

Title:

Wing assembly manual

Document no.:

D2_W0_00

Revision:

R03

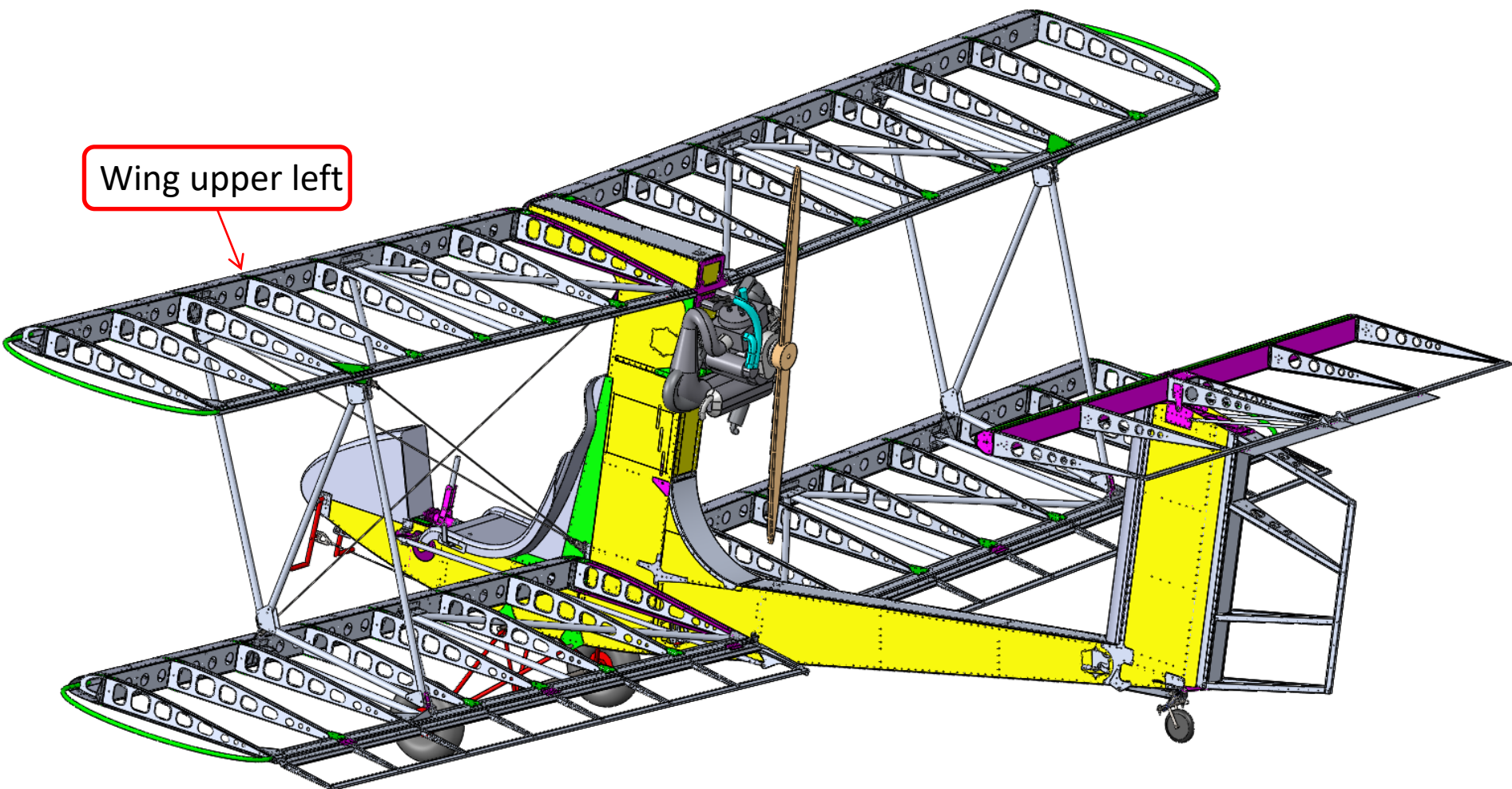
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Table of revisions

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
03	All	Changed according to the new design of trailing edge.

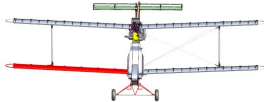
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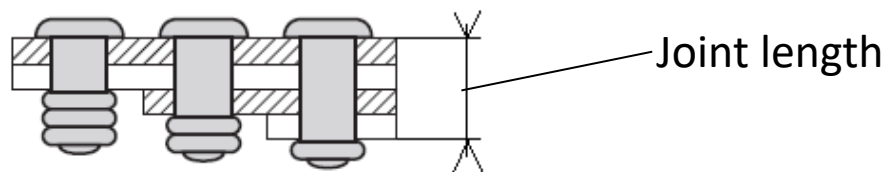
Wing upper left

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General instructions:

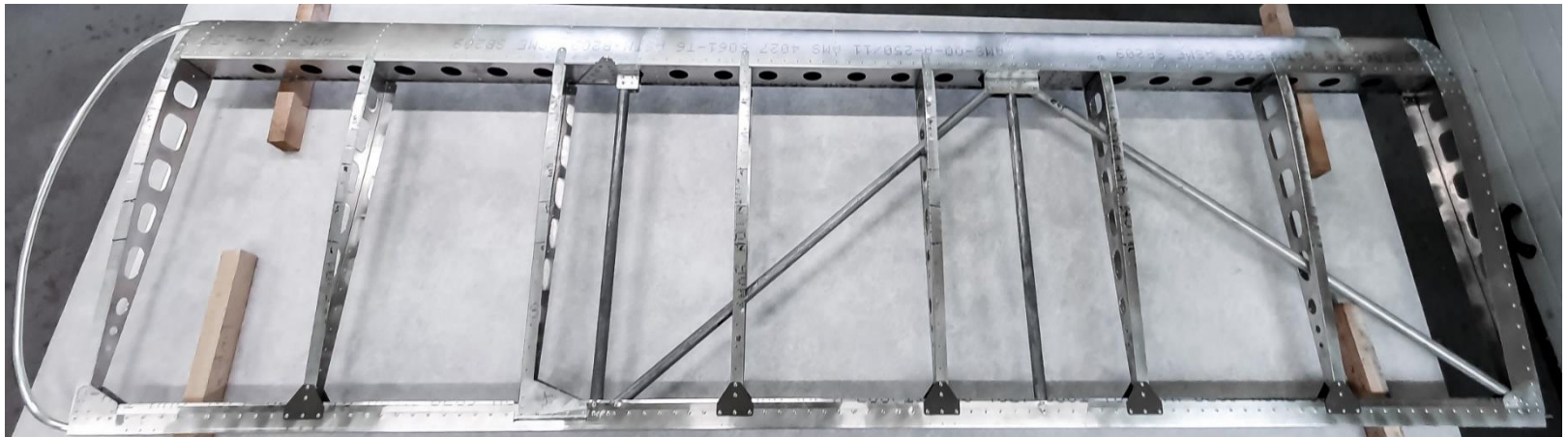
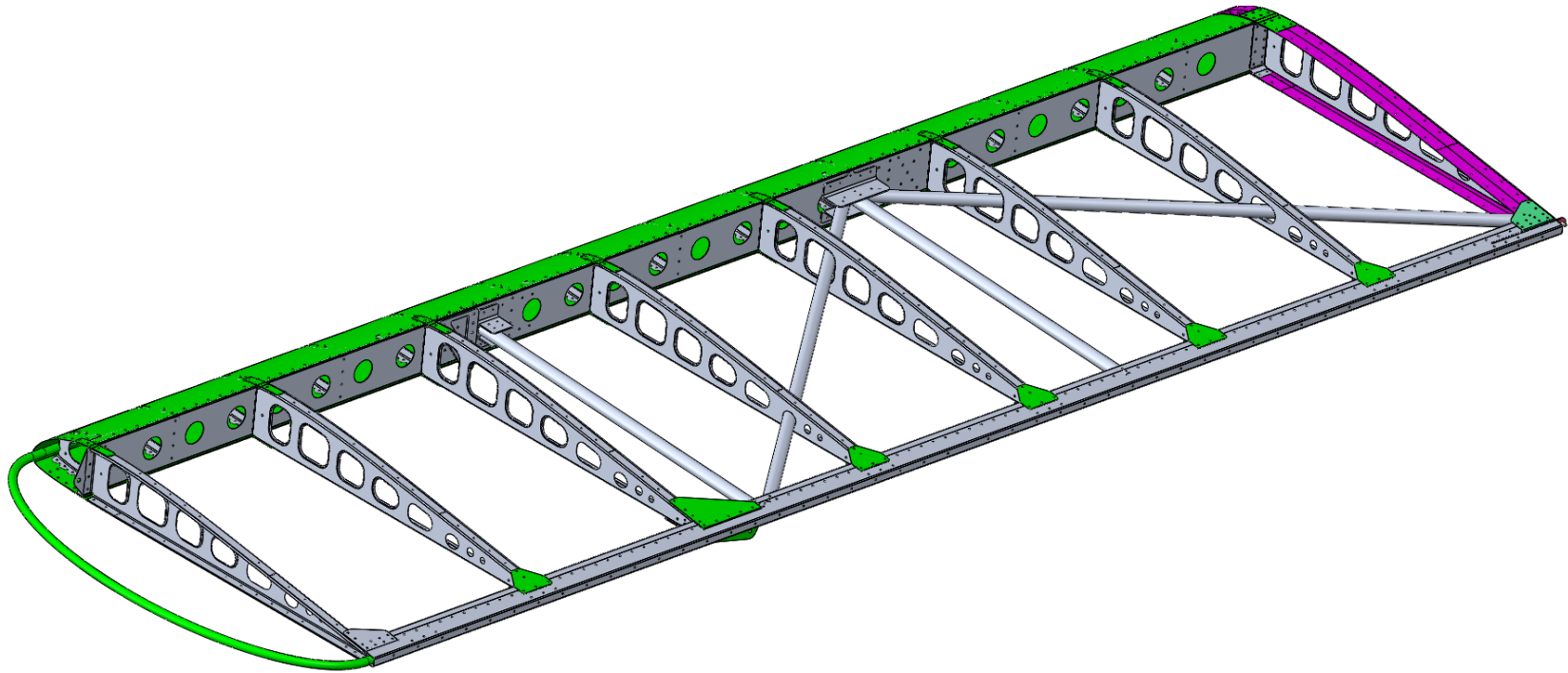
- This manual is for the upper left wing, right one is symmetrical. Specific places of construction are shown also for other wings. Follow this mark: 
- Use clecos for the preassembly, as shown in the video tutorial
- If there is no specific rivet shown or called in the assembly, use rivet AVEX 3,2x7,9 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
AVINOX Φ 4x10 EST/EST PH	14514010	INOX 4x10	AVINOX Φ 4x10 EST/EST PH	1,5mm	5mm
AVINOX Φ 4x12 EST/EST PH	14514012	INOX 4x12	AVINOX Φ 4x12 EST/EST PH	3,5mm	7,0mm

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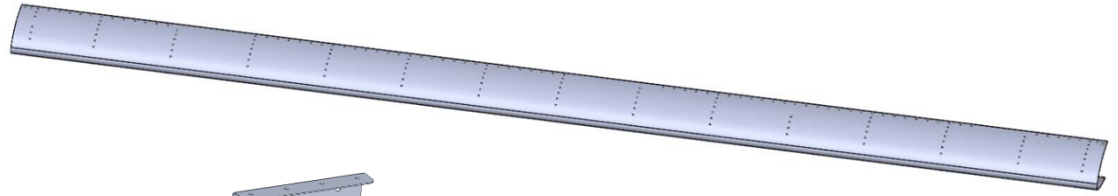
Assembly tool



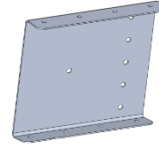
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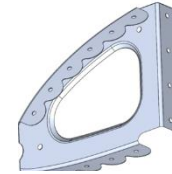
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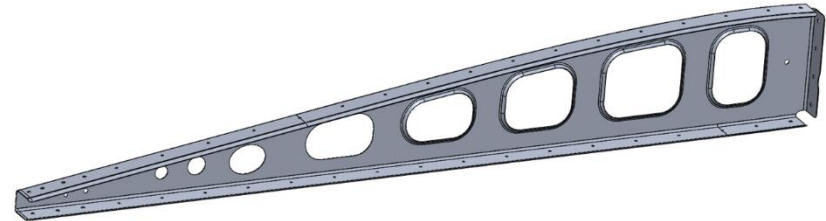
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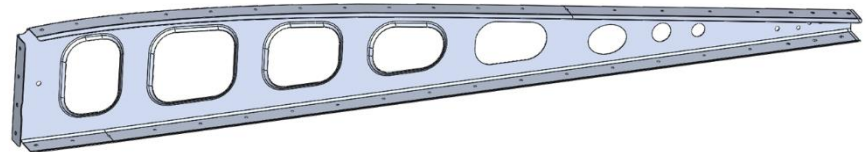
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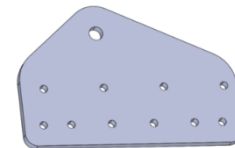
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Quantity 7



Part number D2_W11_06P
Quantity 1



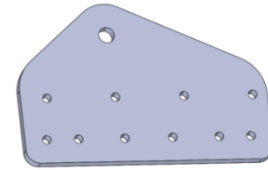
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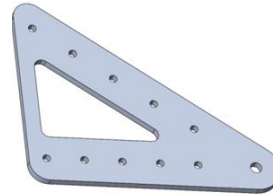
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Part number D2_W11_07N
Quantity 1



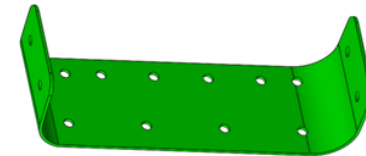
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Part number D2_W11_16N
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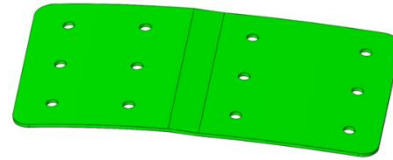
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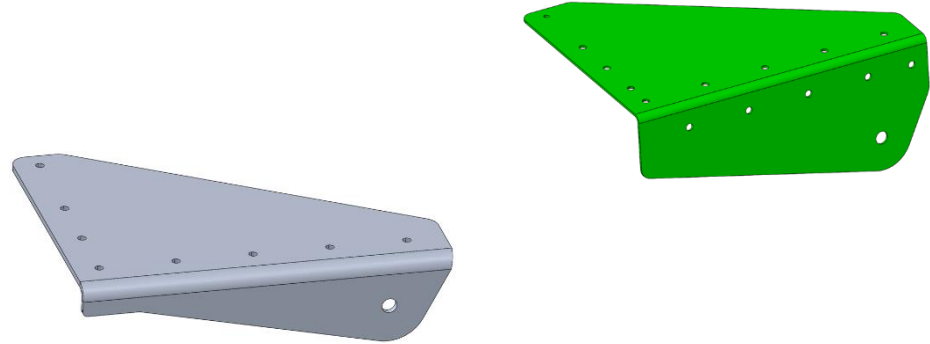
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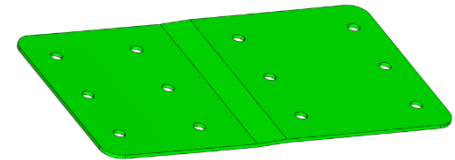


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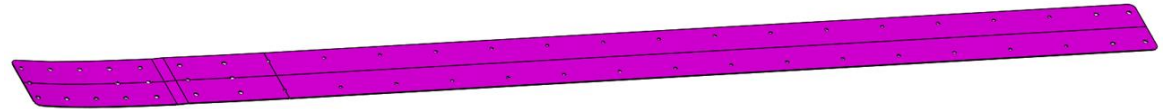


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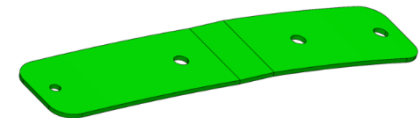
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Part number D2_W11_24N
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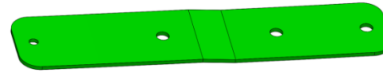
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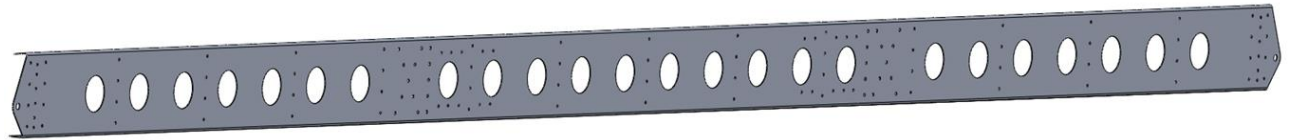
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Quantity 7



Part number D2_W11_01N
Quantity 1



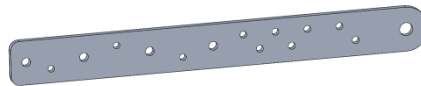
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Part number D2_W11_38N
Quantity 1



Part number D2_W21_10N
Quantity 1



Part number D2_W11_29N
Quantity 1



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Part number D2_W11_32N
Quantity 2



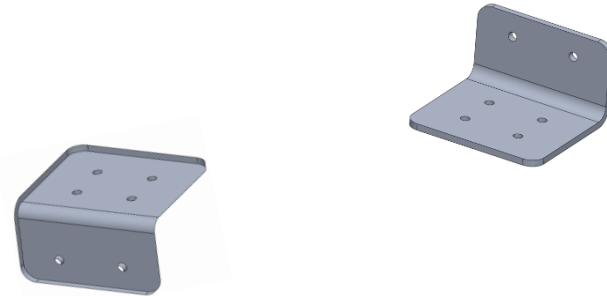
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Quantity 1

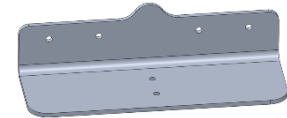


Part number D2_W11_31N
Quantity 1



Part number D2_W11_40N
Quantity 1

Part number D2_W11_30N
Quantity 1



Part number D2_W11_39N
Quantity 1



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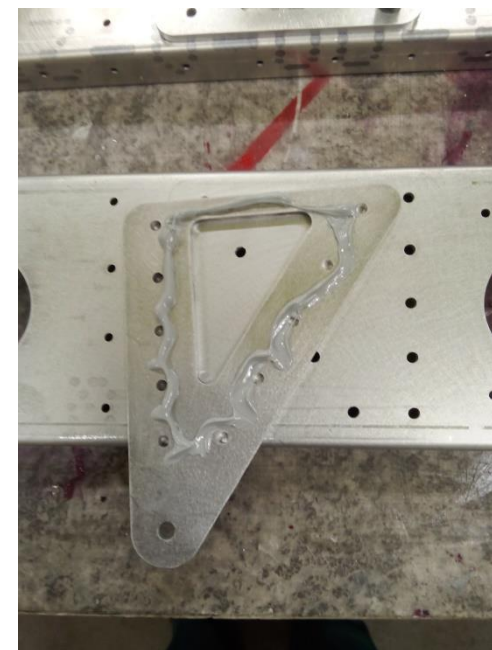
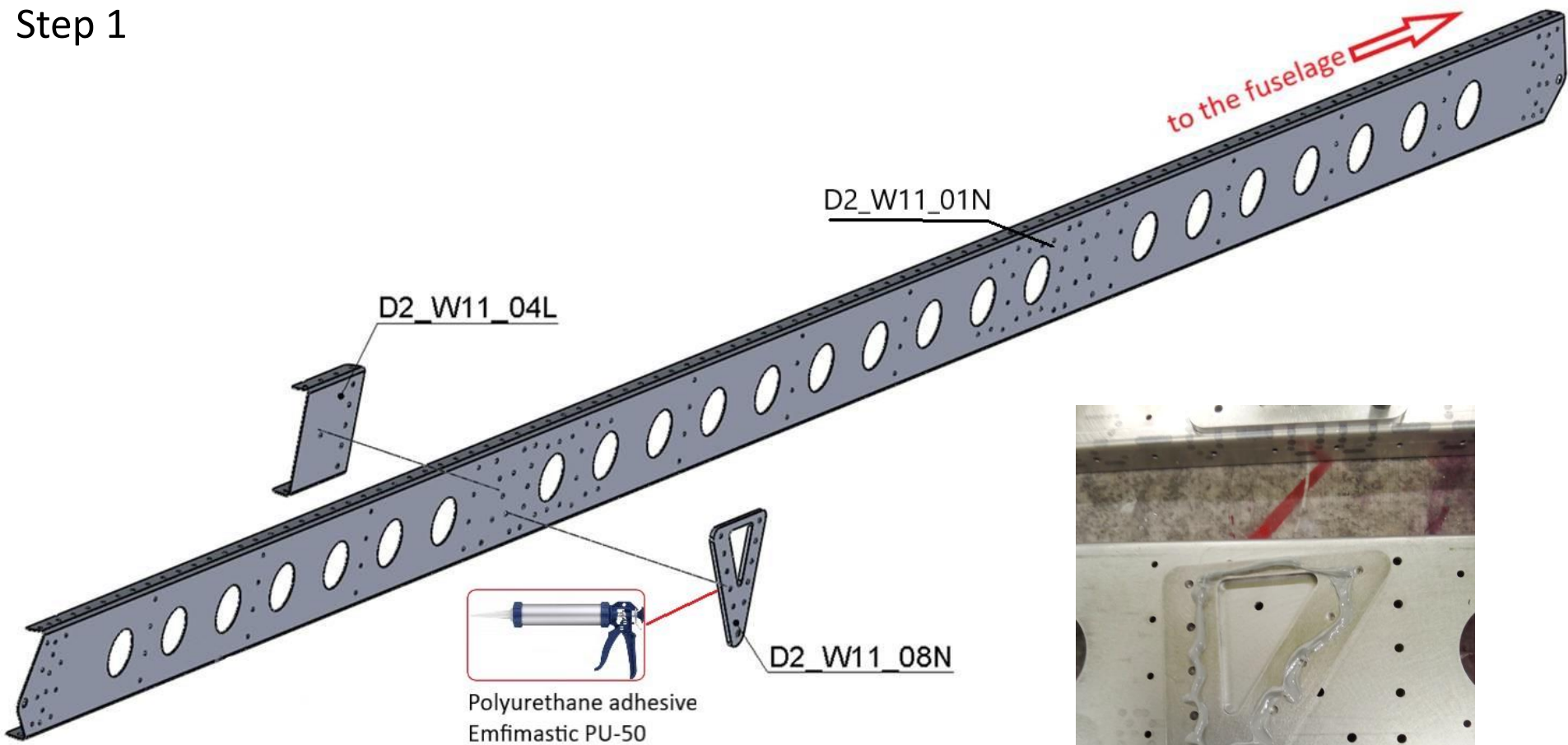


Standard parts	
Part	Quantity
Blind rivets AVEX Ø3,2x7,9 Al/St	729
Blind rivets AVEX Ø3,2x11,2 Al/St	16
Blind rivets AVEX Ø4,0x9,5 Al/St	46
Blind rivets AVINOX Ø4,0x10 EST/EST PH	2
Blind rivets AVINOX Ø4,0x12,0 EST/EST PH	14

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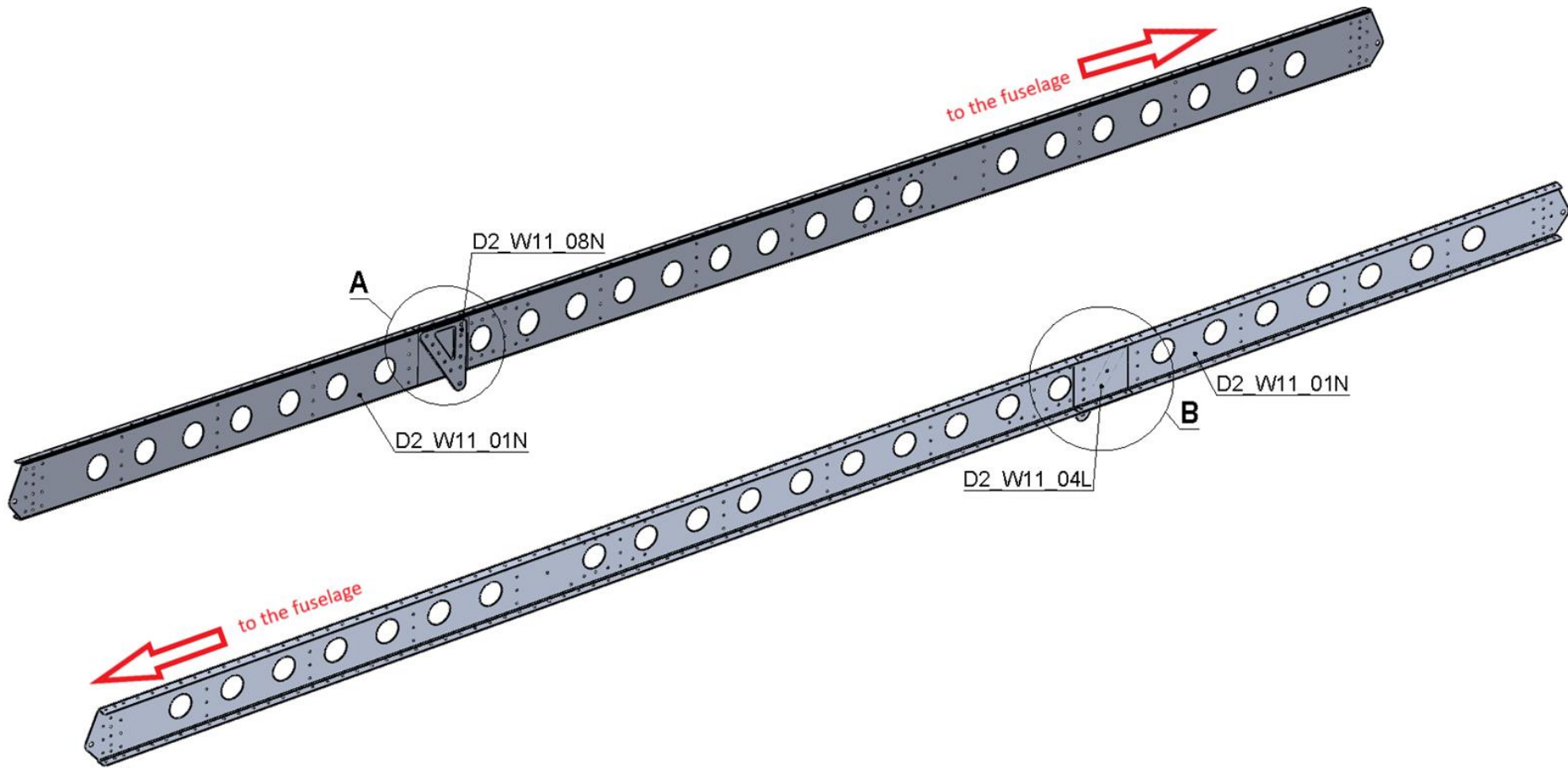
Step 1



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Step 2



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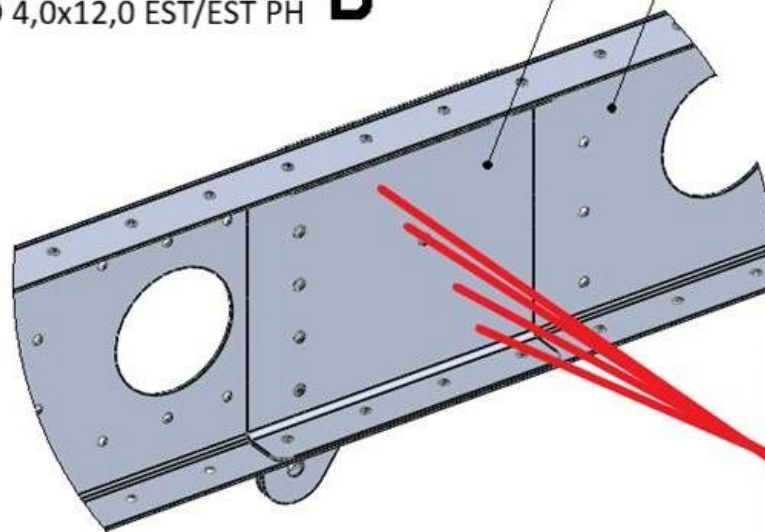
Step 2
A

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

B

D2_W11_04L

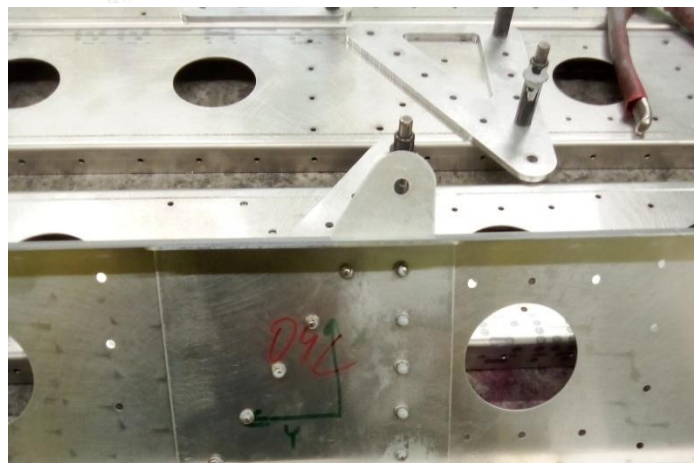
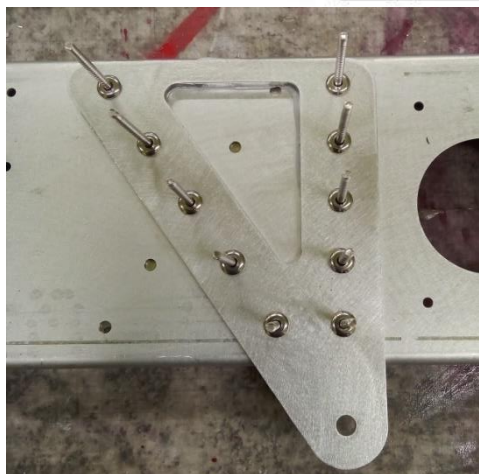
D2_W11_01N



Hole Ø4mm

D2_W11_01N

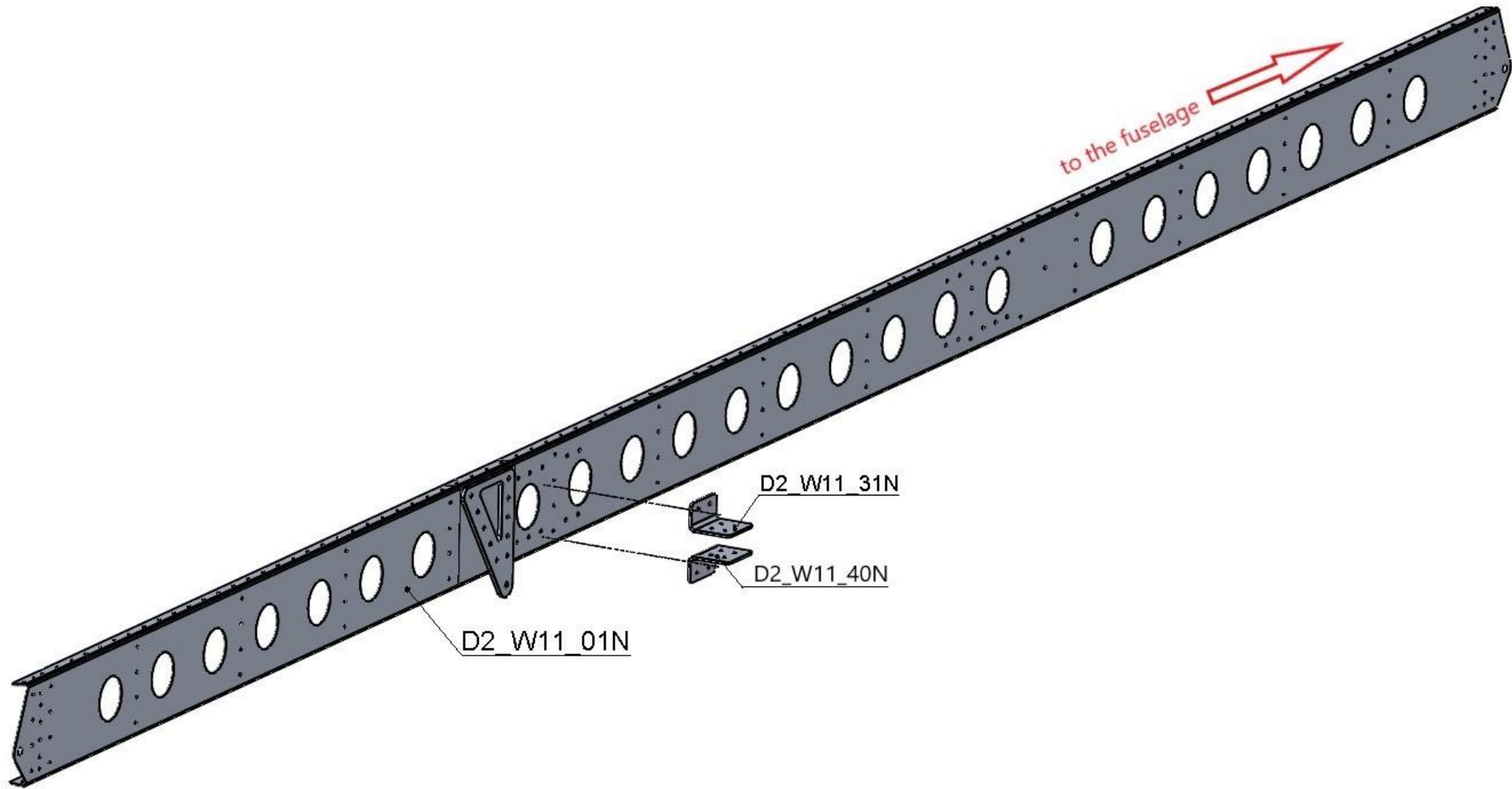
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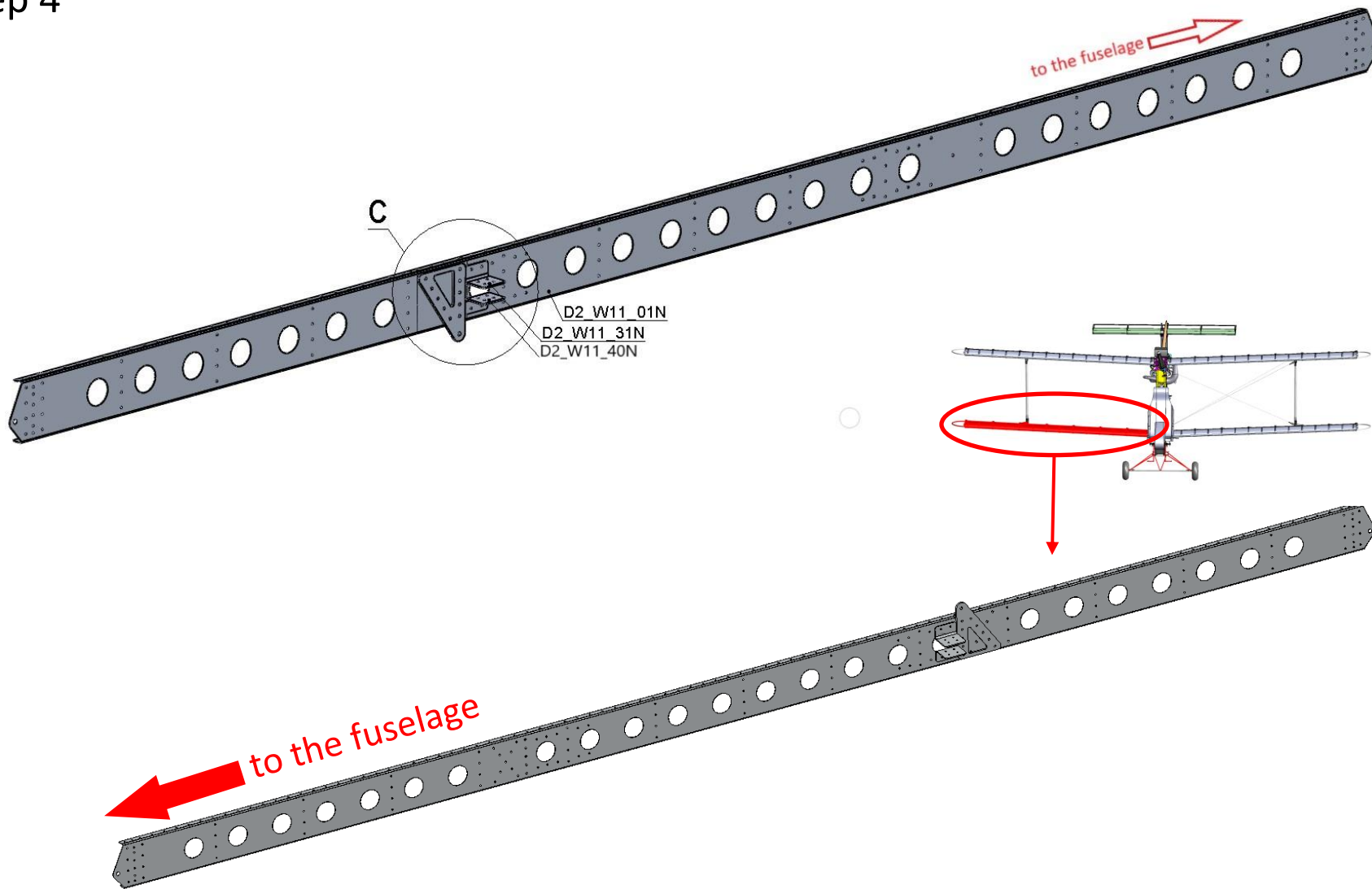
Step 3



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Step 4



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Step 4

C

D2_W11_31N

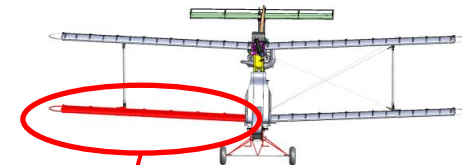
D2_W11_01N

Blind rivets

AVEX Ø 4,0x9,5 AL/st



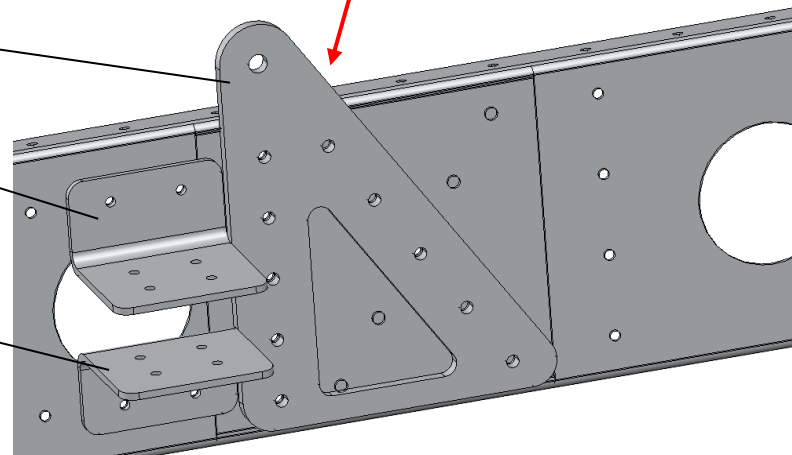
D2_W11_40N



D2_W11_08N

D2_W11_31N

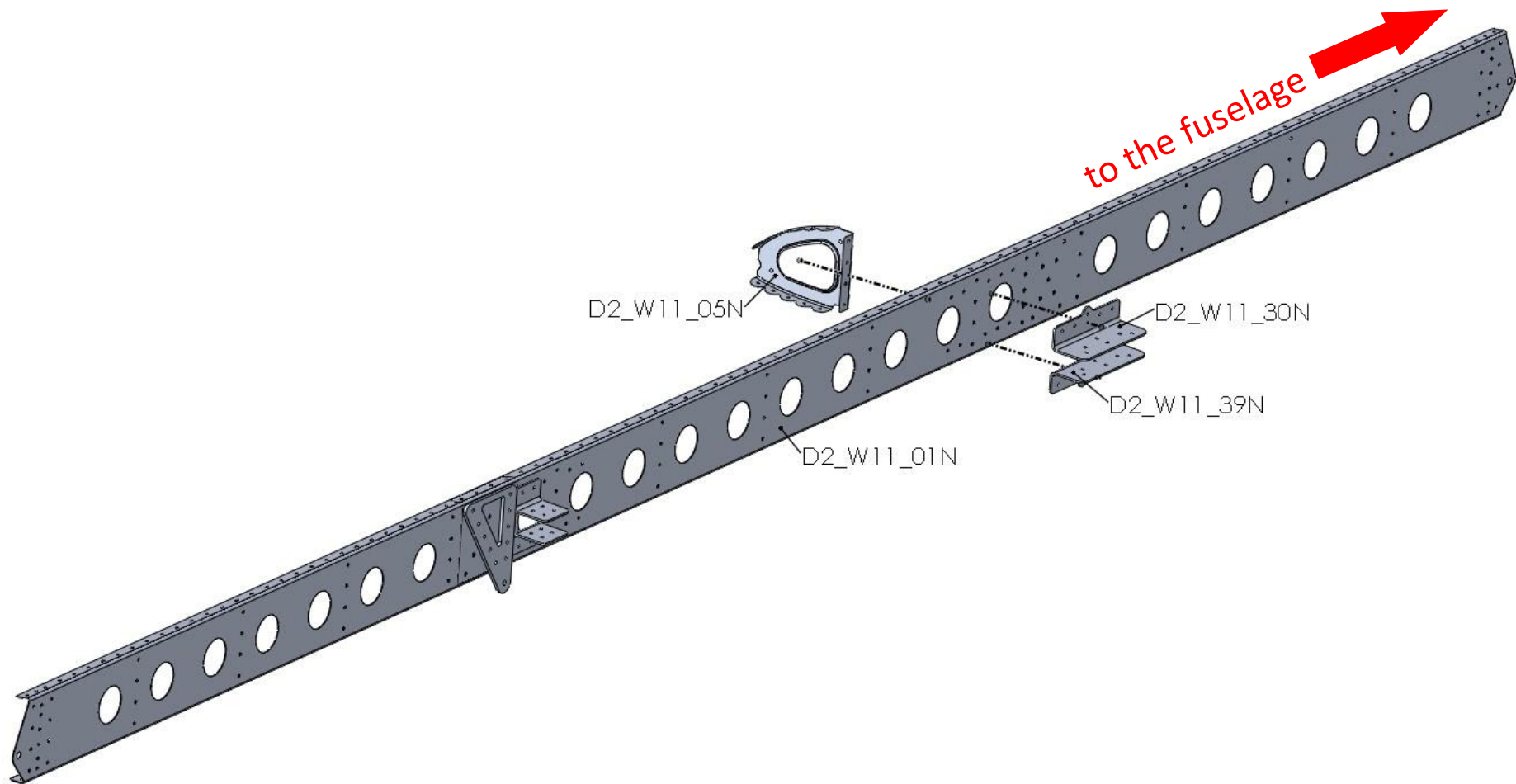
D2_W11_40N



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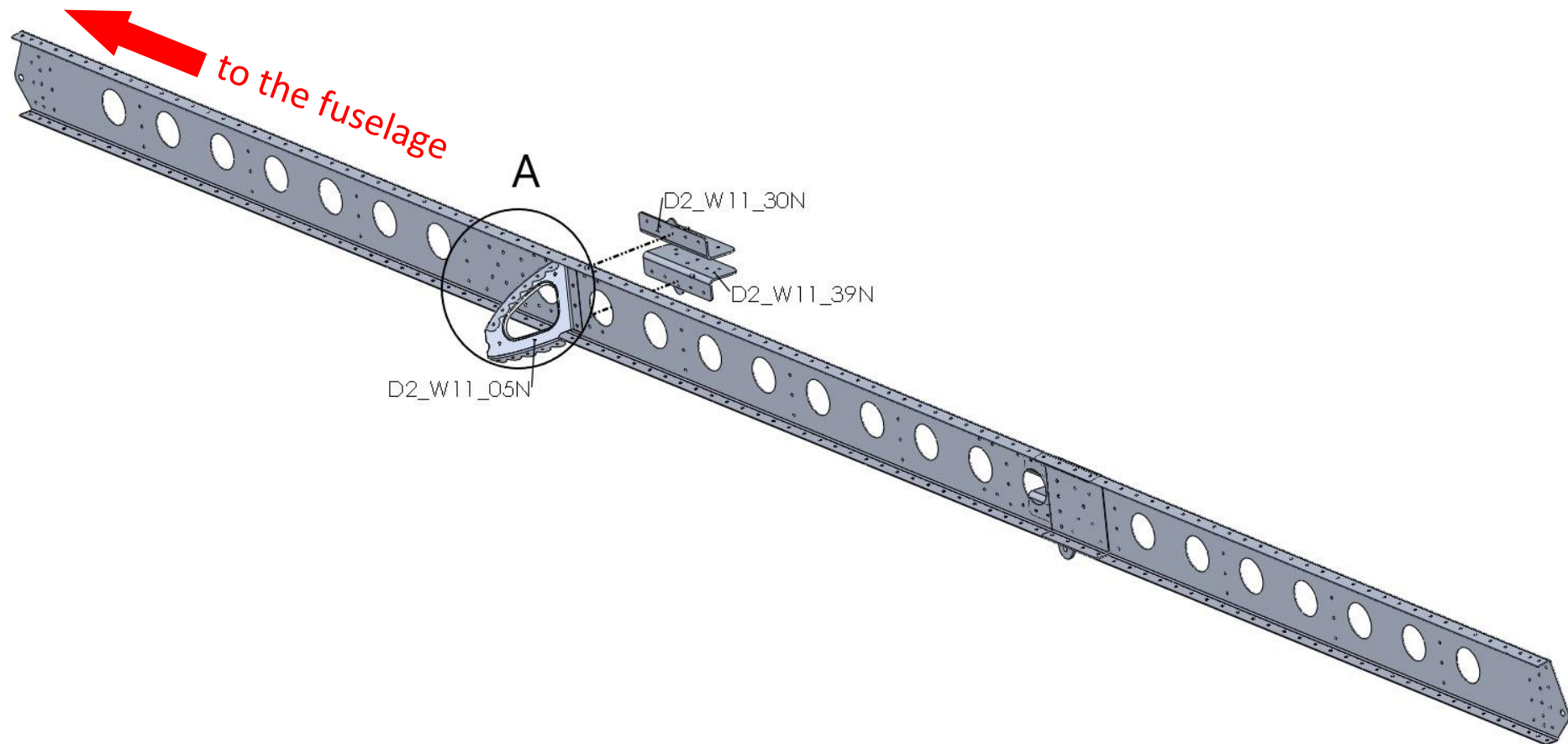
Step 5



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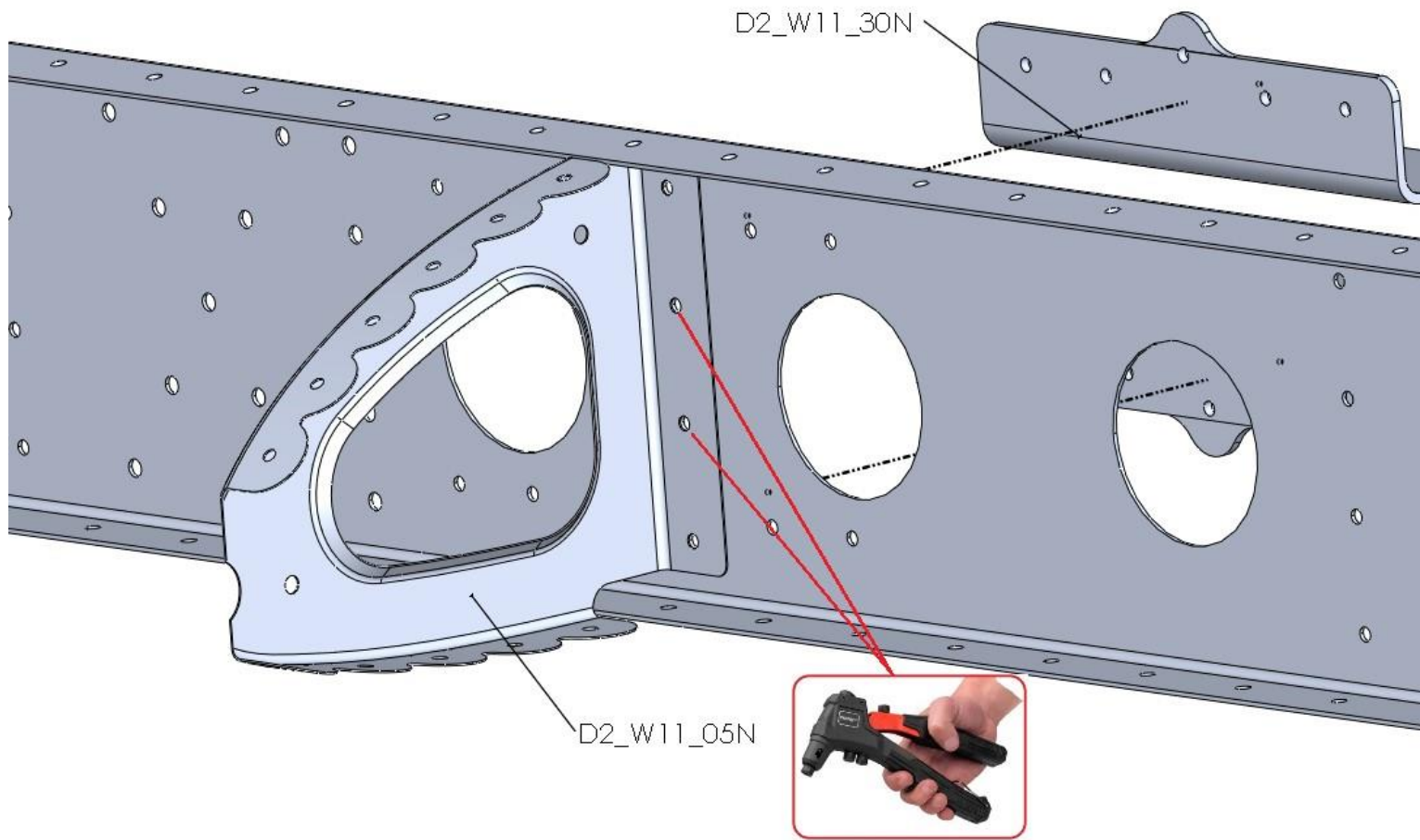
Step 6



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Step 6A

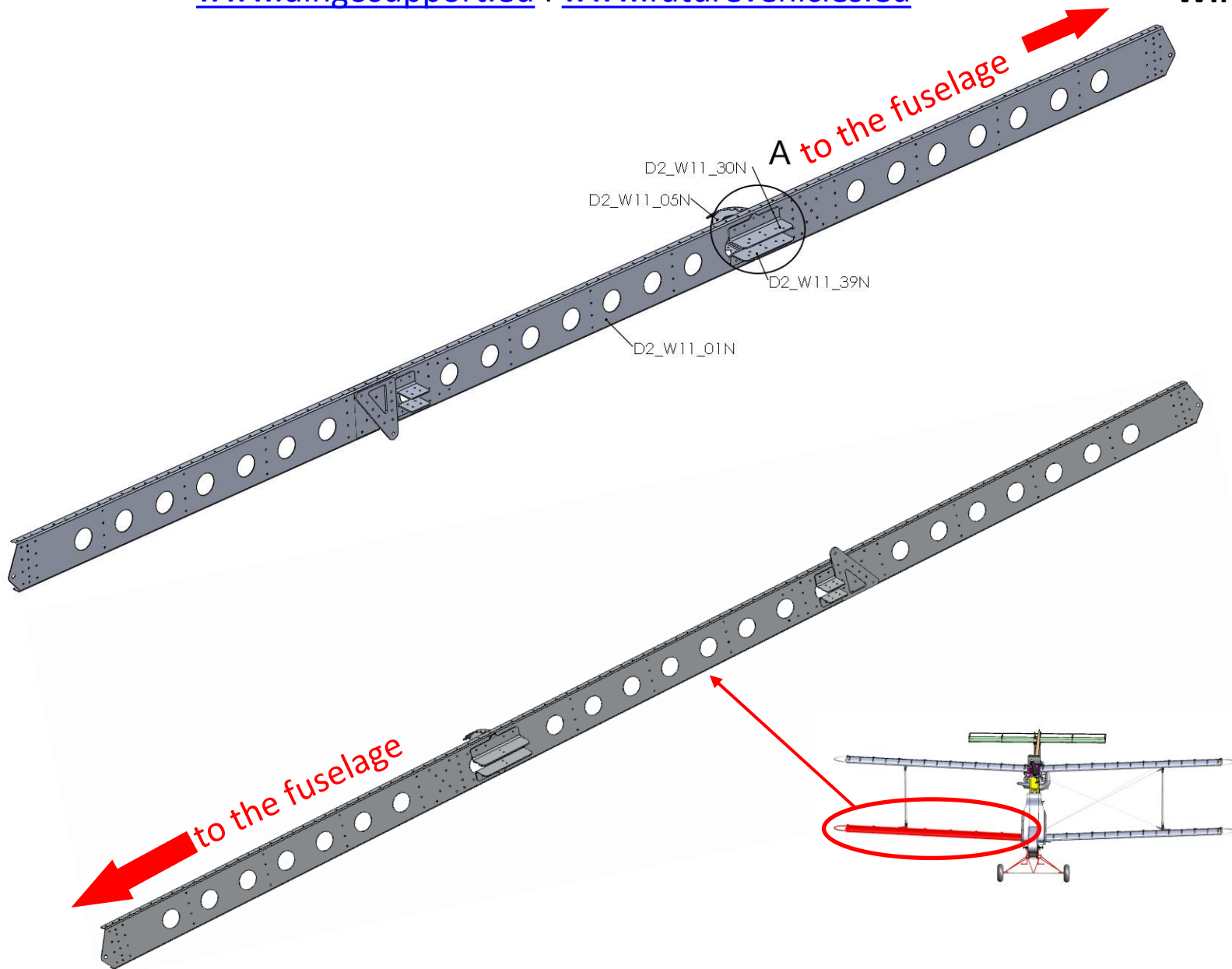


Blind rivets
AVEX Ø3,2x7,9 Al/St

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Step 7



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Step 7A



Blind rivets
AVEX Ø 4,0x9,5 AL/st

D2_W11_01N

D2_W11_05N

D2_W11_30N

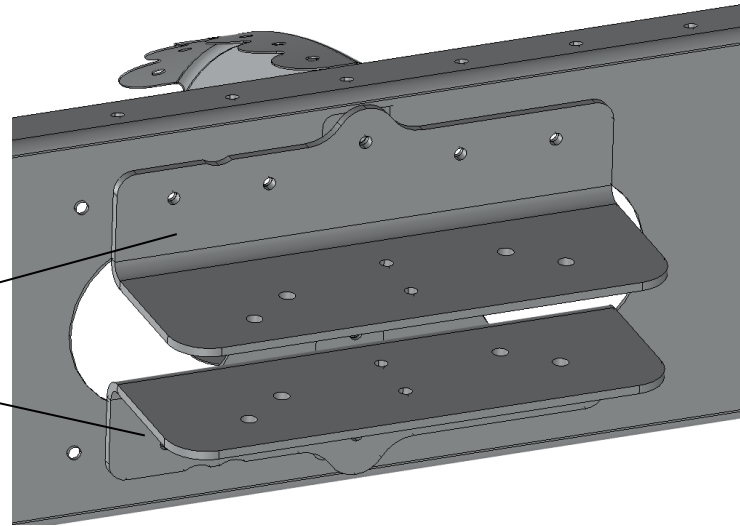
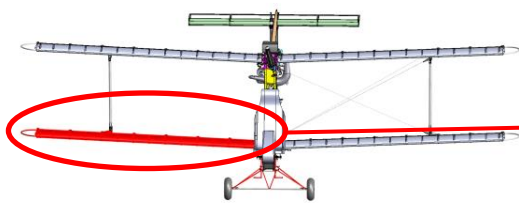


Blind rivets
AVEX Ø 4,0x9,5 AL/st

D2_W11_39N

D2_W11_30N

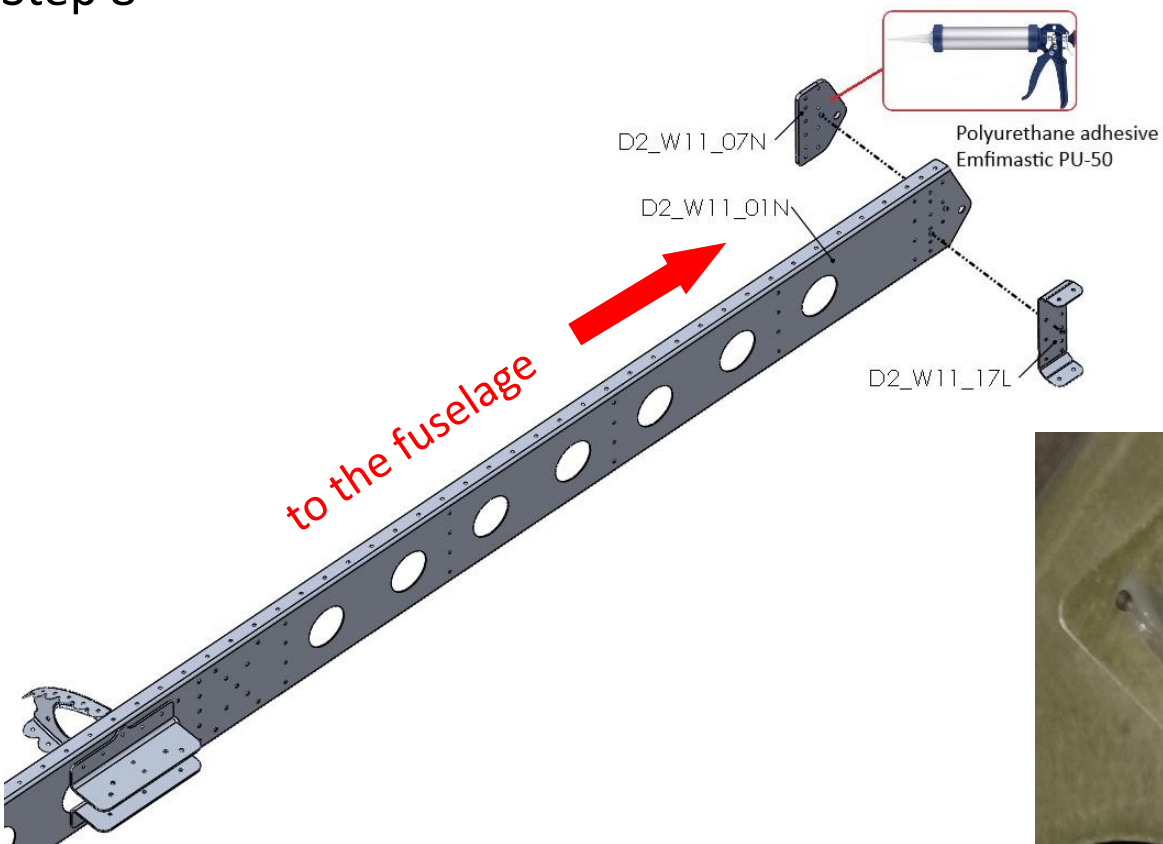
D2_W11_39N



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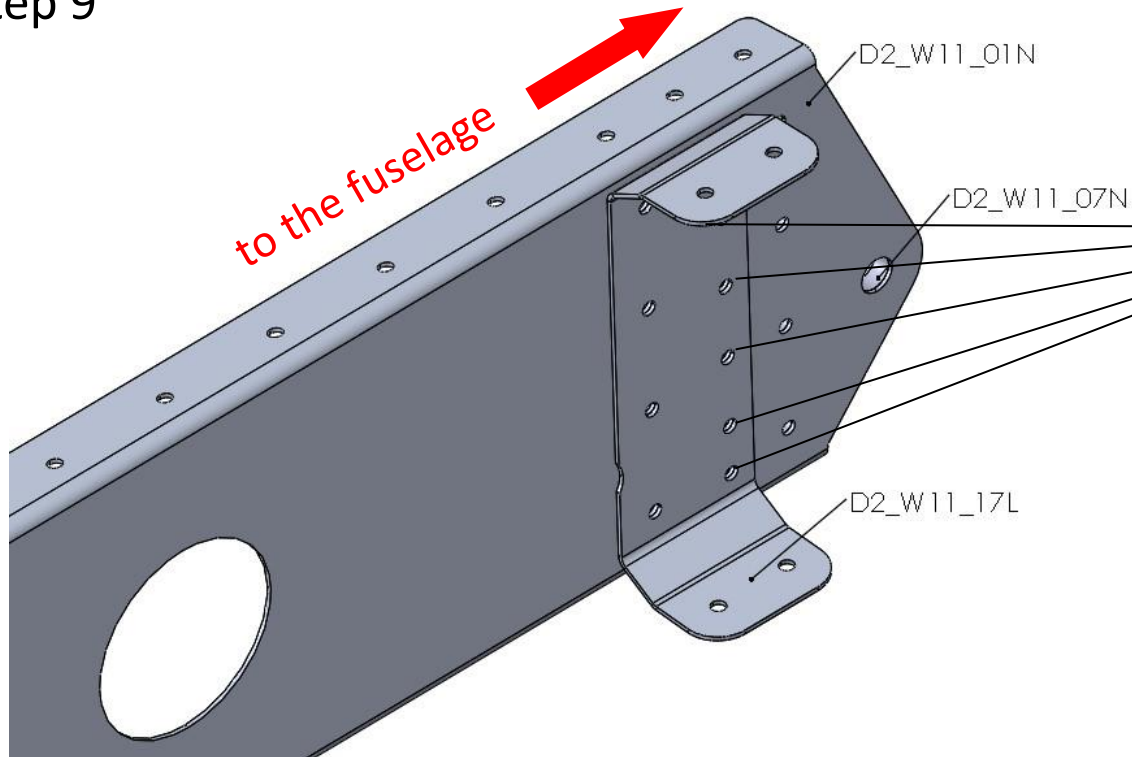
Step 8



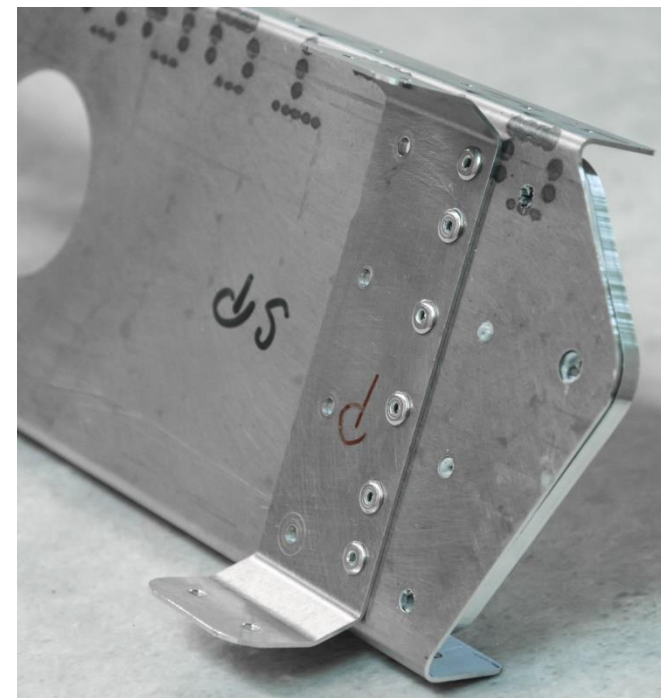
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Step 9




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



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Step 10

to the fuselage 

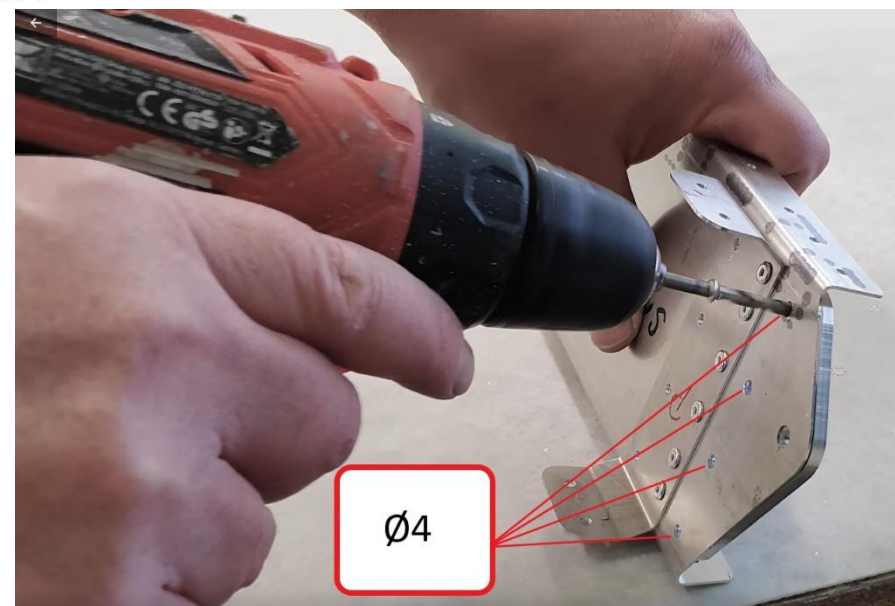
D2_W11_01N

D2_W11_07N



Hole Ø4mm

D2_W11_17L

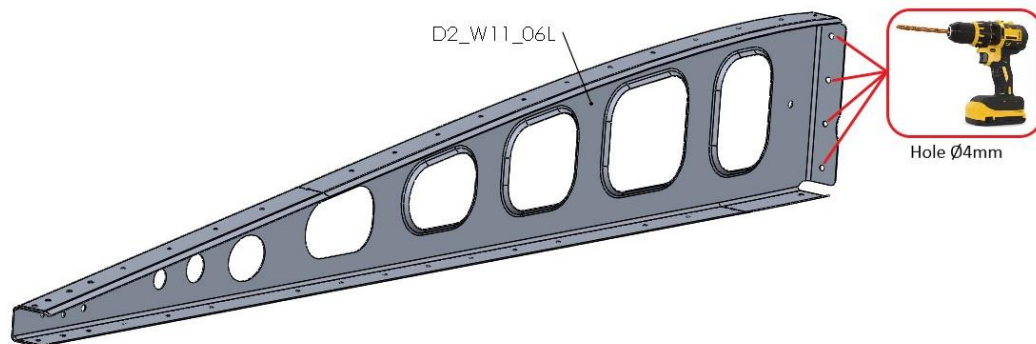
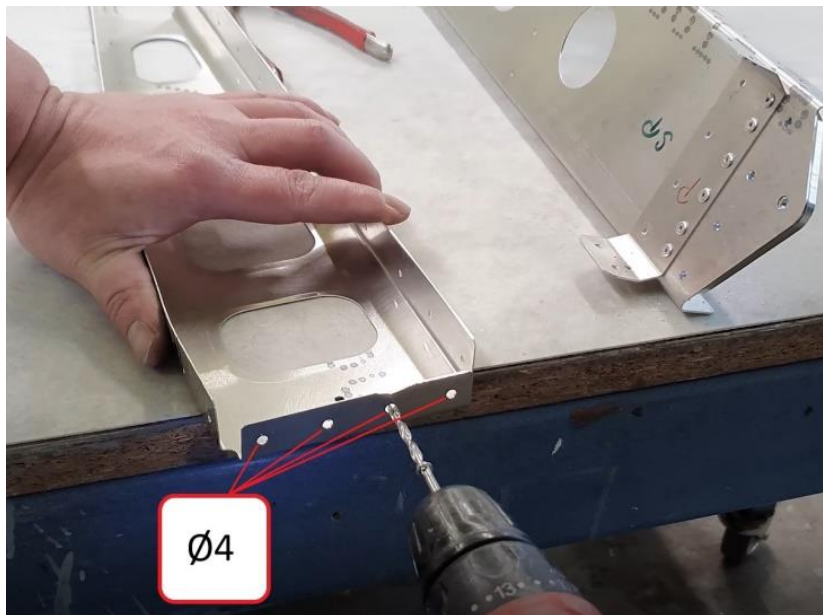
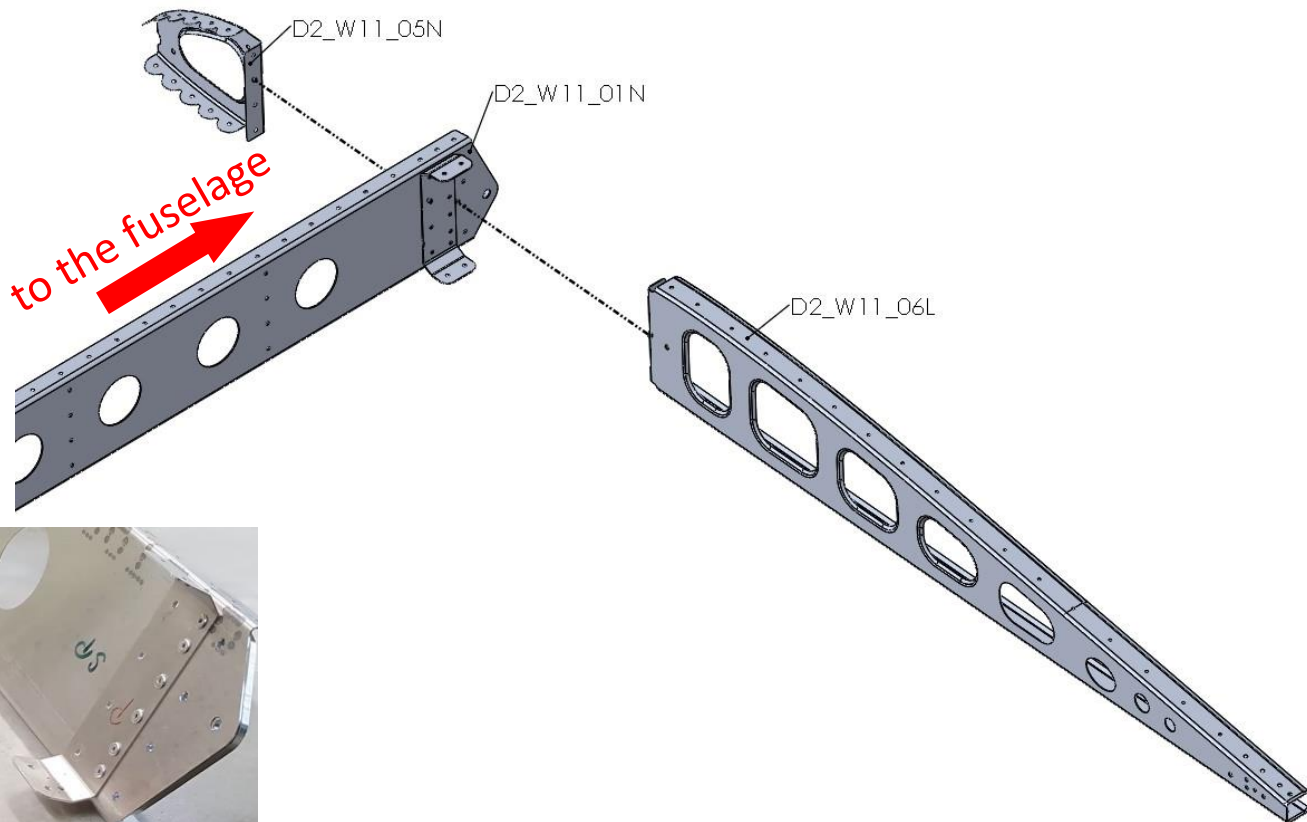


Ø4

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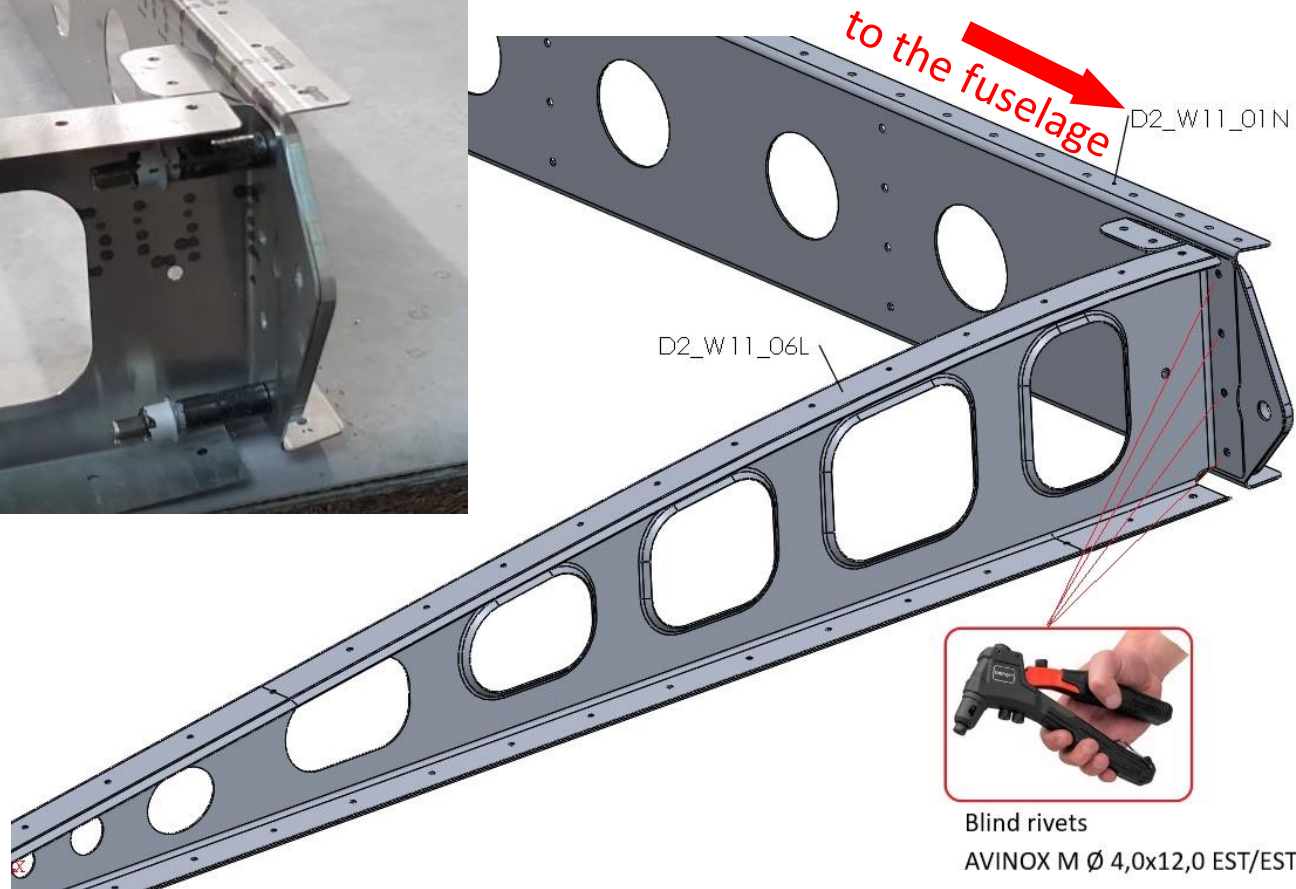
Step 11



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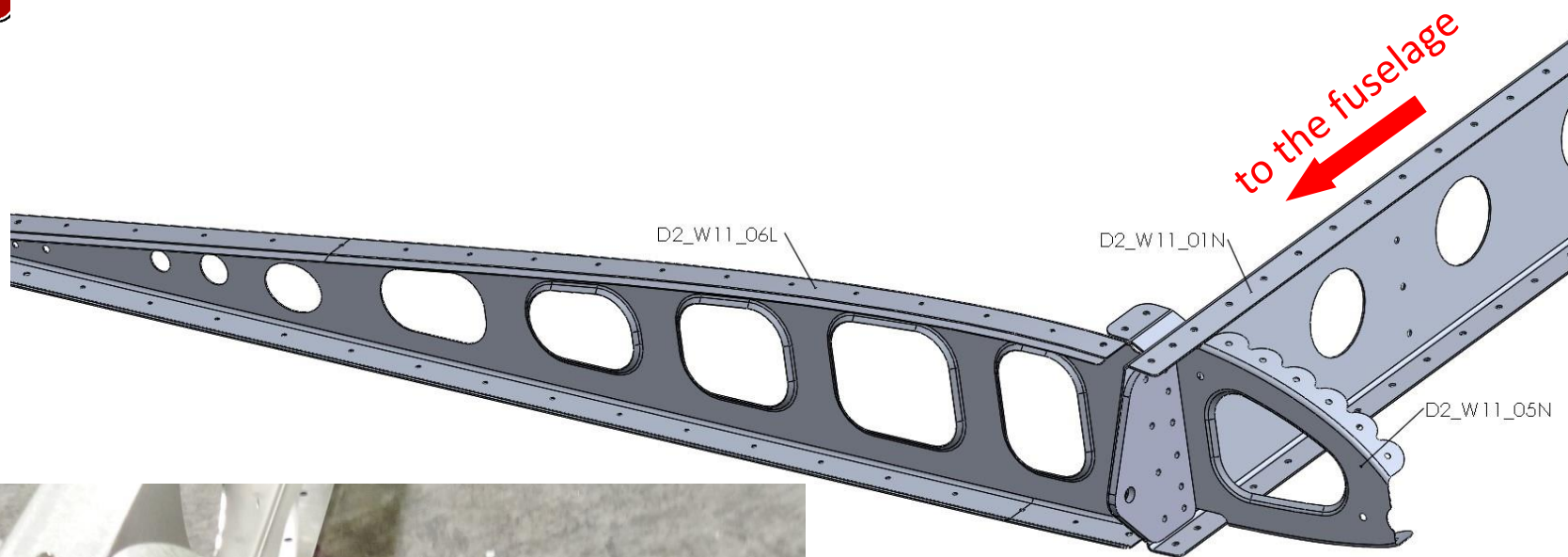
Step 12



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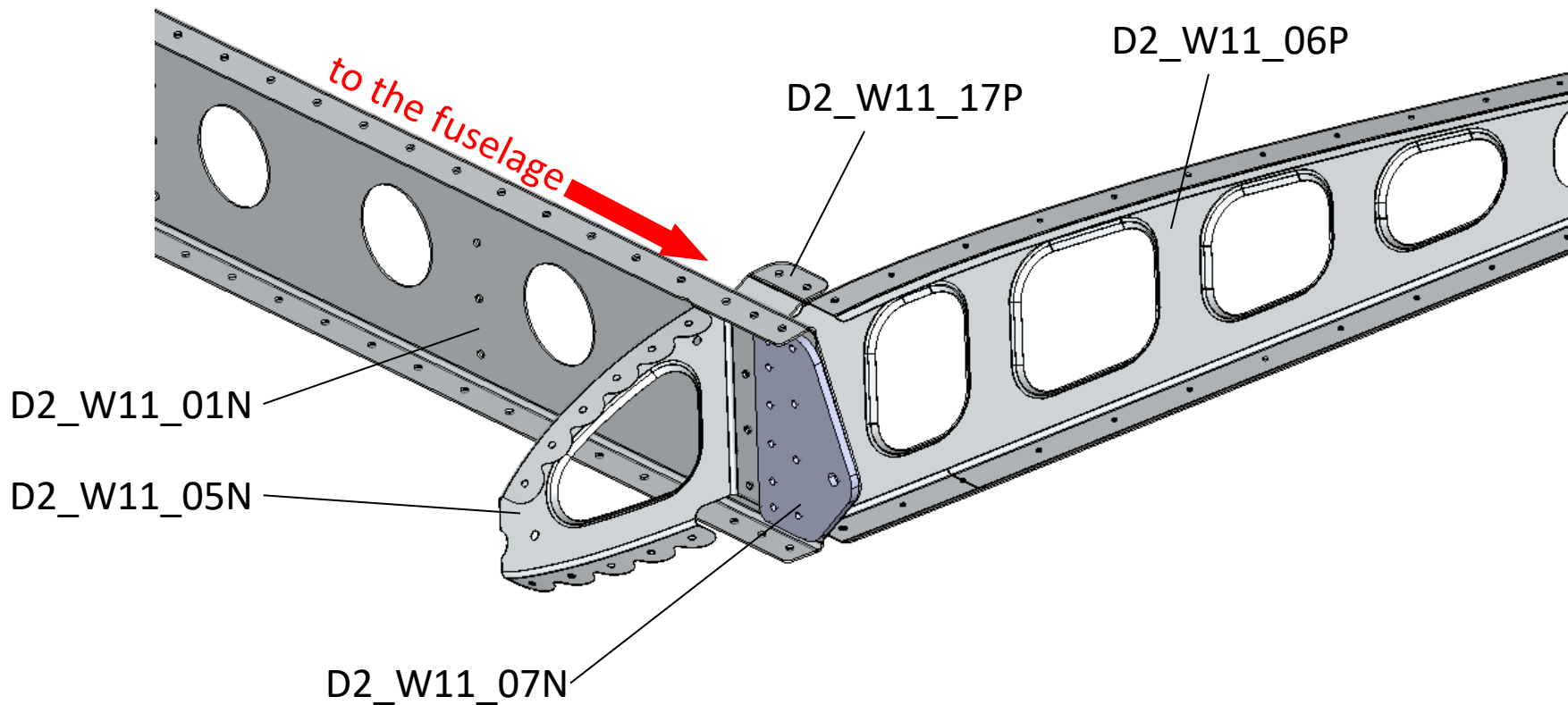
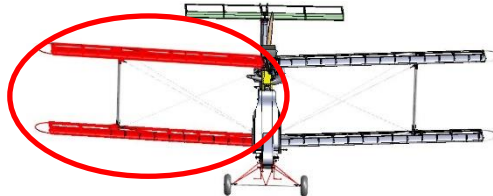


Step 13



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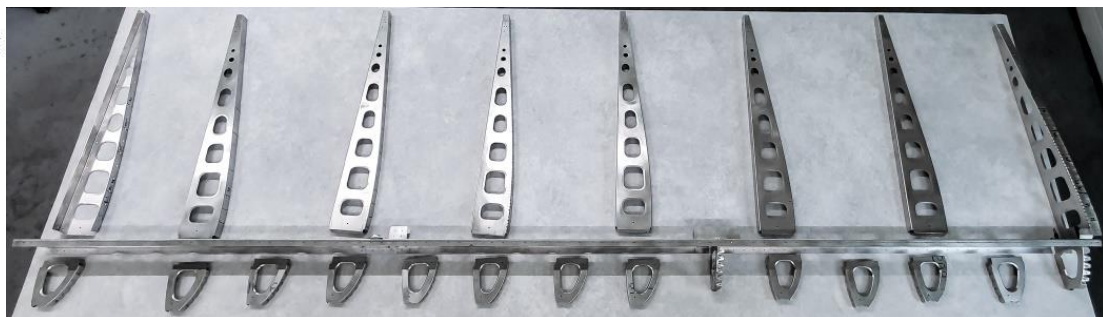
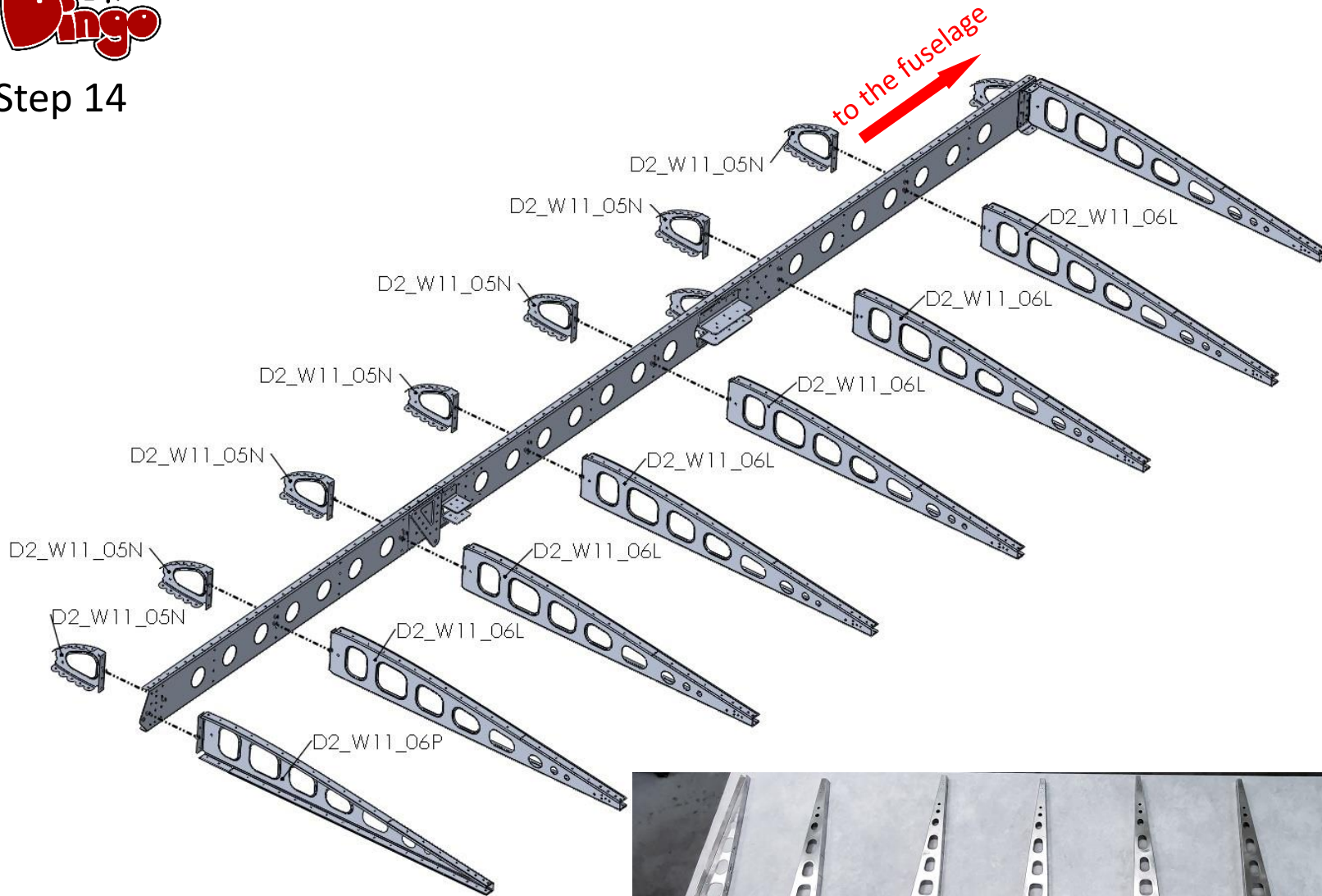
Step 13P



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Step 14

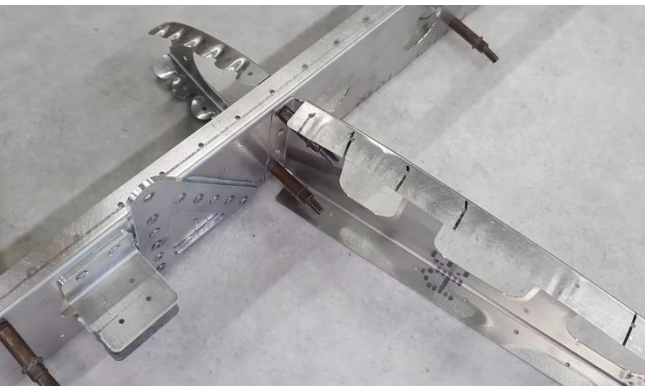


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Step 15

to the fuselage



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D2_W11_06L

Step 15P



D2_W11_05L

D2_W11_06P

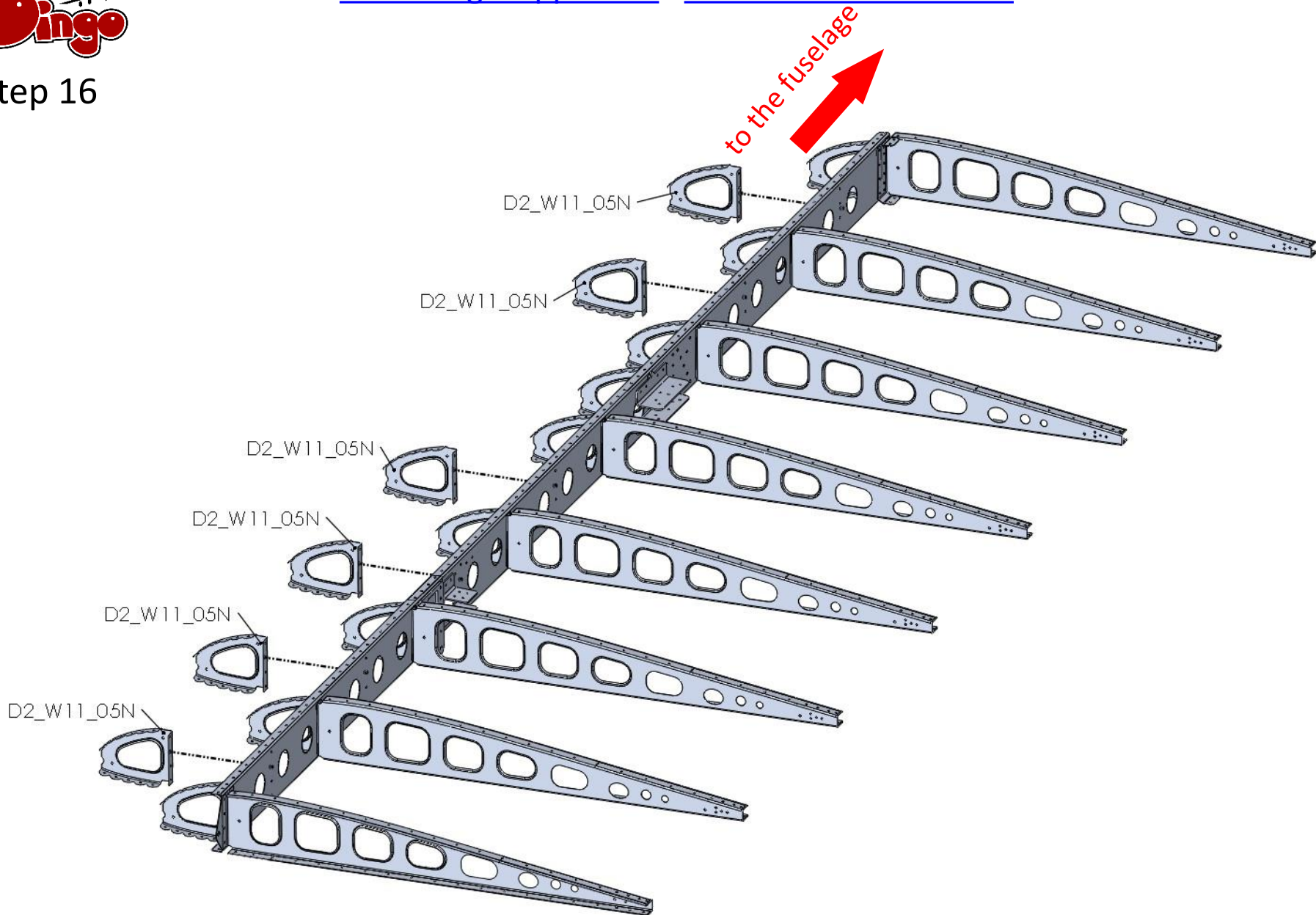
to the fuselage

D2_W11_06P

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Step 16

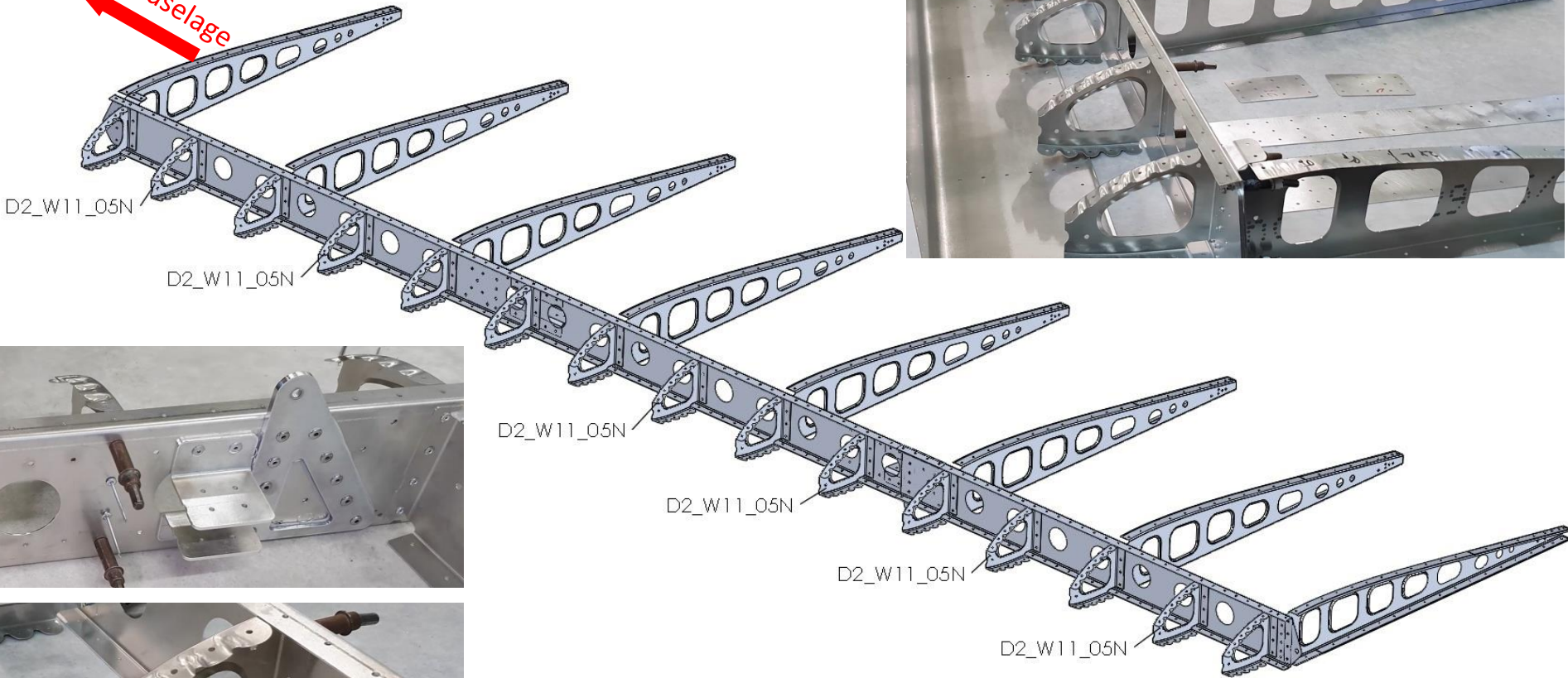


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Step 17

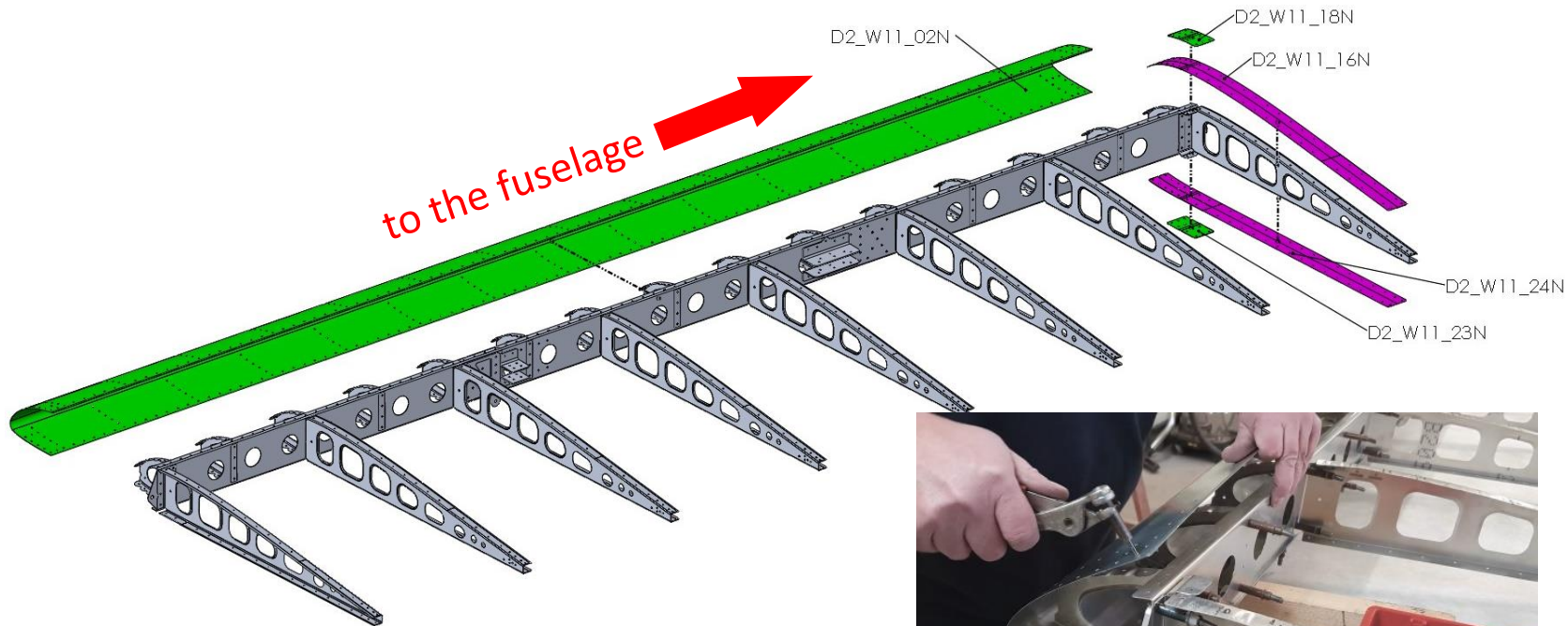
to the fuselage



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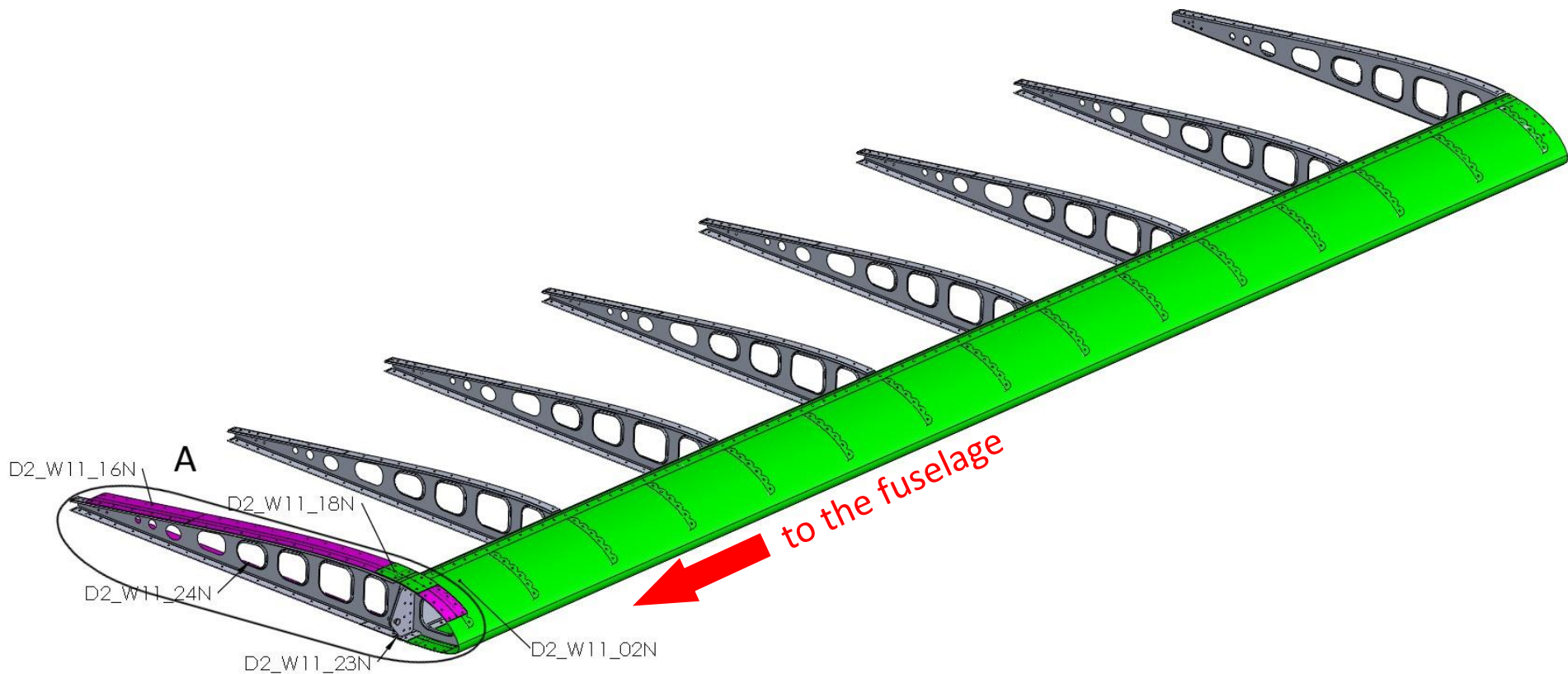
Step 18



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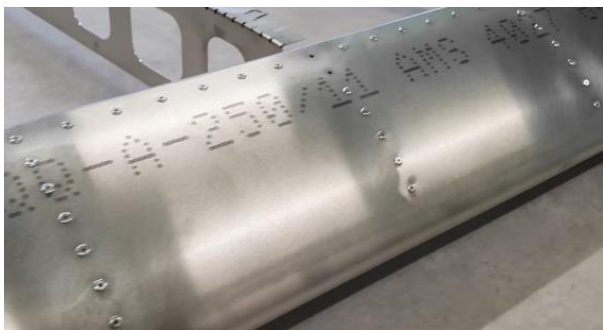
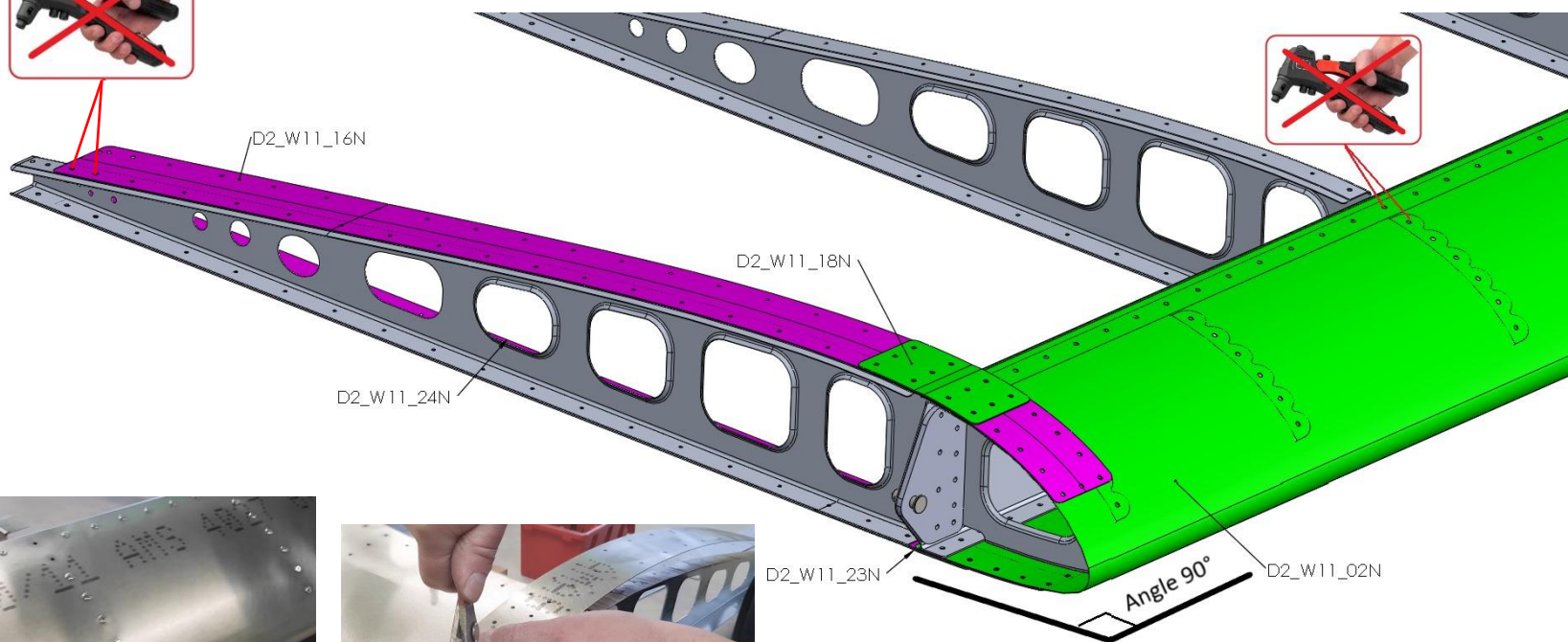
Step 19



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Step 19A



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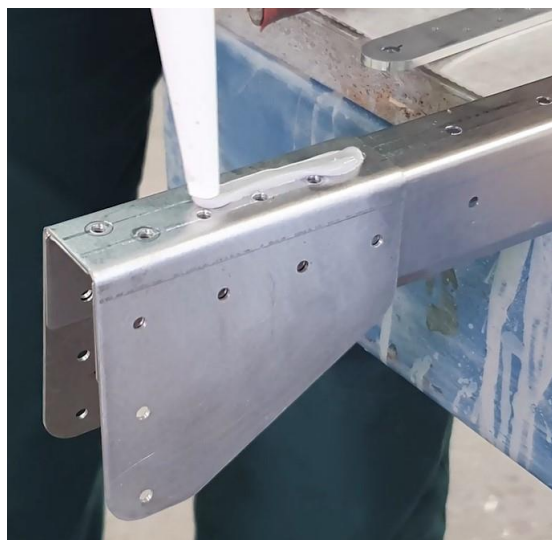
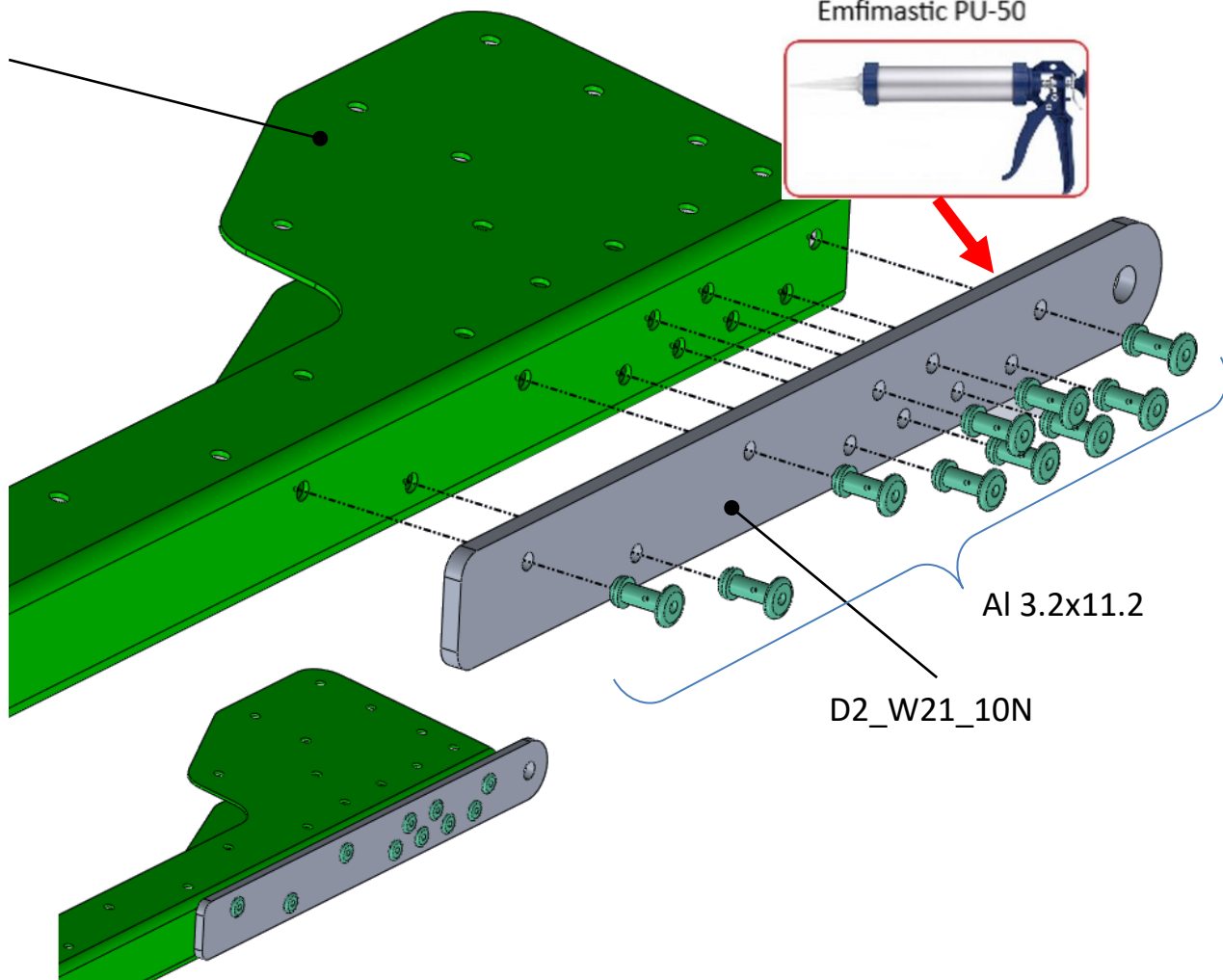


Polyurethane adhesive
Emfimastic PU-50



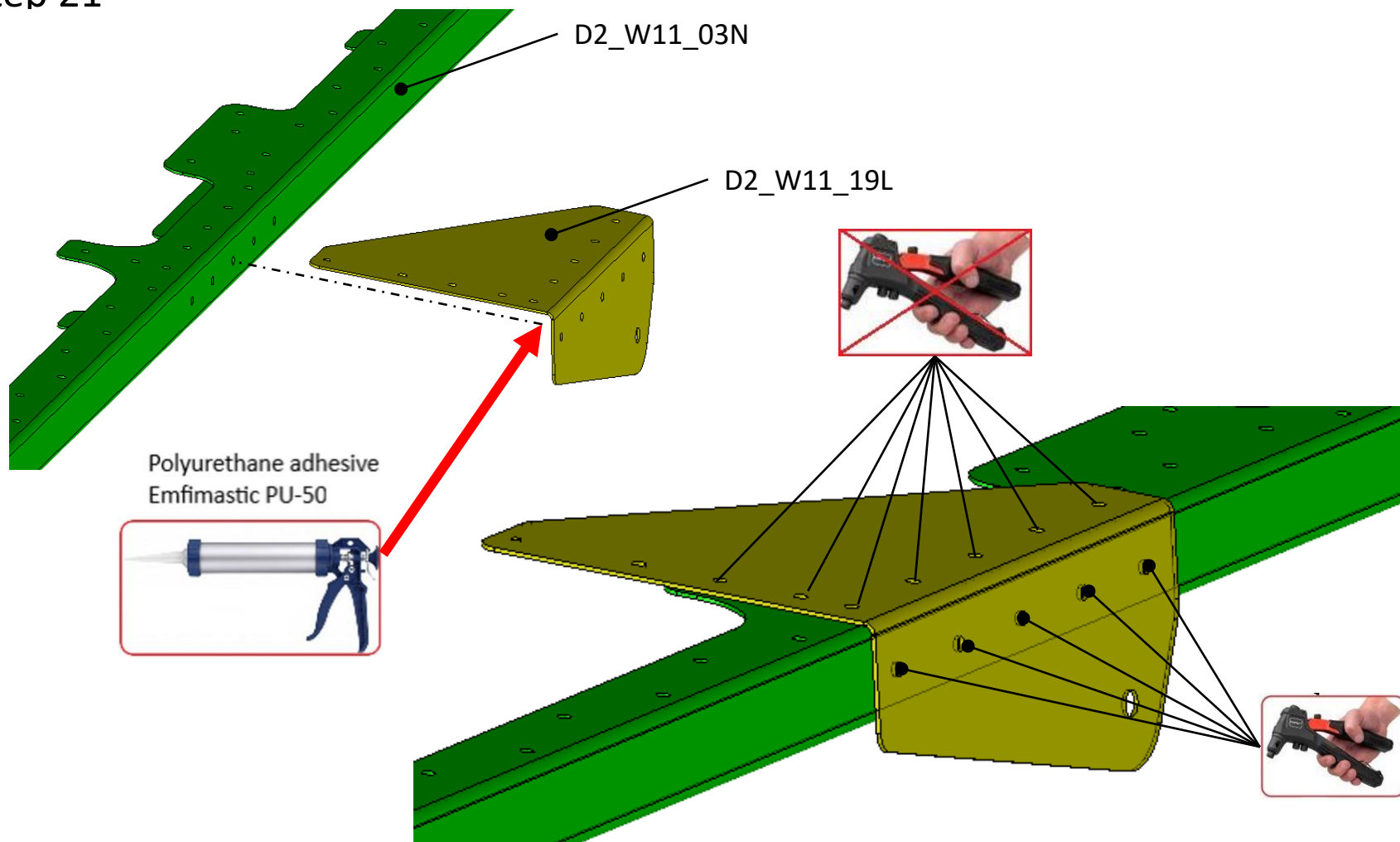
Step 20

D2_W11_03N



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	39	71

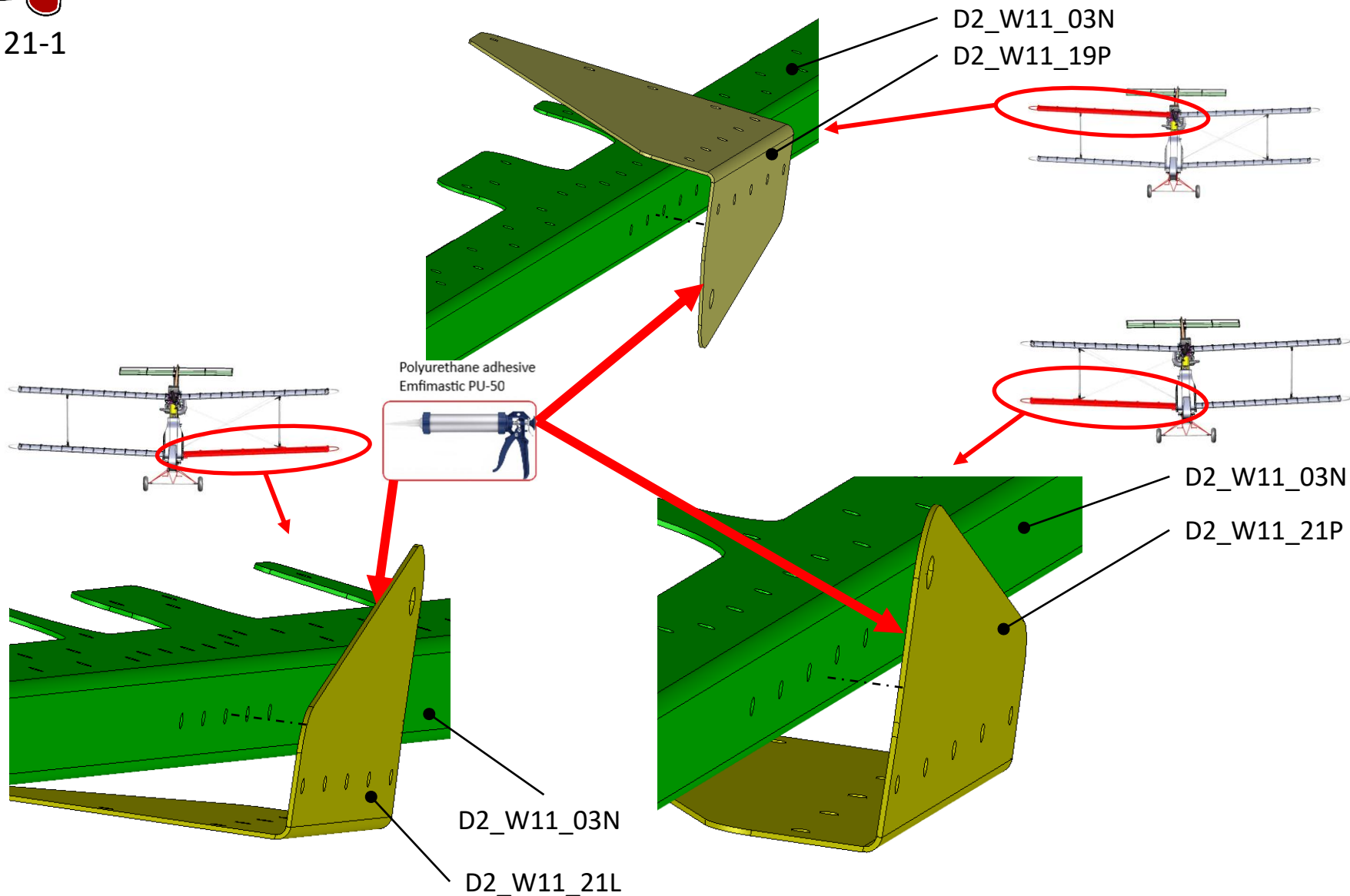
Step 21



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	40	71



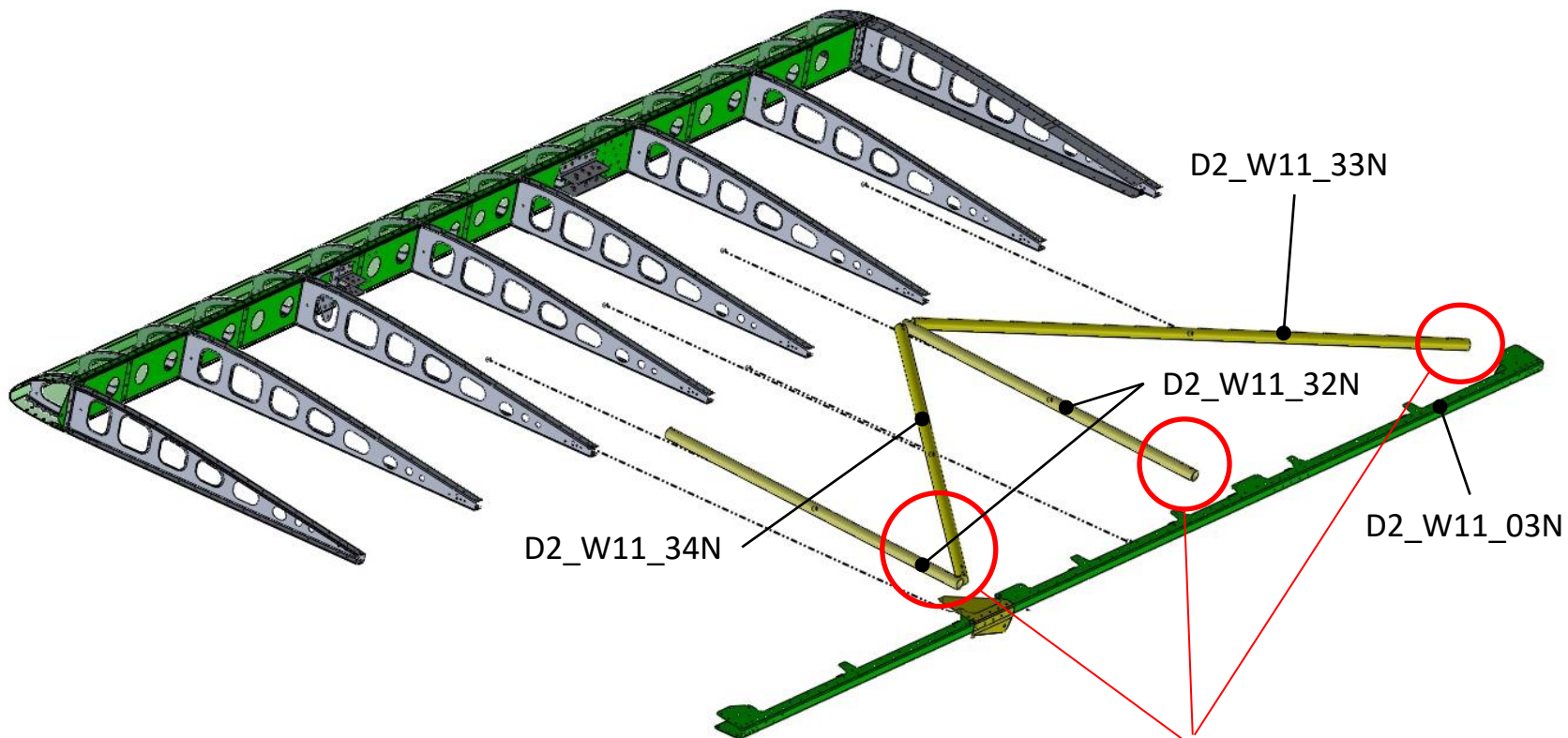
Step 21-1



Title	Document no.	Revision	Page	Pages
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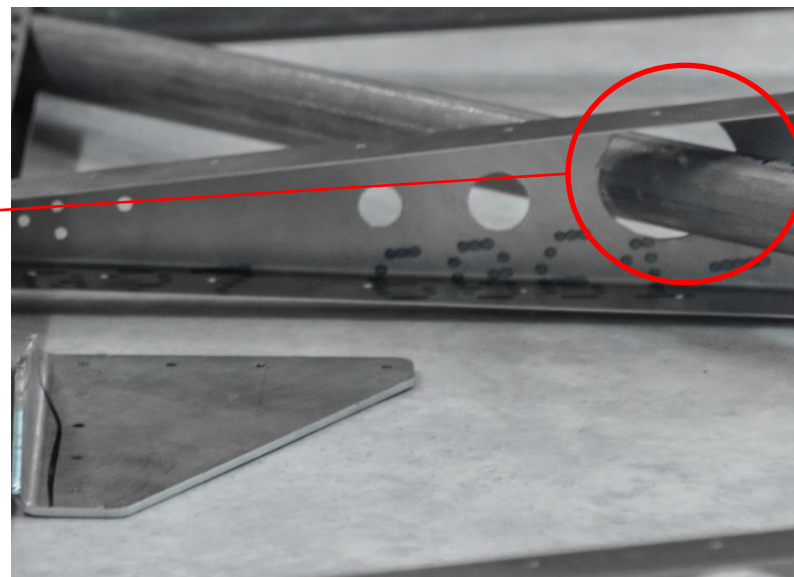
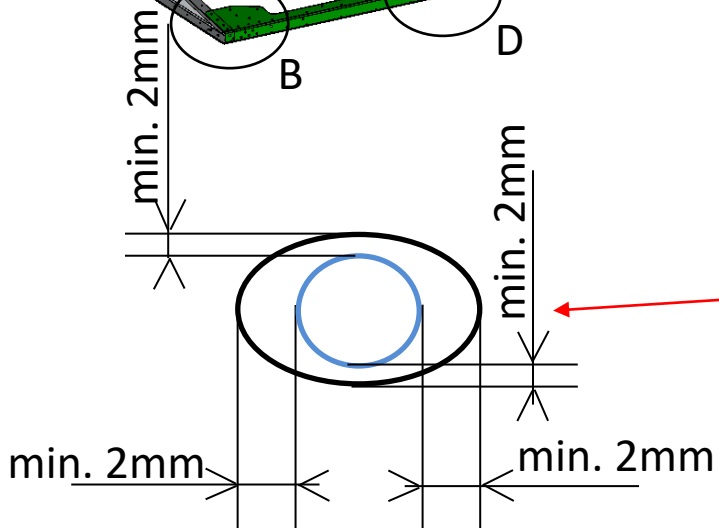
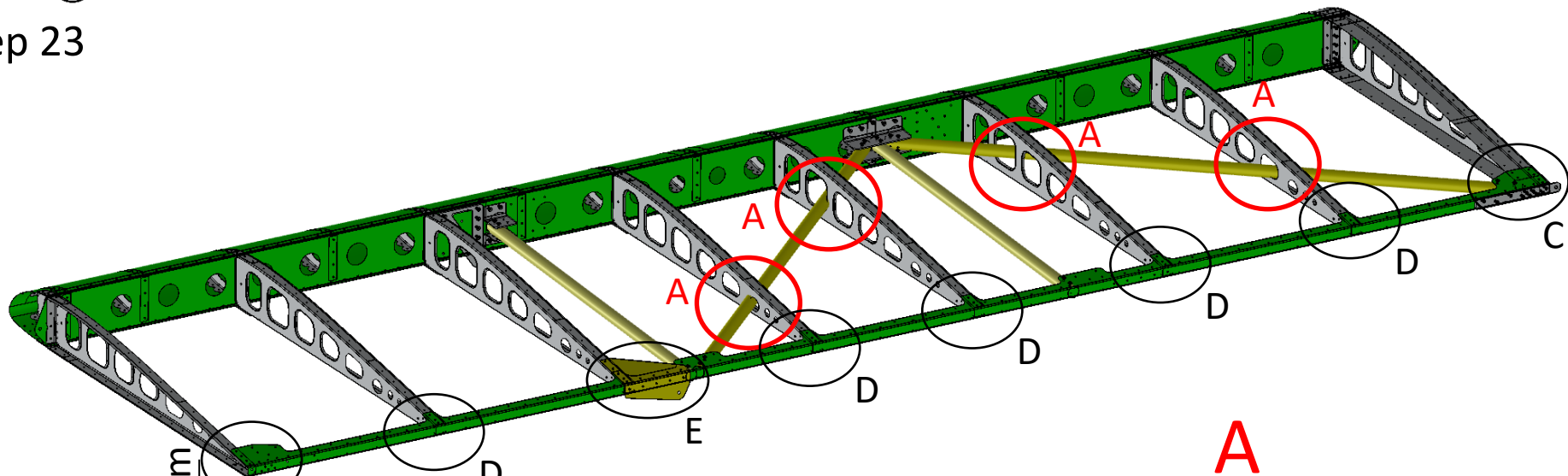
Step 22



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	42	71



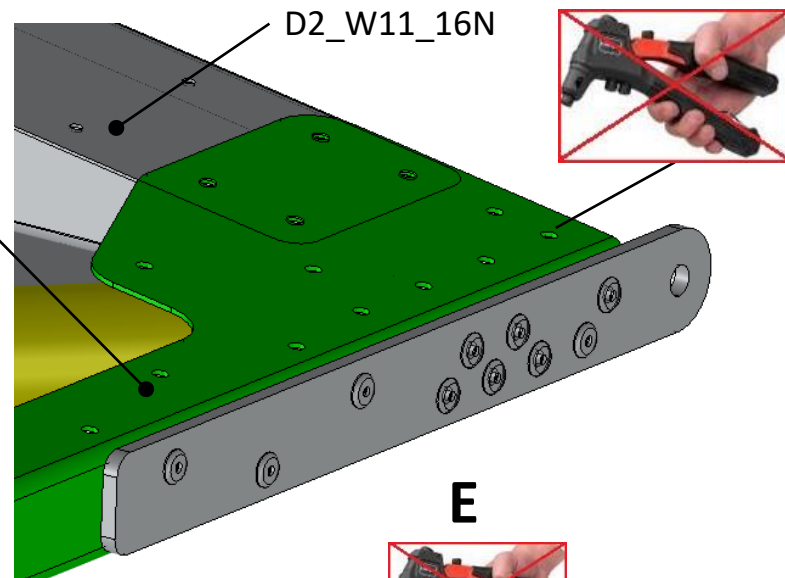
Step 23



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C



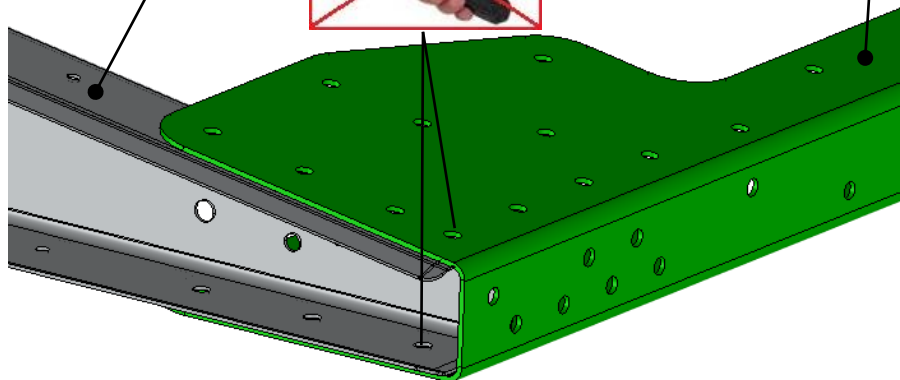
B

Step 24

D2_W11_06P



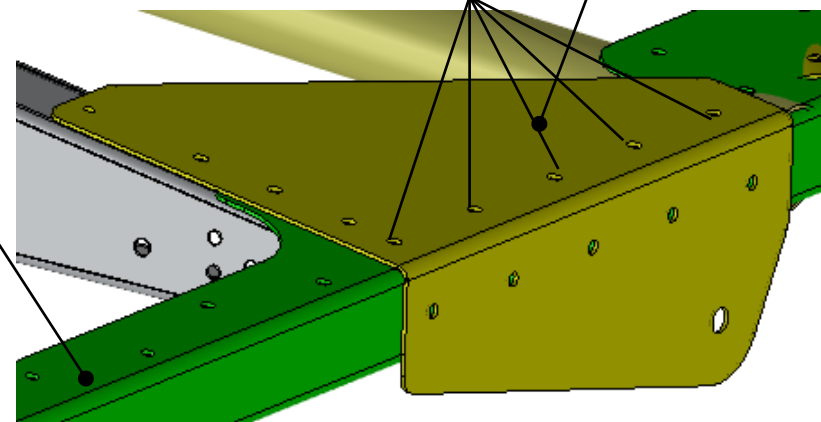
D2_W11_03N



E



D2_W11_19L

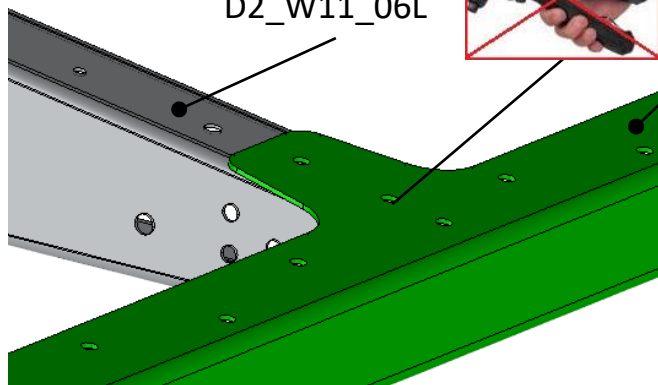


D

D2_W11_06L



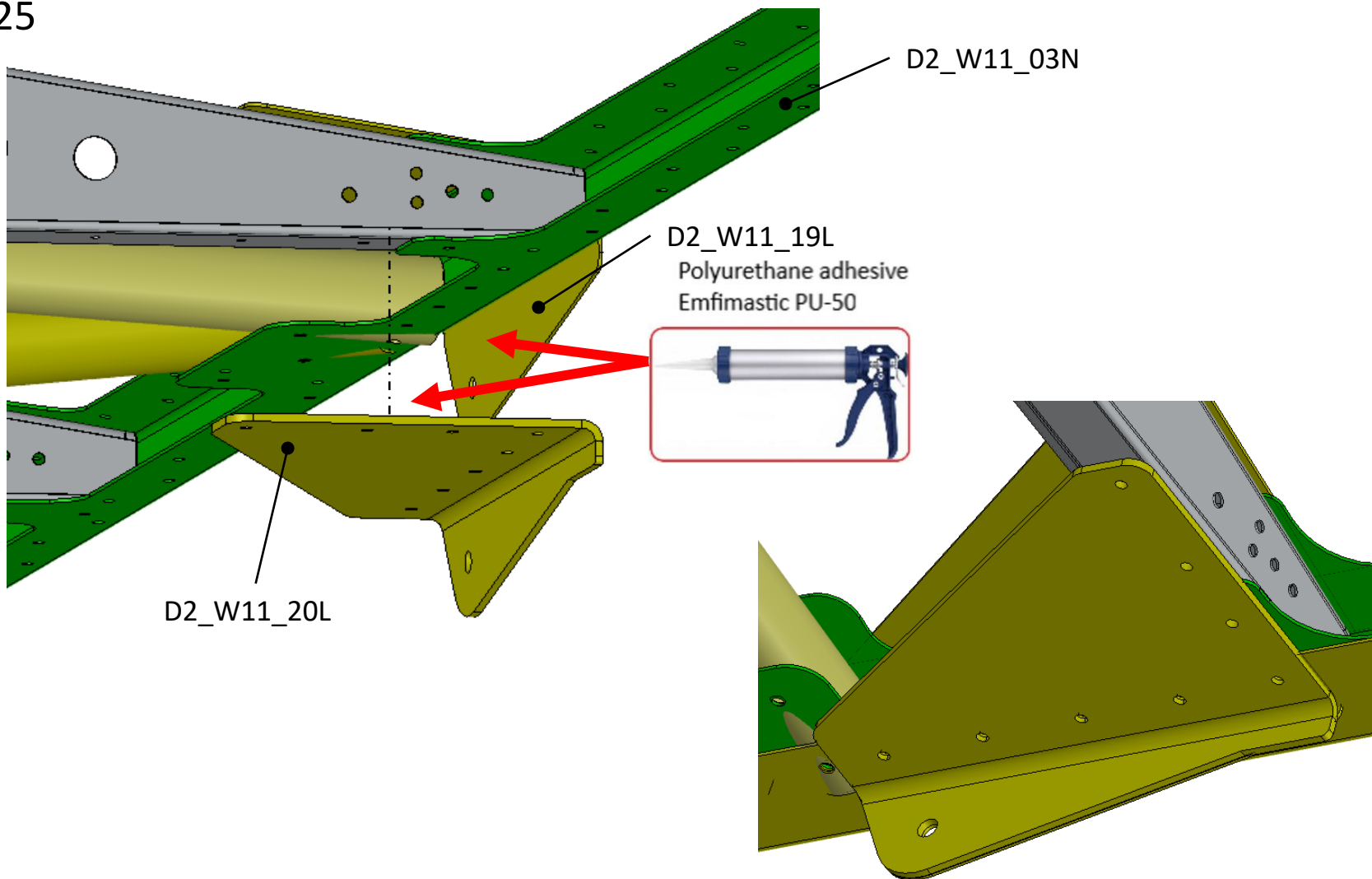
D2_W11_03N



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	44	71



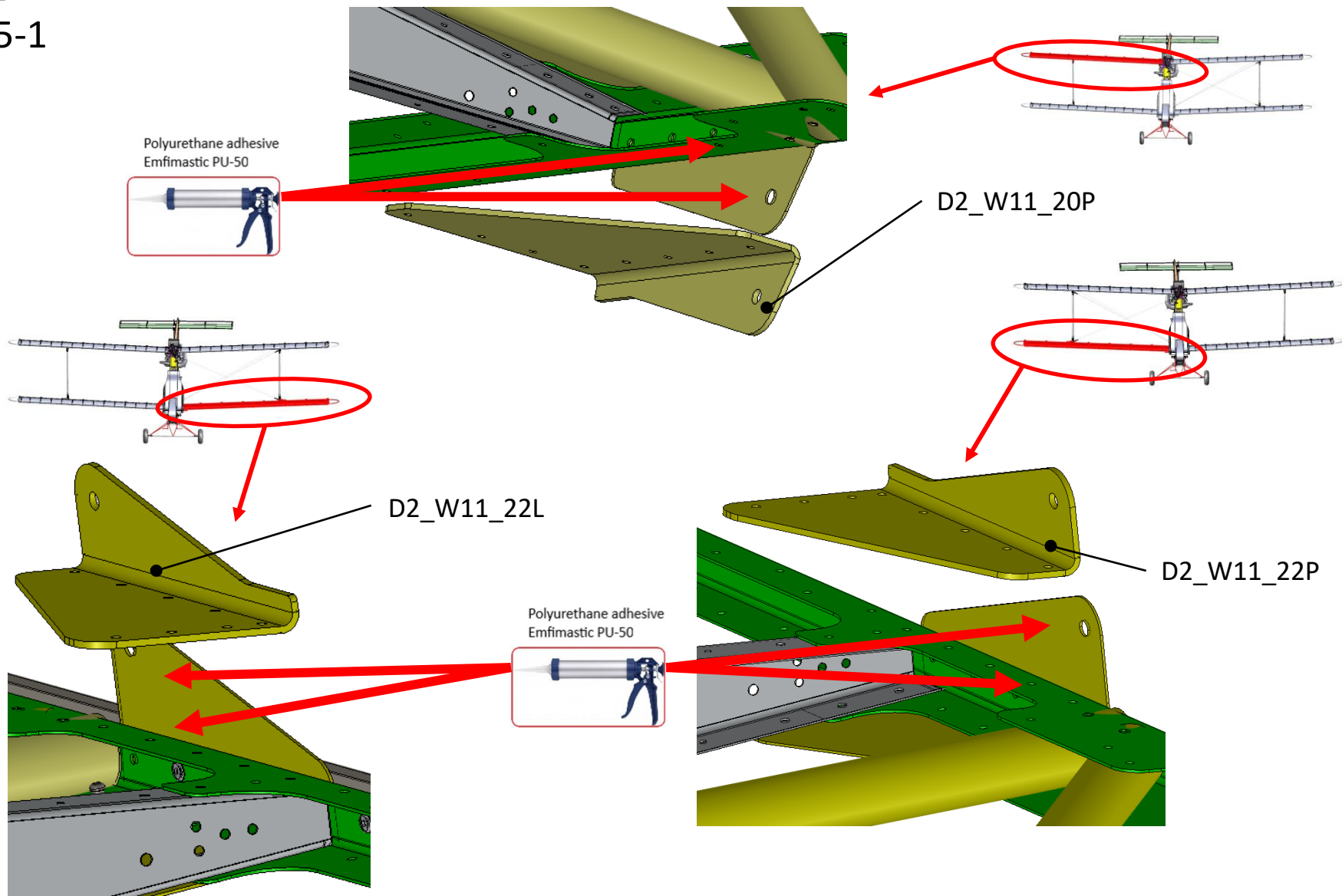
Step 25



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	45	71



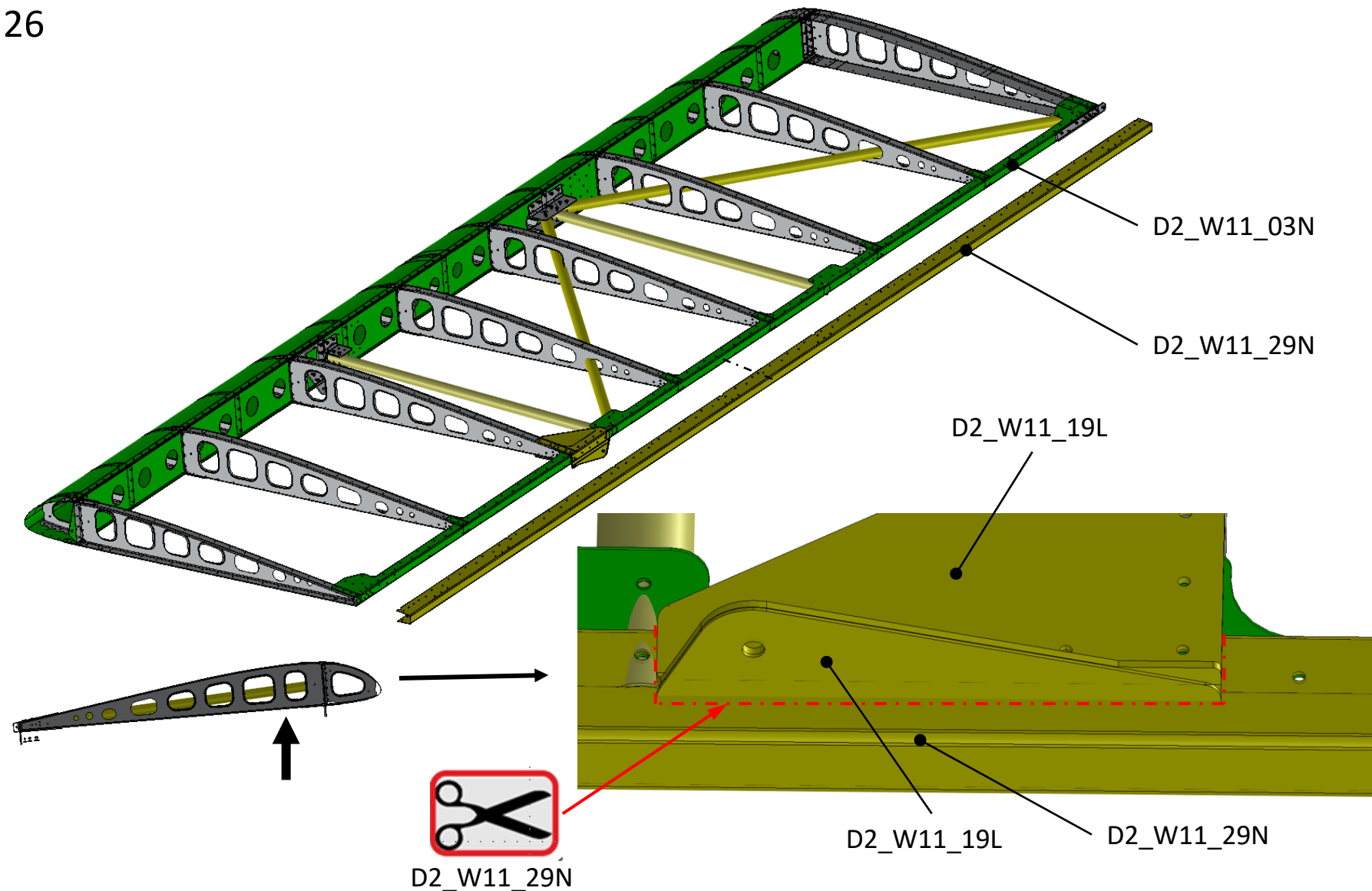
Step 25-1



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	46	71



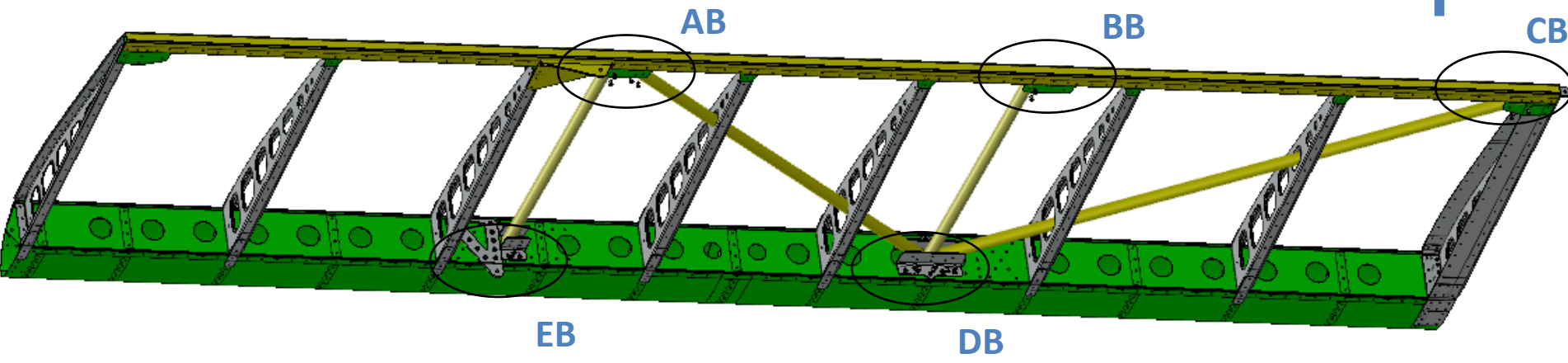
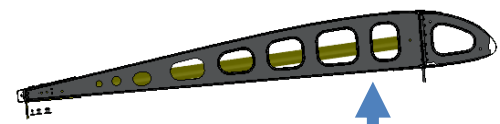
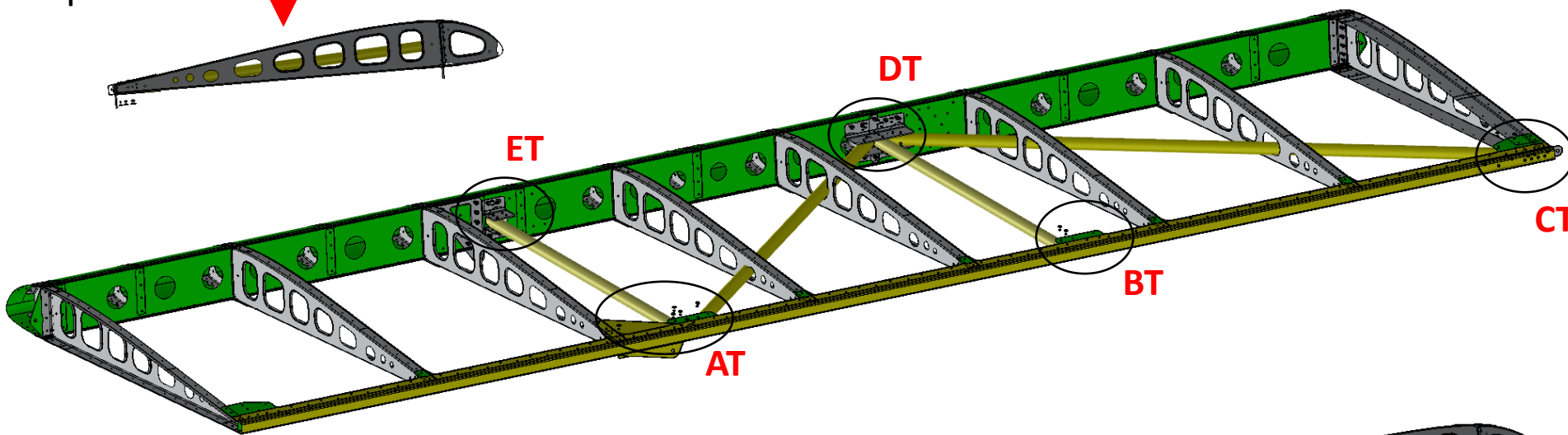
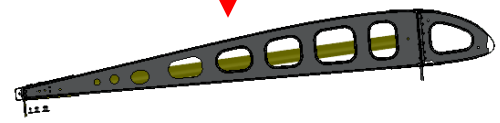
Step 26



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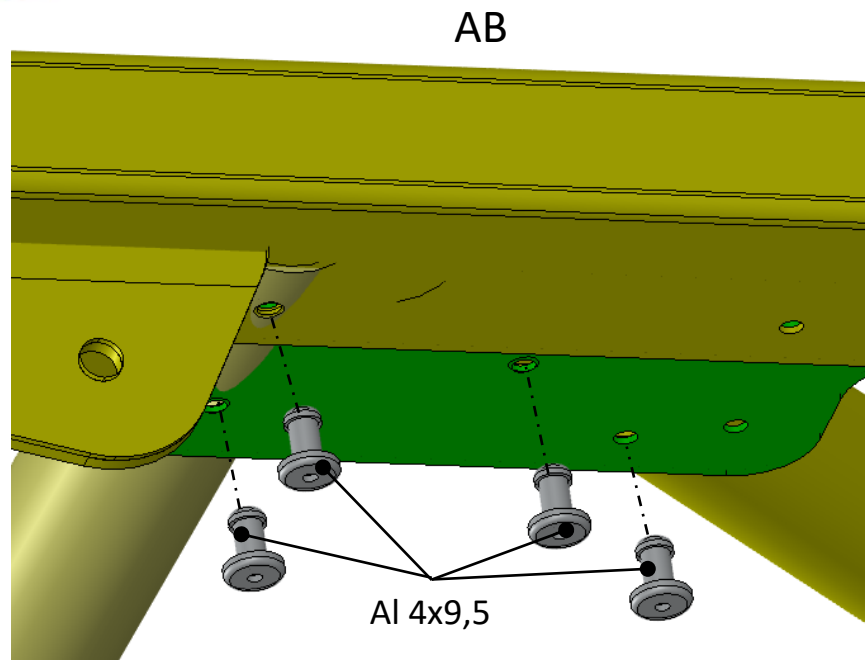
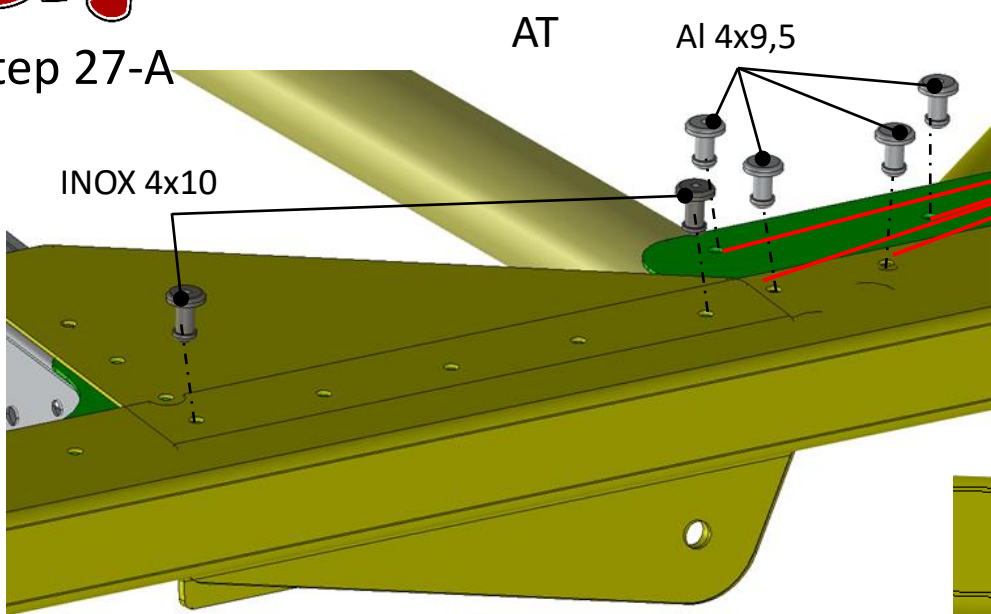
Step 27



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	48	71



Step 27-A



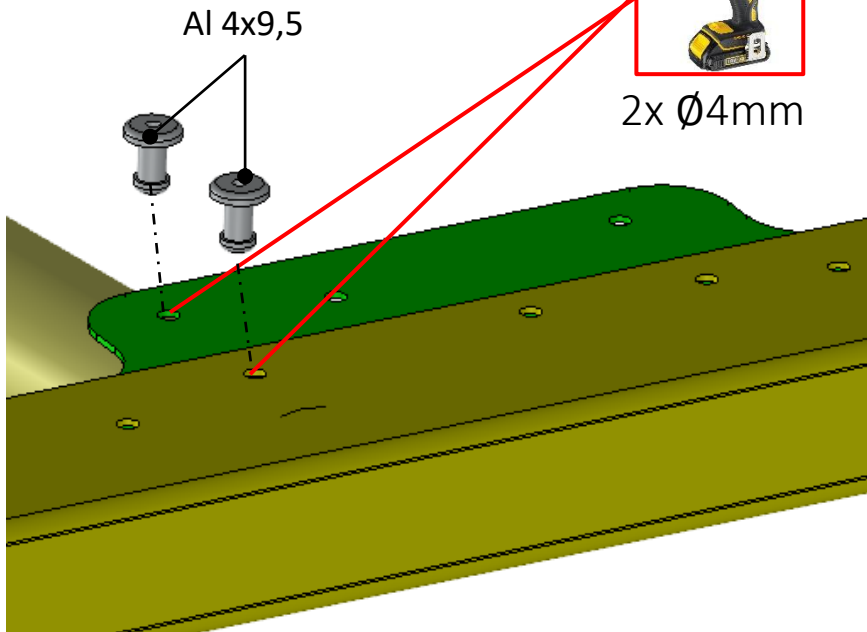
Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	49	71

Step 27-B

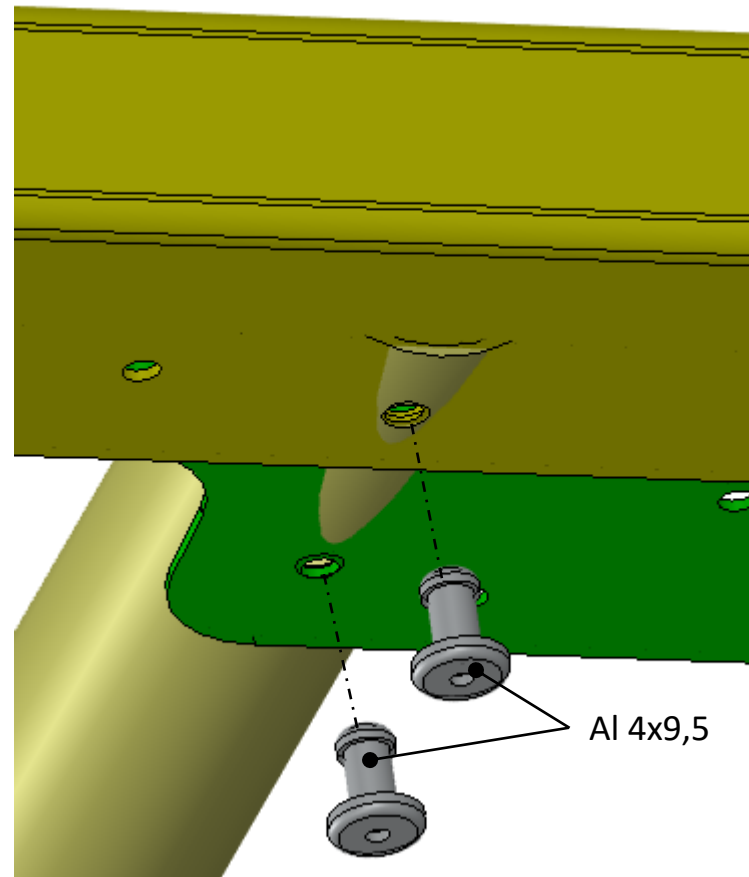
BT



2x Ø4mm



BB



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	50	71

Step 27-C

CT

Al 4x9,5



2x Ø4mm

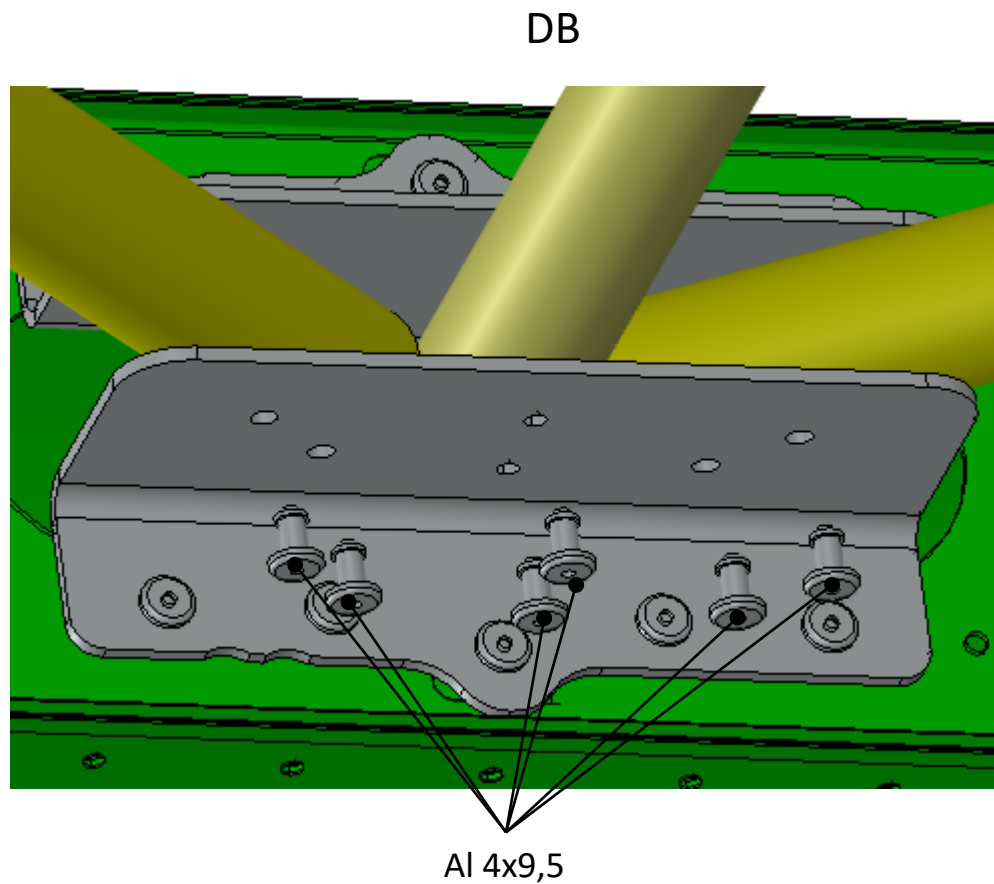
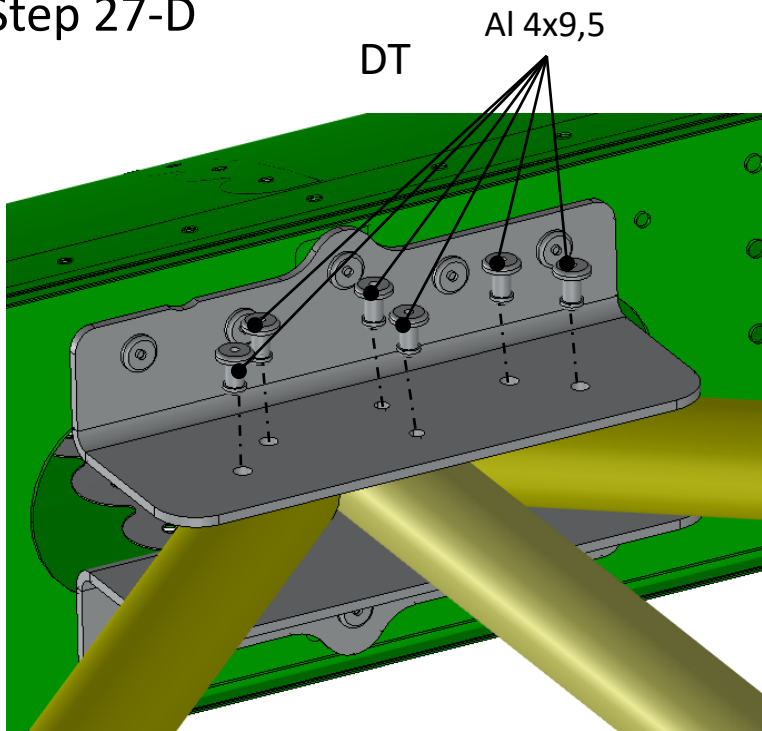
CB

Al 4x9,5

Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	51	71

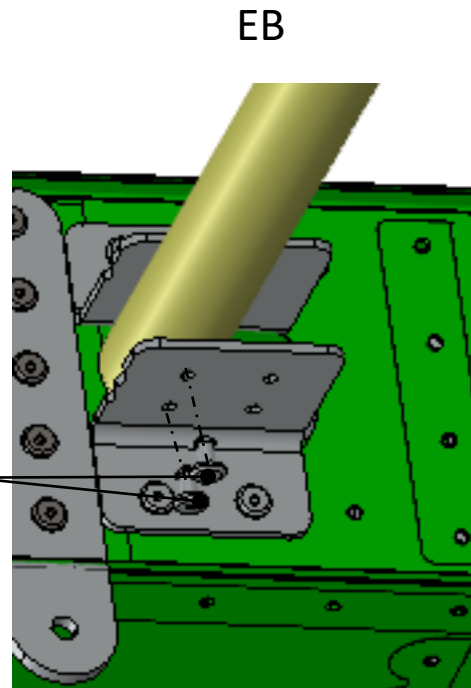
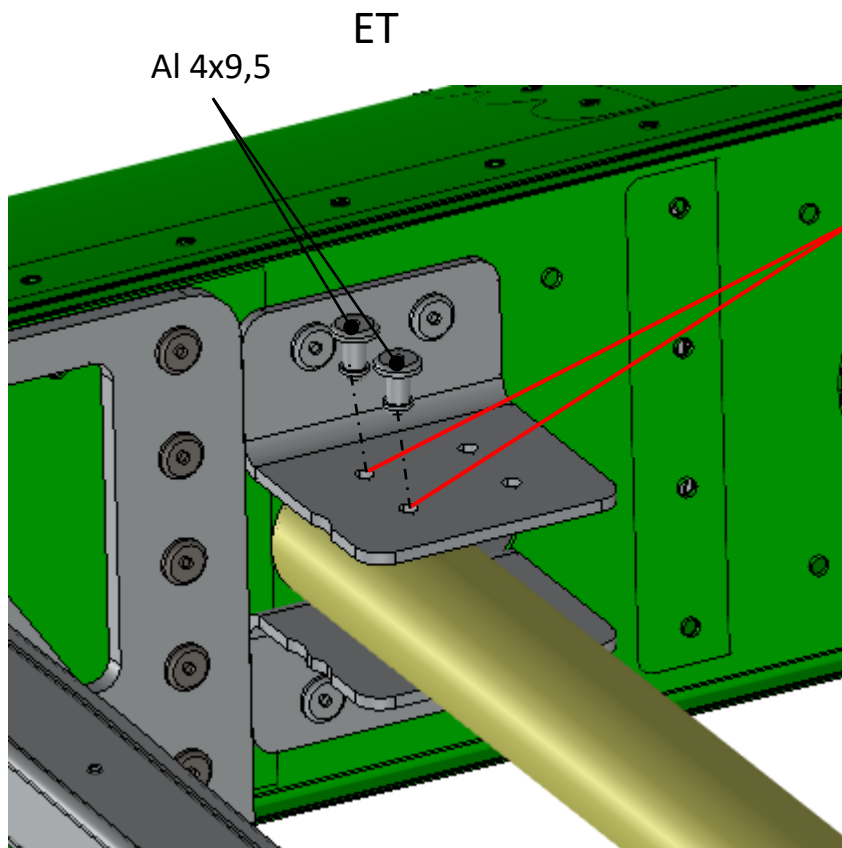


Step 27-D



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	53	71

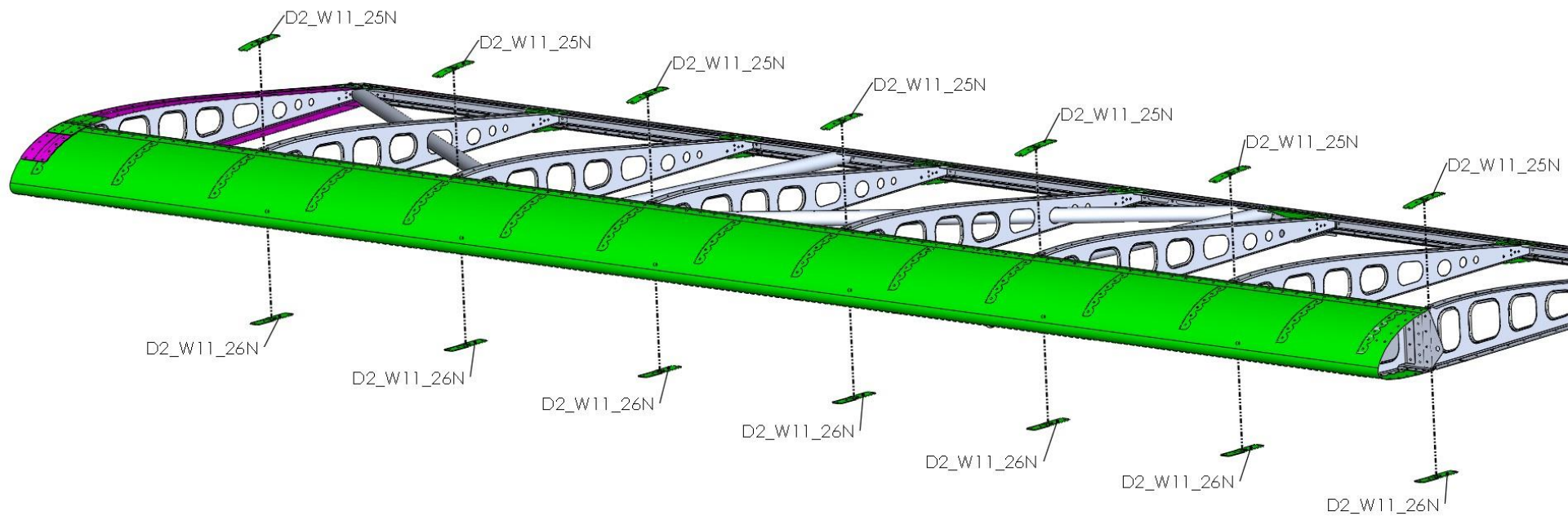
Step 27-E



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	54	71



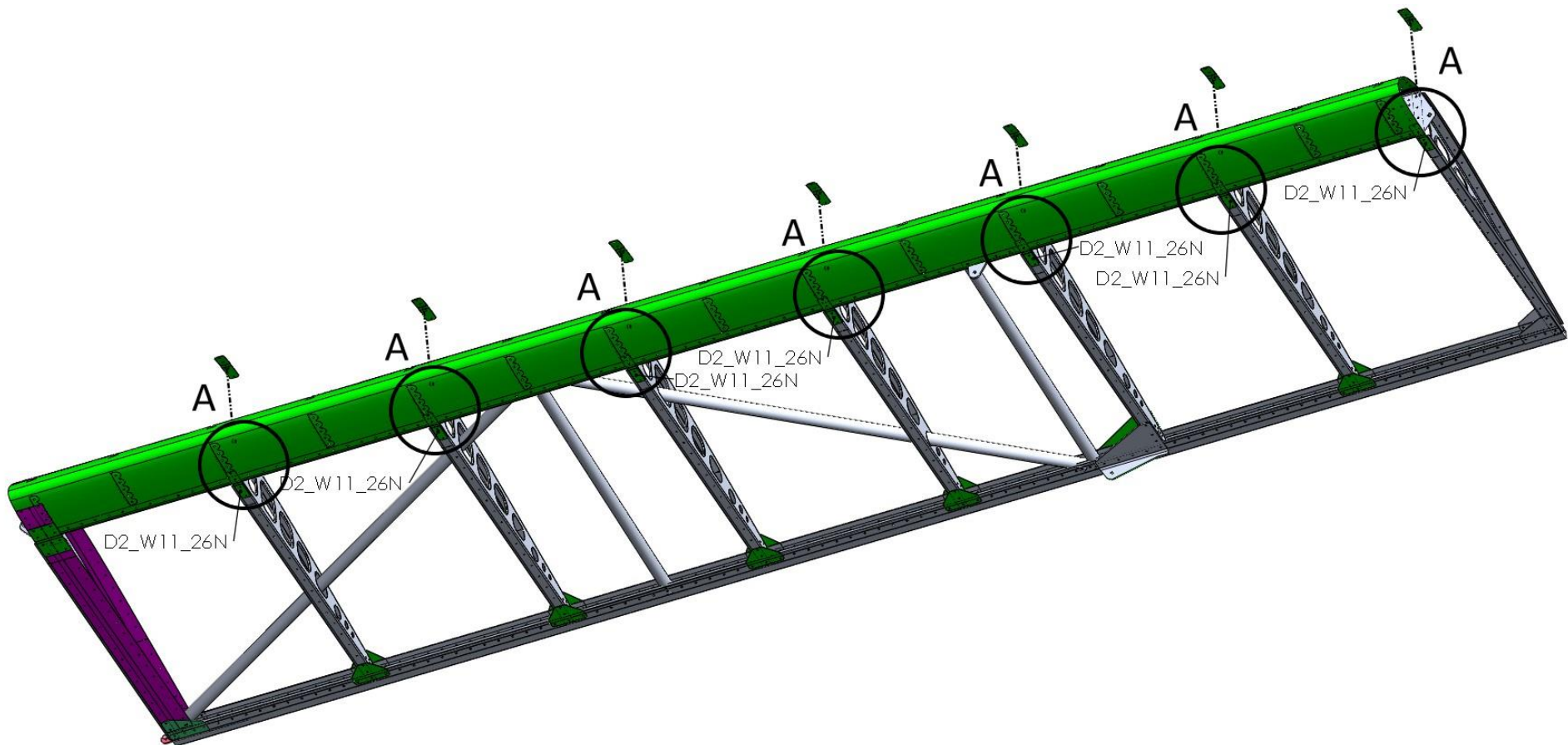
Step 28



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	55	71



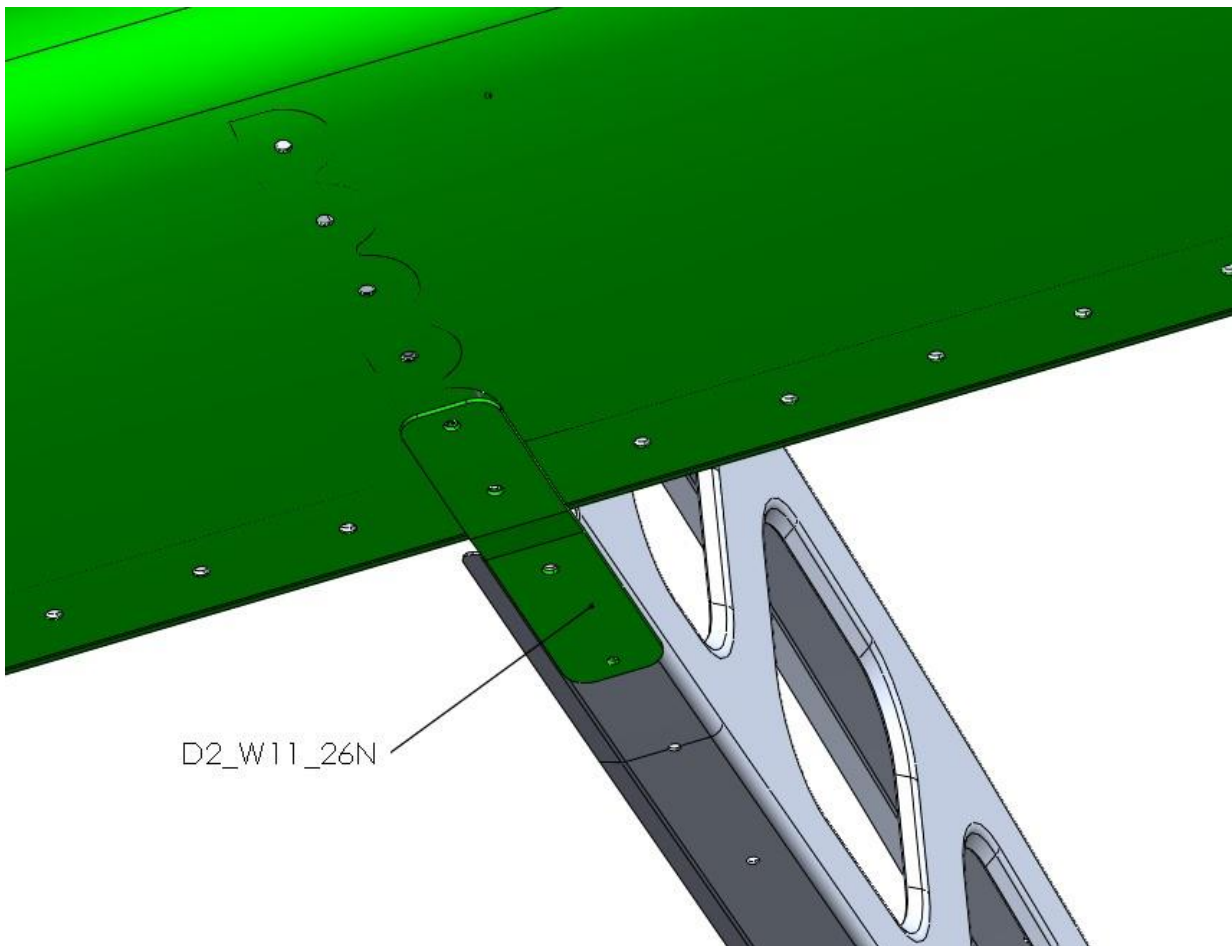
Step 29



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	56	71



Step 29-A

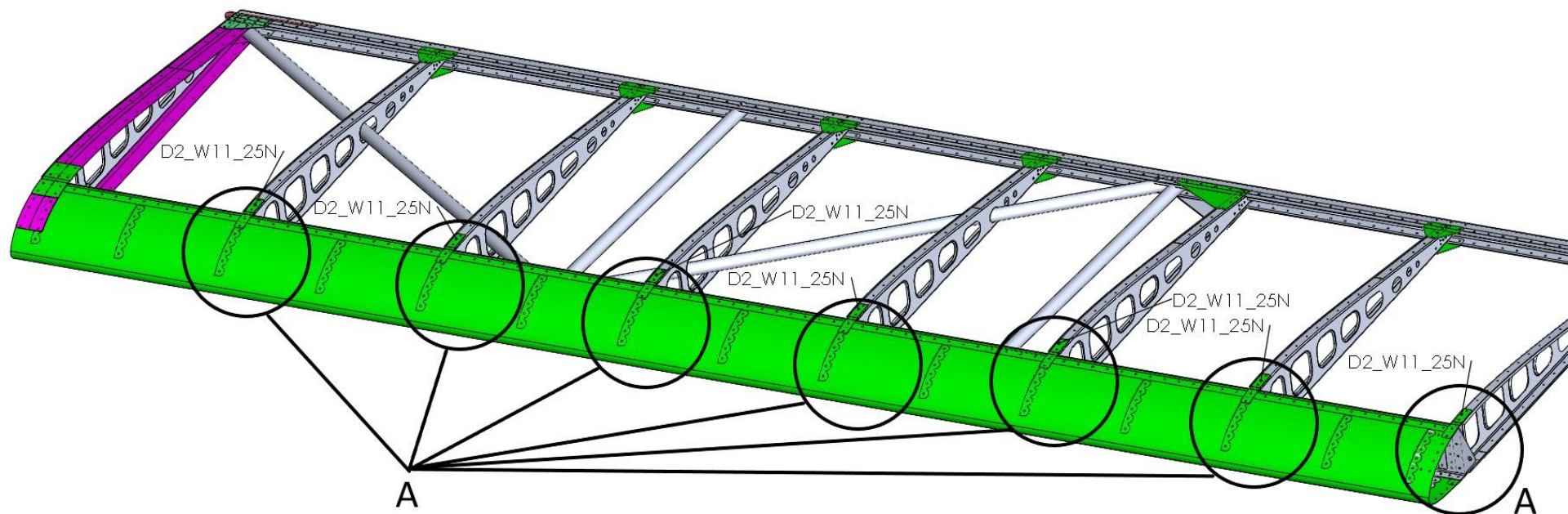


D2_W11_26N

Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	57	71



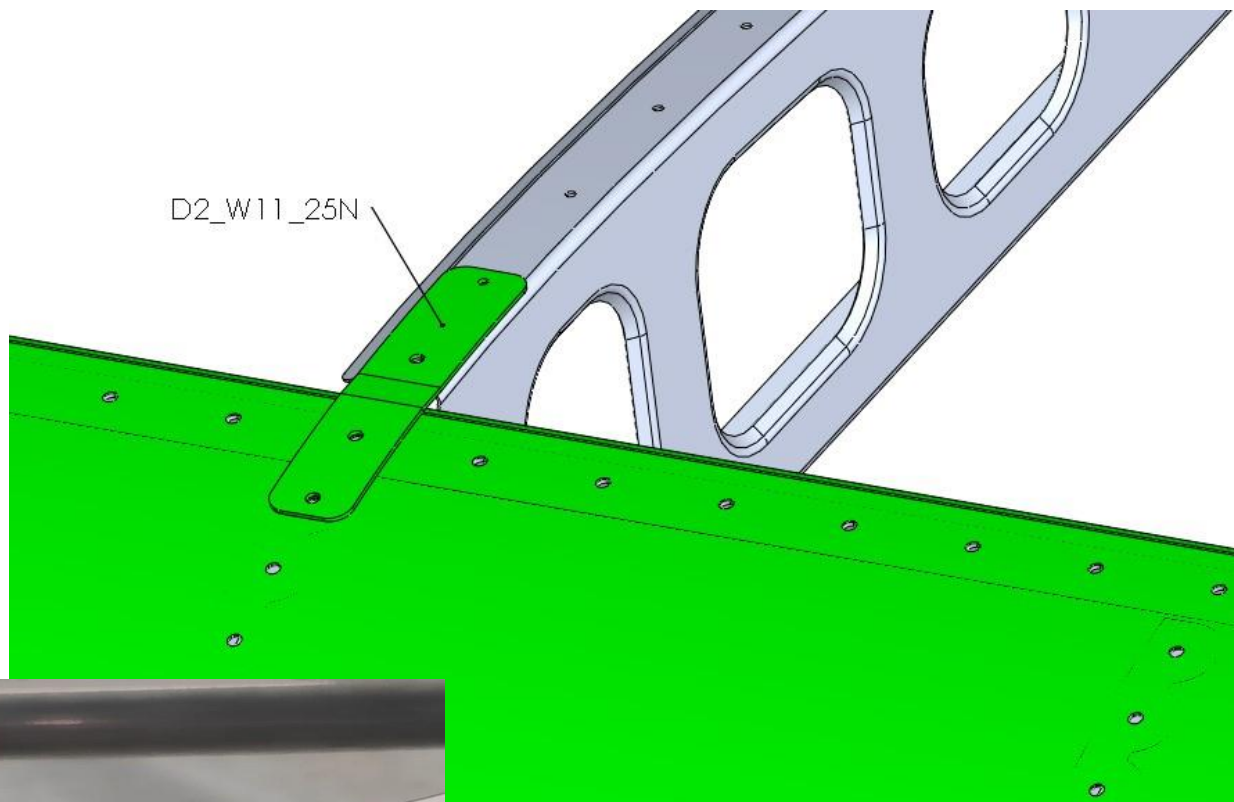
Step 30



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	58	71



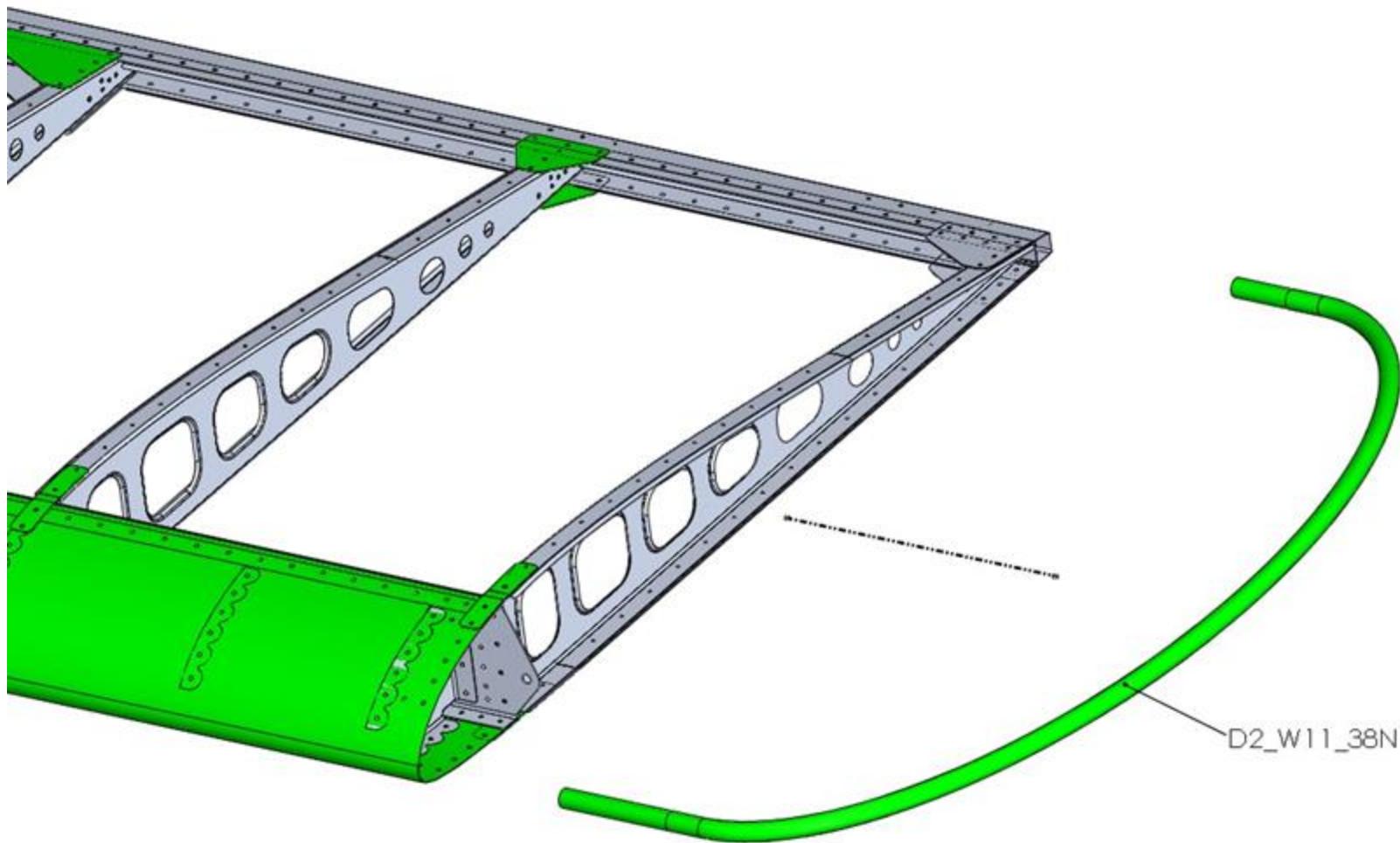
Step 30-A



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	59	71



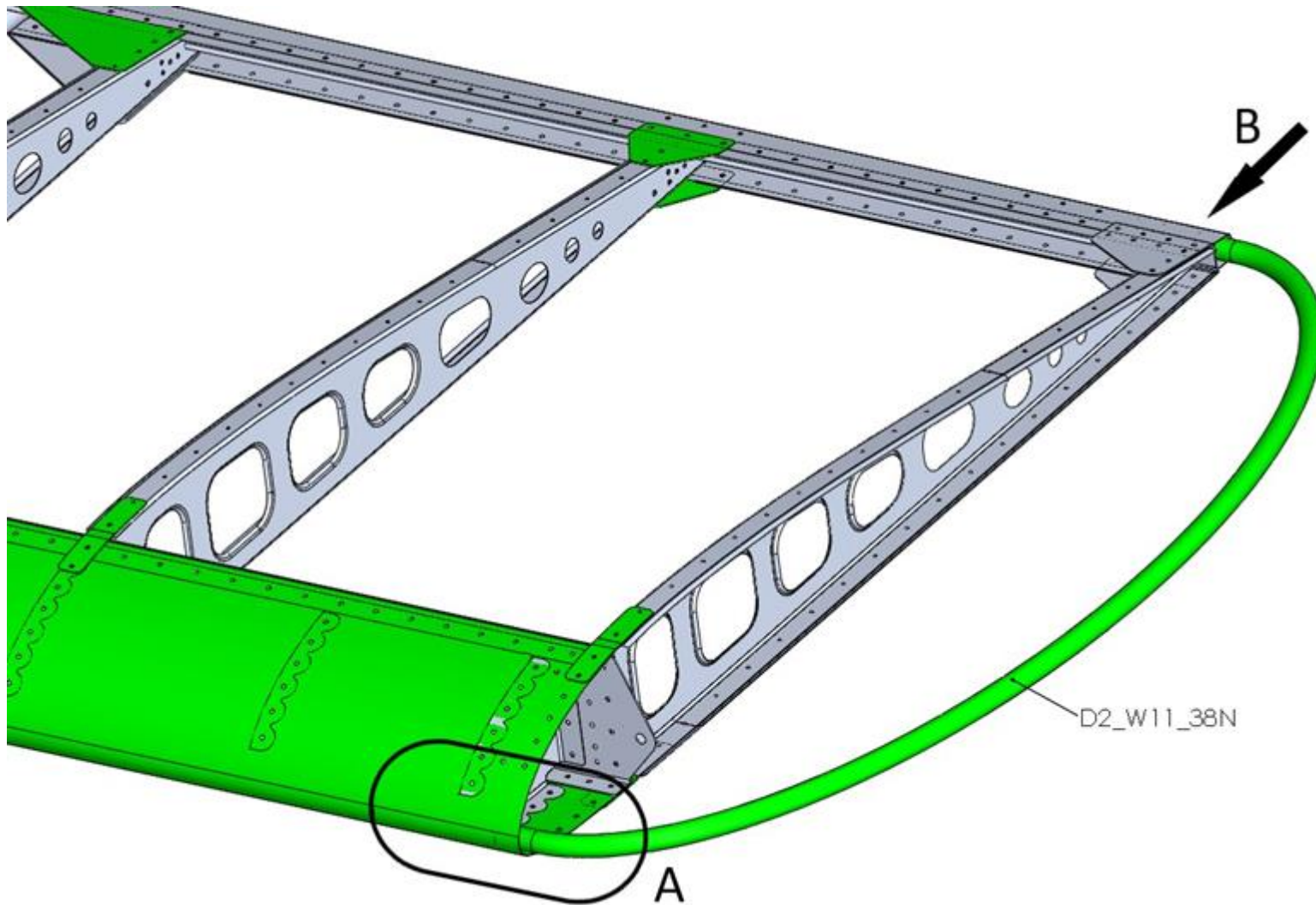
Step 31



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	60	71



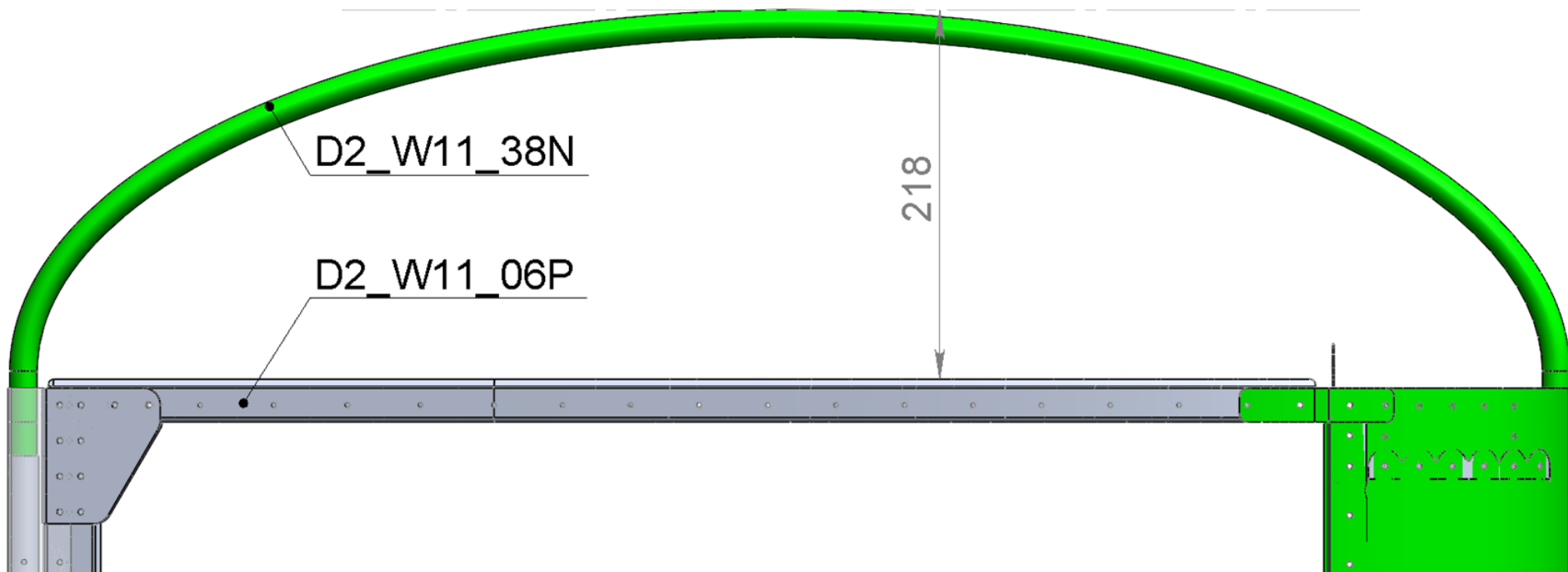
Step 32



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	61	71



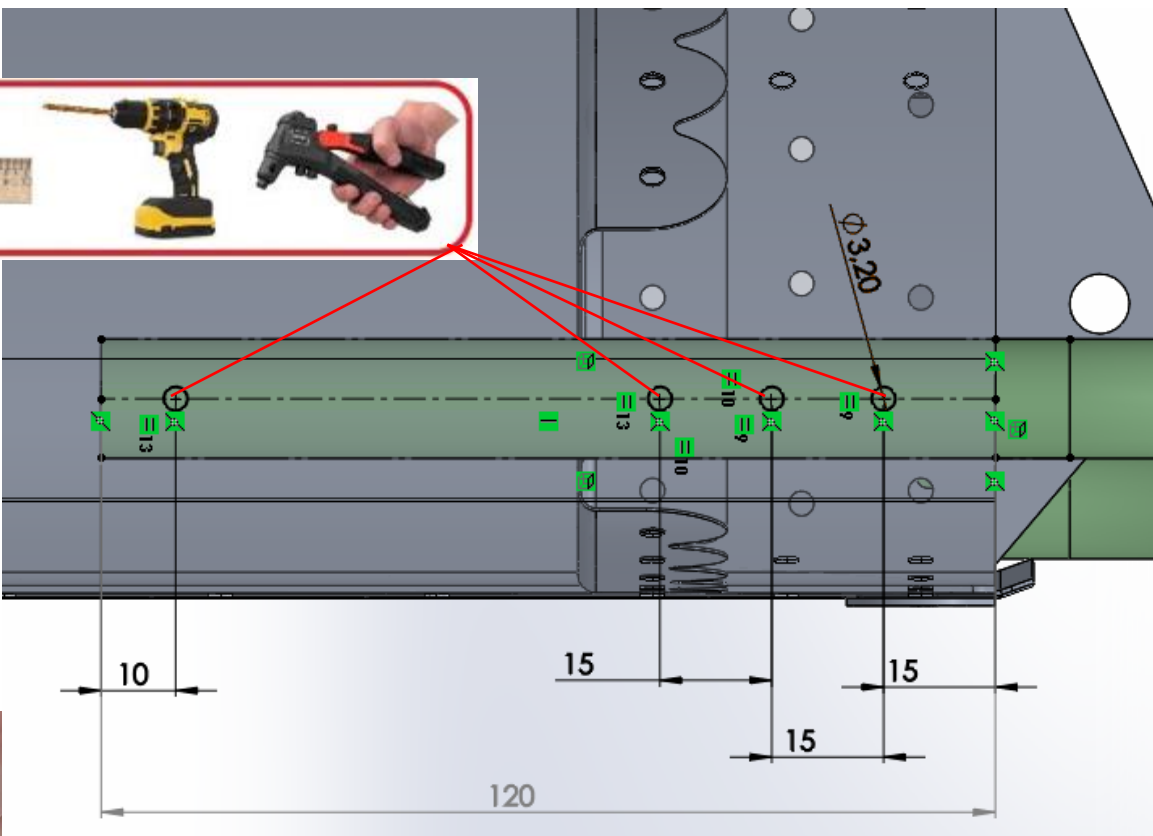
Step 33



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	62	71



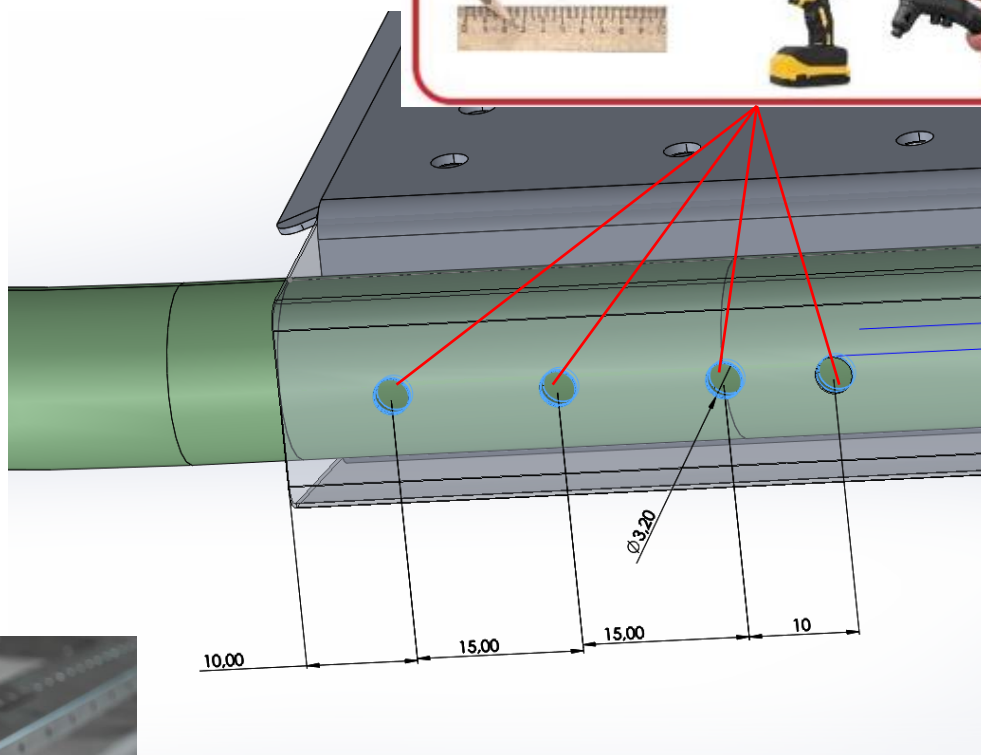
Step 32-A



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	63	71



Step 32-B

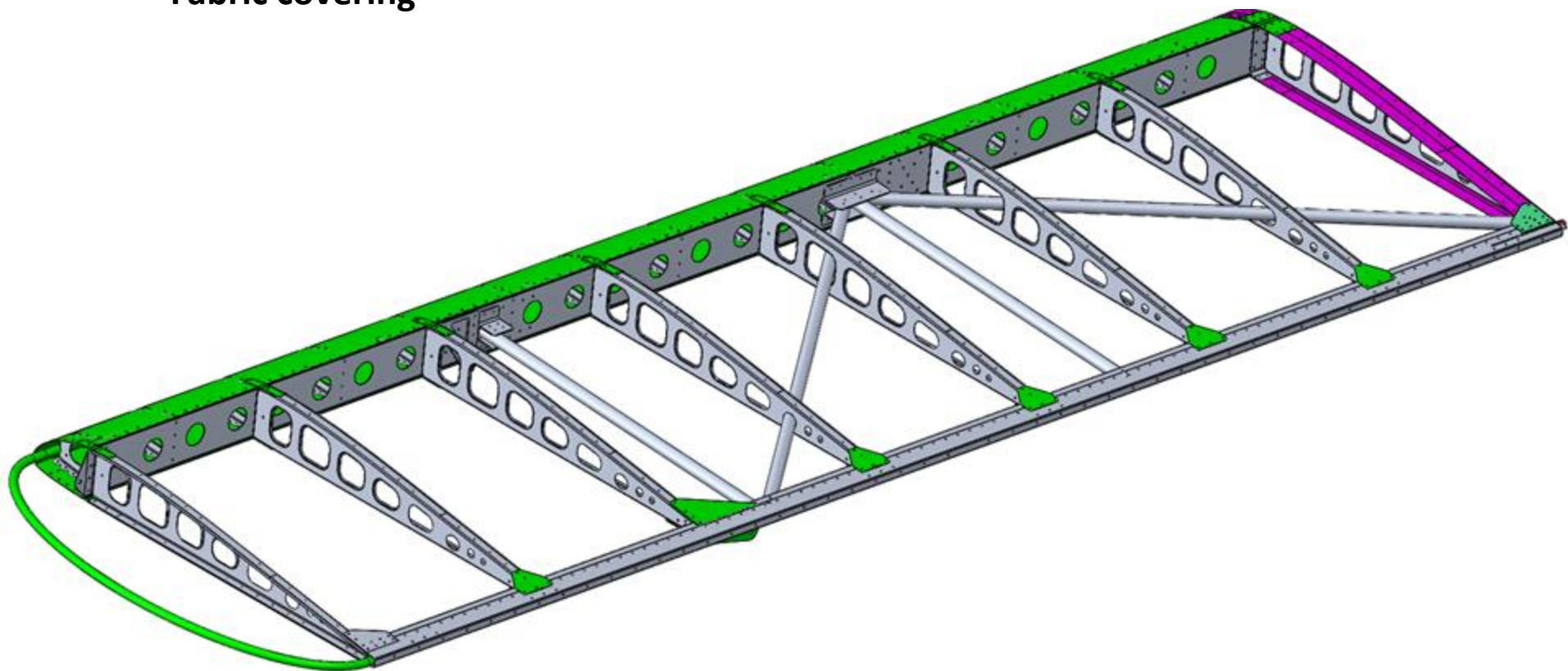


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Wing assembly manual	D2_W0_00	Rev. 03	64	71



Step 34

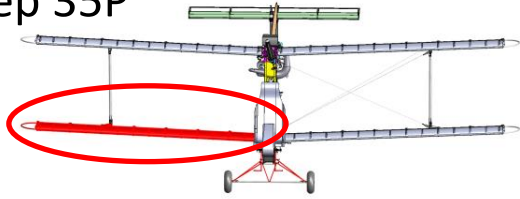
Fabric covering



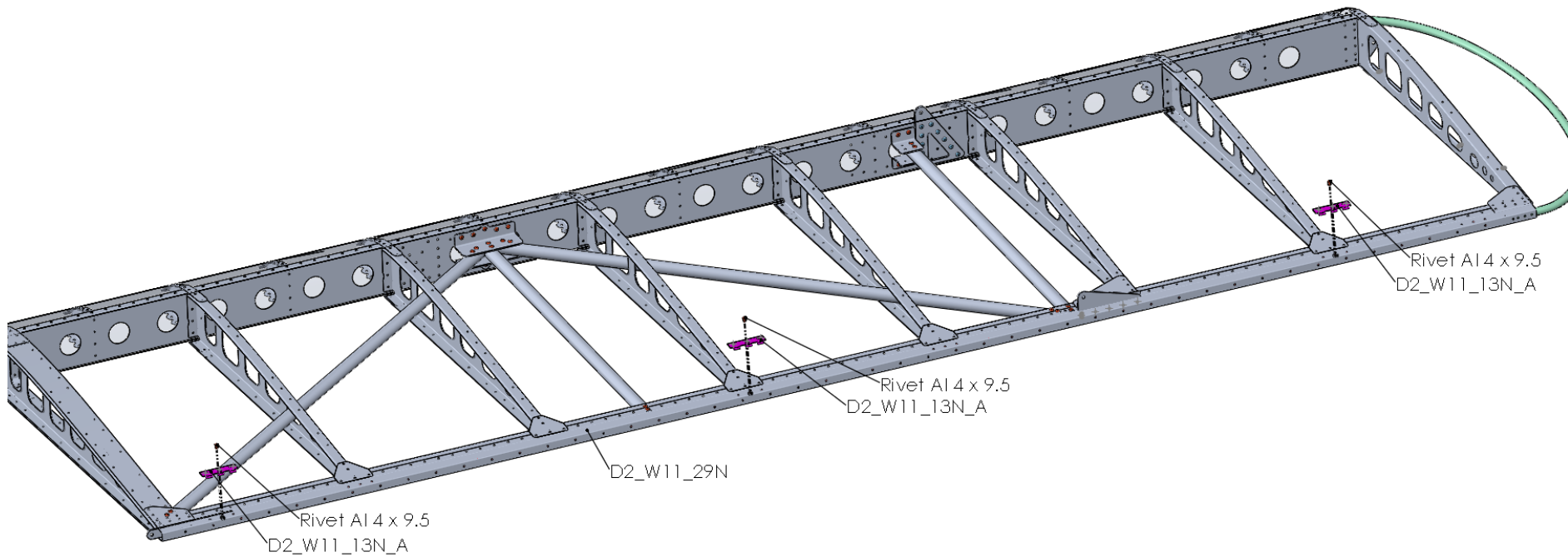
Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	65	71



Step 35P



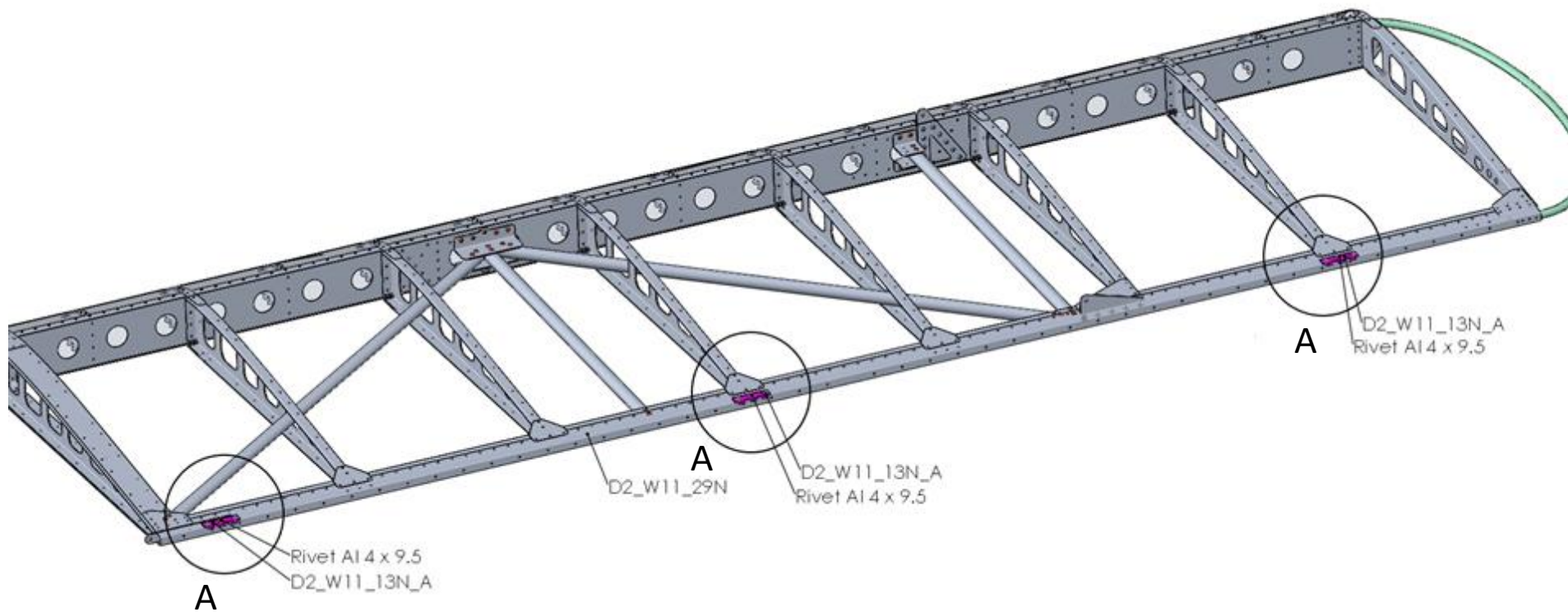
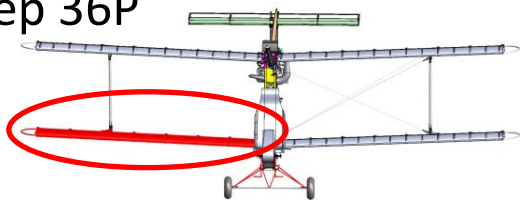
D2_W11_13N-A	3x
Rivet AVEX 3,2x7,9 Al/St	6x
Rivet AVEX 4x9,5 Al/St	3x



Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	66	71



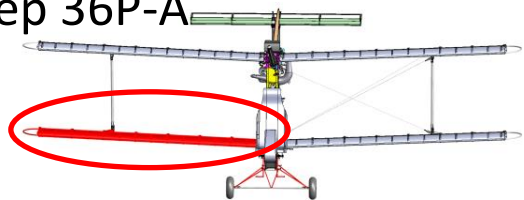
Step 36P



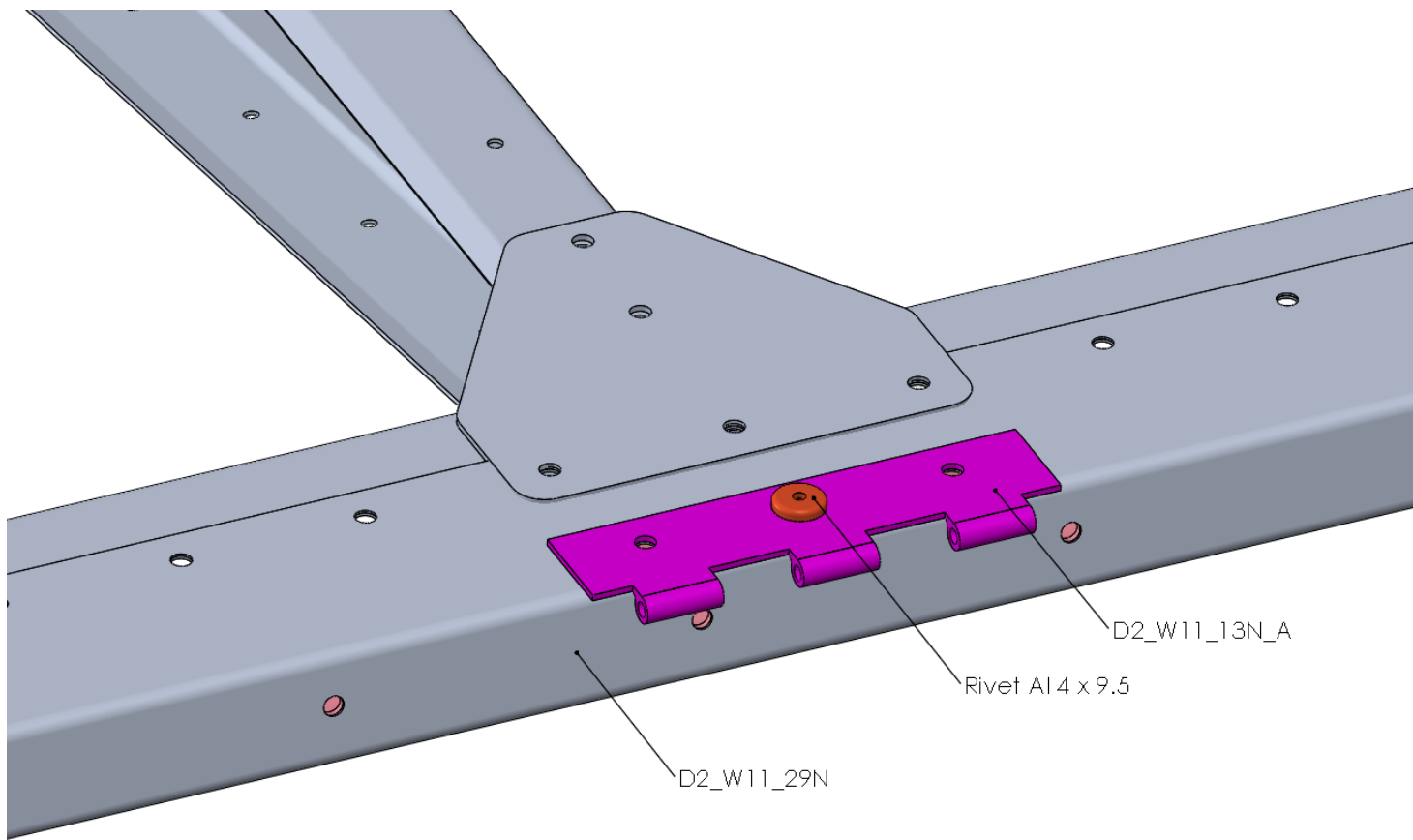
Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	67	71



Step 36P-A



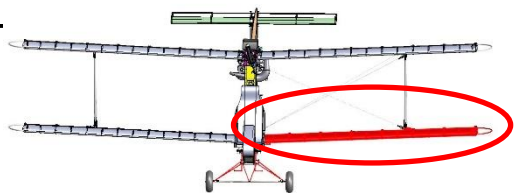
A



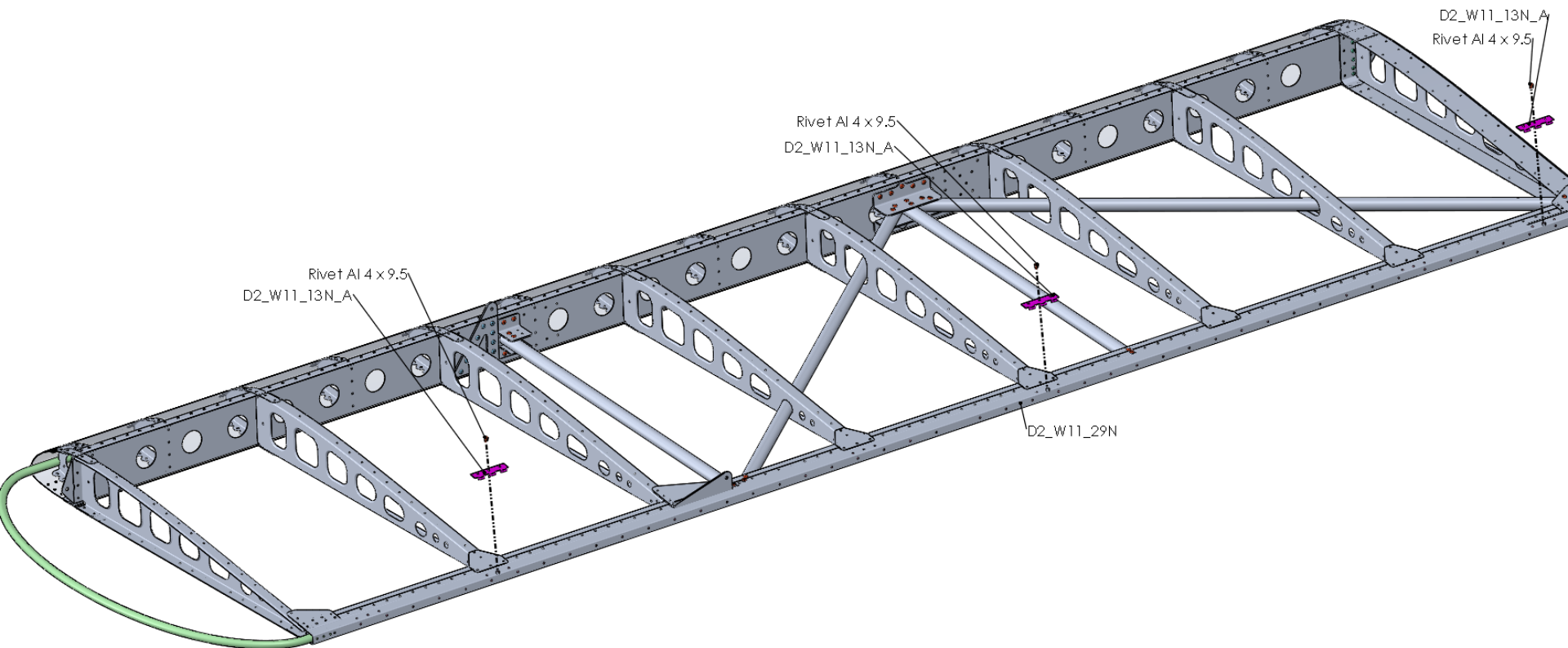
Title	Document no.	Revision	Page	Pages
Wing assembly manual	D2_W0_00	Rev. 03	68	71



Step 37L



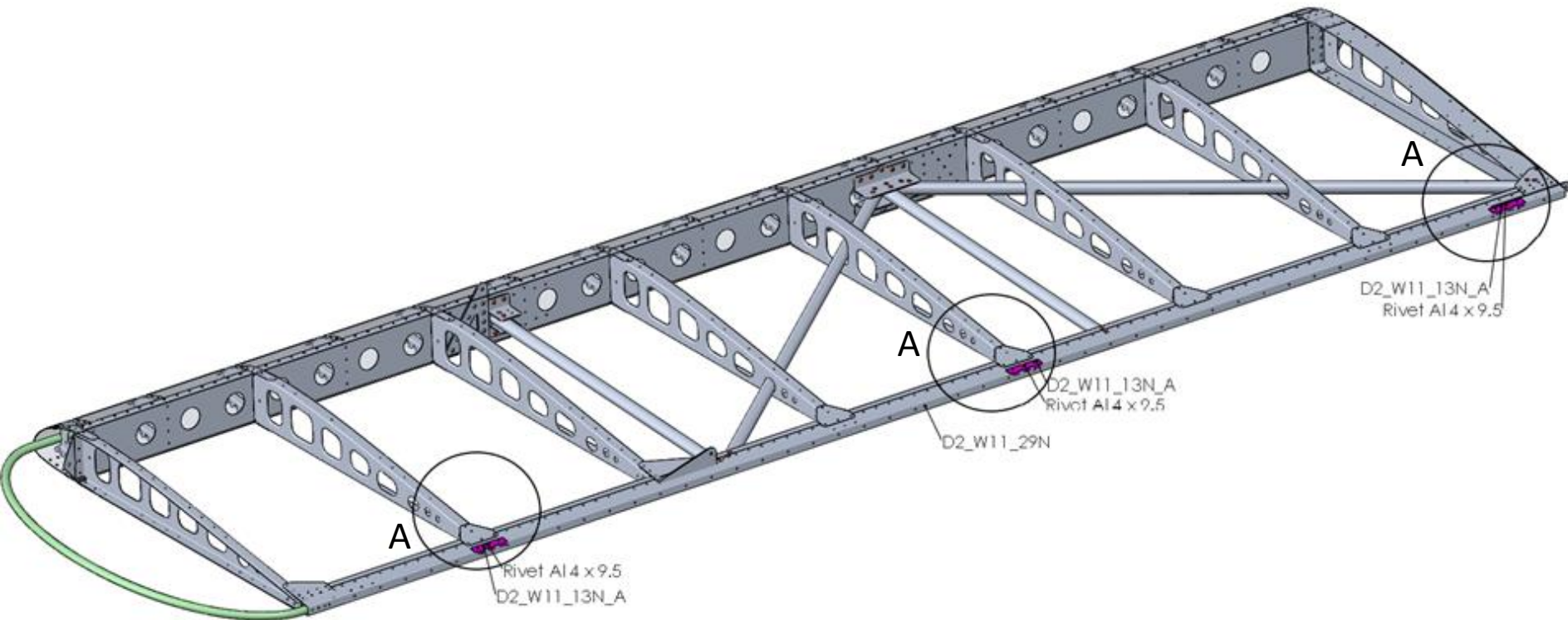
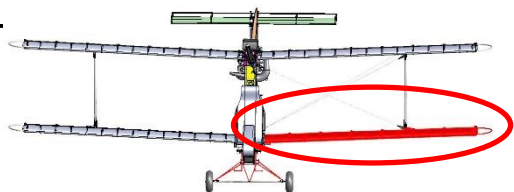
D2_W11_13N-A	3x
Rivet AVEX 3,2x7,9 Al/St	6x
Rivet AVEX 4x9,5 Al/St	3x



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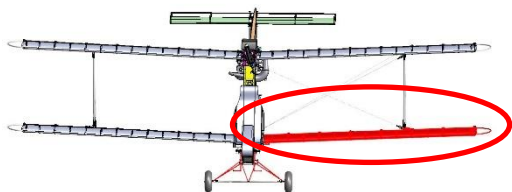
Step 38L



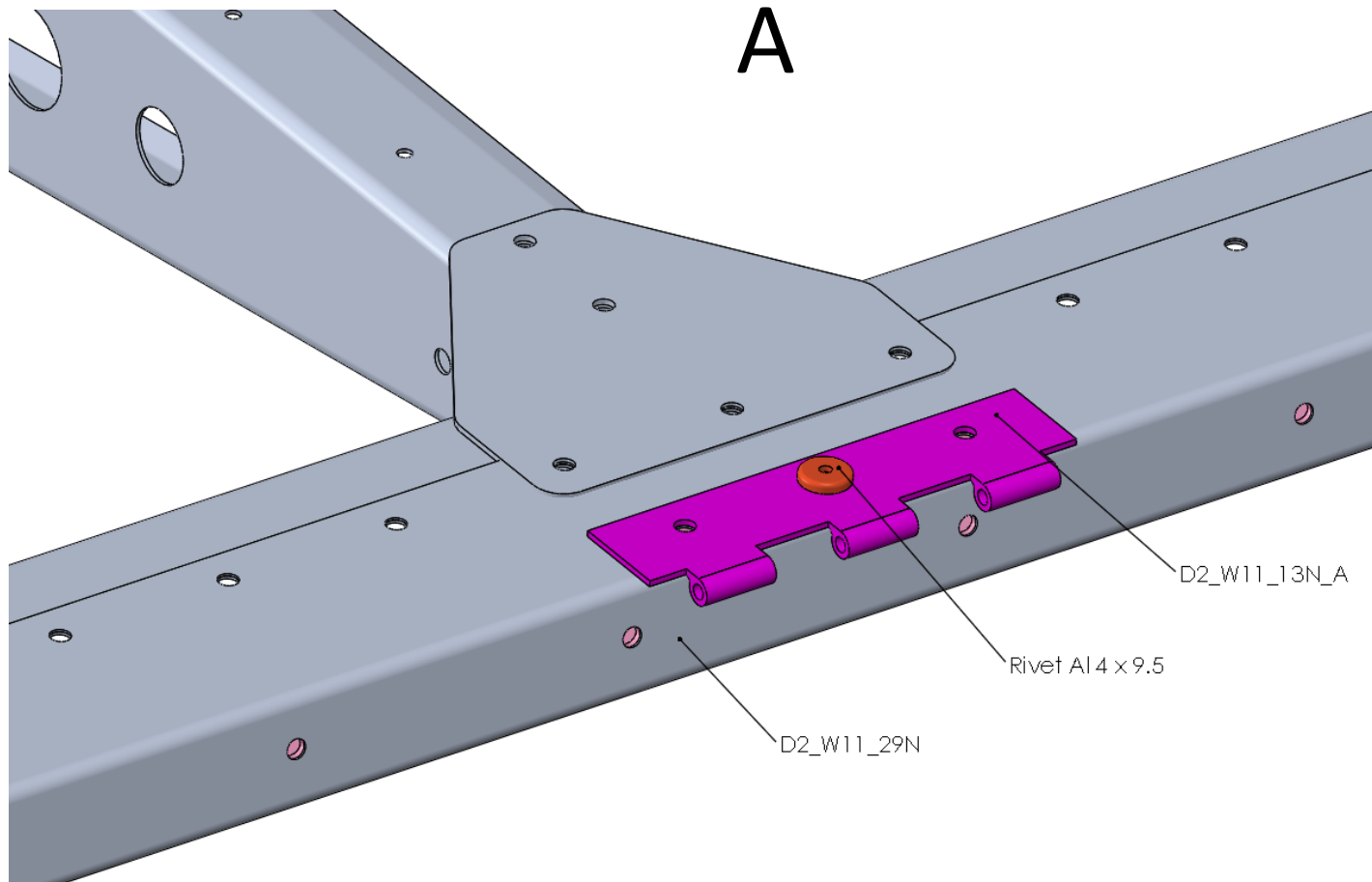
Title	Document no.	Revision	Page	Pages
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Step 38L-A



A



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