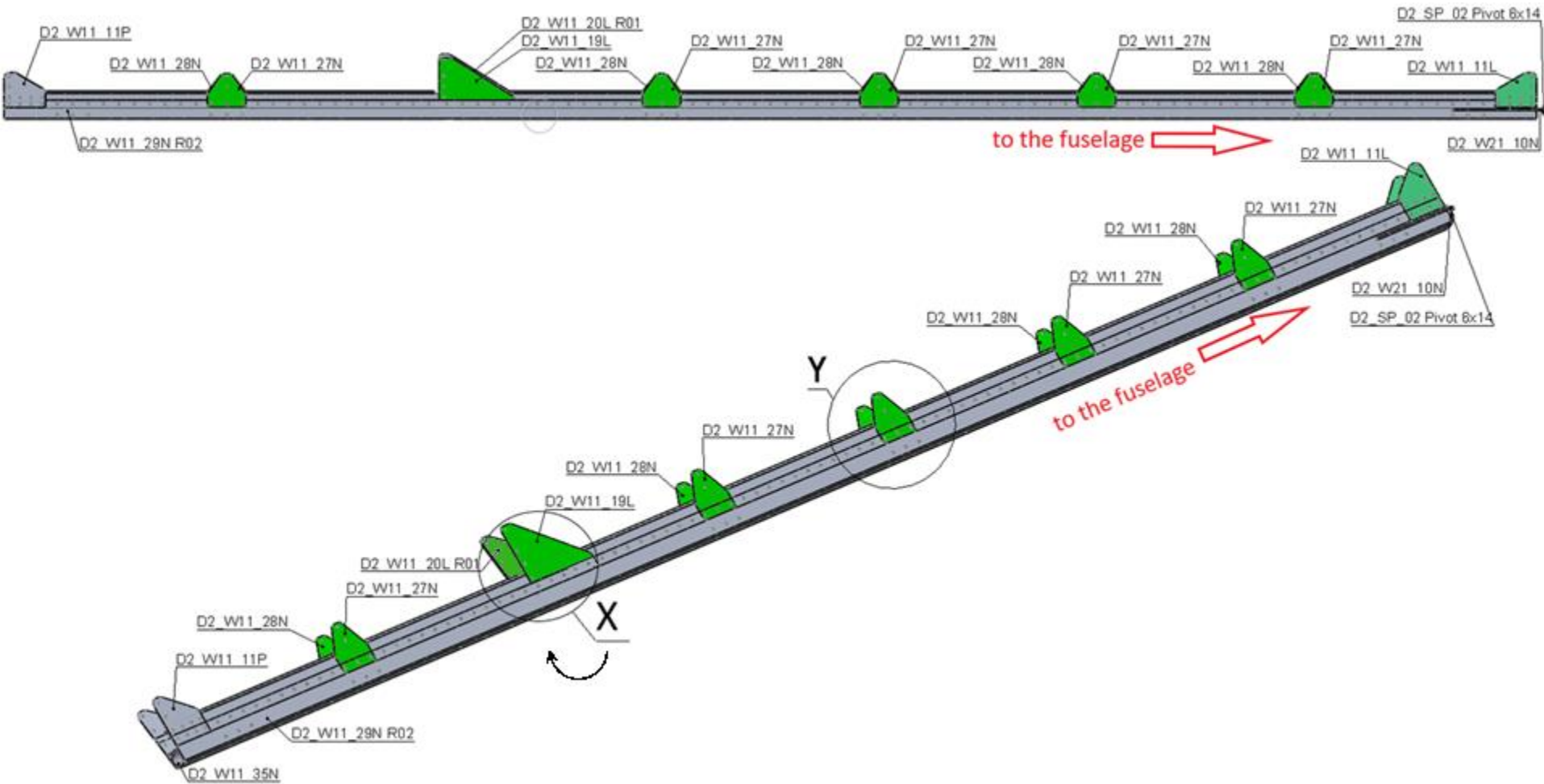
Step 37



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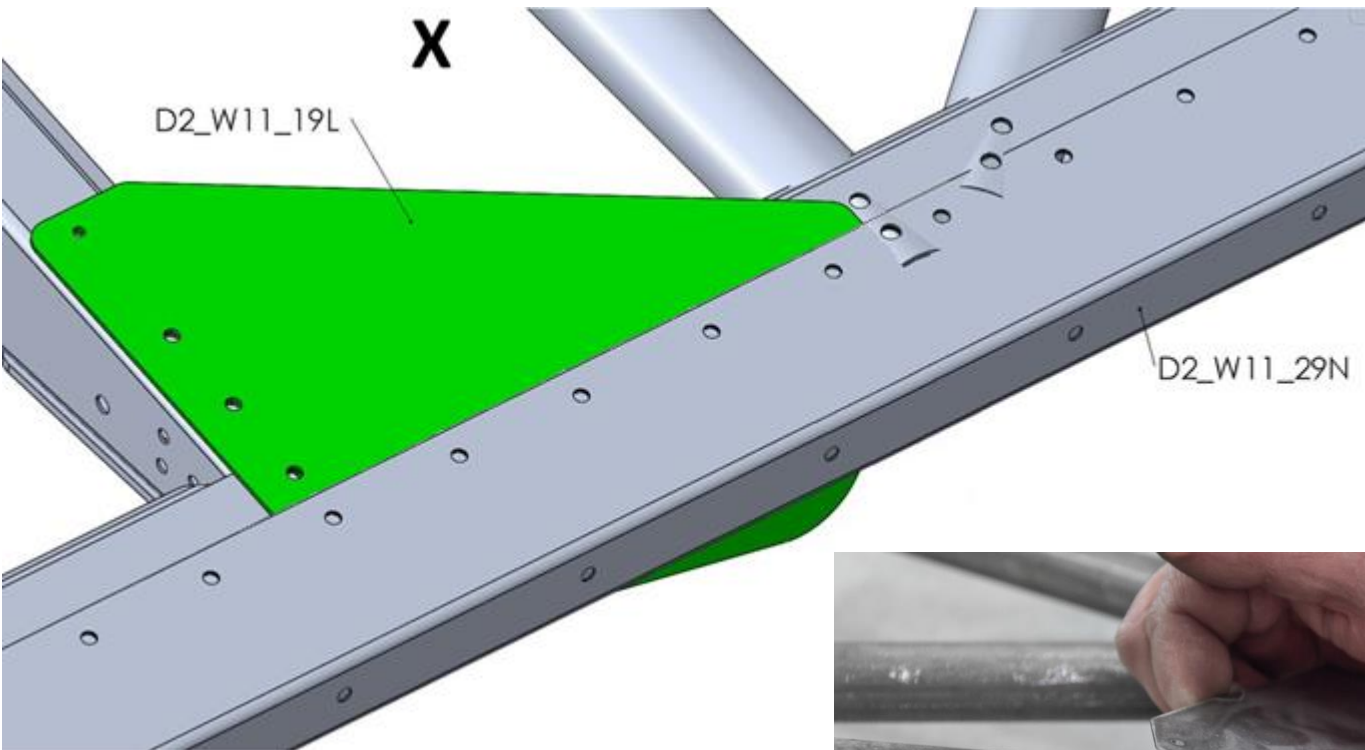
Step 38



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	80	108



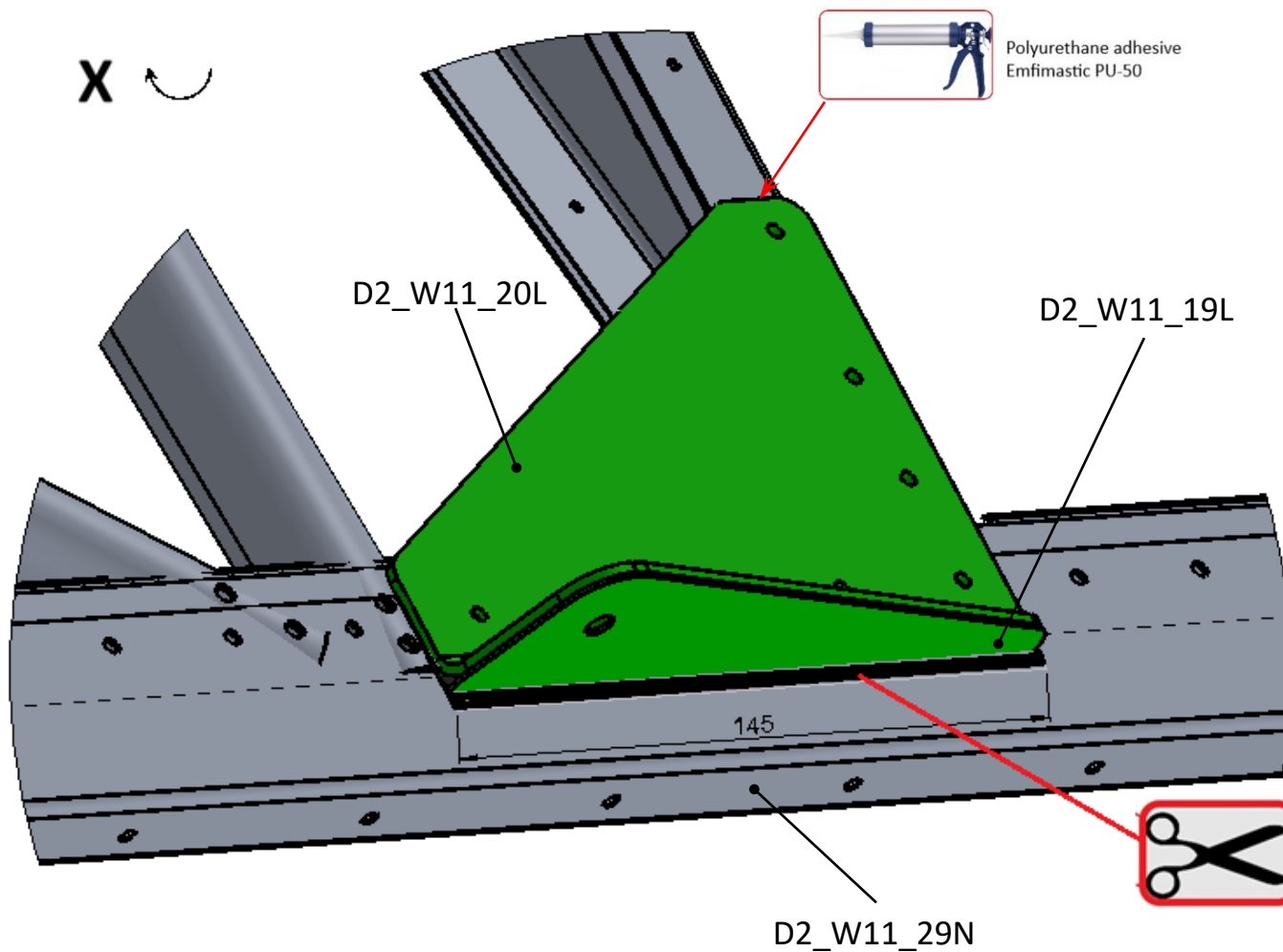
Step 38-X



Title	Document no.	Revision	Page	Pages
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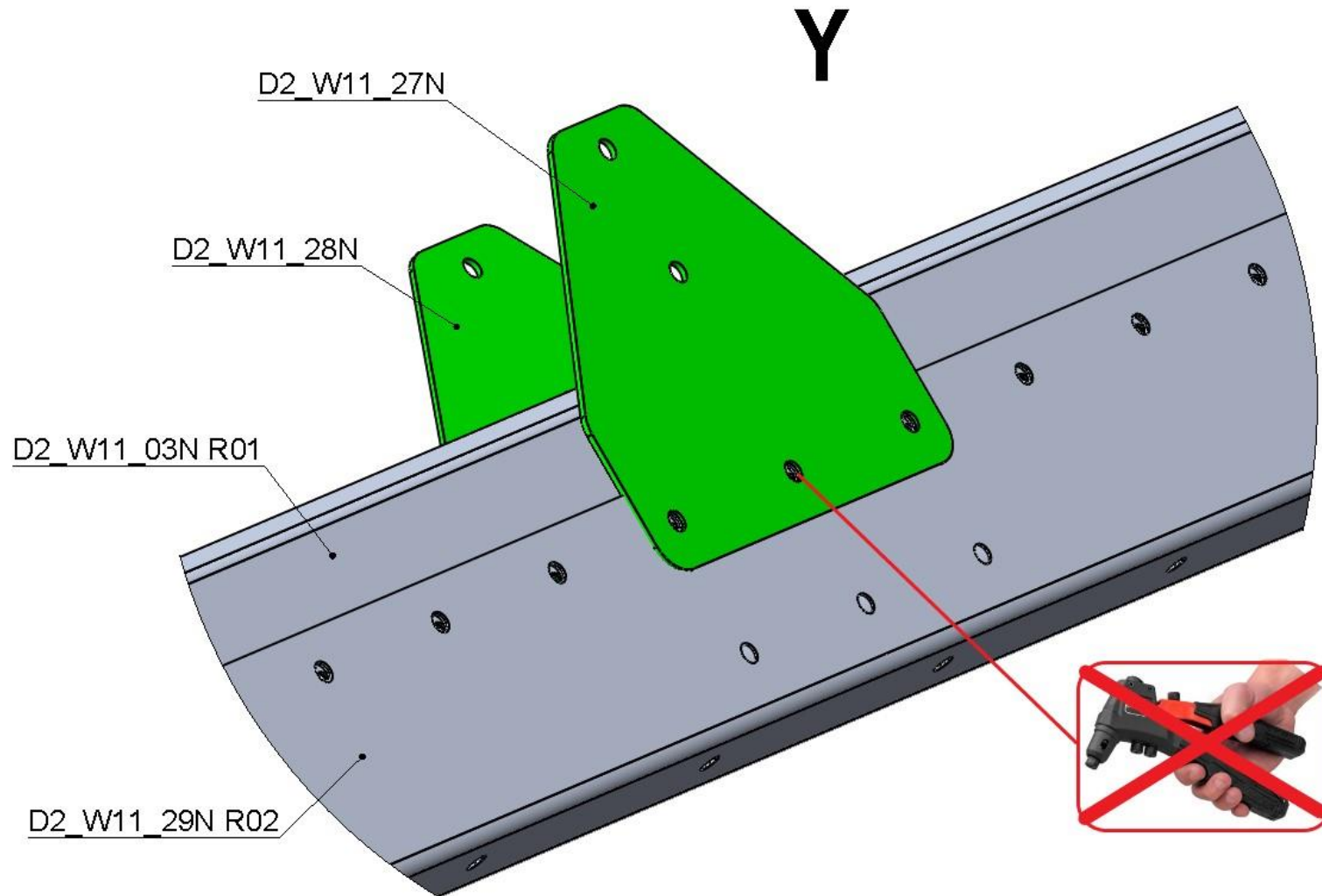
Step 38-X



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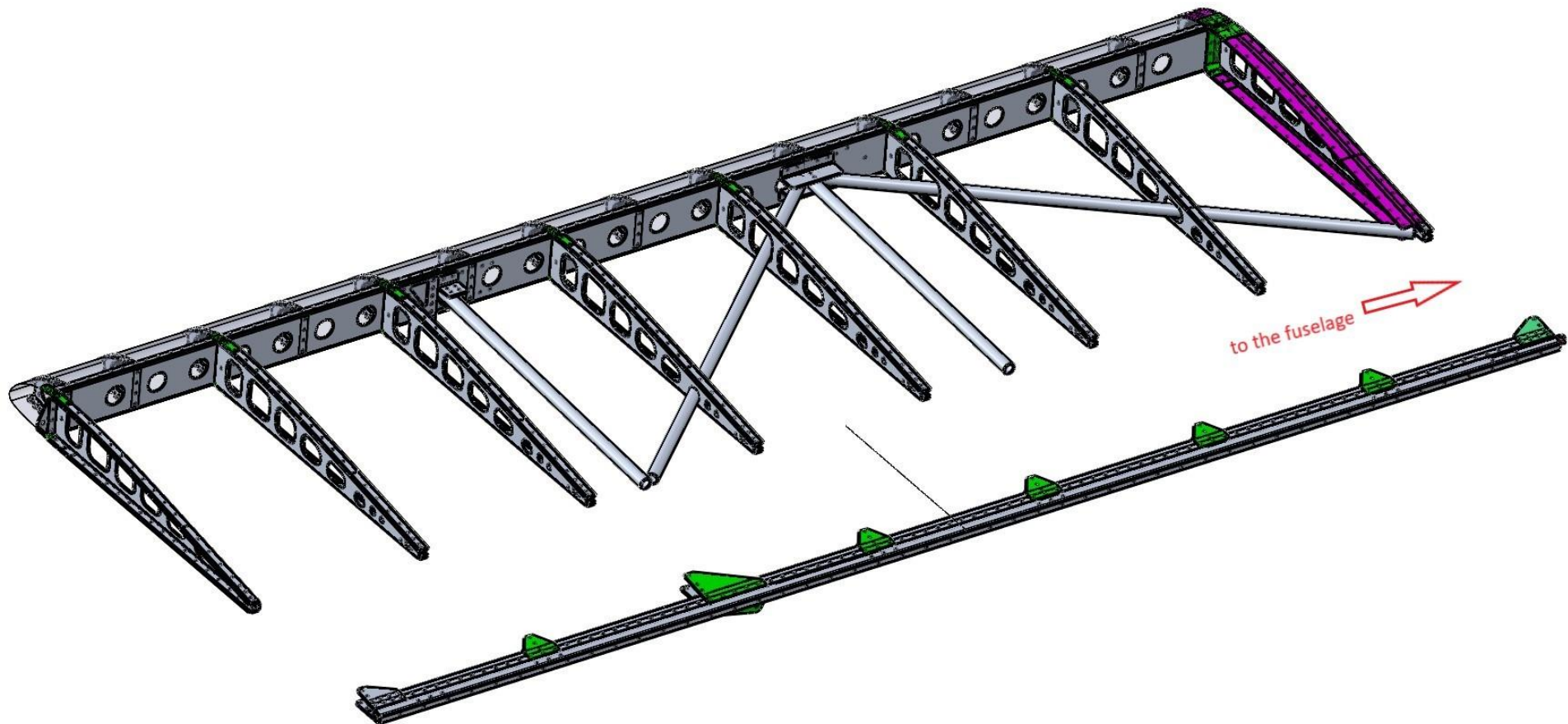


Step 38-Y



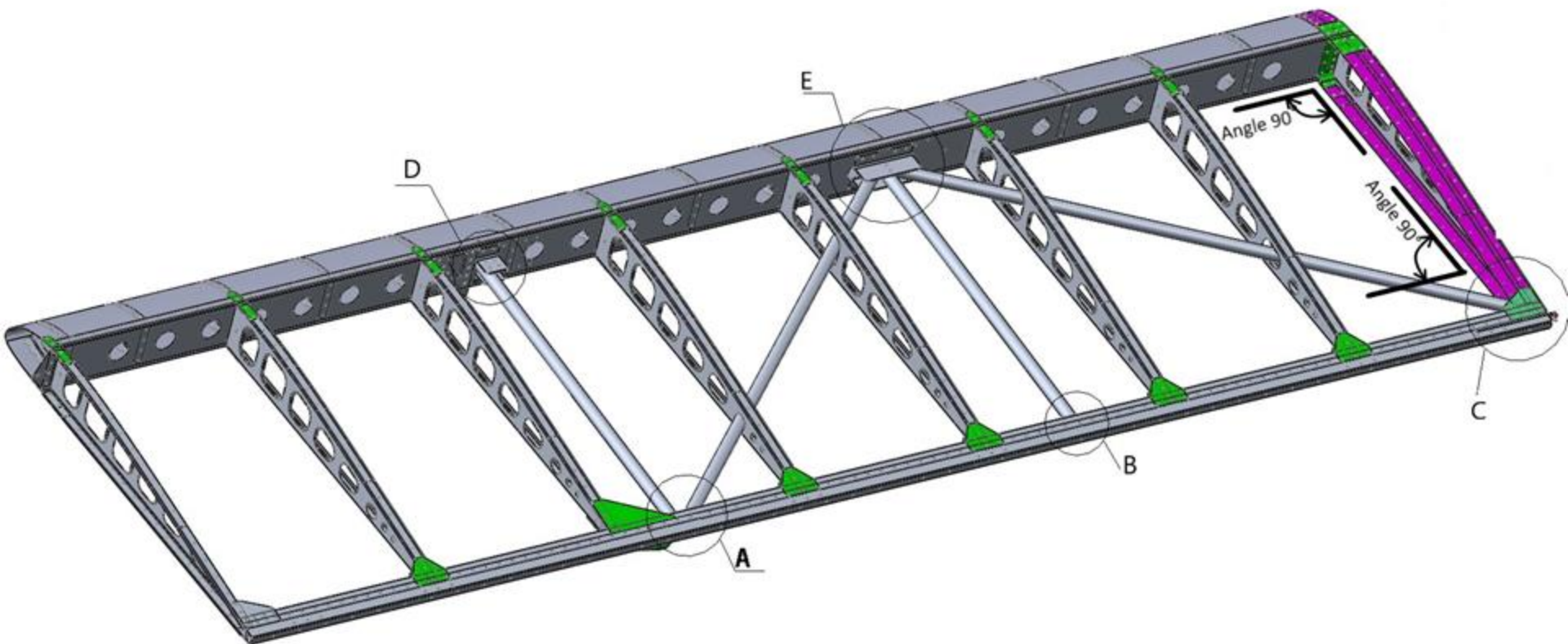
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Step 39



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 02	84	108

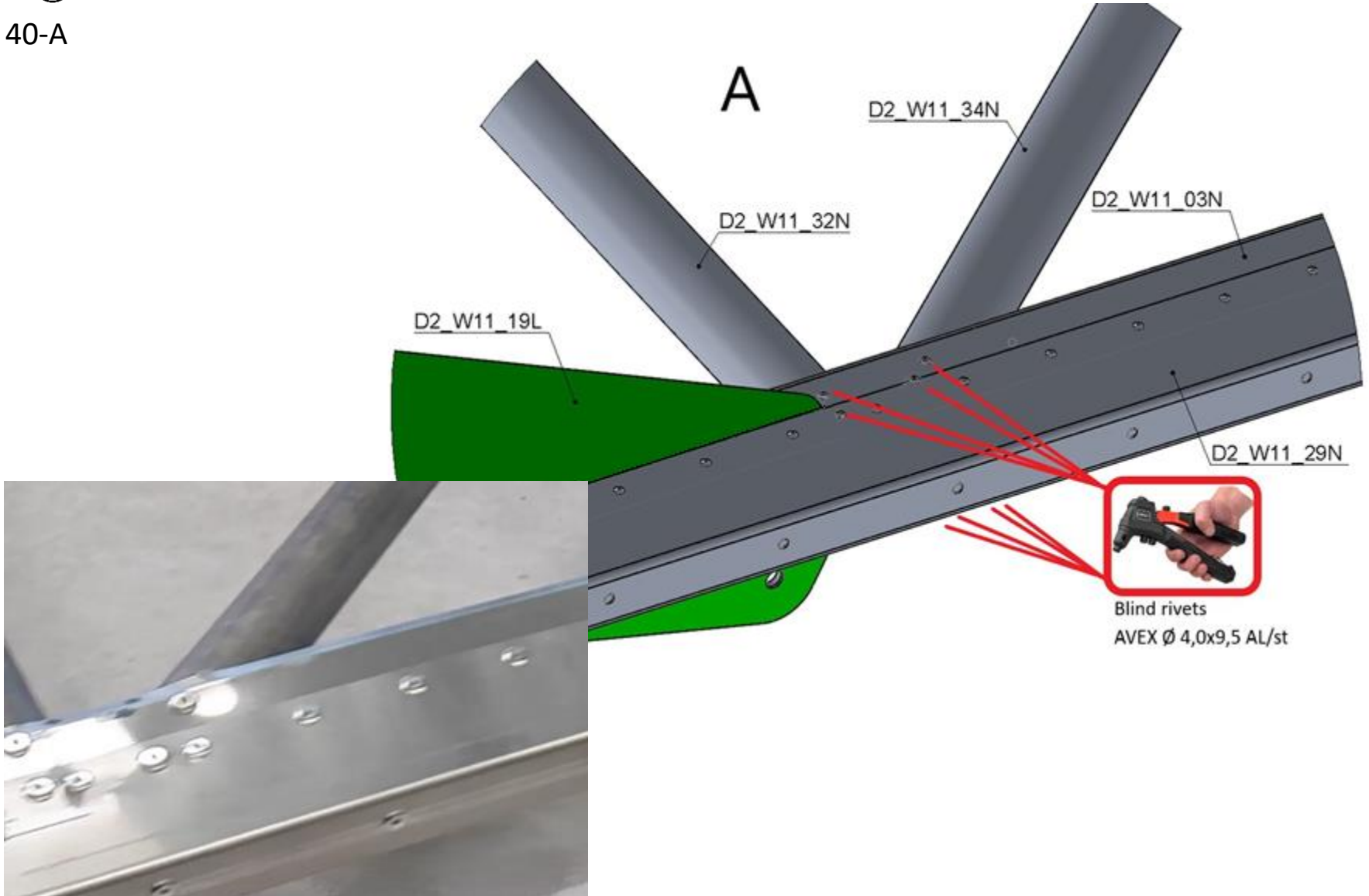
Step 40



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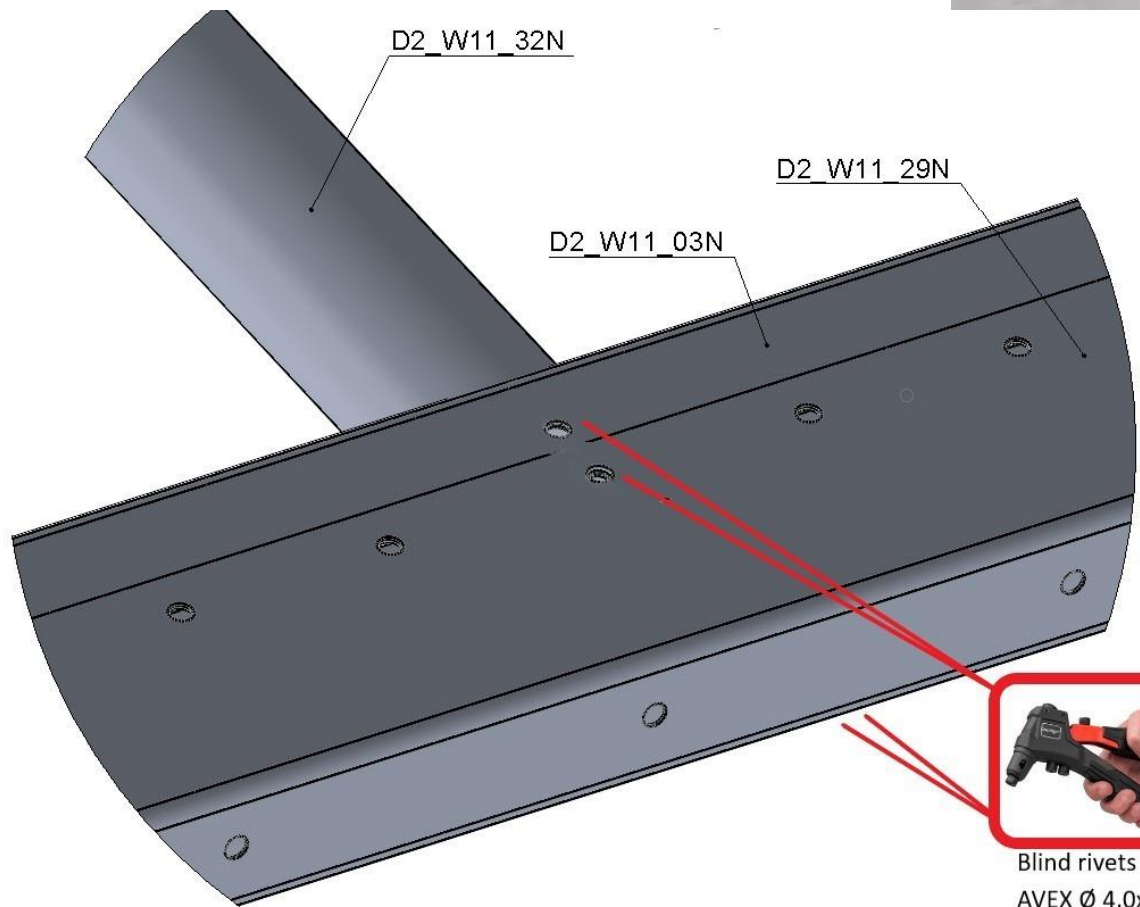
Step 40-A



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Step 40-B

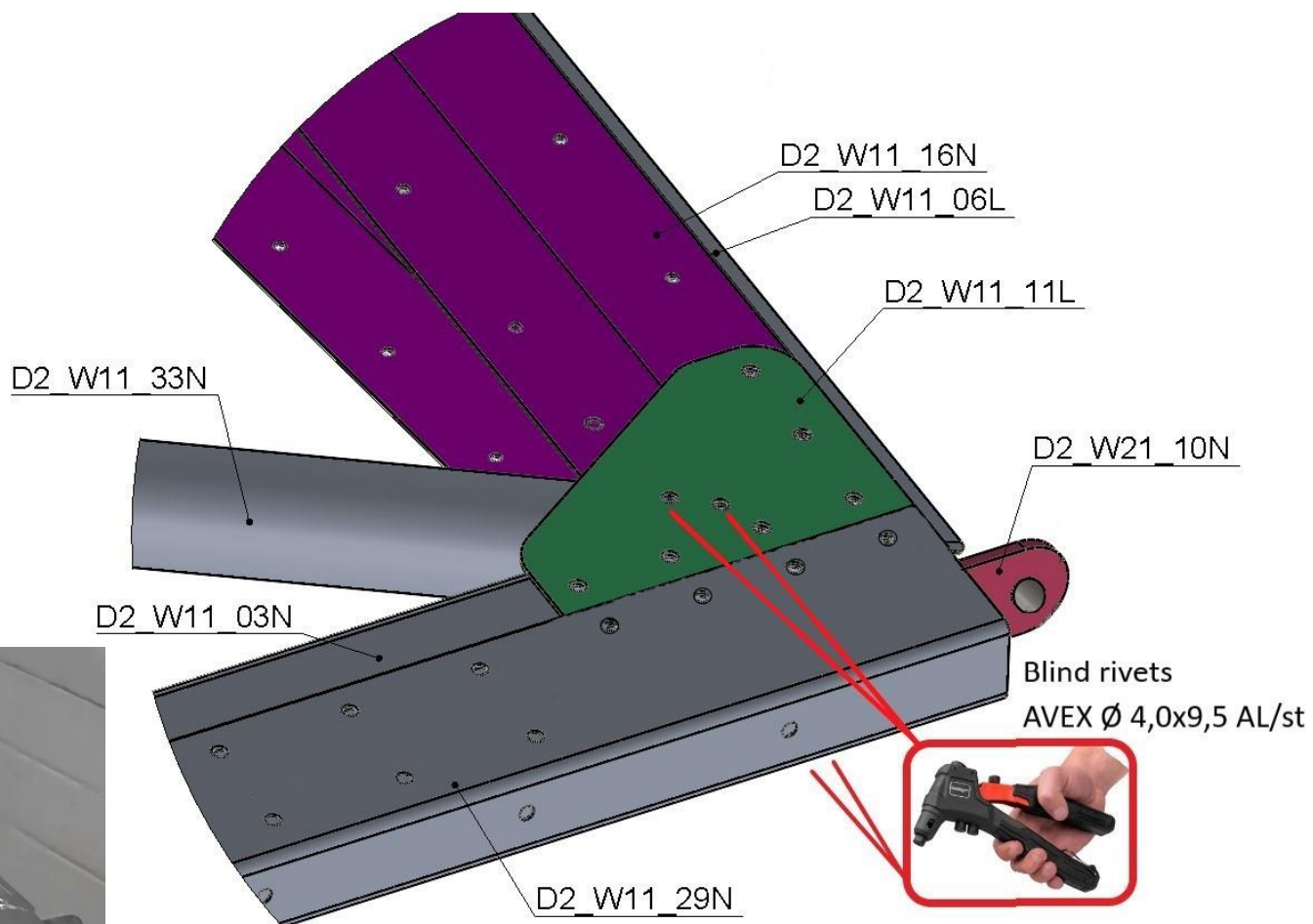


Blind rivets
AVEX Ø 4,0x9,5 AL/st

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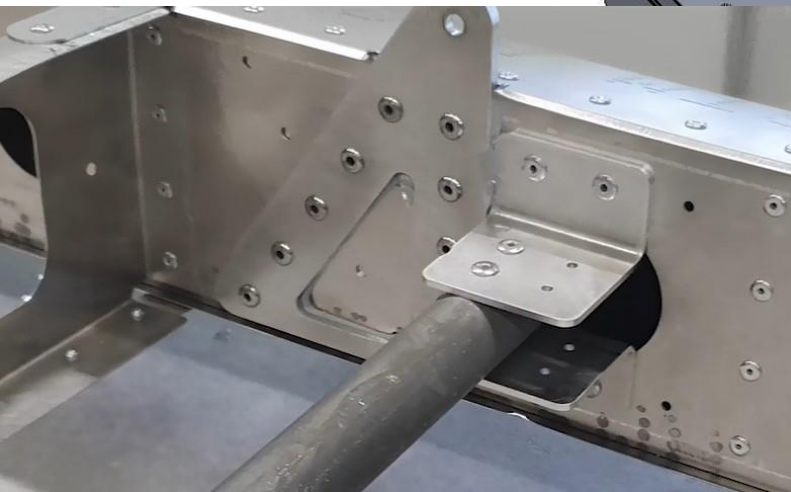
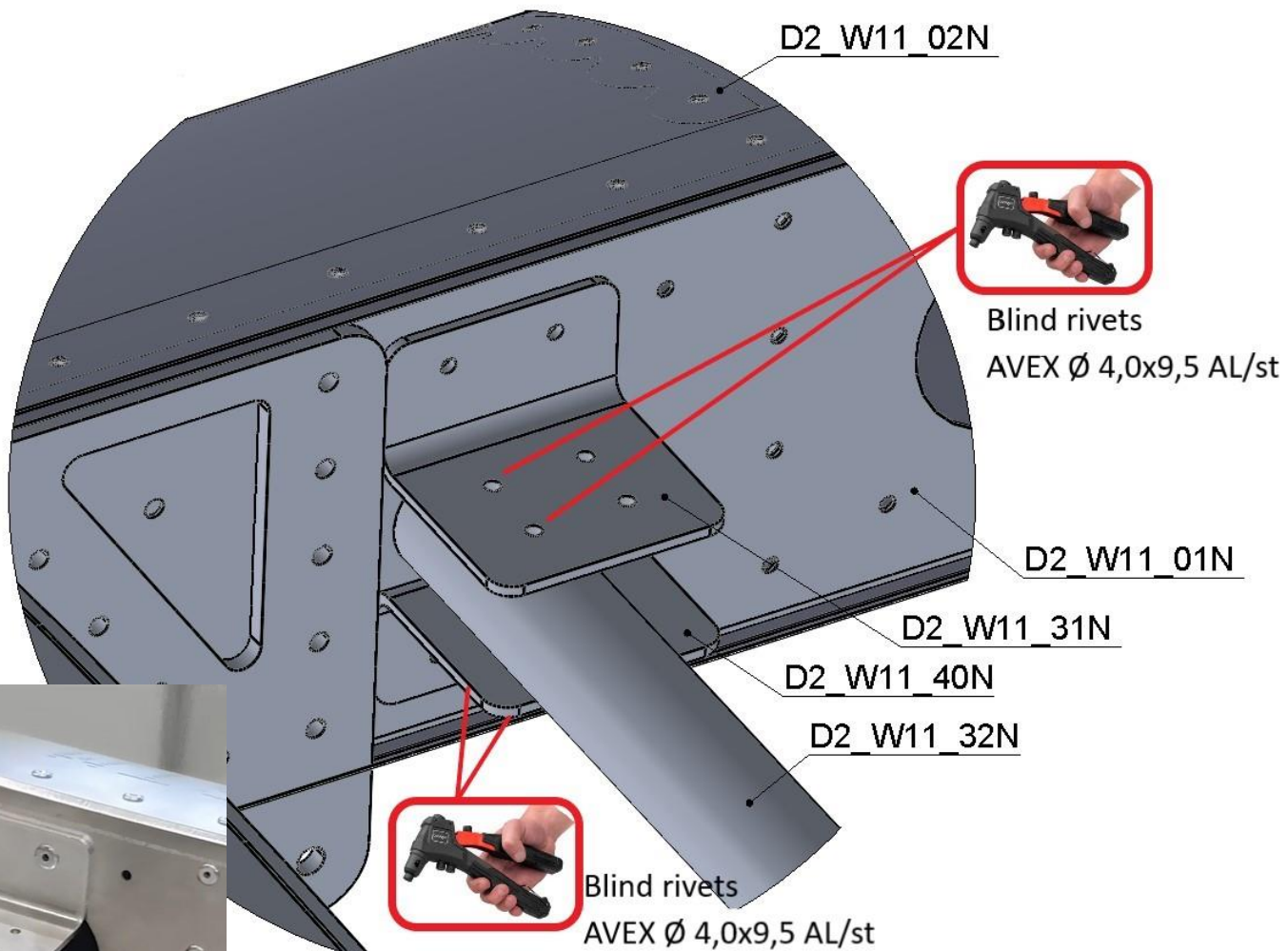
Step 40-C



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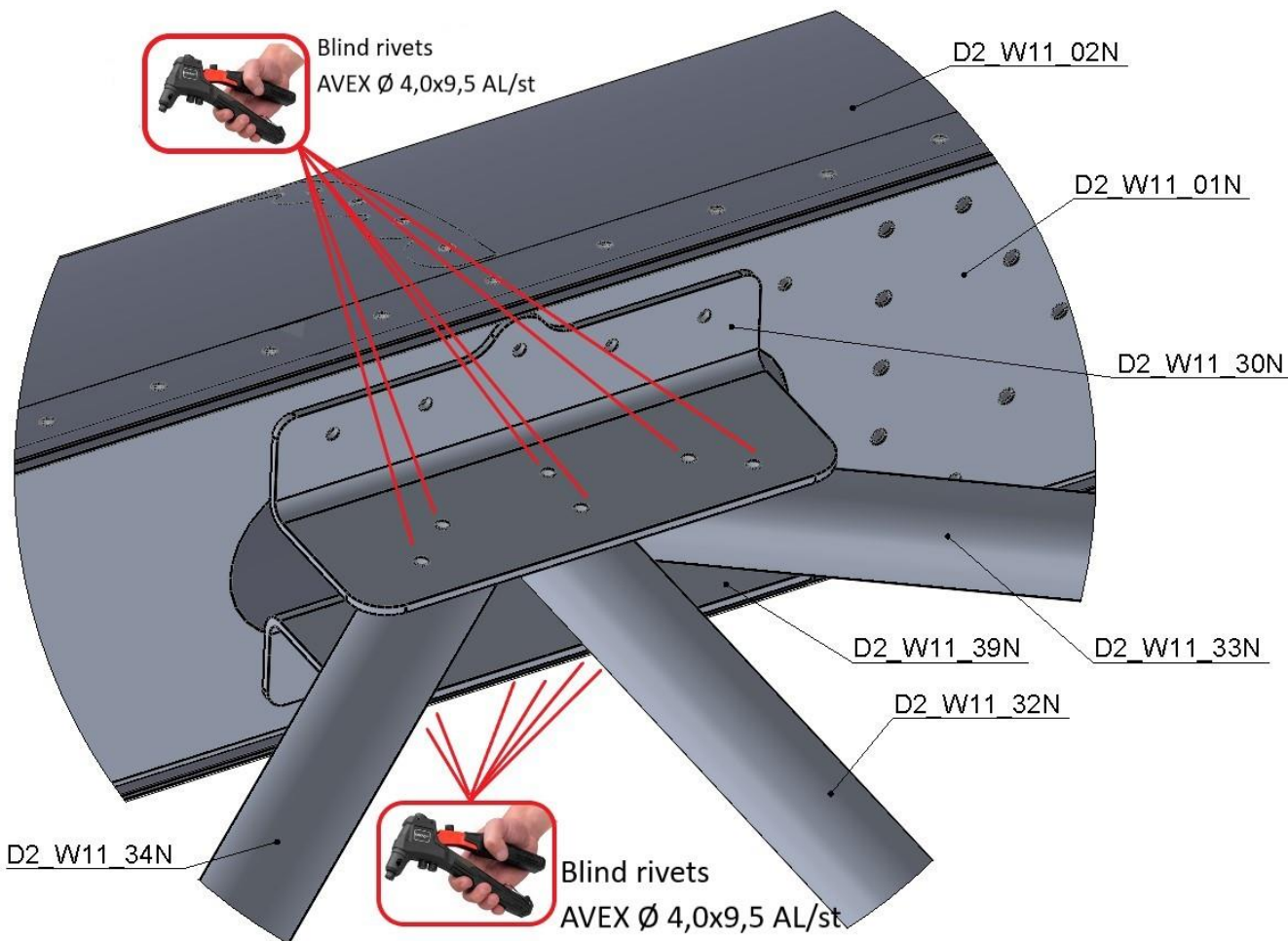
Step 40-D



Title	Document no.	Revision	Page	Pages
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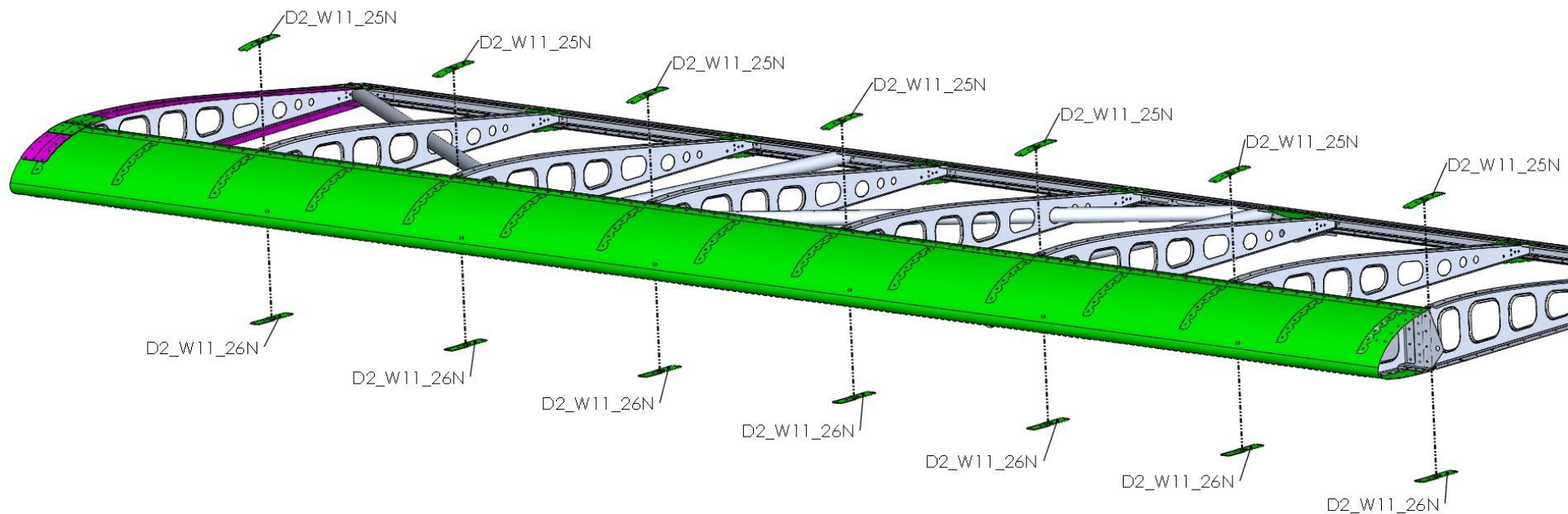
Step 40-E



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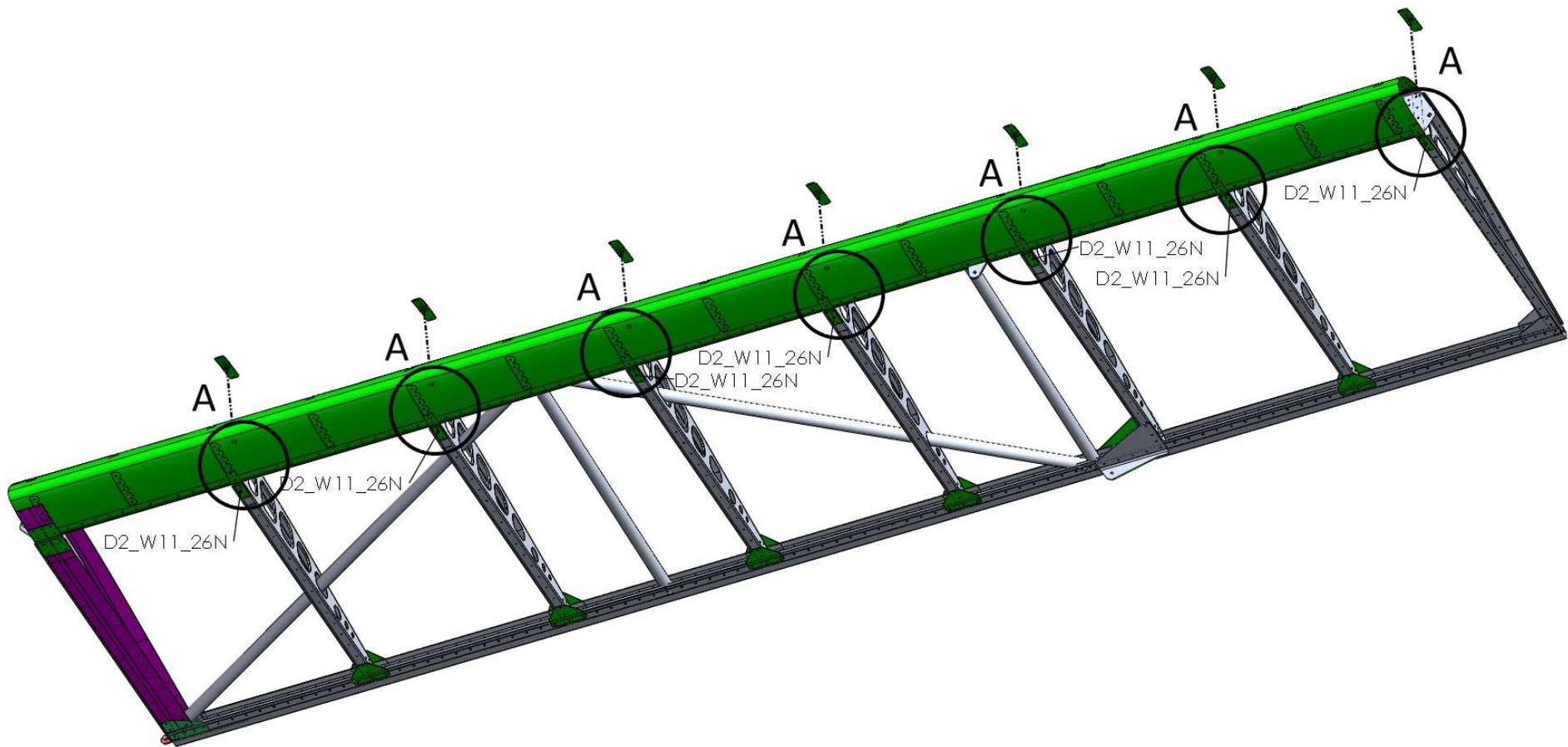
Step 41



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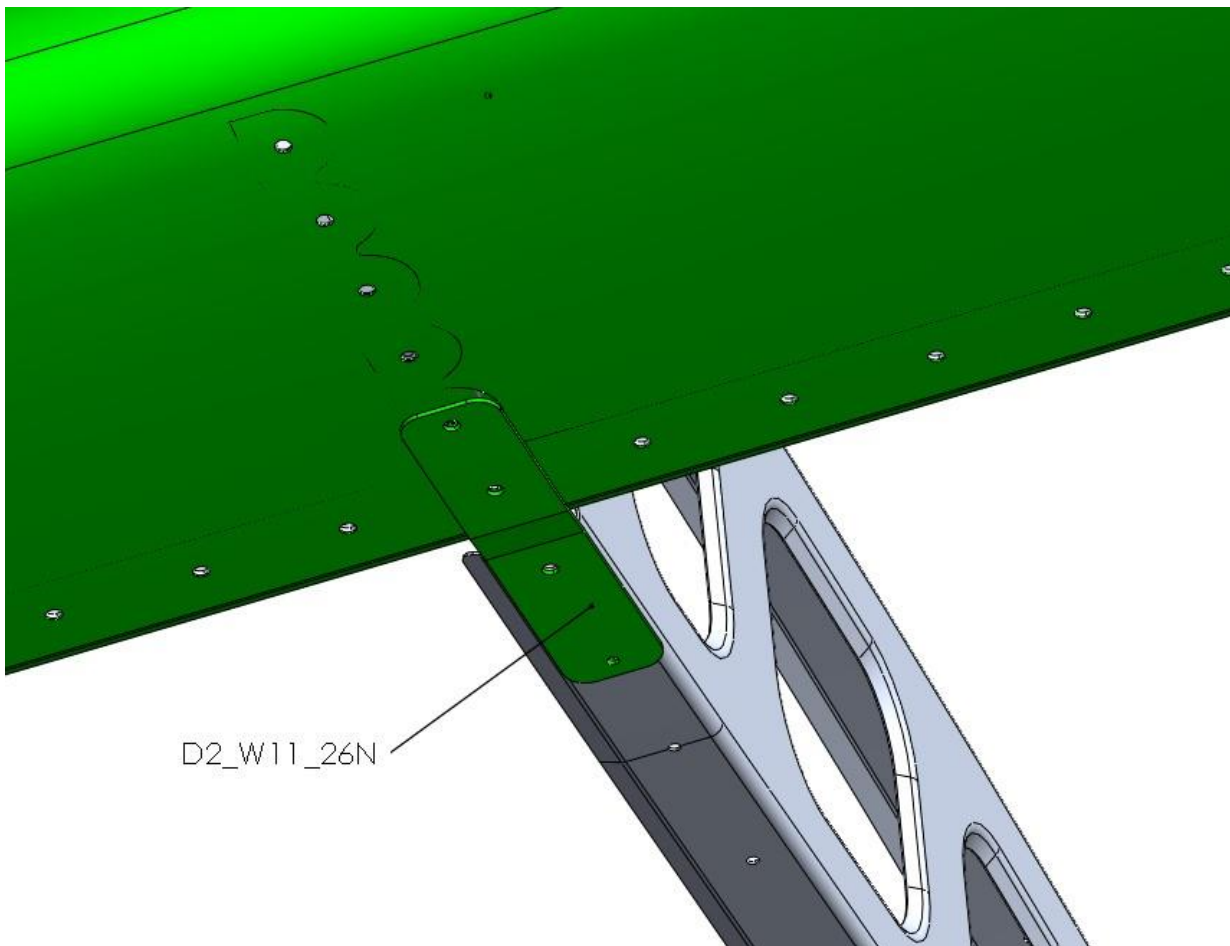
Step 42



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Wing assembly manual	D2_W0_00	Rev. 02	92	108



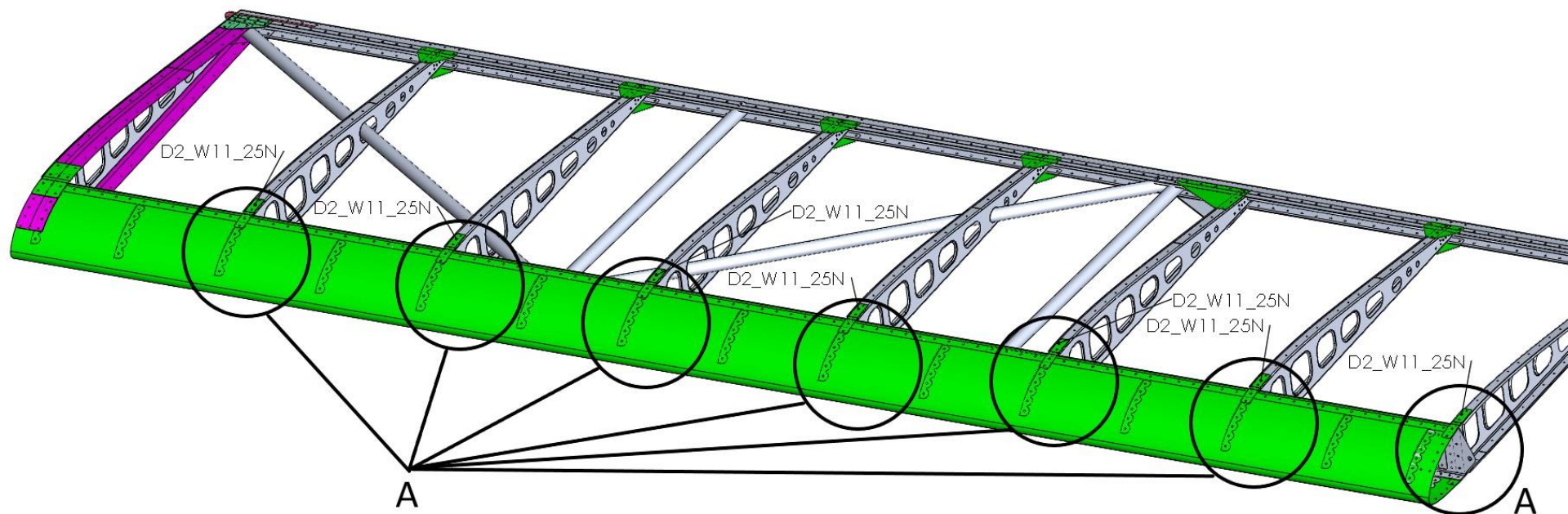
Step 42-A



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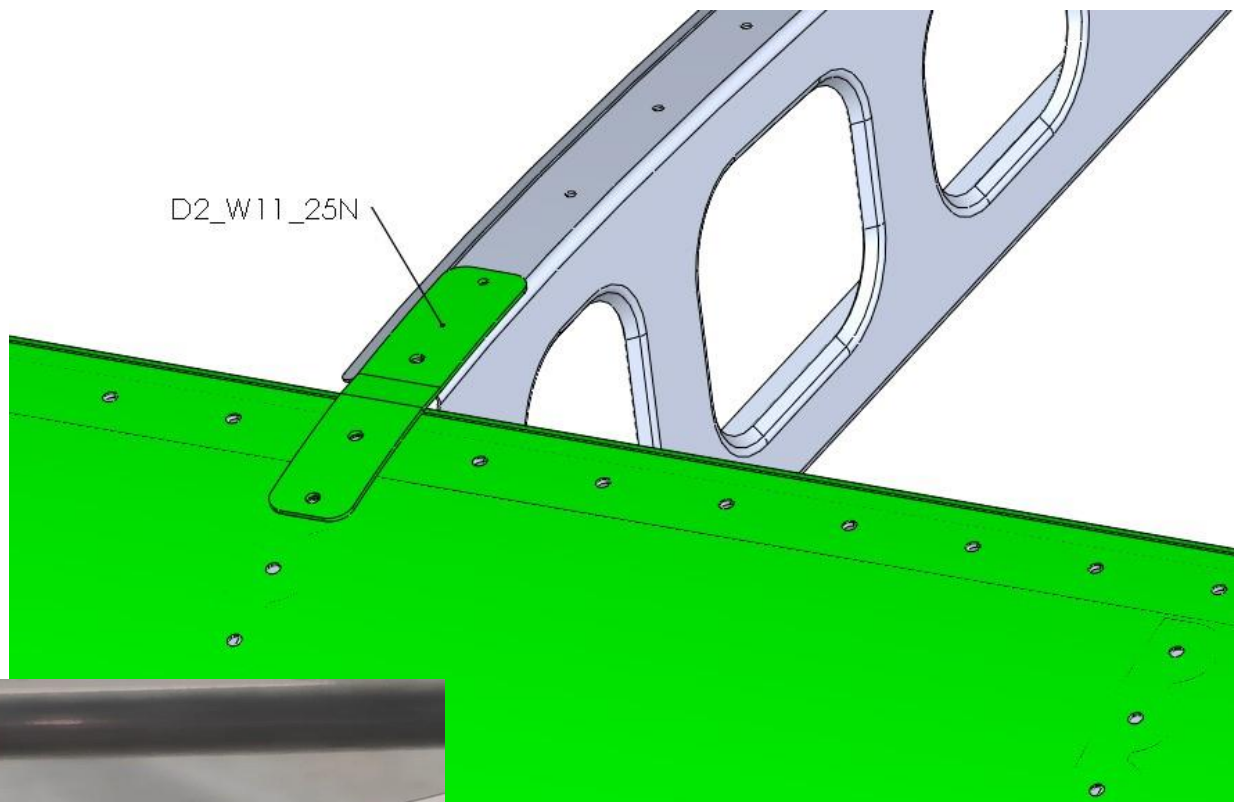
Step 43



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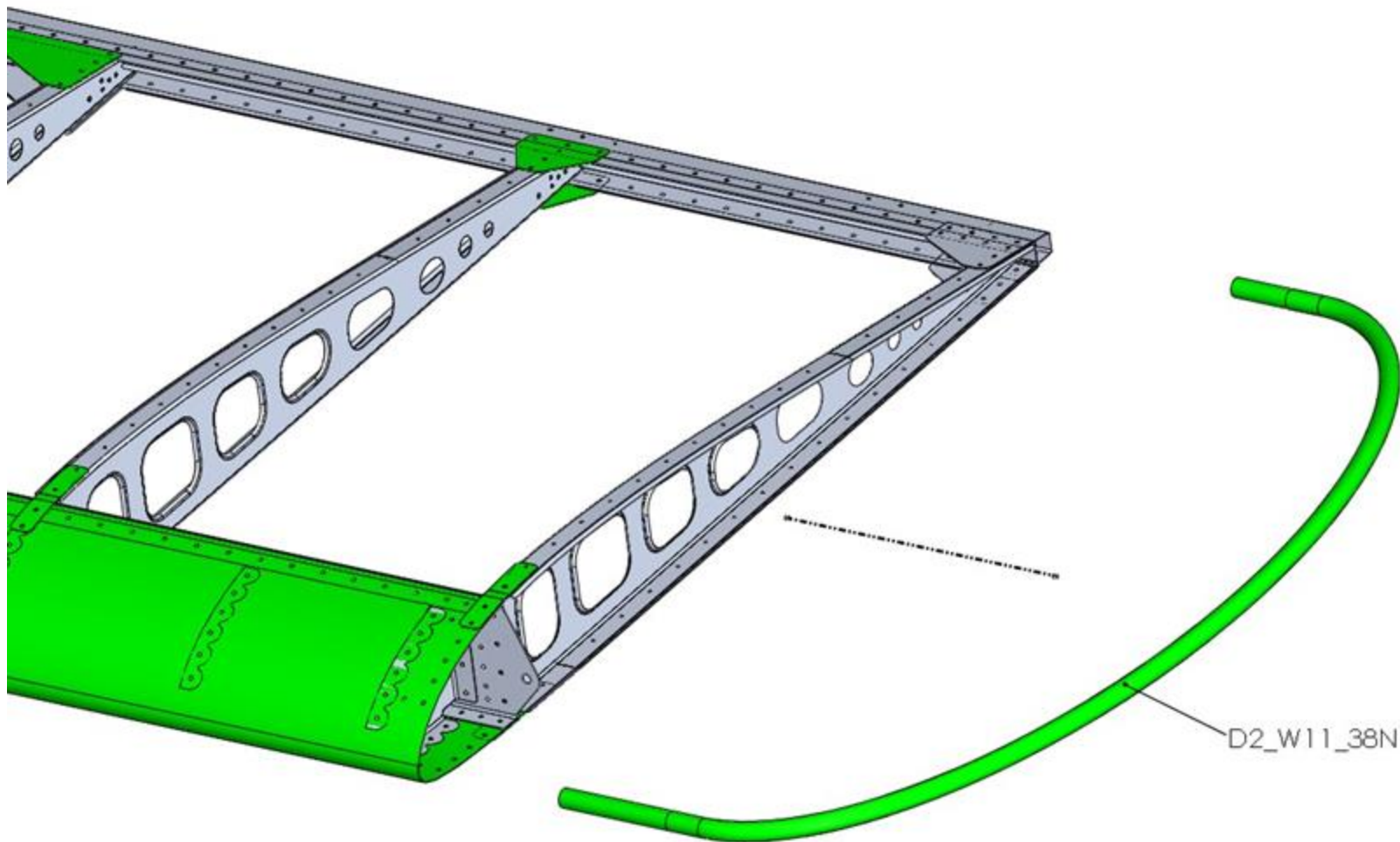
Step 43-A



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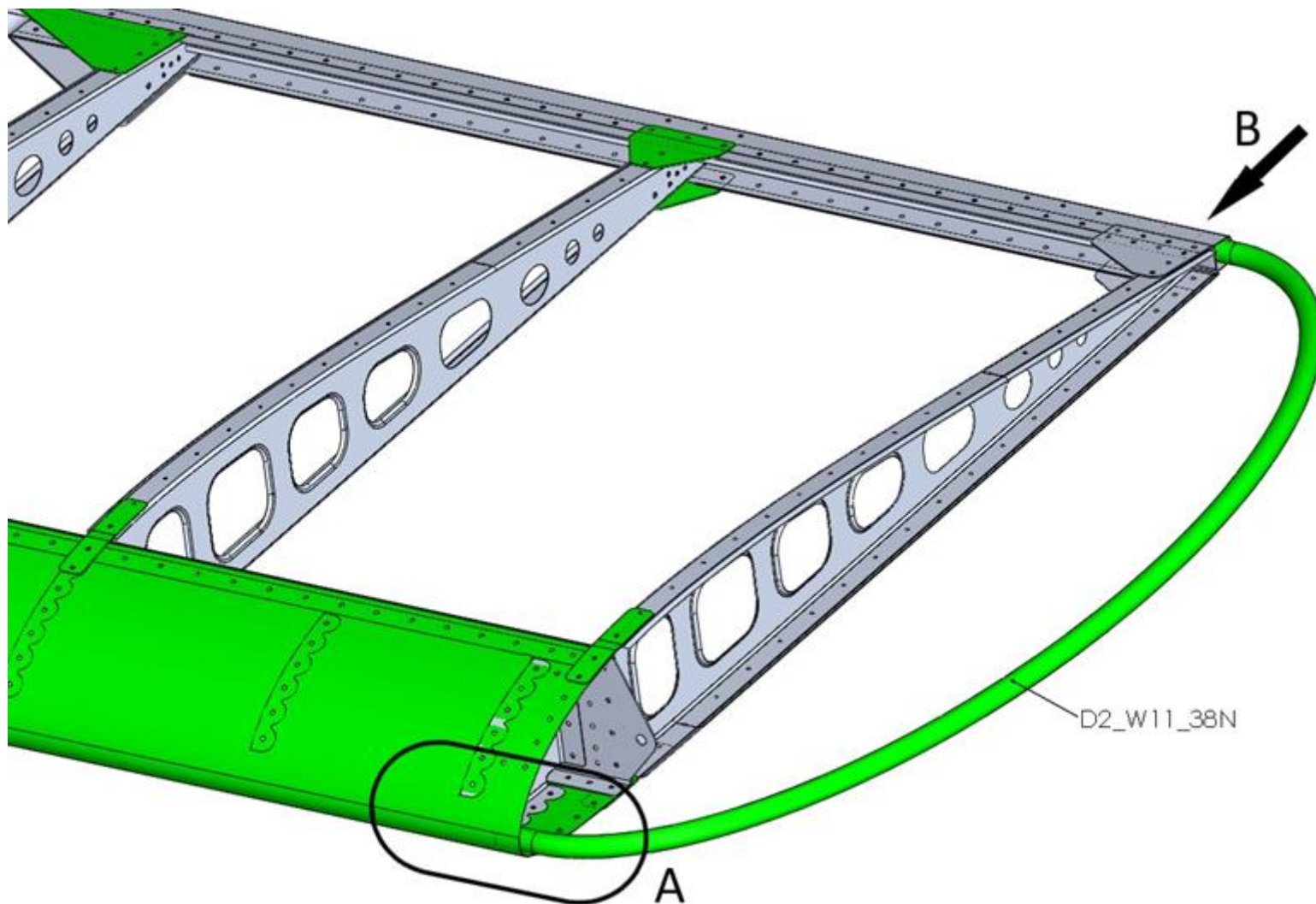
Step 44



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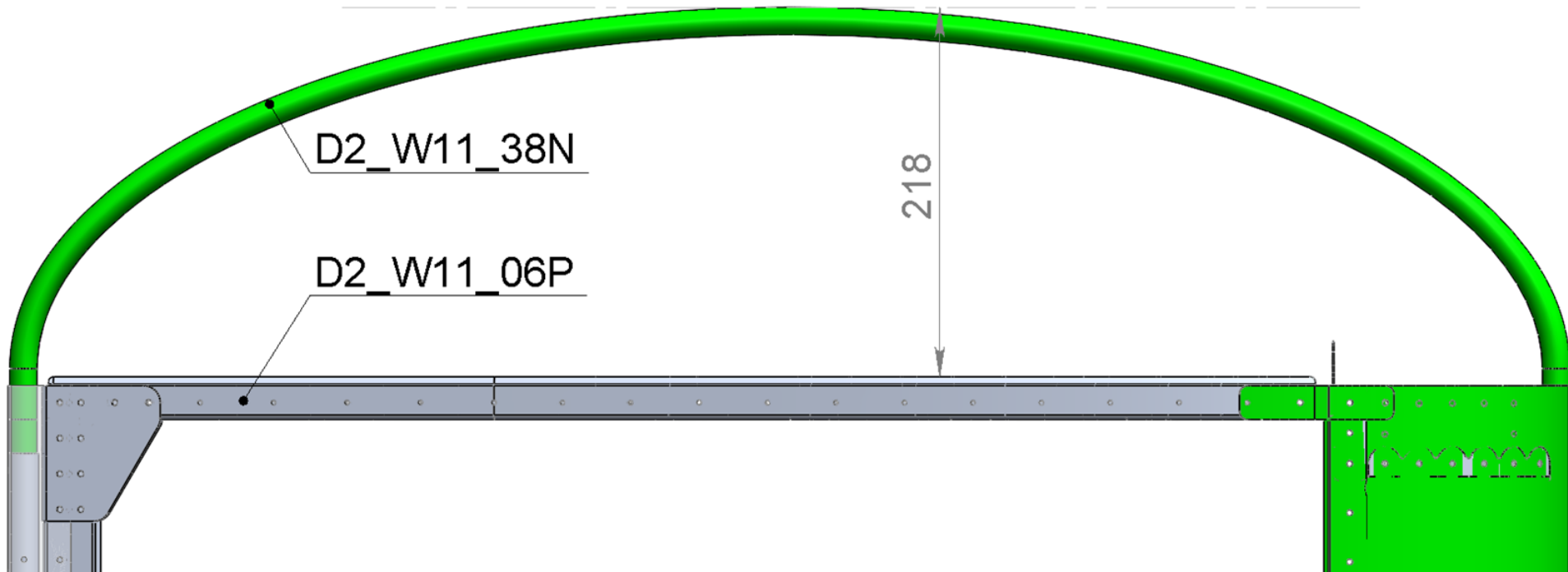
Step 45



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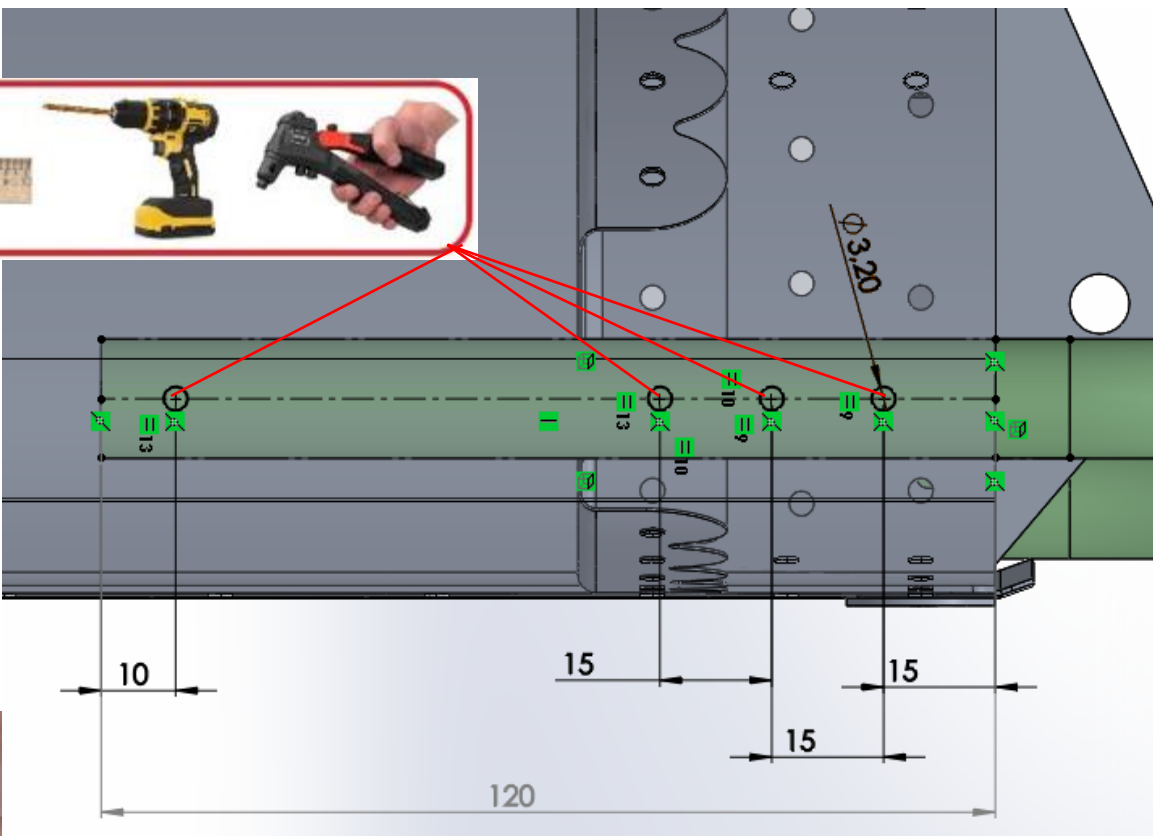
Step 45



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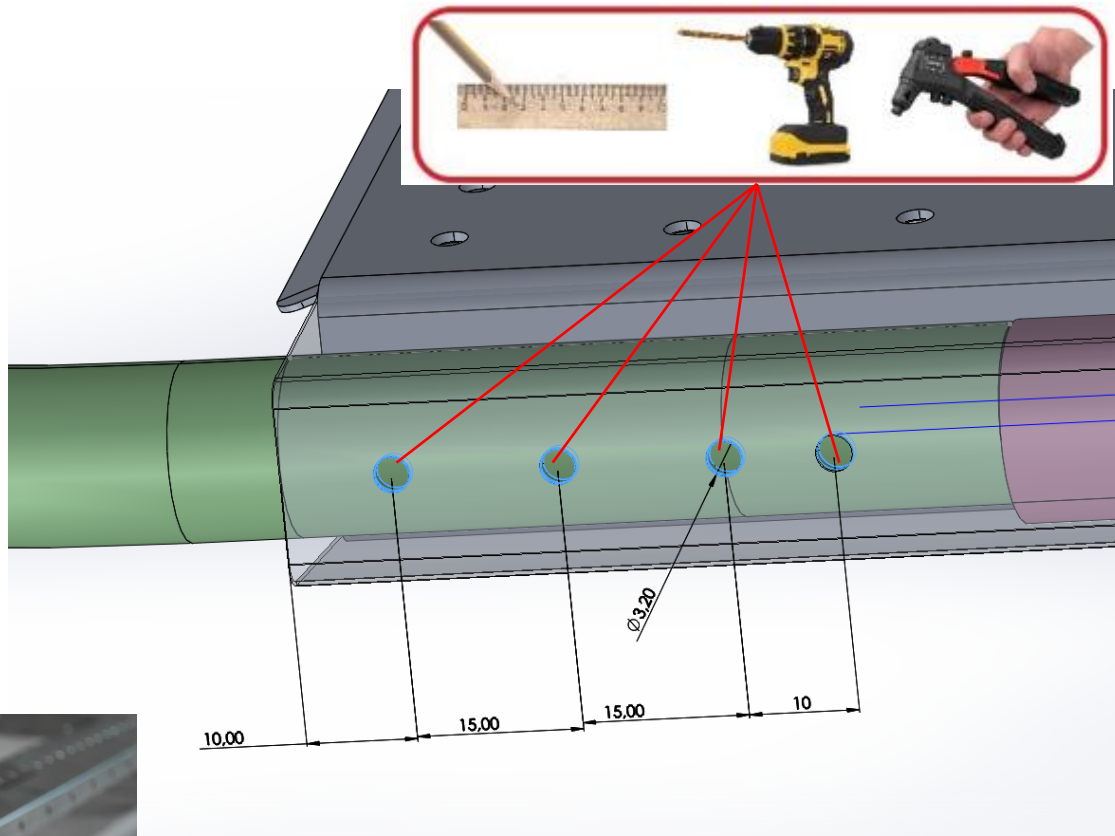
Step 45-A



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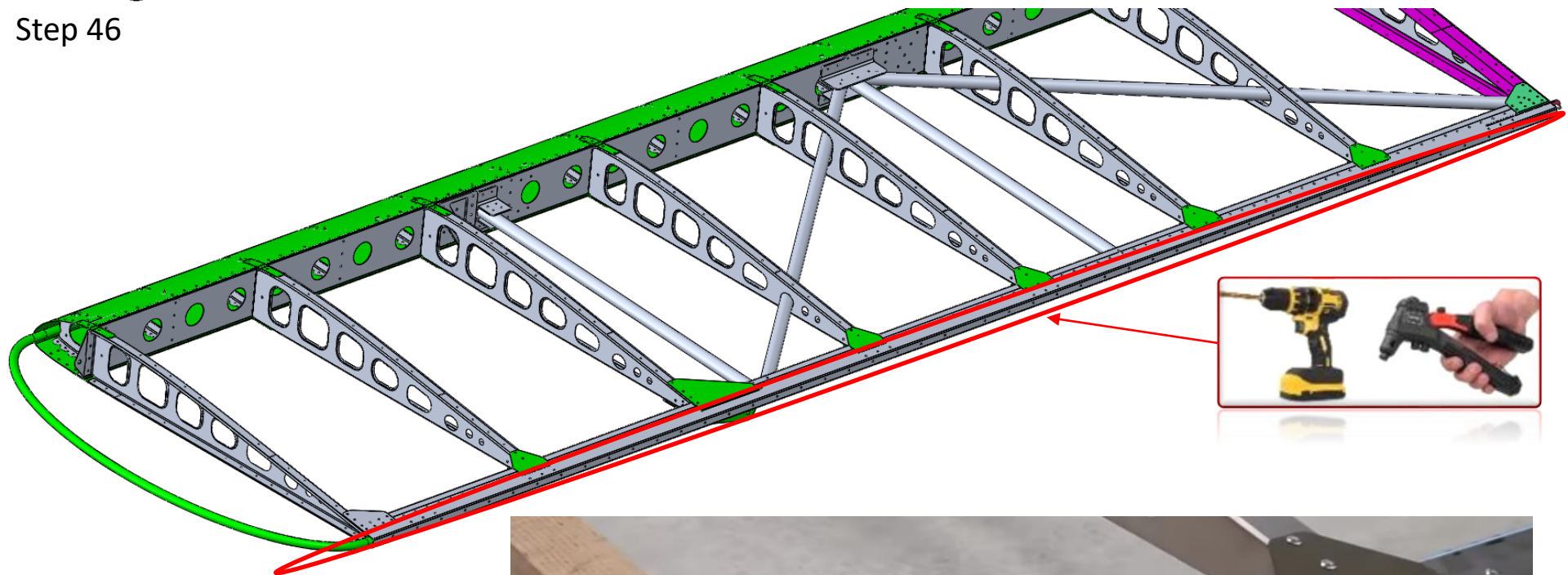
Step 45-B



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Step 46

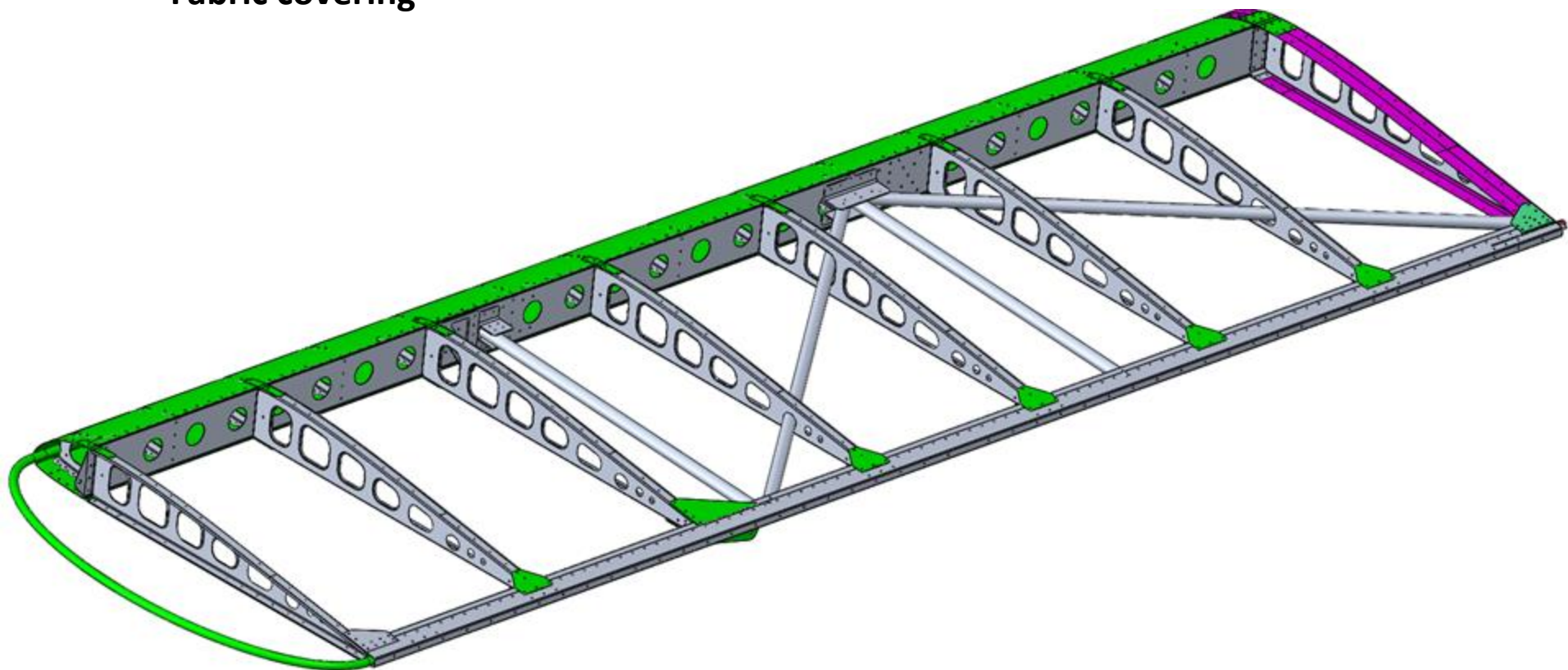


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Step 47

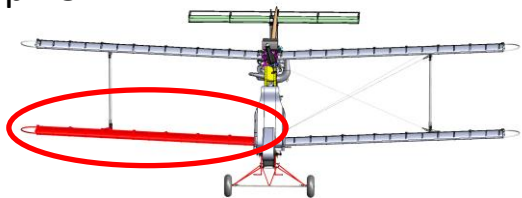
Fabric covering



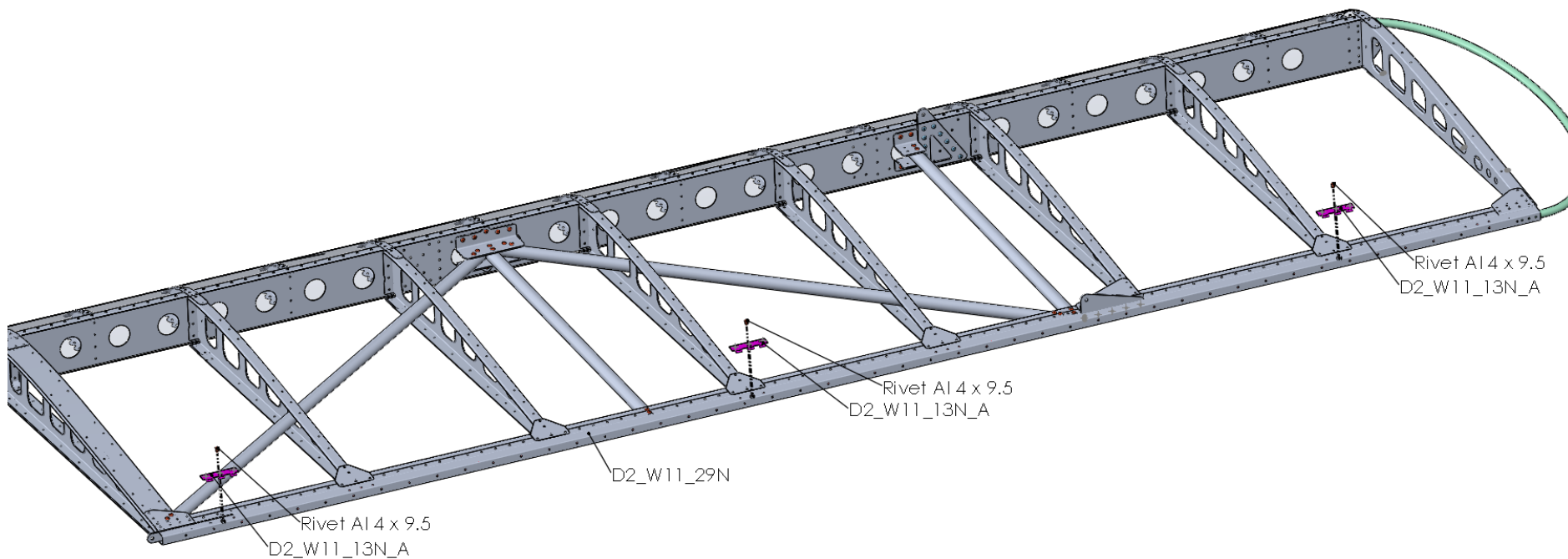
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Step 48P



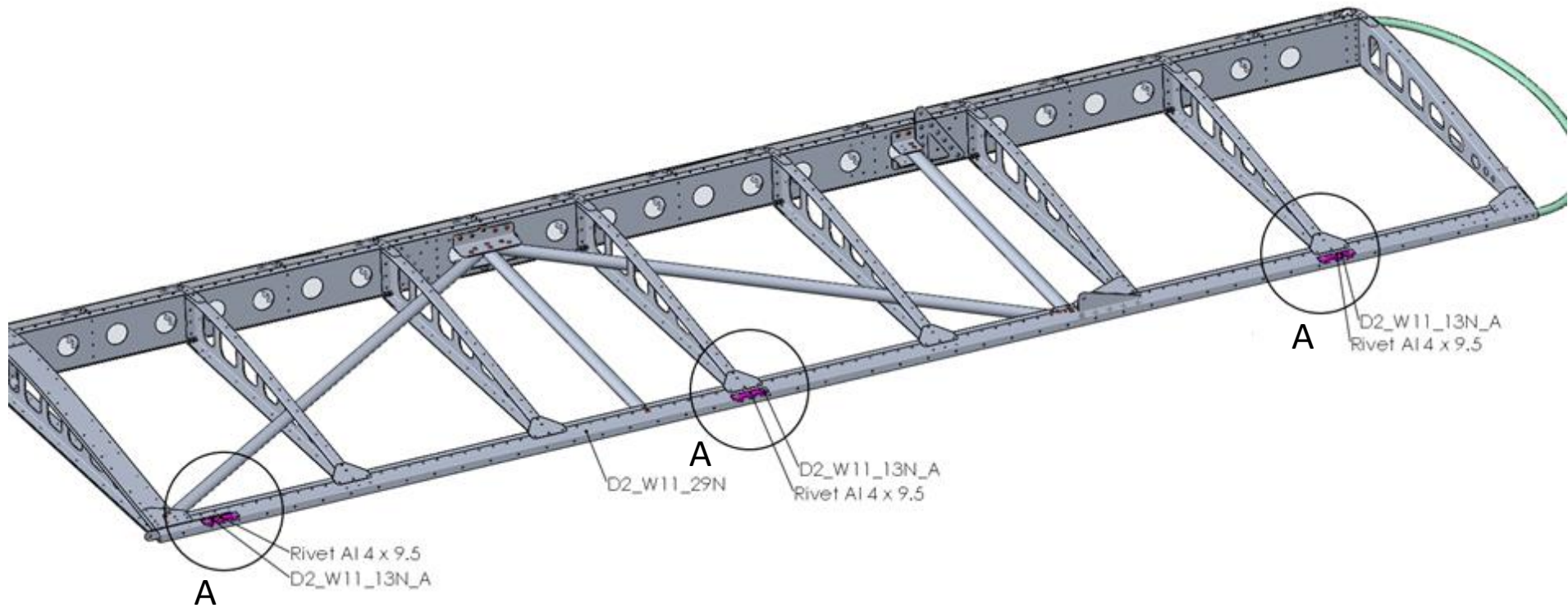
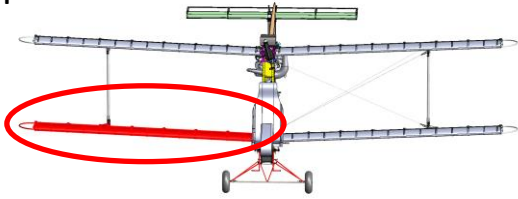
D2_W11_13N-A	3x
Rivet AVEX 3,2x7,9 Al/St	6x
Rivet AVEX 4x9,5 Al/St	3x



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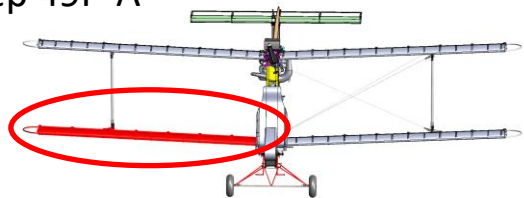
Step 49P



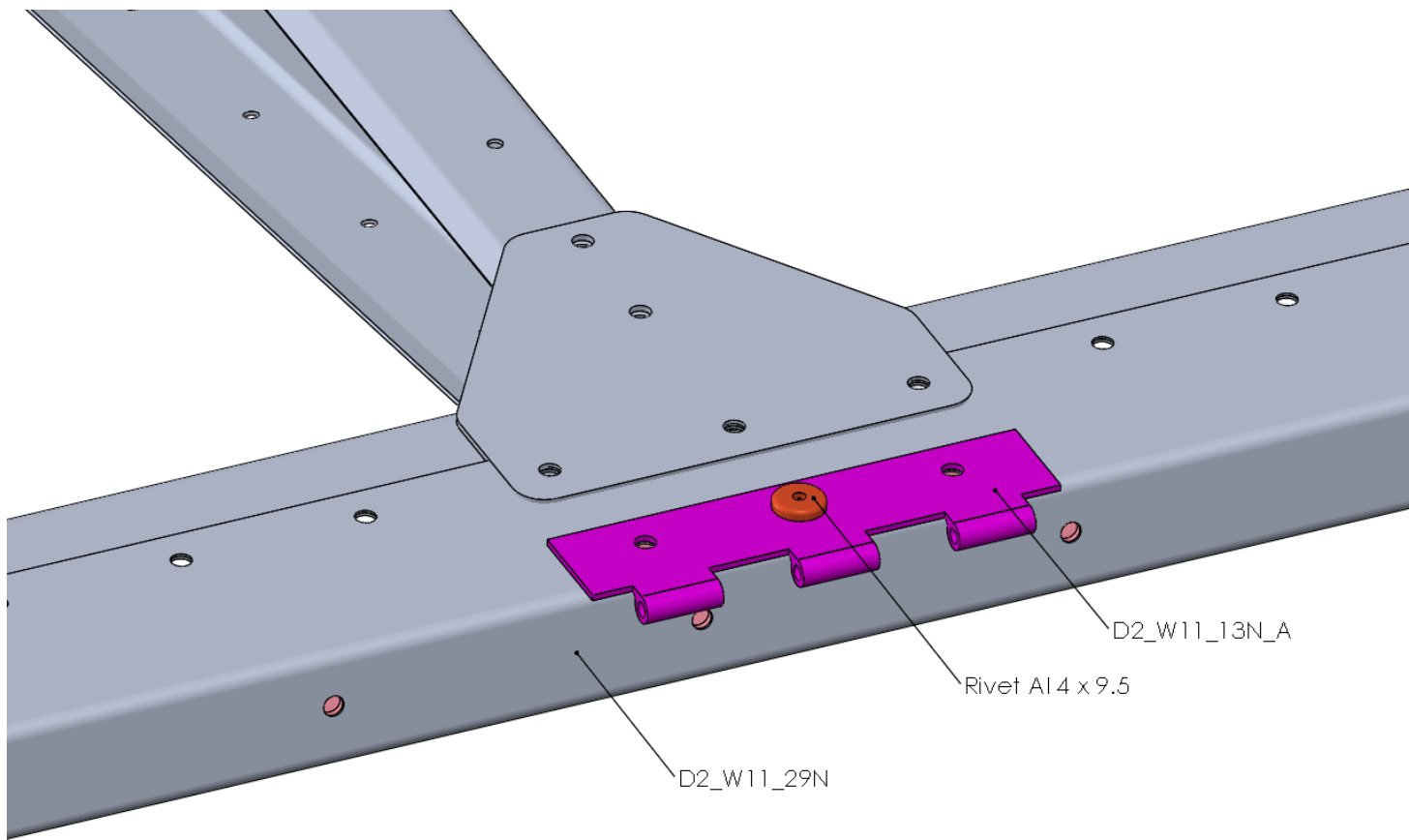
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Step 49P-A



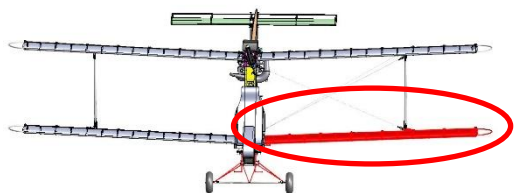
A



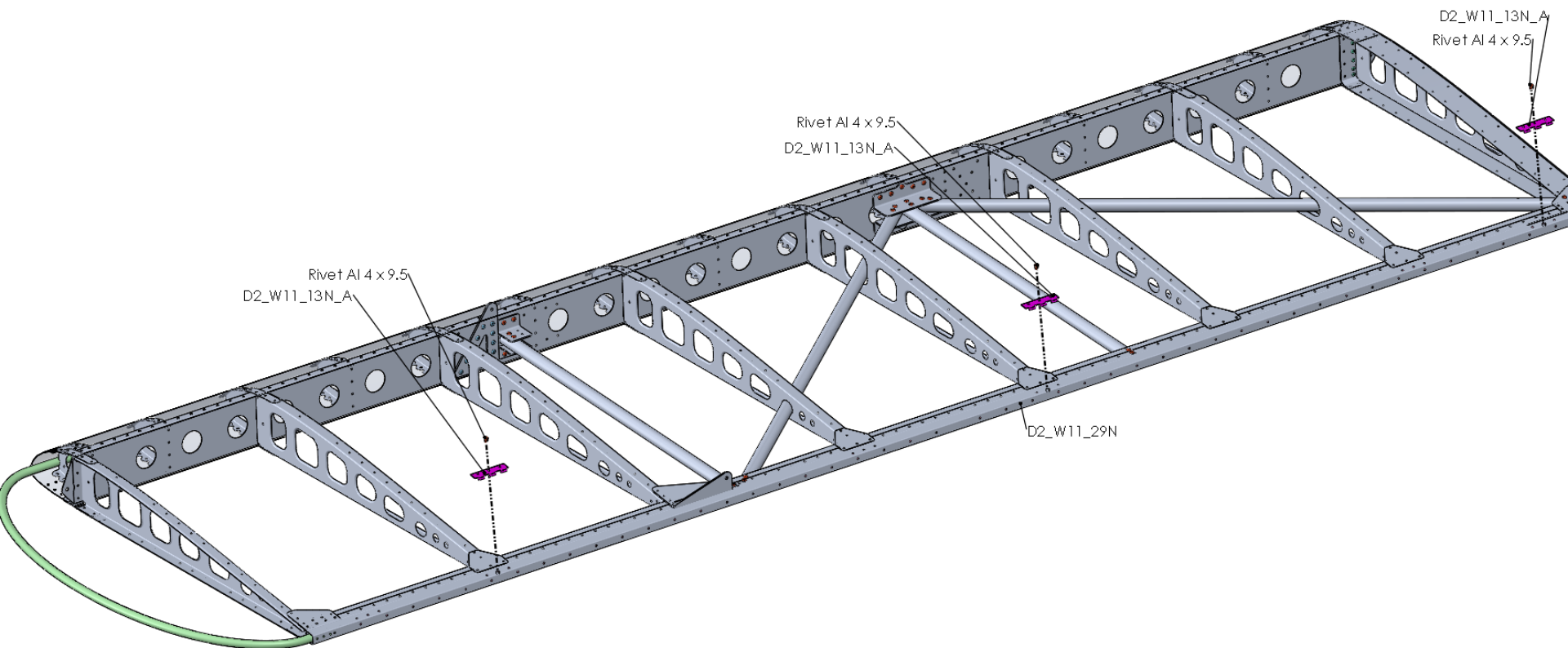
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Step 50L



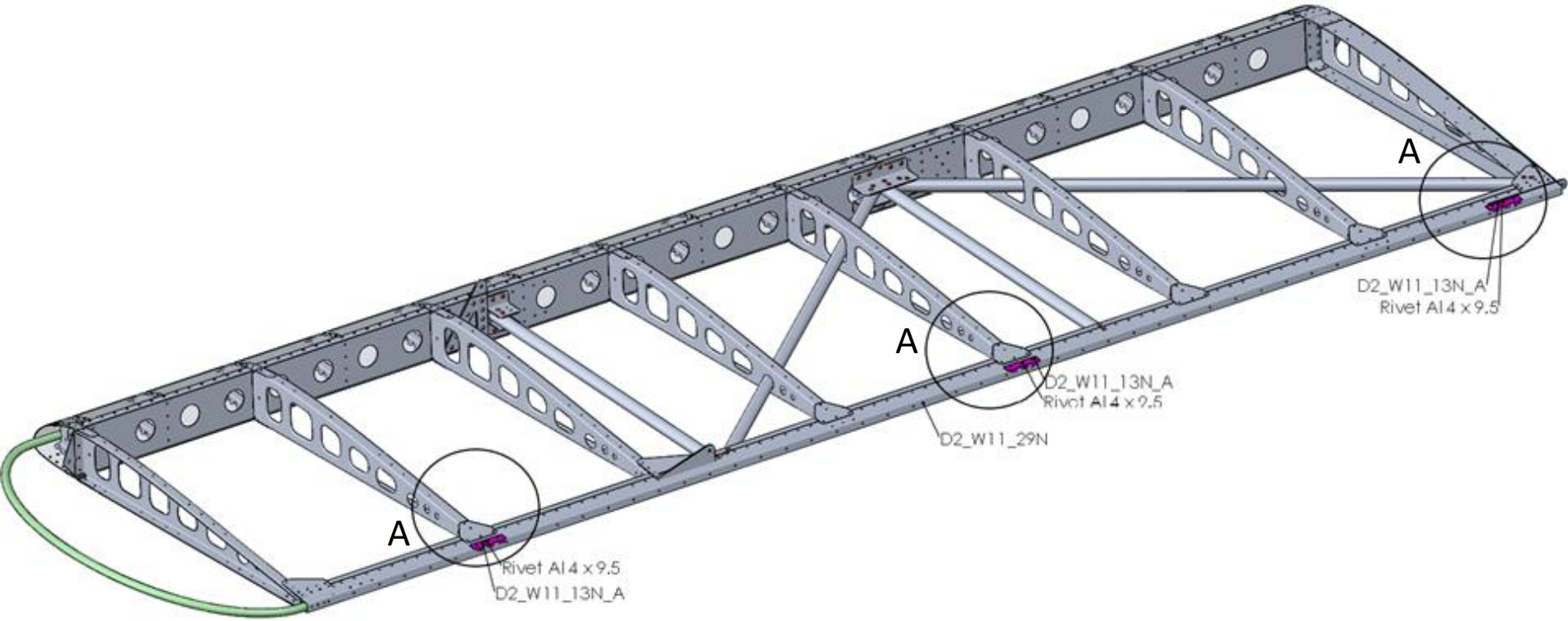
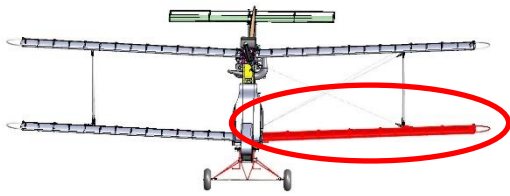
D2_W11_13N-A	3x
Rivet AVEX 3,2x7,9 Al/St	6x
Rivet AVEX 4x9,5 Al/St	3x



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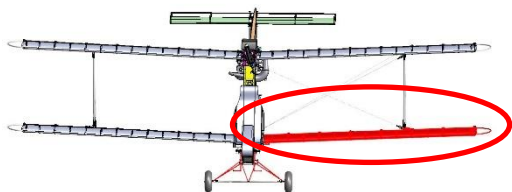
Step 51L



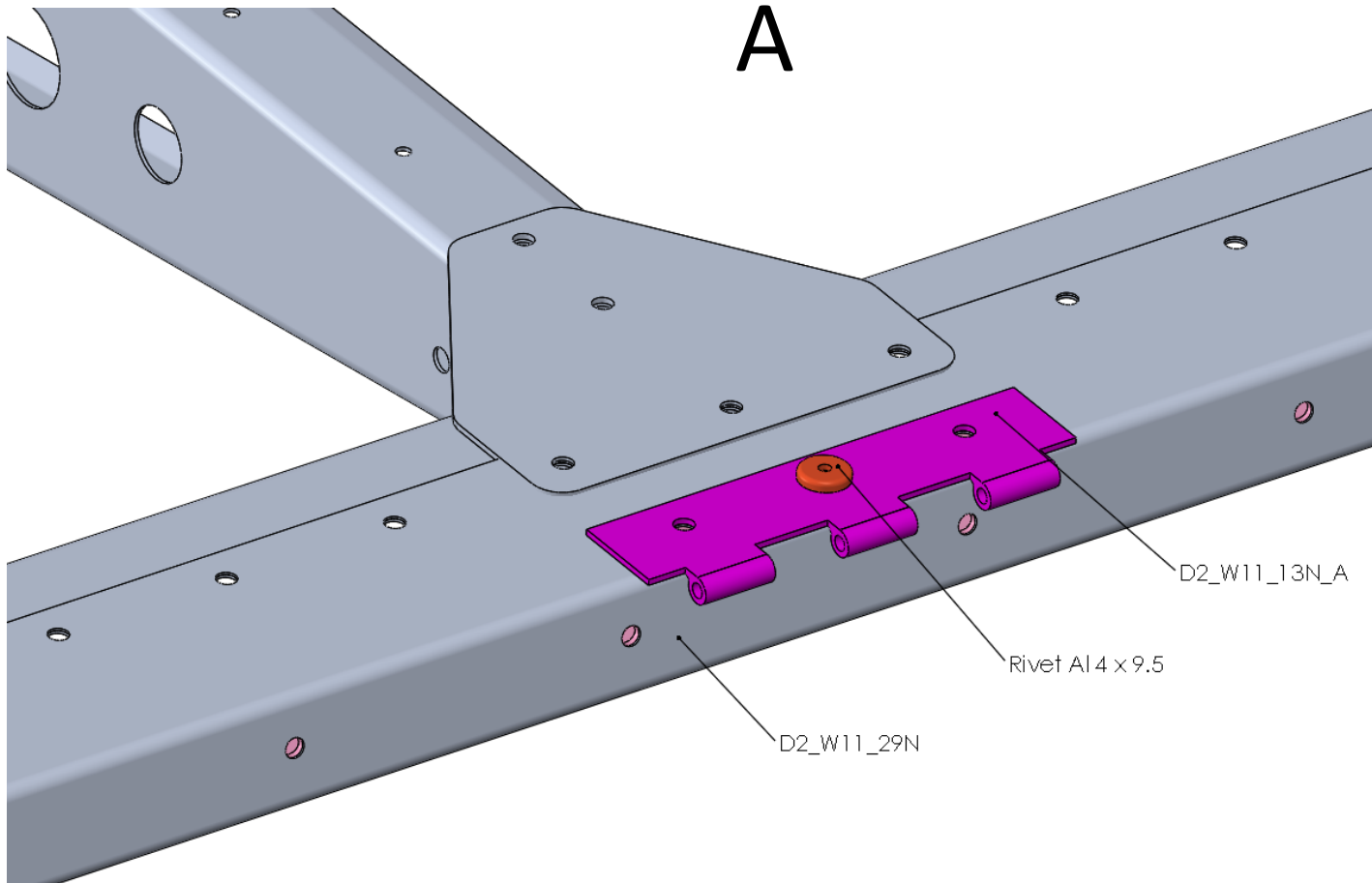
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Step 51L-A



A



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