



Title:

Wing assembly manual

Document no.:

D2_W0_00

Revision:

R04

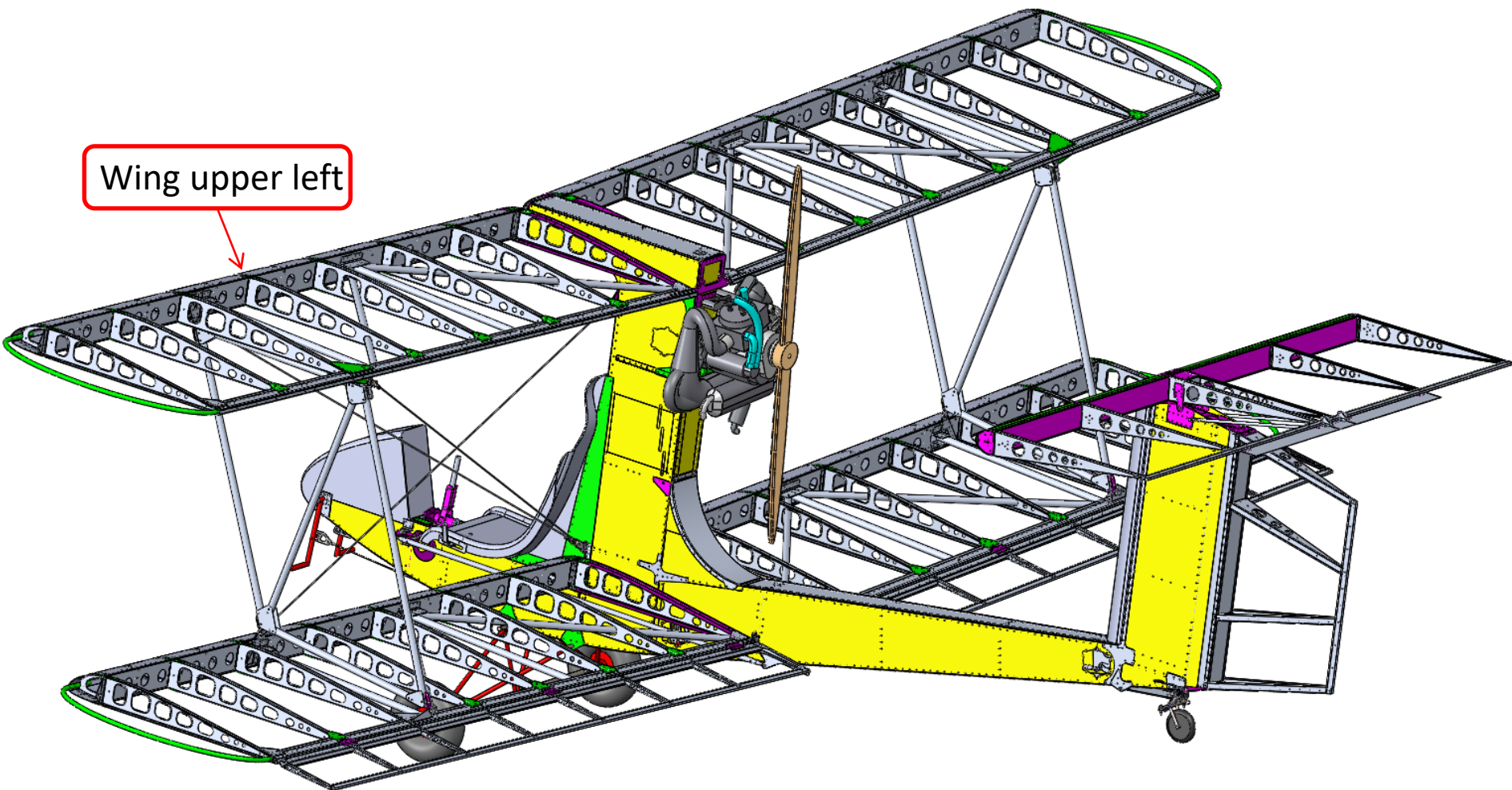
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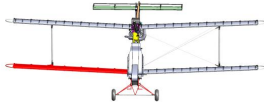
Revision	Affected pages	Short description of change
00	All	Original issue
01	02, 81, 82	Table of revision added, step 38-X - cutout corrected
02	103 – 108	Riveting of aileron hinges corrected
03	All	Changed according to the new design of trailing edge.
04	68, 71	Drilling pattern for the aileron hinge inserted. Step 33, part D2_W11_38N, lenght from the wing end rib changed according to the new design.

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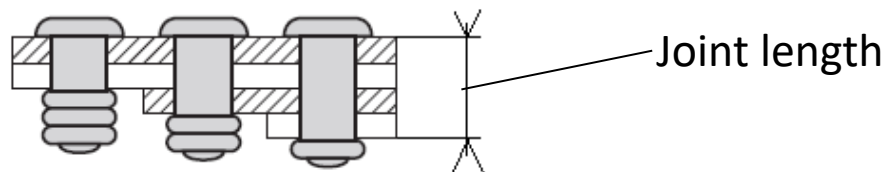


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General instructions:

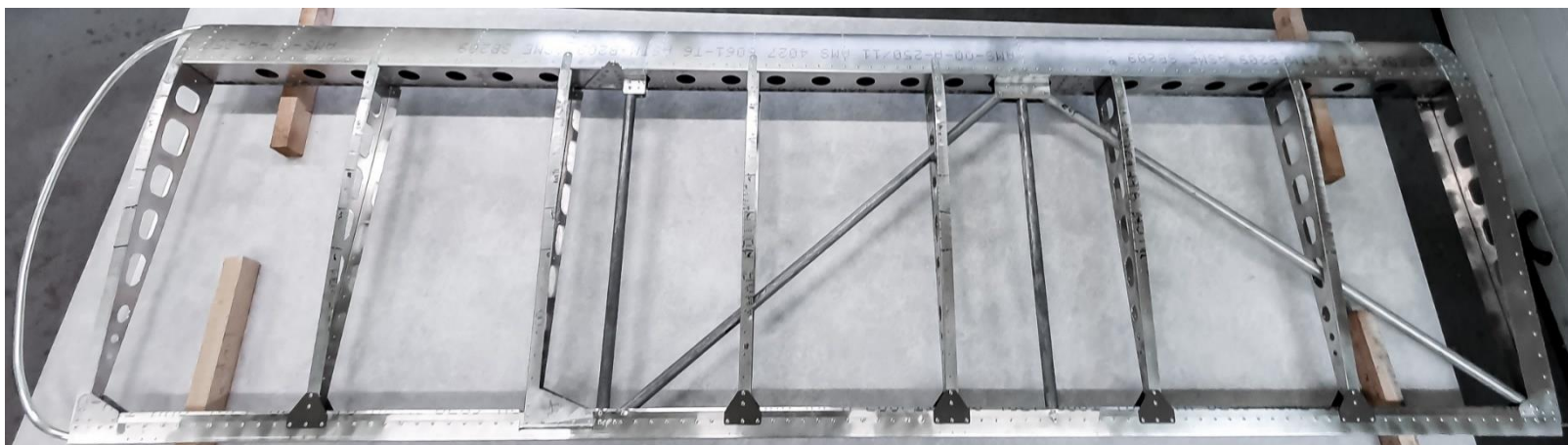
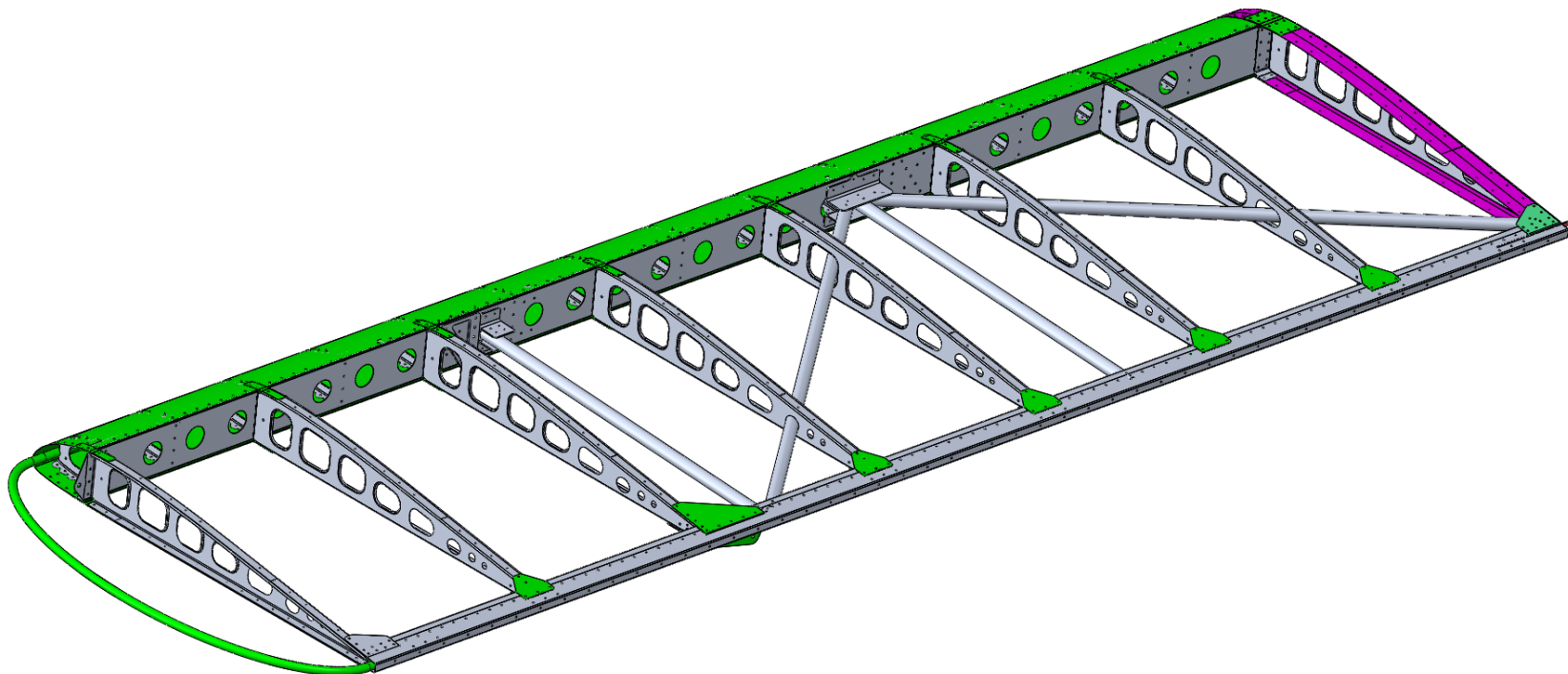
- This manual is for the upper left wing, right one is symmetrical. Specific places of construction are shown also for other wings. Follow this mark: 
- Use clecos for the preassembly, as shown in the video tutorial
- If there is no specific rivet shown or called in the assembly, use rivet AVEX 3,2x7,9 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
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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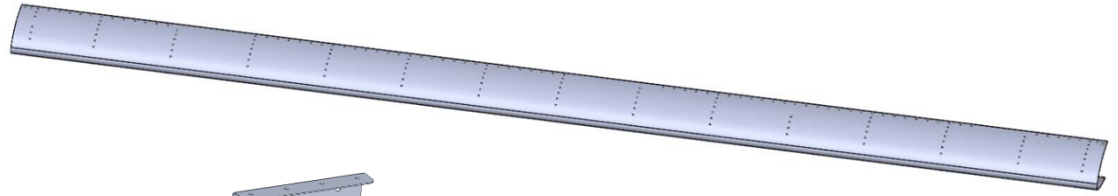
Assembly tool



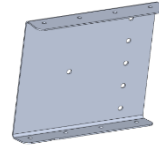
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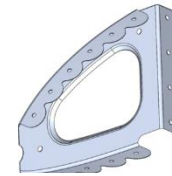
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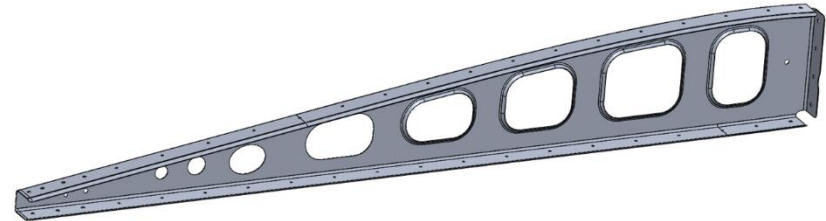
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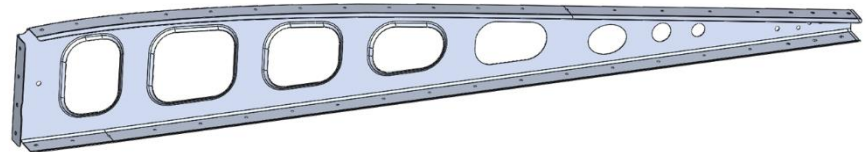
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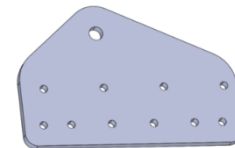
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Quantity 7



Part number D2_W11_06P
Quantity 1



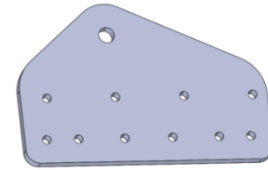
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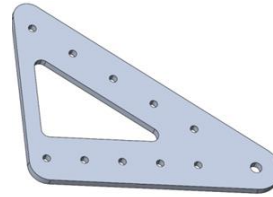
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Quantity 1



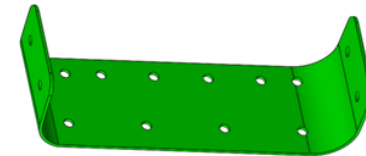
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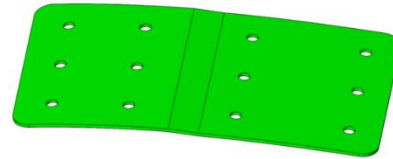
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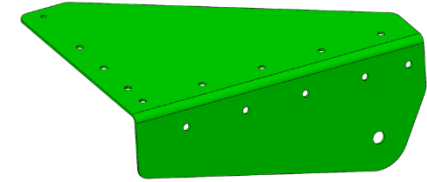
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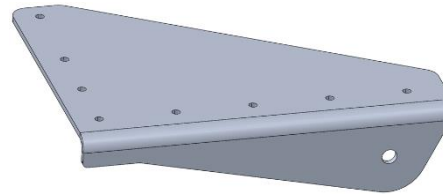
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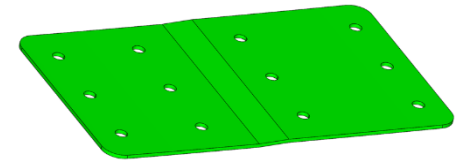
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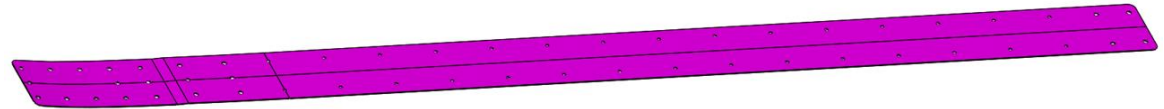
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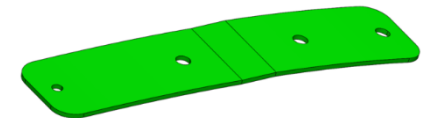
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Part number D2_W11_24N
Quantity 1



Part number D2_W11_25N
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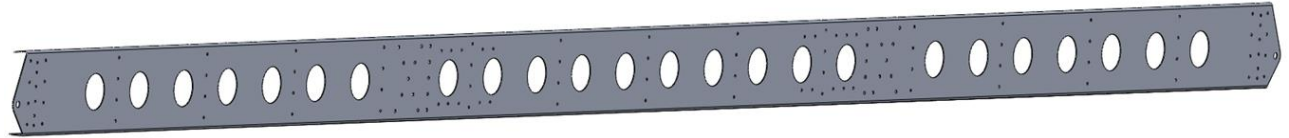
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Quantity 7



Part number D2_W11_01N
Quantity 1



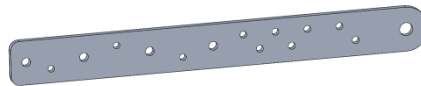
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Quantity 1



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



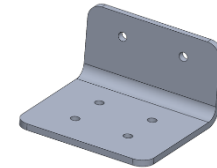
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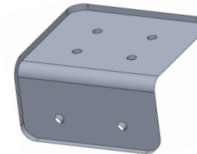
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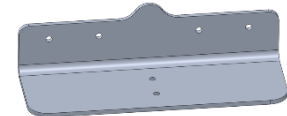
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Quantity 1



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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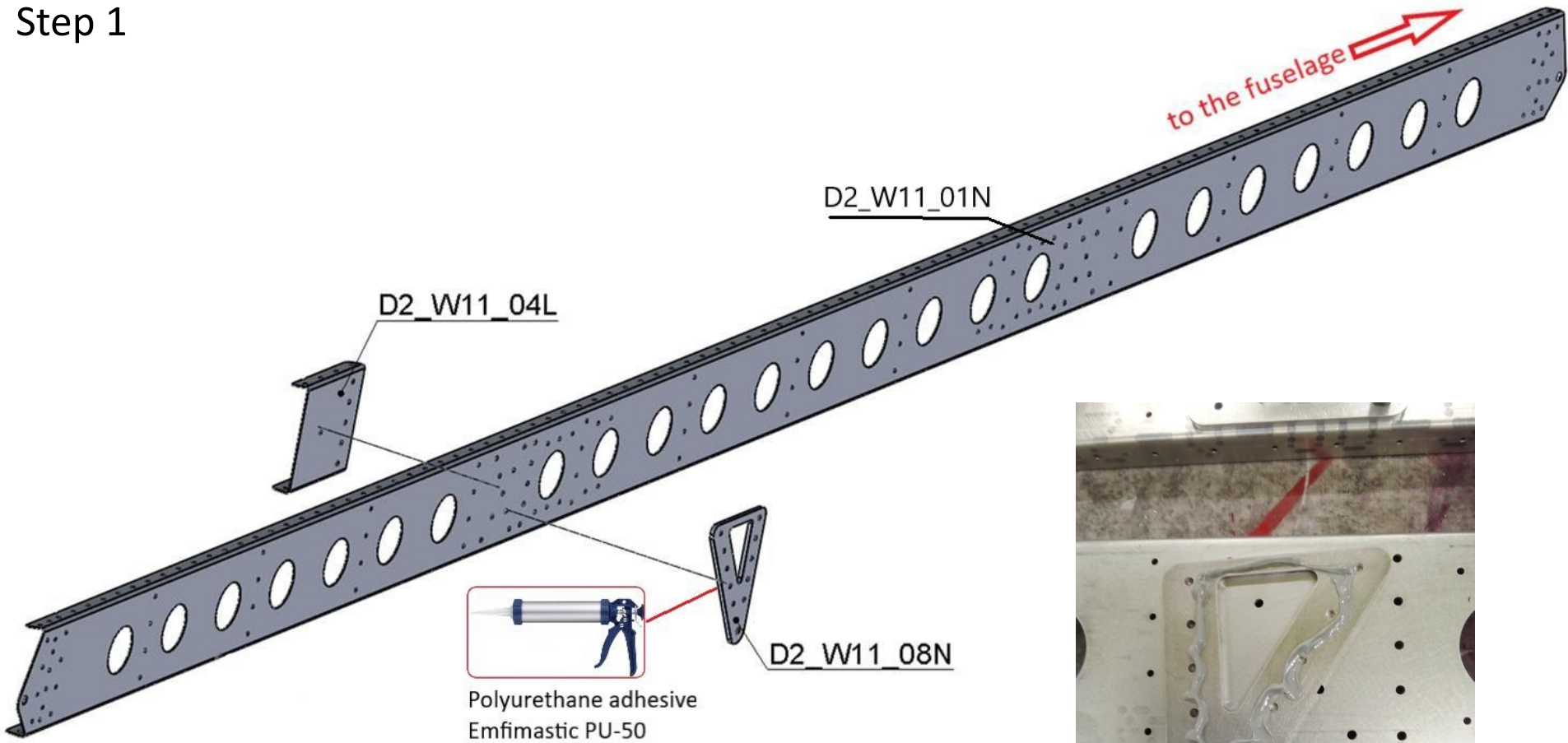


Standard parts	
Part	Quantity
Blind rivets AVEX Ø3,2x7,9 Al/St	729
Blind rivets AVEX Ø3,2x11,2 Al/St	16
Blind rivets AVEX Ø4,0x9,5 Al/St	46
Blind rivets AVINOX Ø4,0x10 EST/EST PH	2
Blind rivets AVINOX Ø4,0x12,0 EST/EST PH	14

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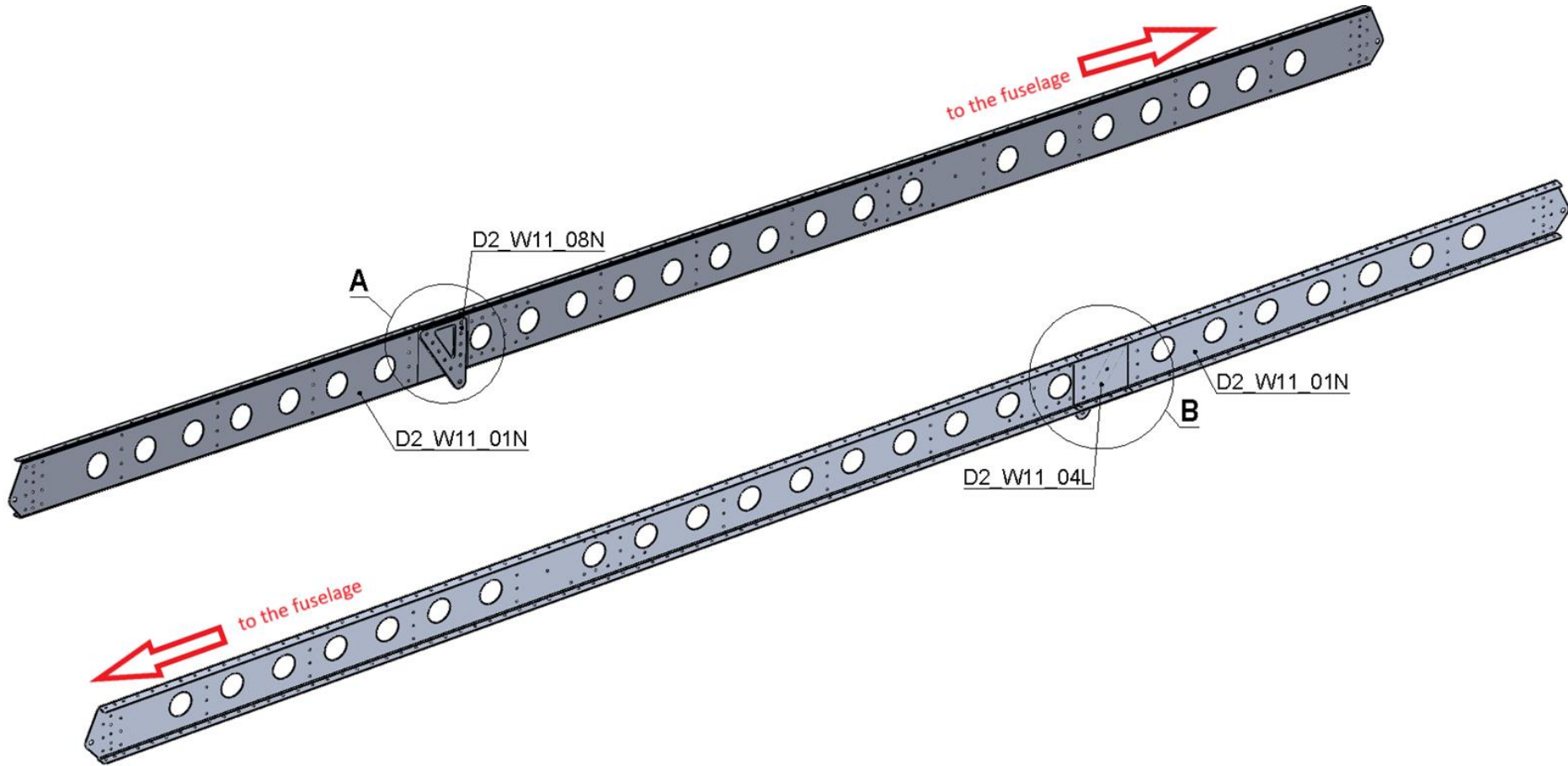
Step 1



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Step 2



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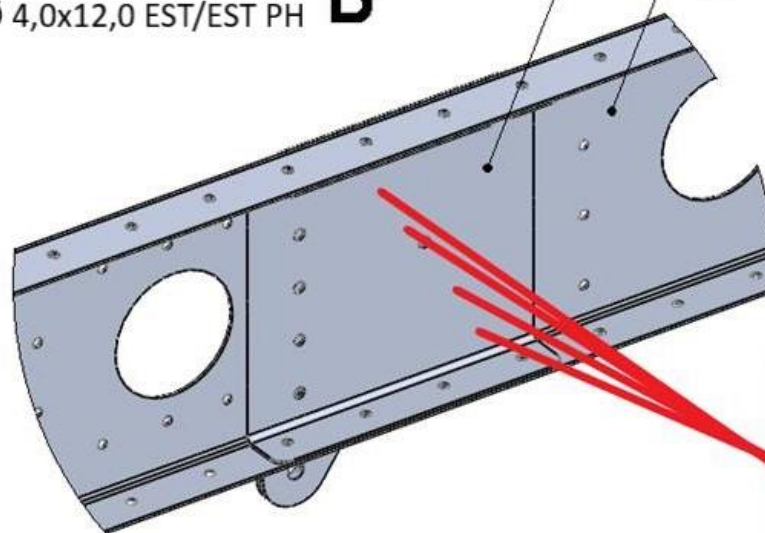
Step 2
A

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

B

D2_W11_04L

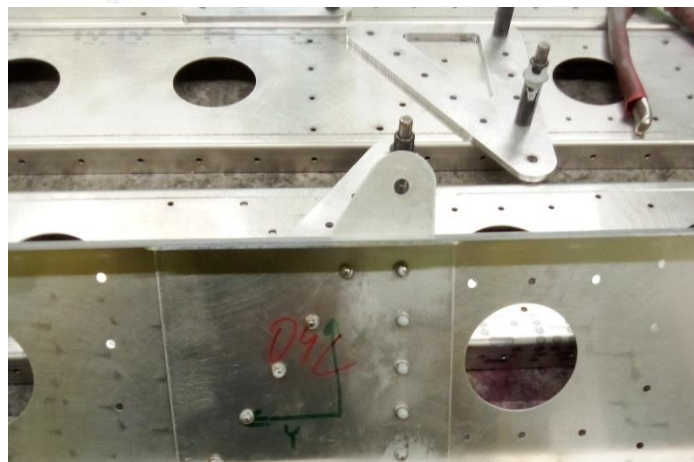
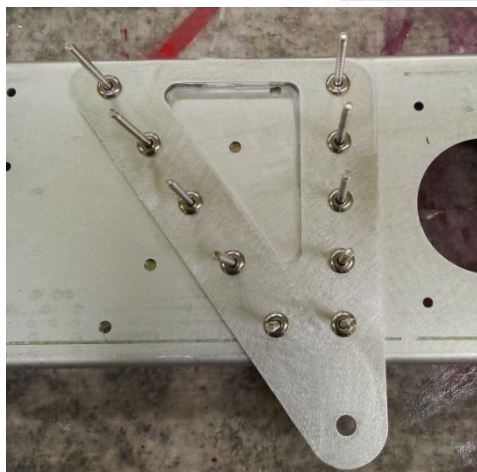
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Hole Ø4mm

D2_W11_01N

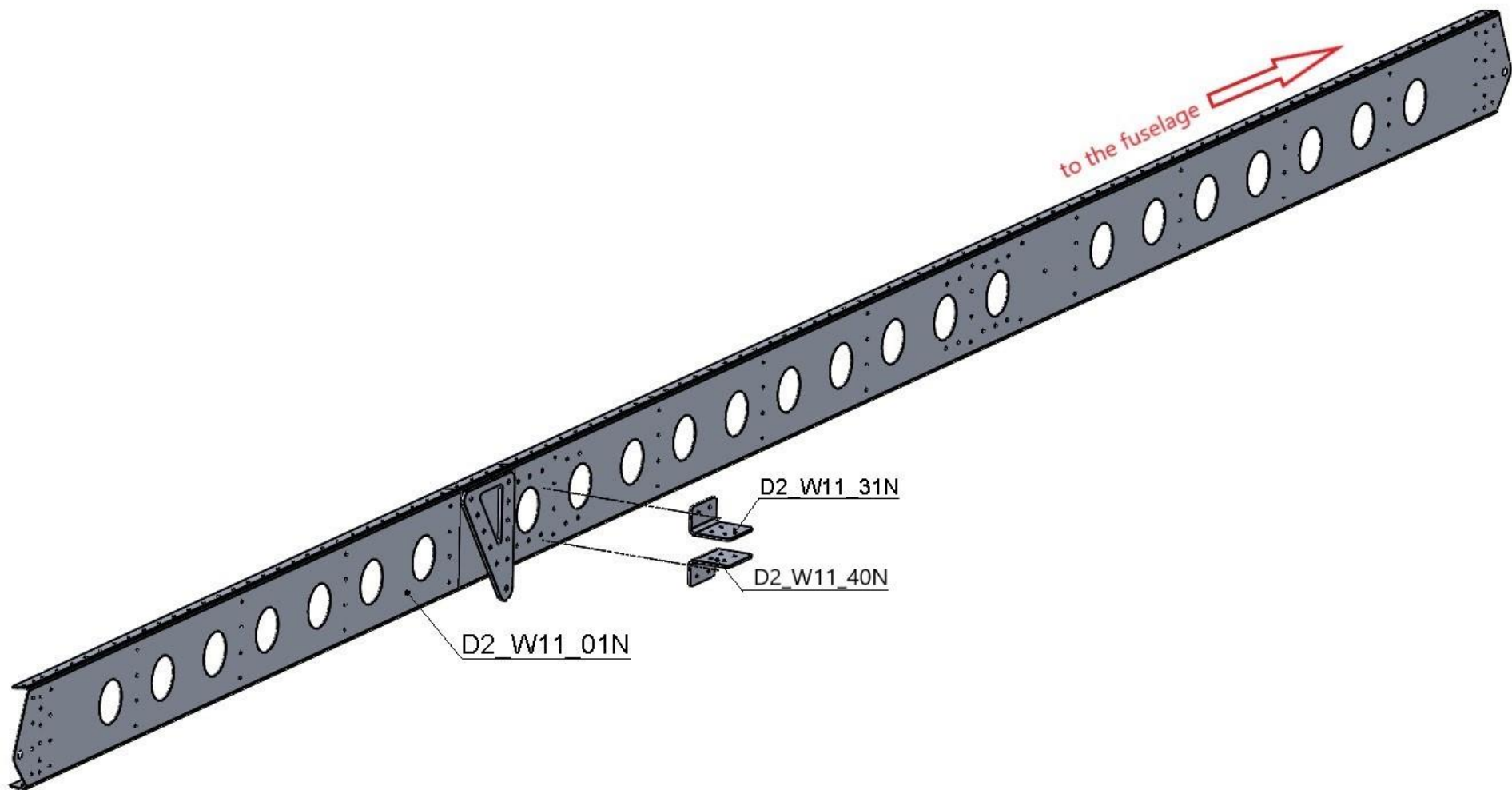
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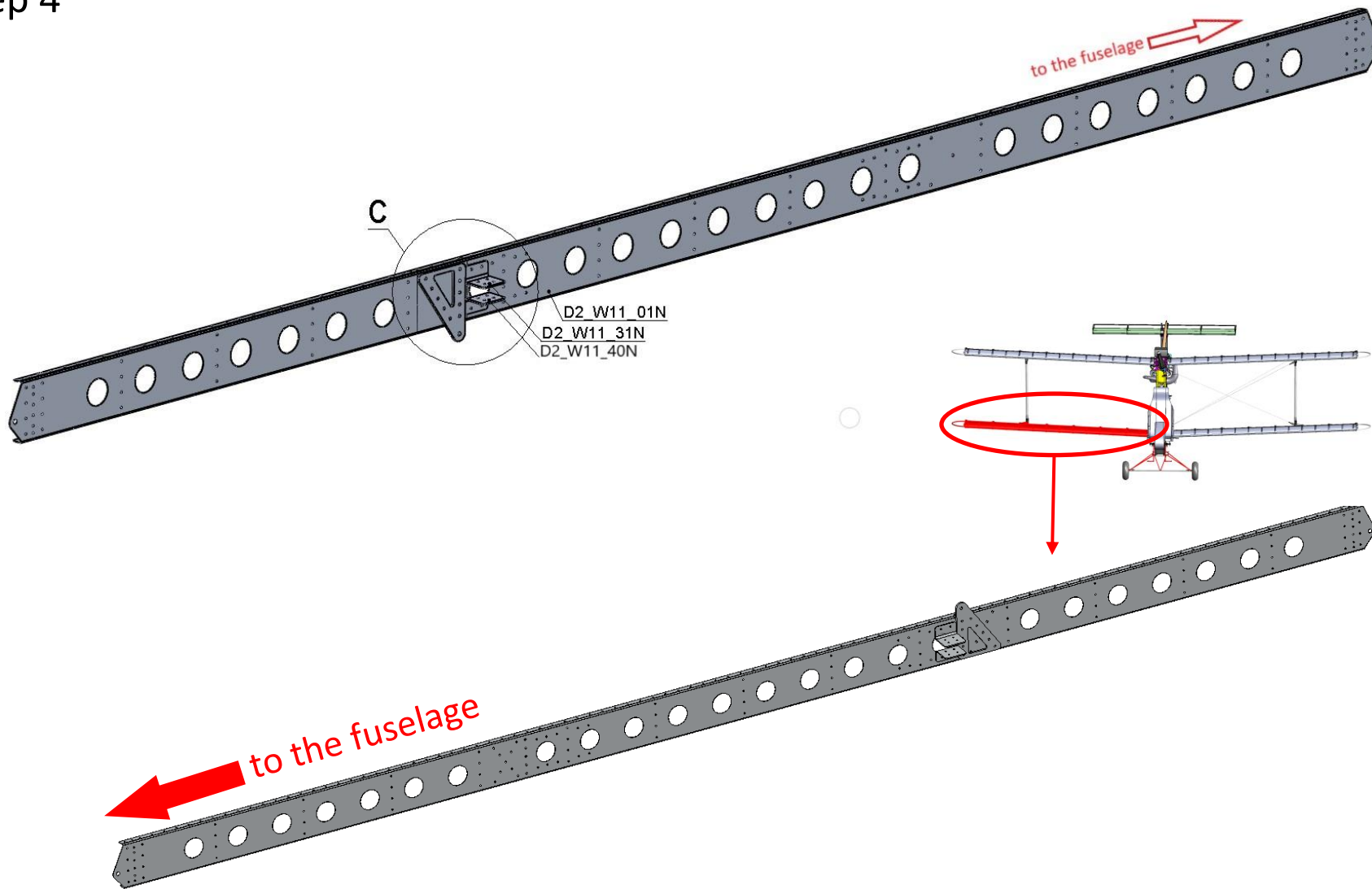
Step 3



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Step 4



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Step 4

C

D2_W11_31N

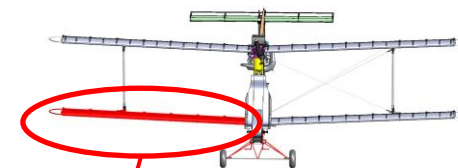
D2_W11_01N

Blind rivets

AVEX Ø 4,0x9,5 AL/st



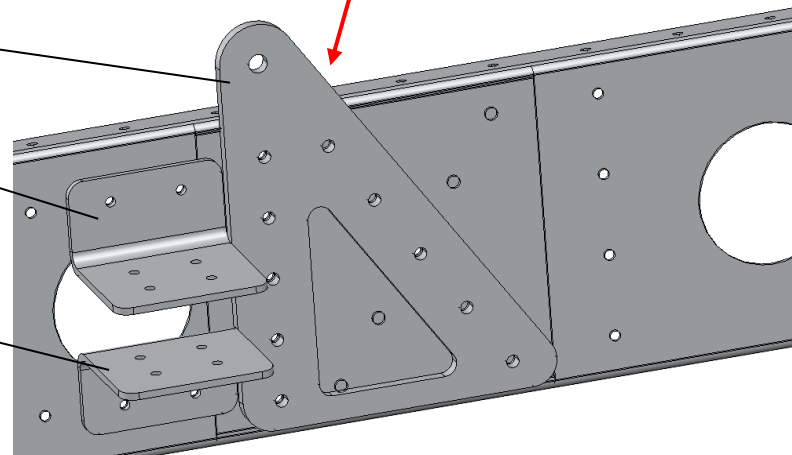
D2_W11_40N



D2_W11_08N

D2_W11_31N

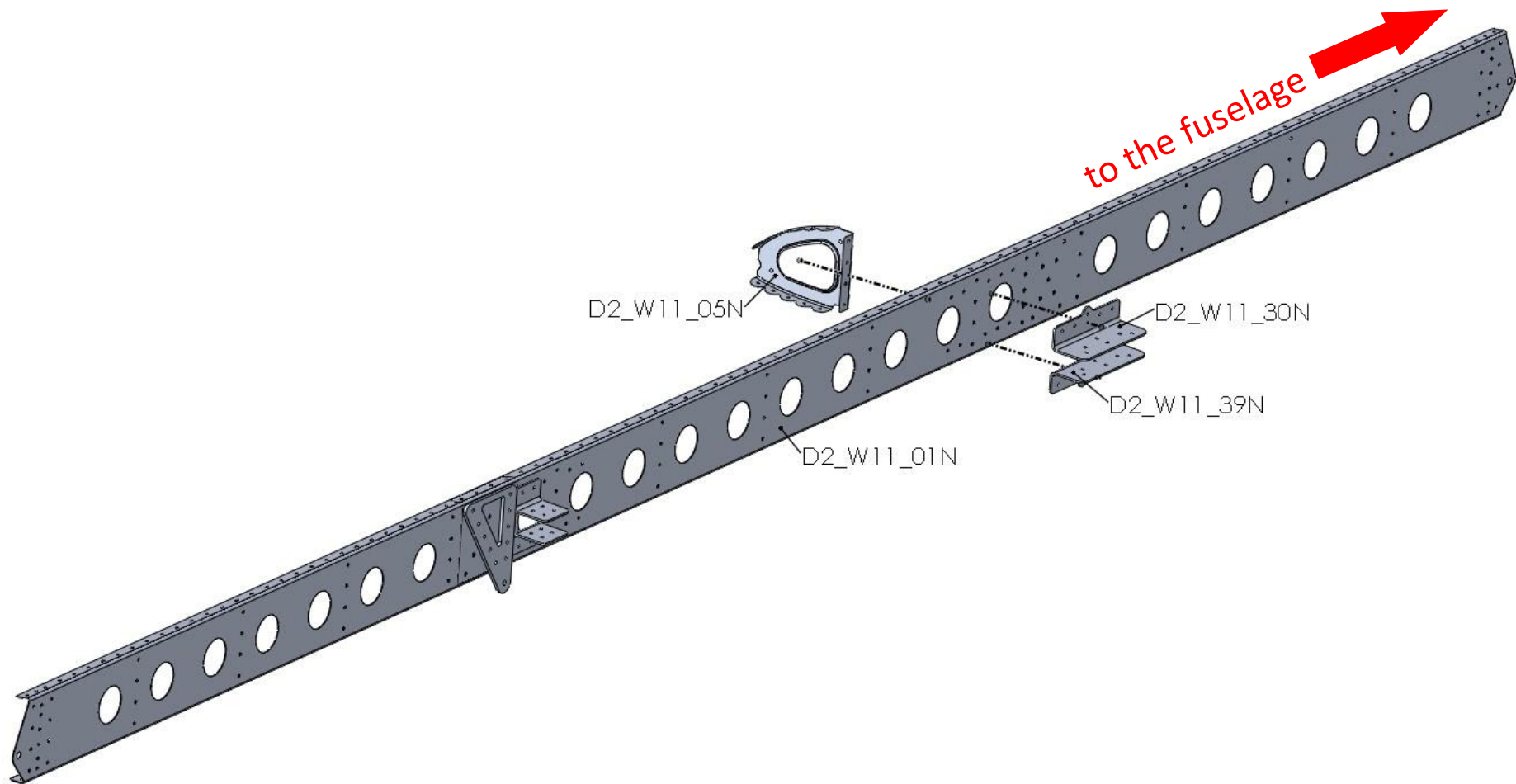
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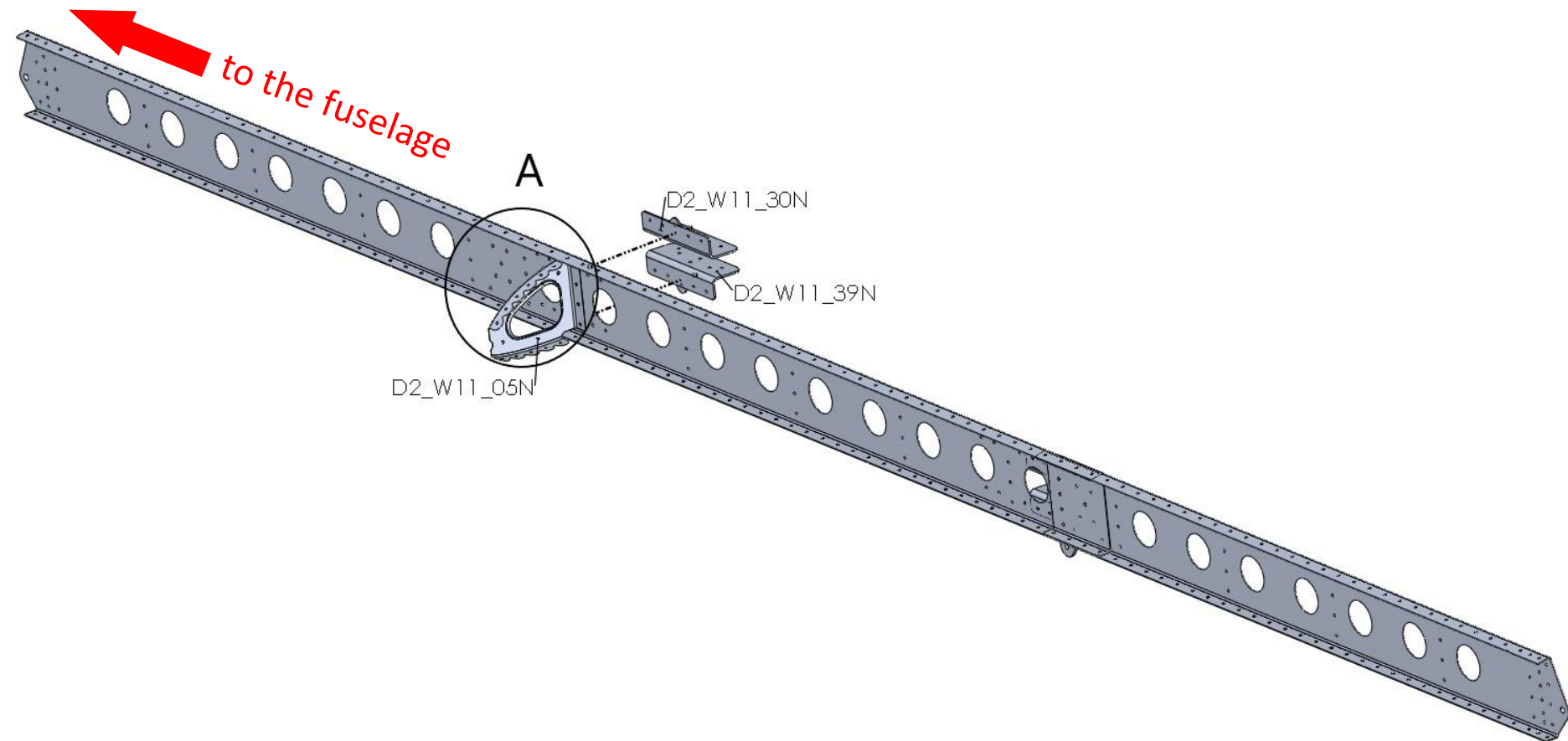
Step 5



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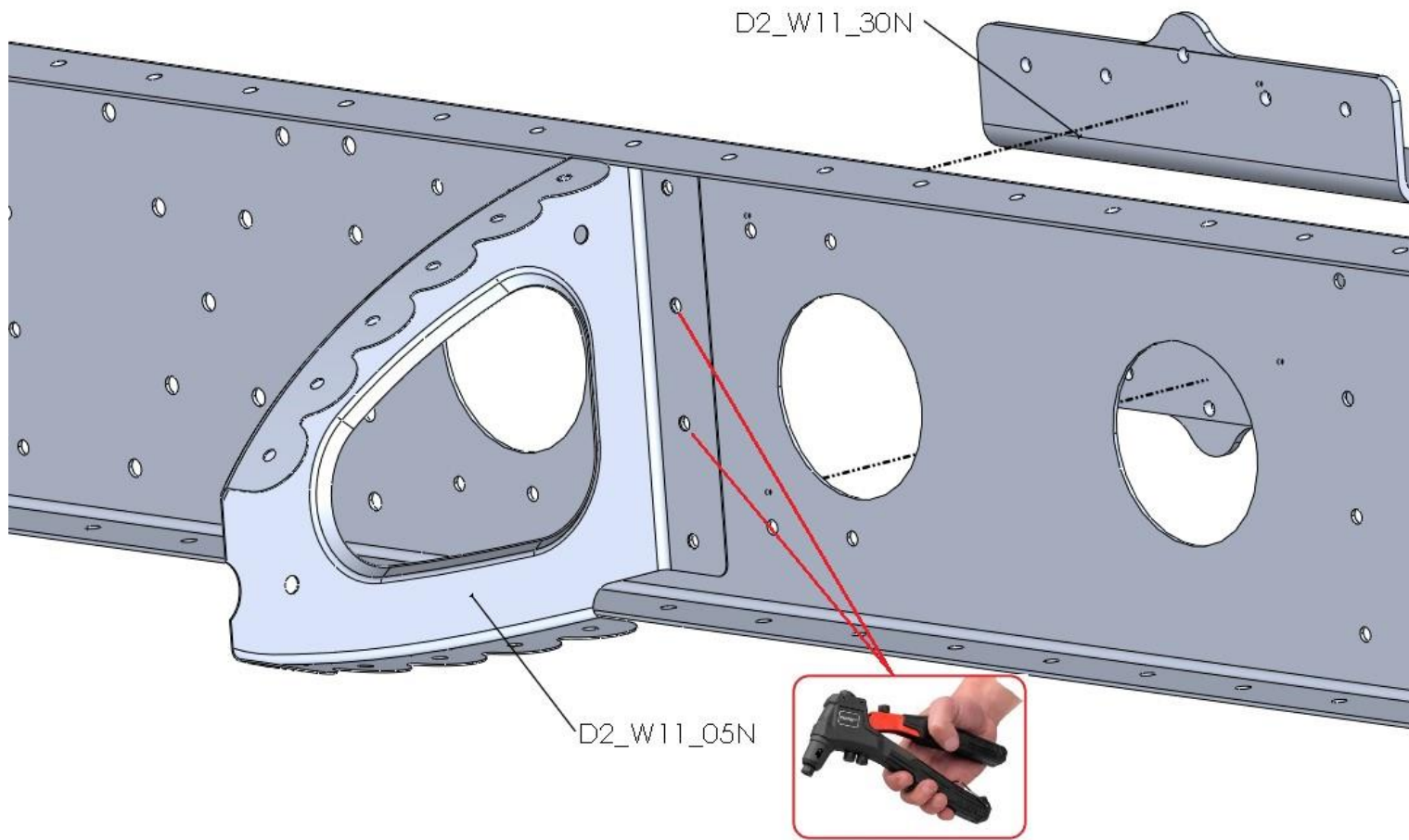
Step 6



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Step 6A

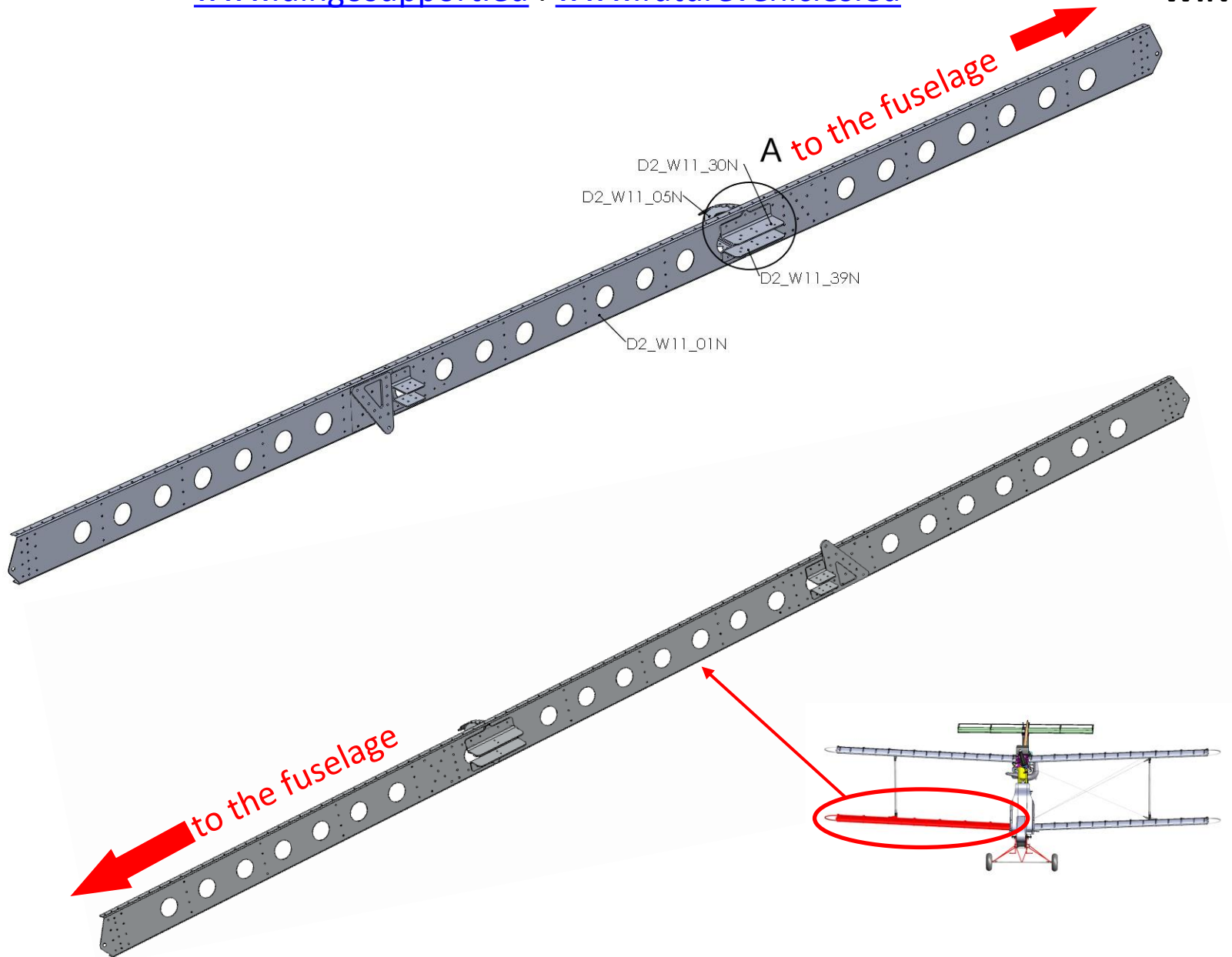


Blind rivets
AVEX Ø3,2x7,9 Al/St

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Step 7



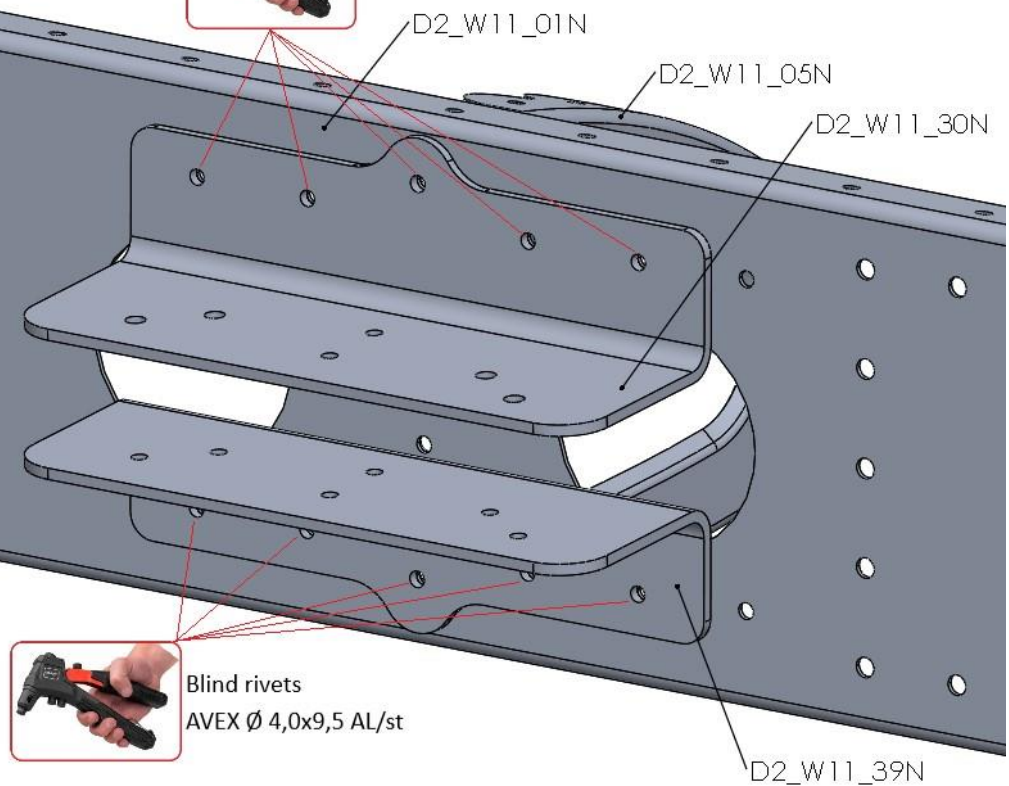
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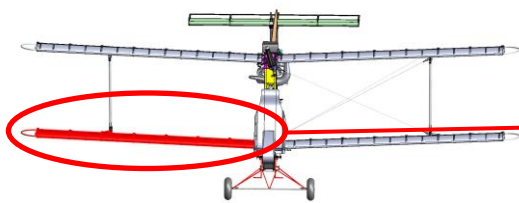
Step 7A



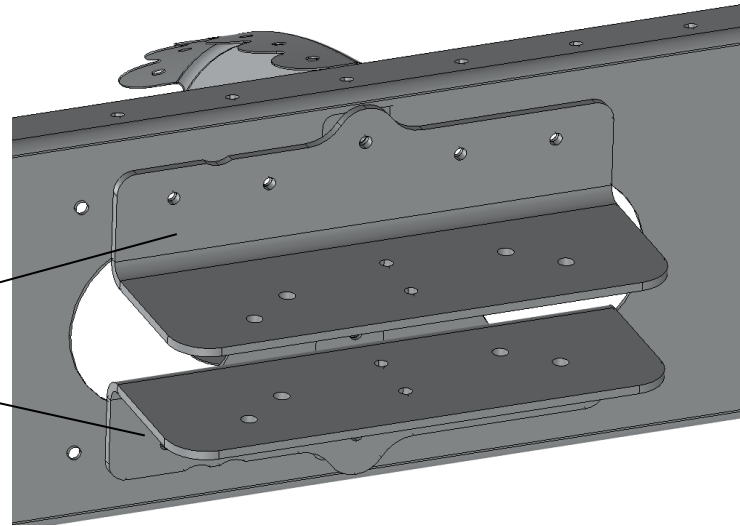
Blind rivets
AVEX Ø 4,0x9,5 AL/st



Blind rivets
AVEX Ø 4,0x9,5 AL/st



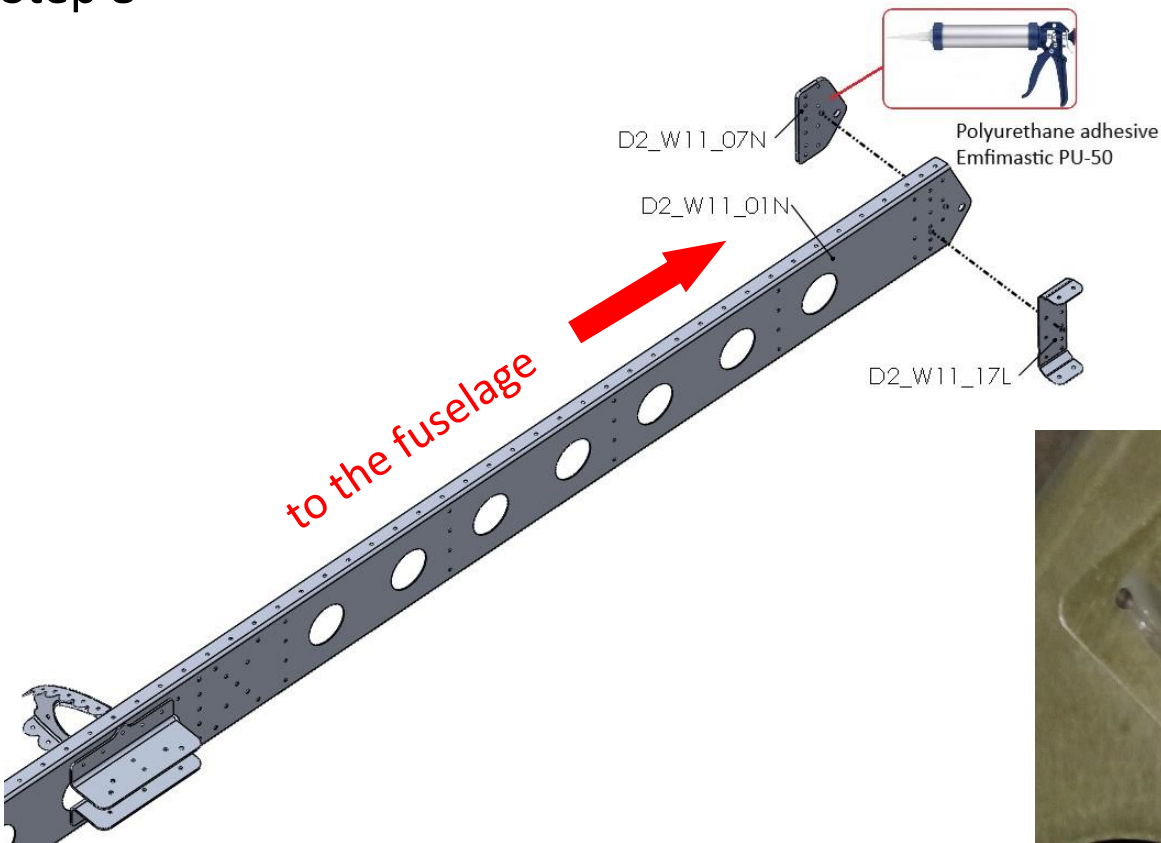
D2_W11_30N
D2_W11_39N



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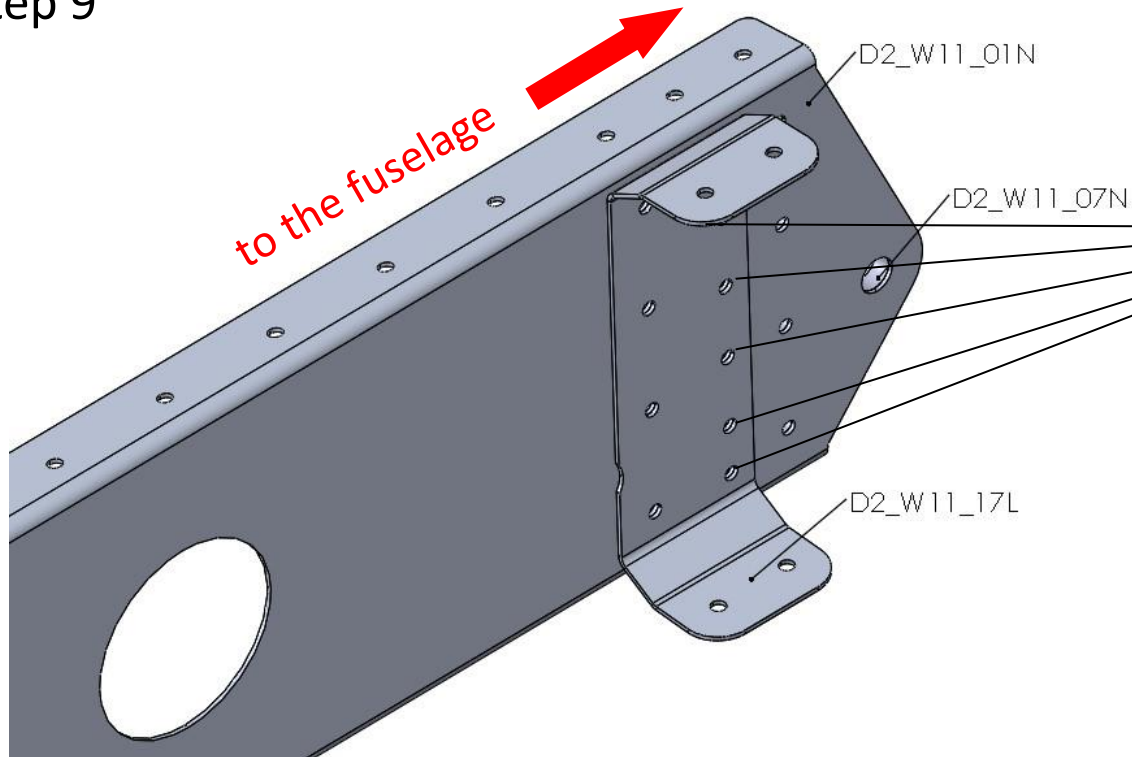
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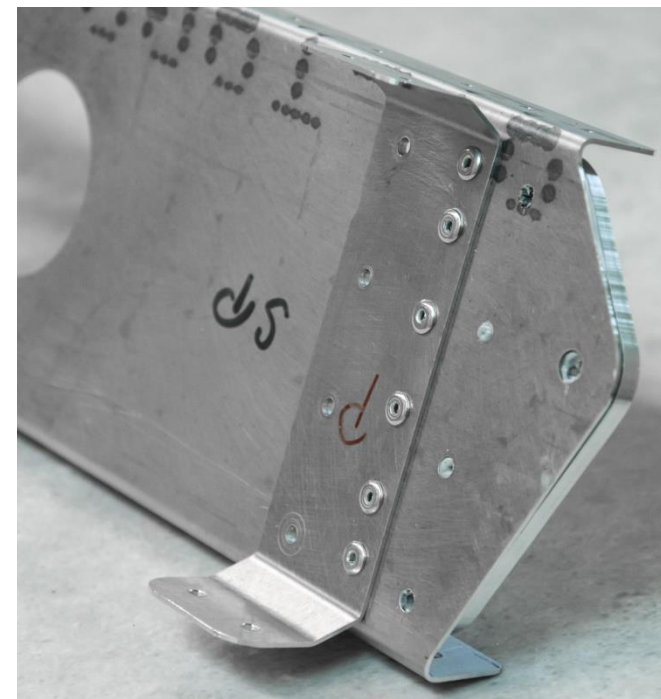
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Step 9




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



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Step 10

to the fuselage 

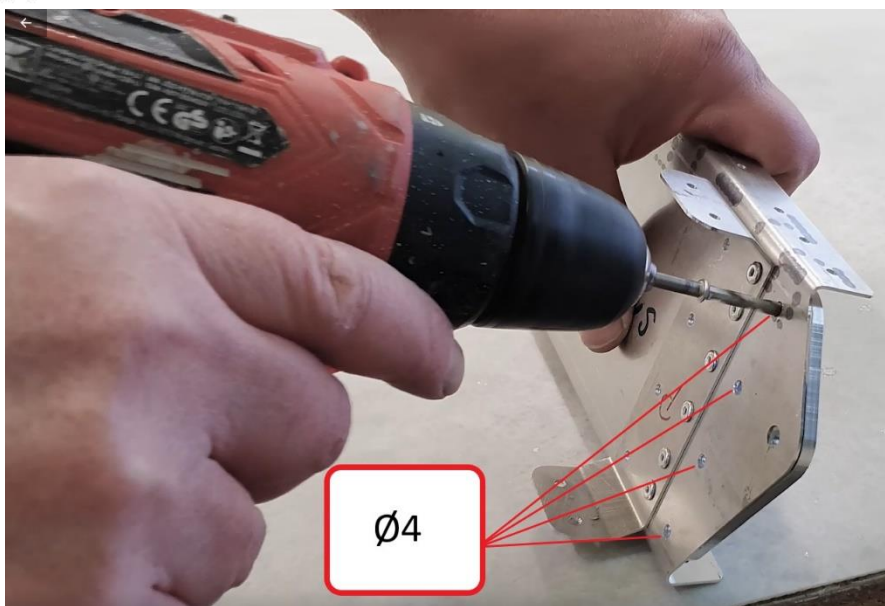
D2_W11_01N

D2_W11_07N



Hole Ø4mm

D2_W11_17L

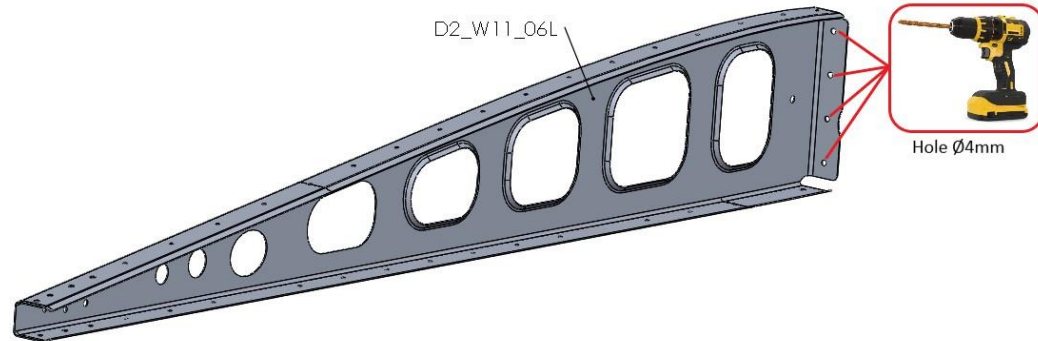
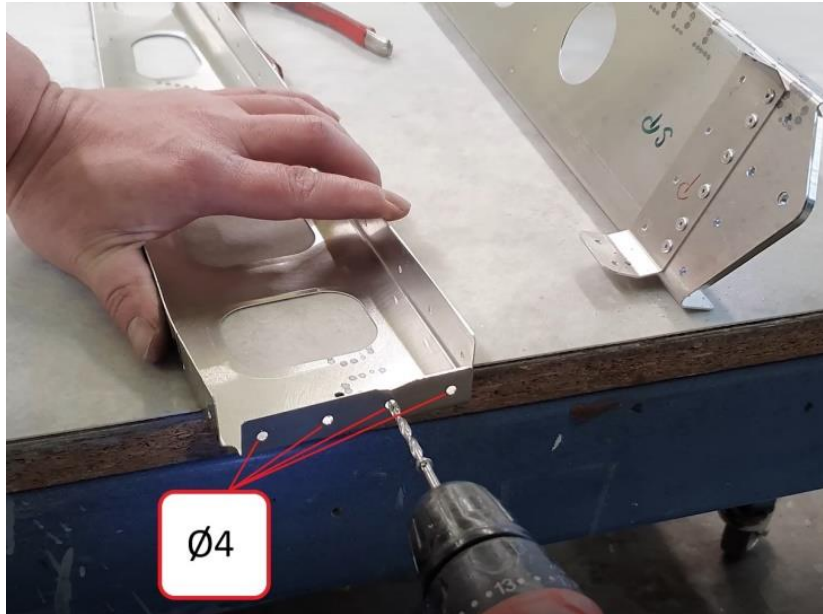
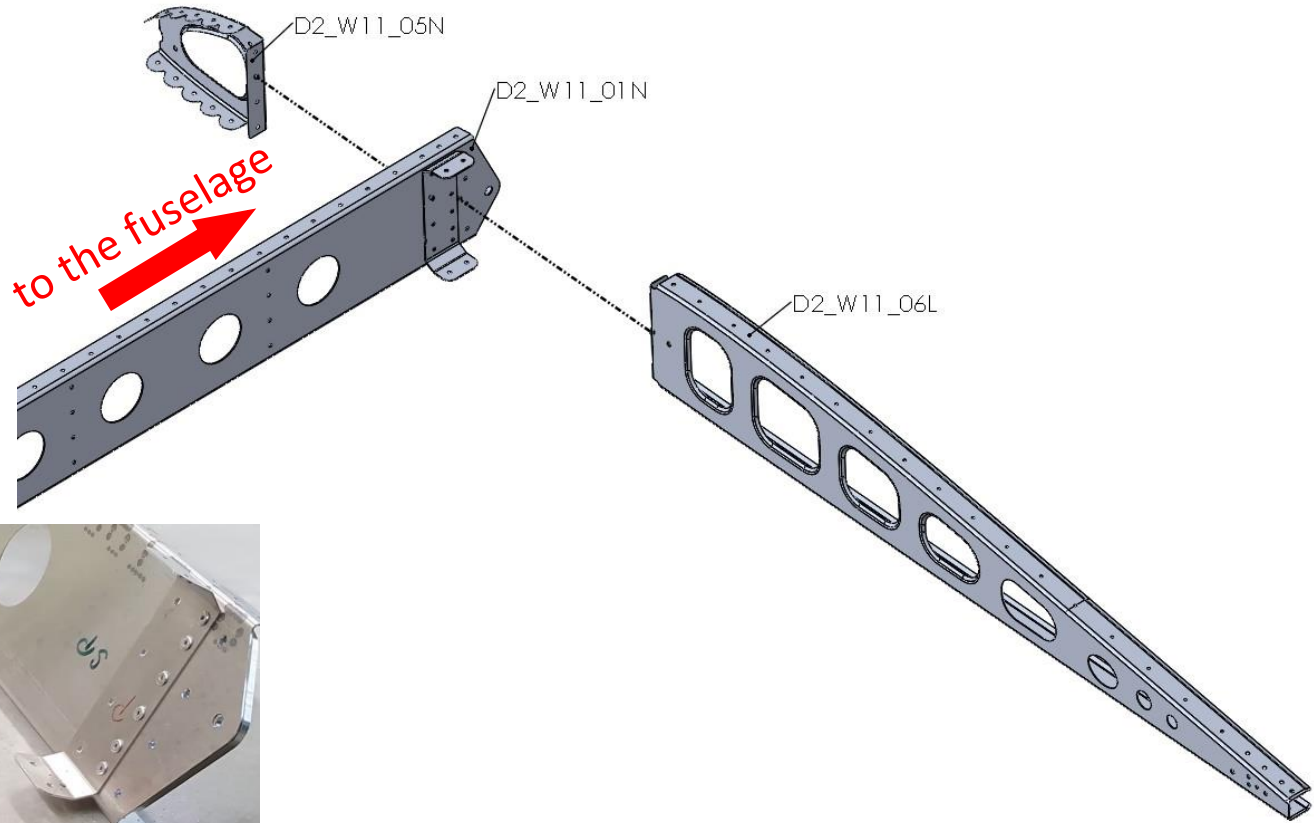


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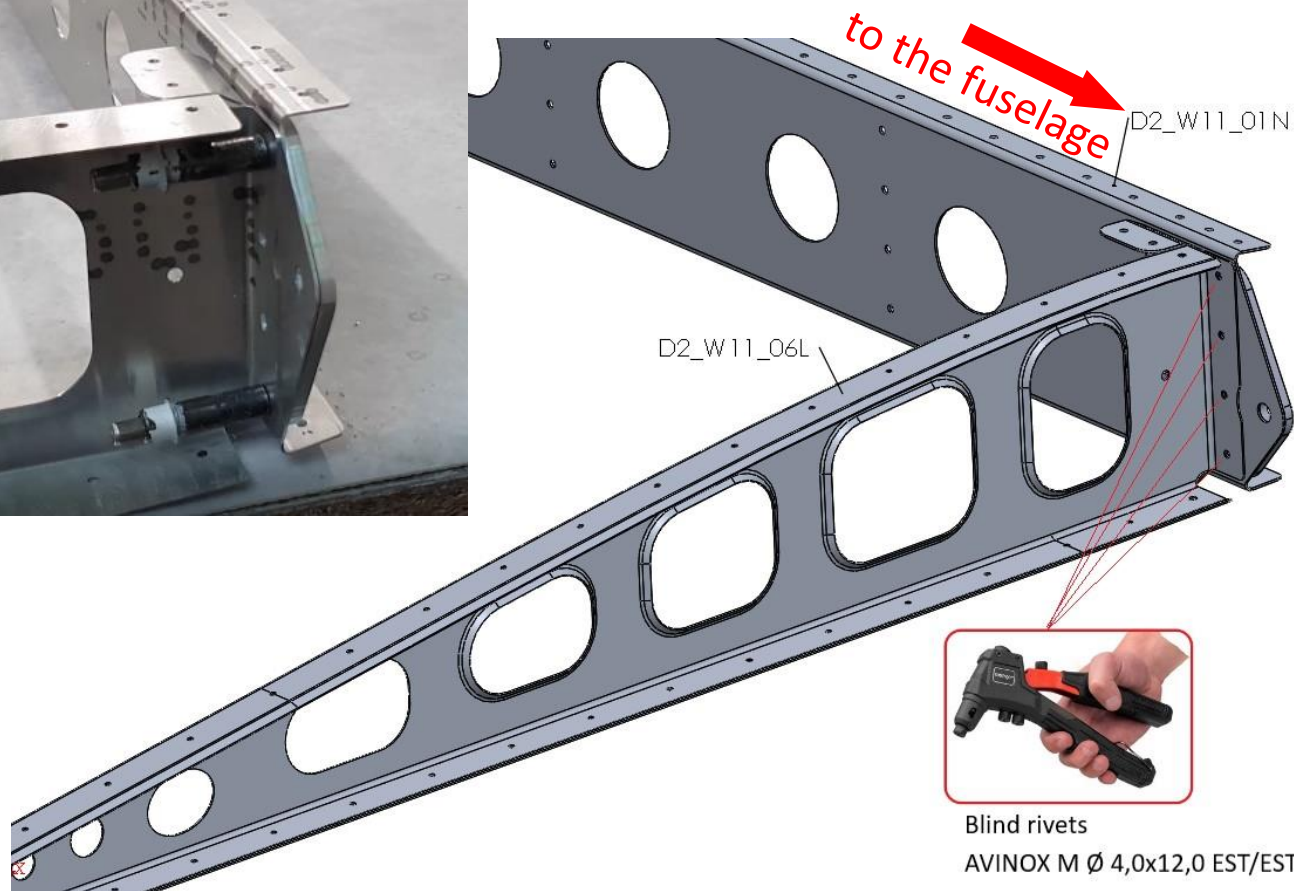
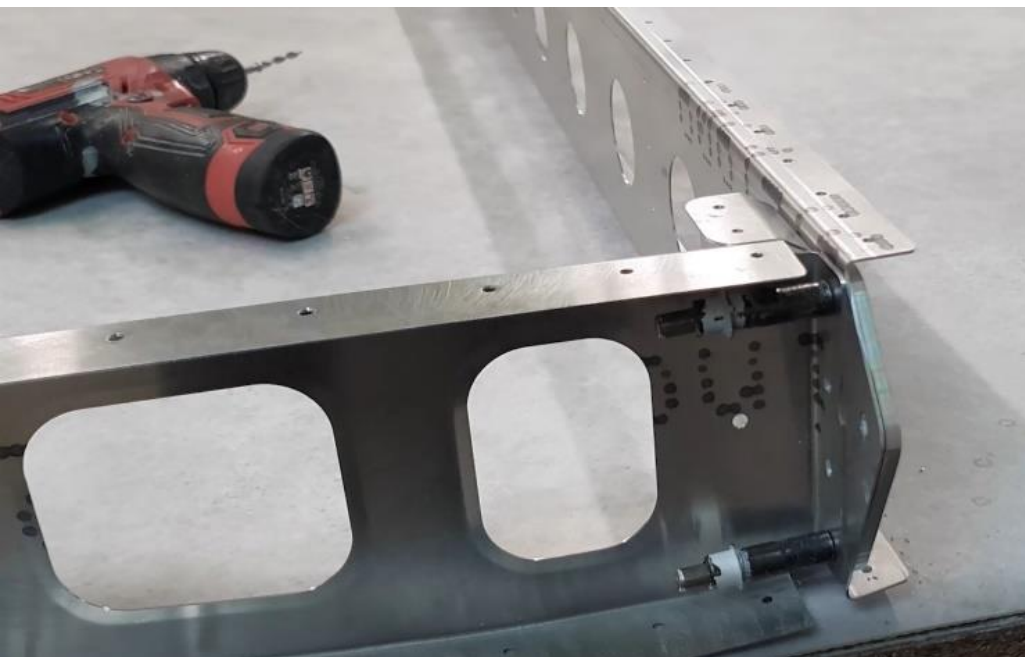


Step 11



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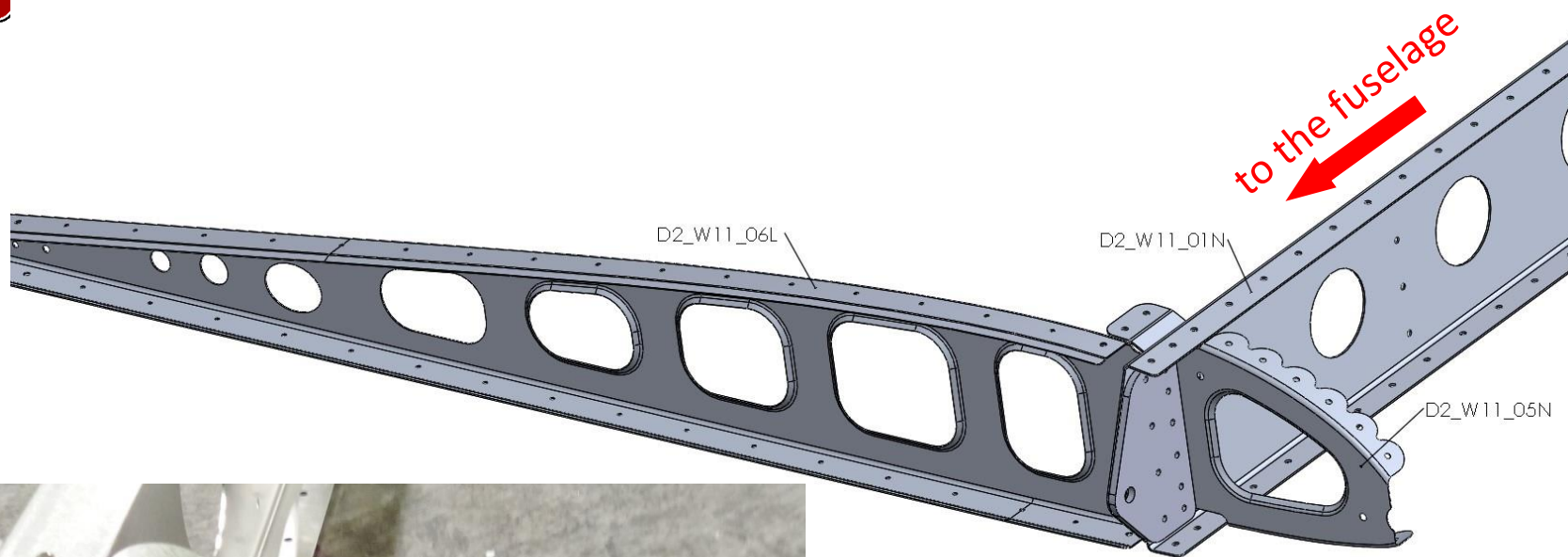
Step 12



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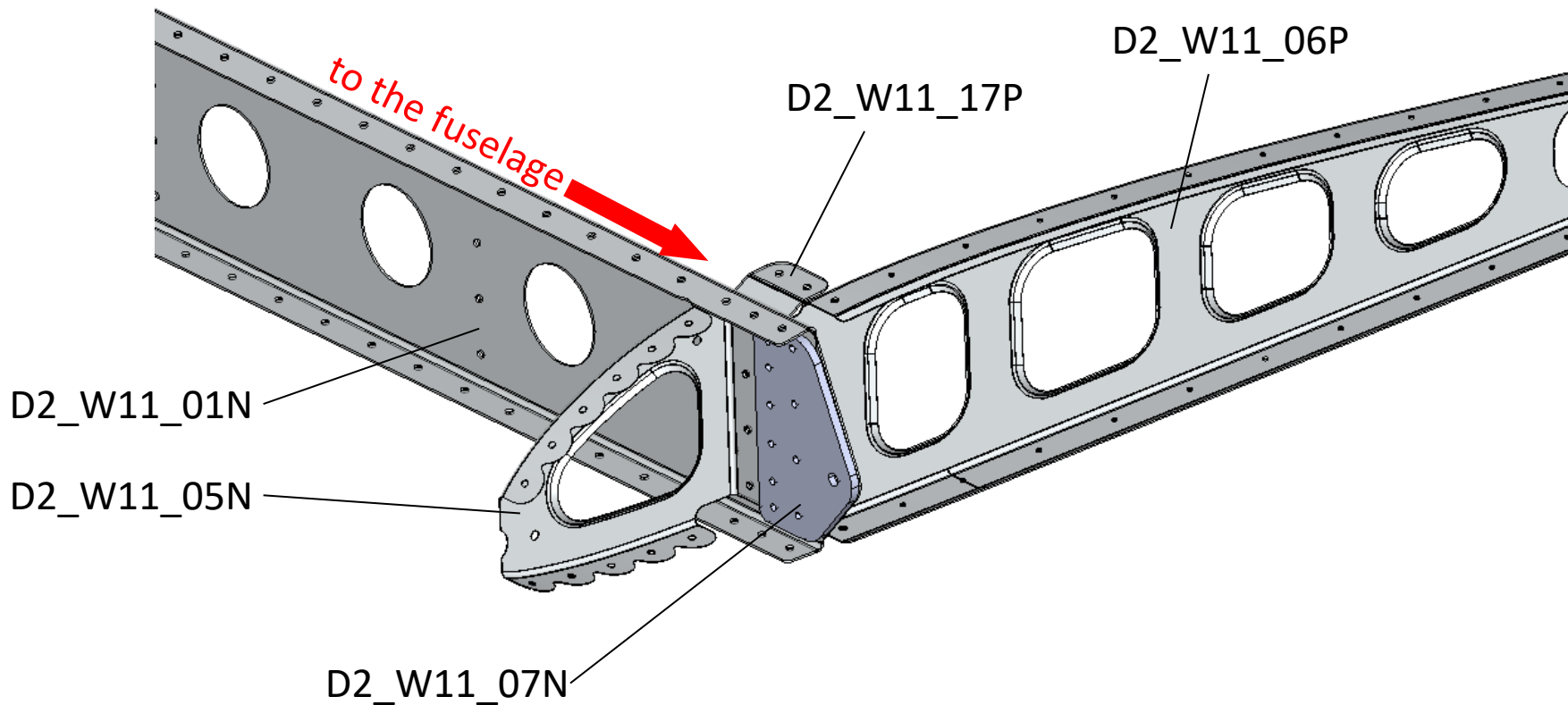
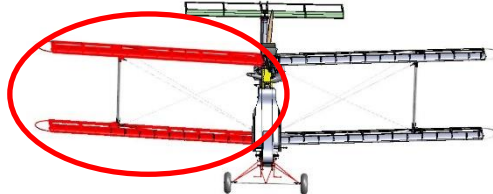


Step 13



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Step 13P



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Step 14

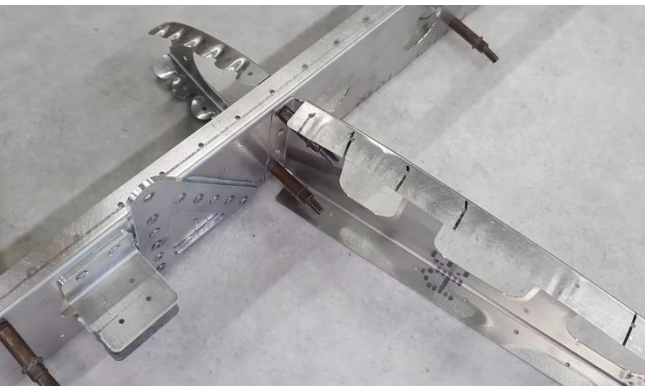


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Step 15

to the fuselage



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D2_W11_06L

Step 15P



D2_W11_05L

D2_W11_06P

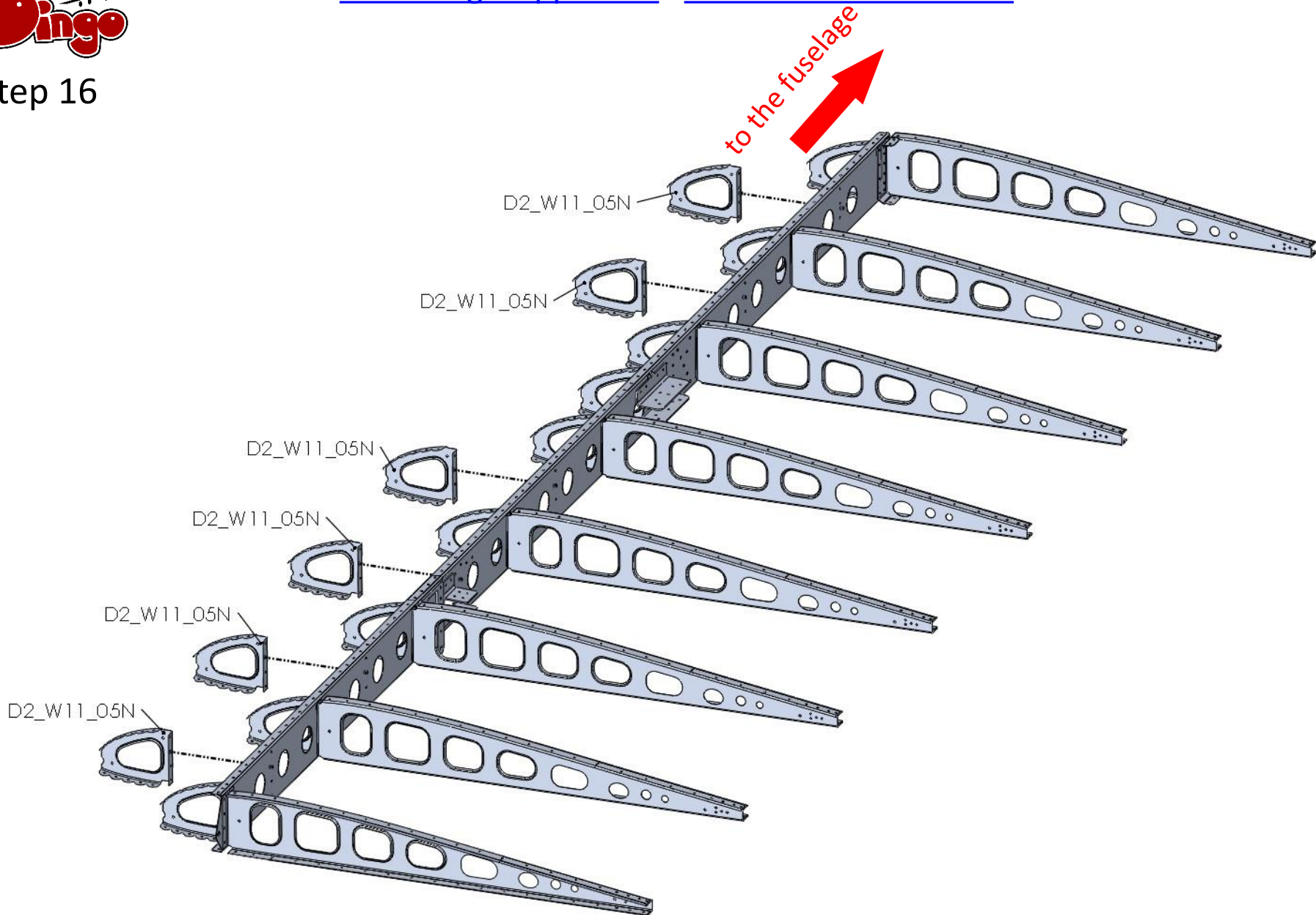
to the fuselage

D2_W11_06P

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Step 16

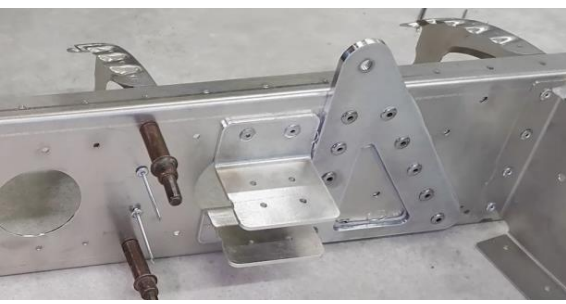
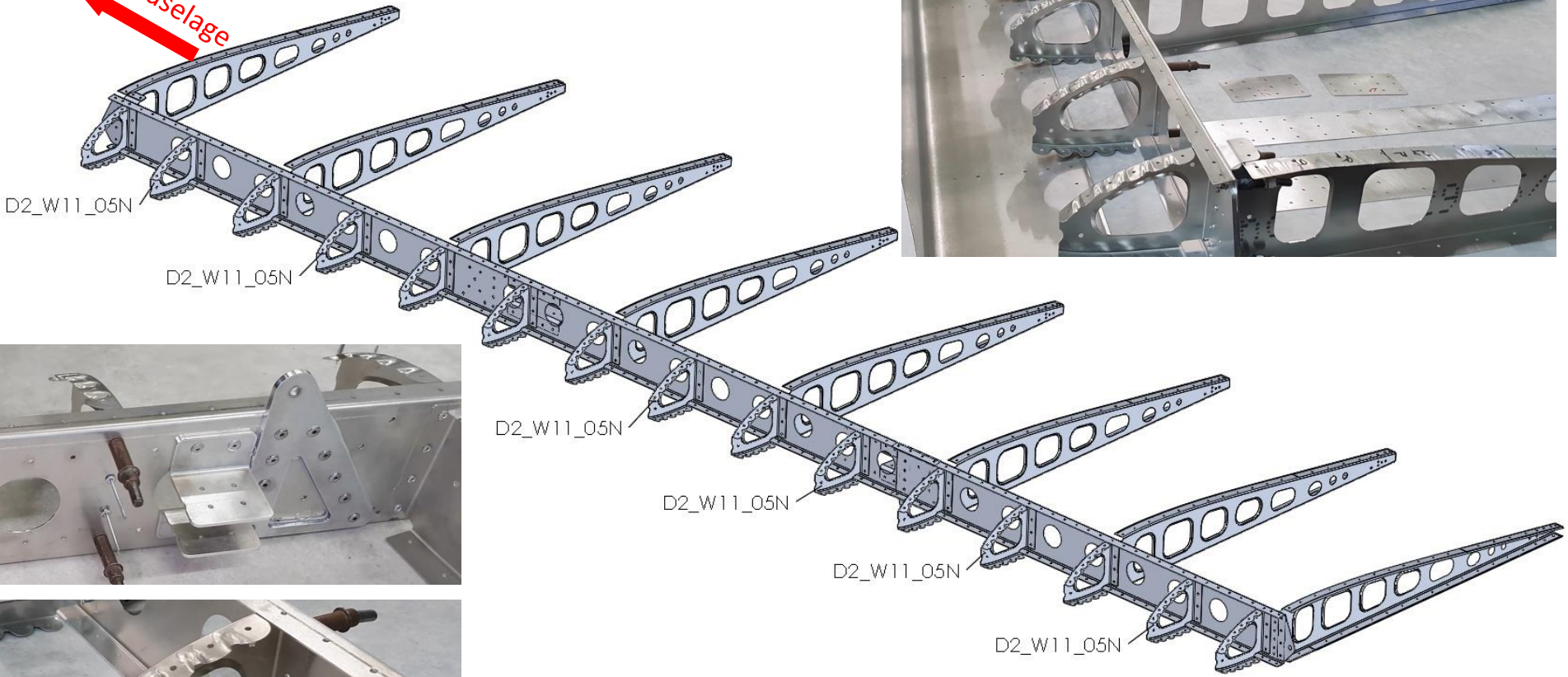


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Step 17

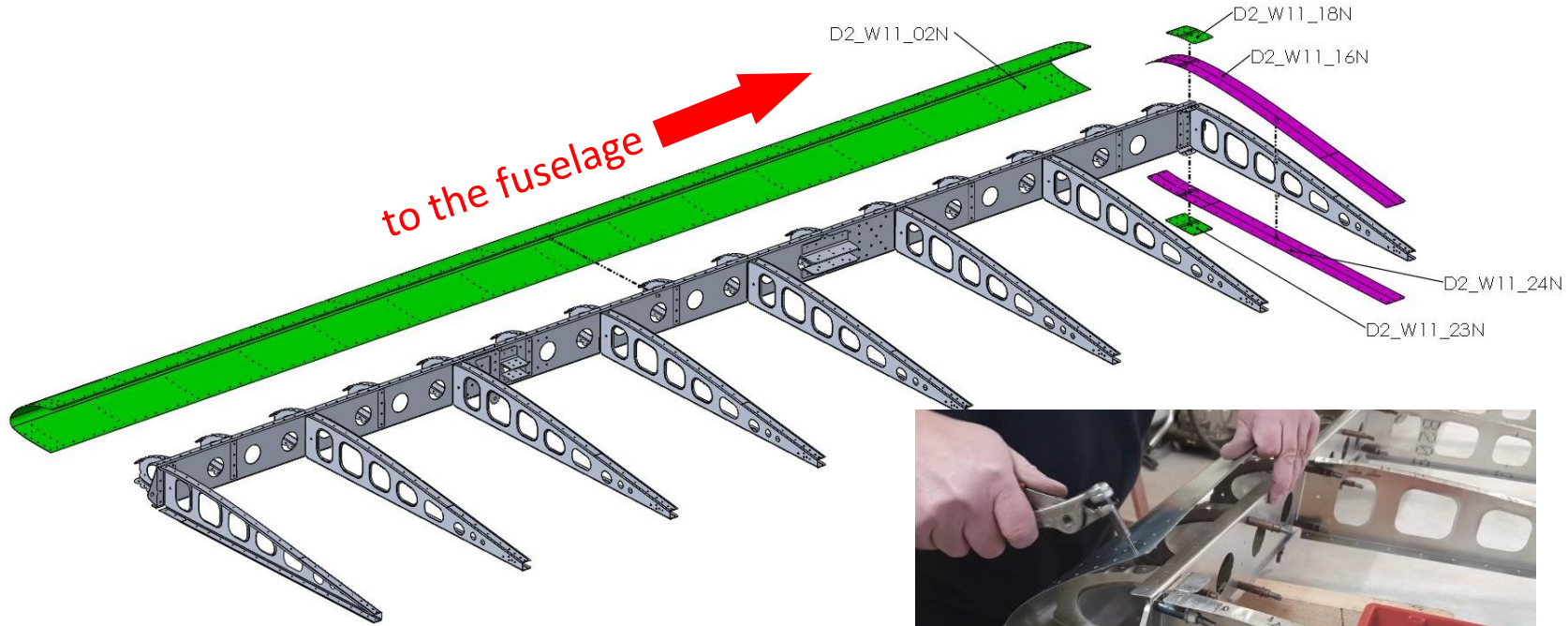
to the fuselage



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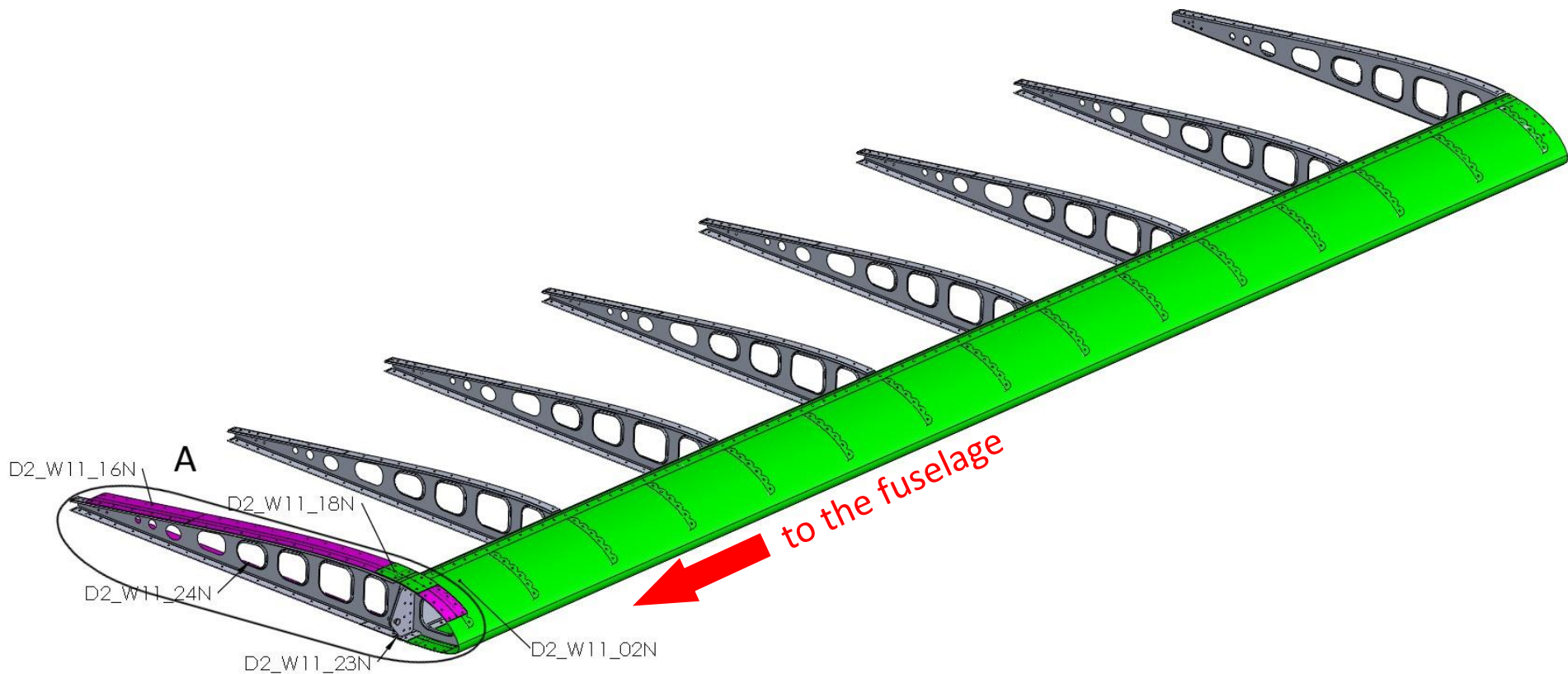
Step 18



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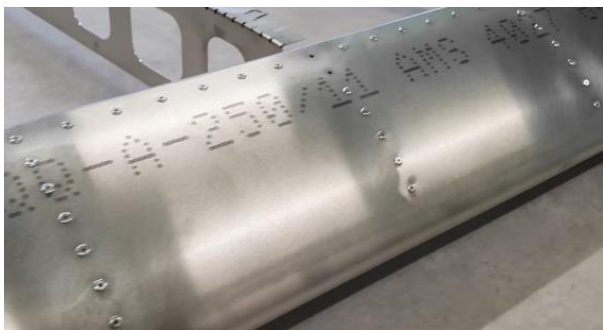
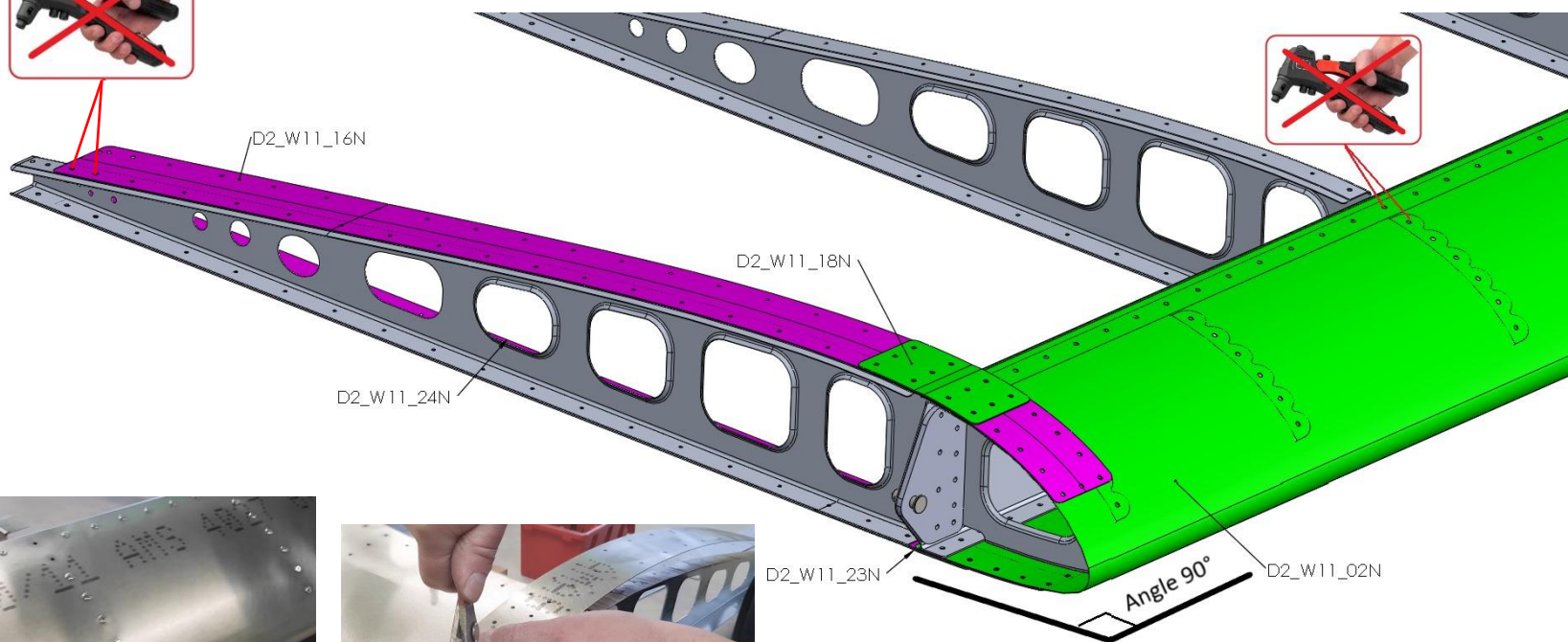
Step 19



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Step 19A



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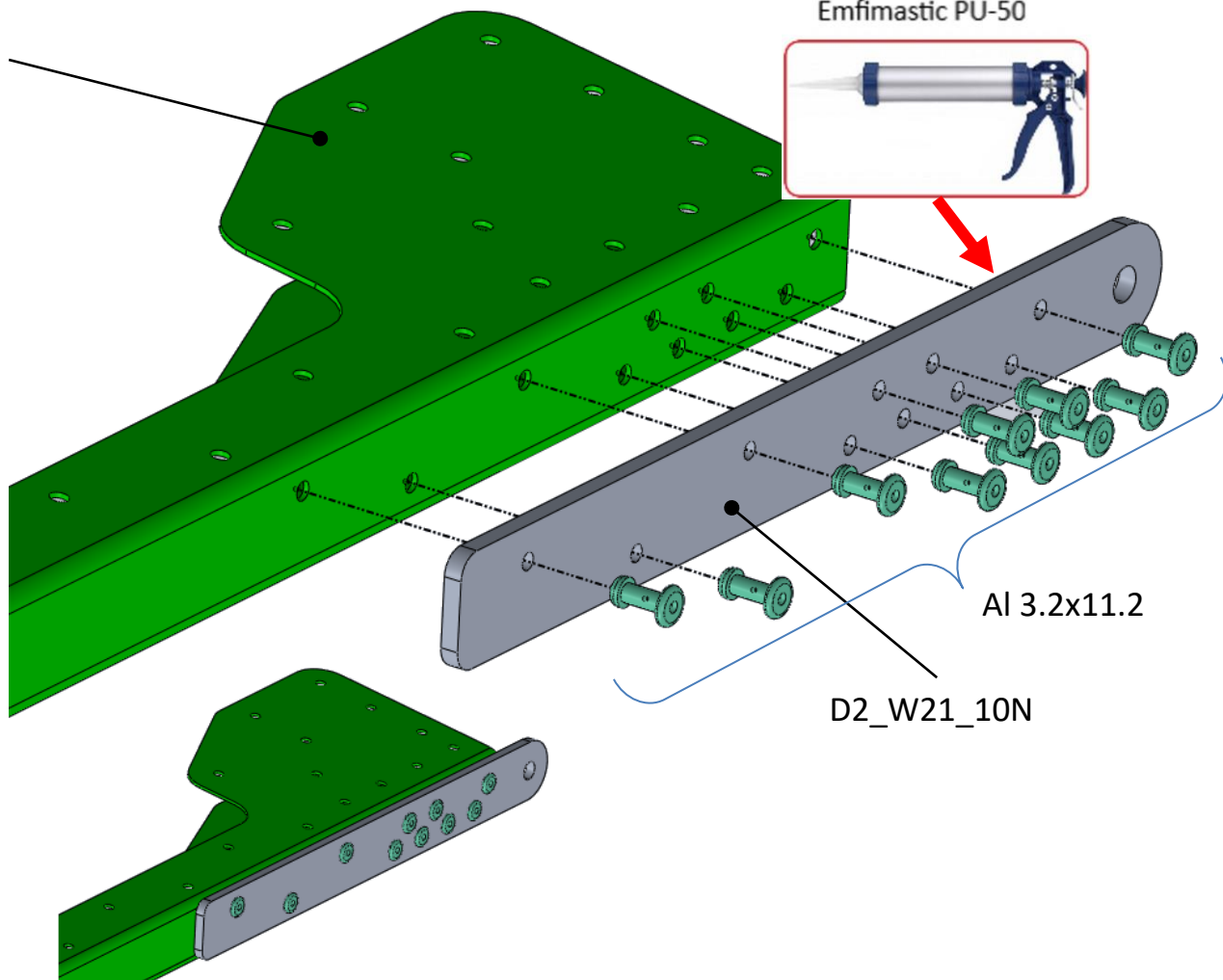


Polyurethane adhesive
Emfimastic PU-50



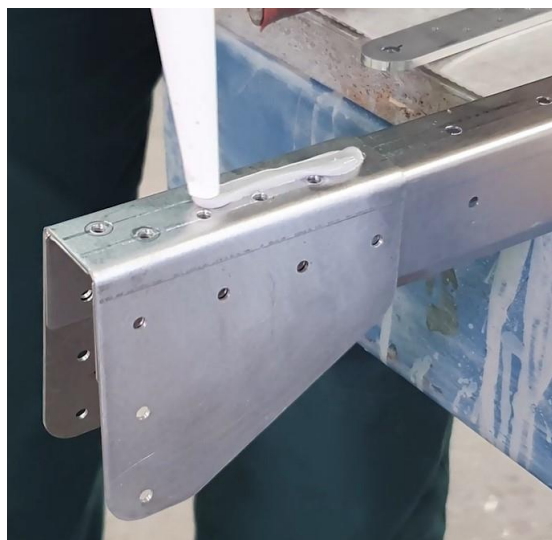
Step 20

D2_W11_03N



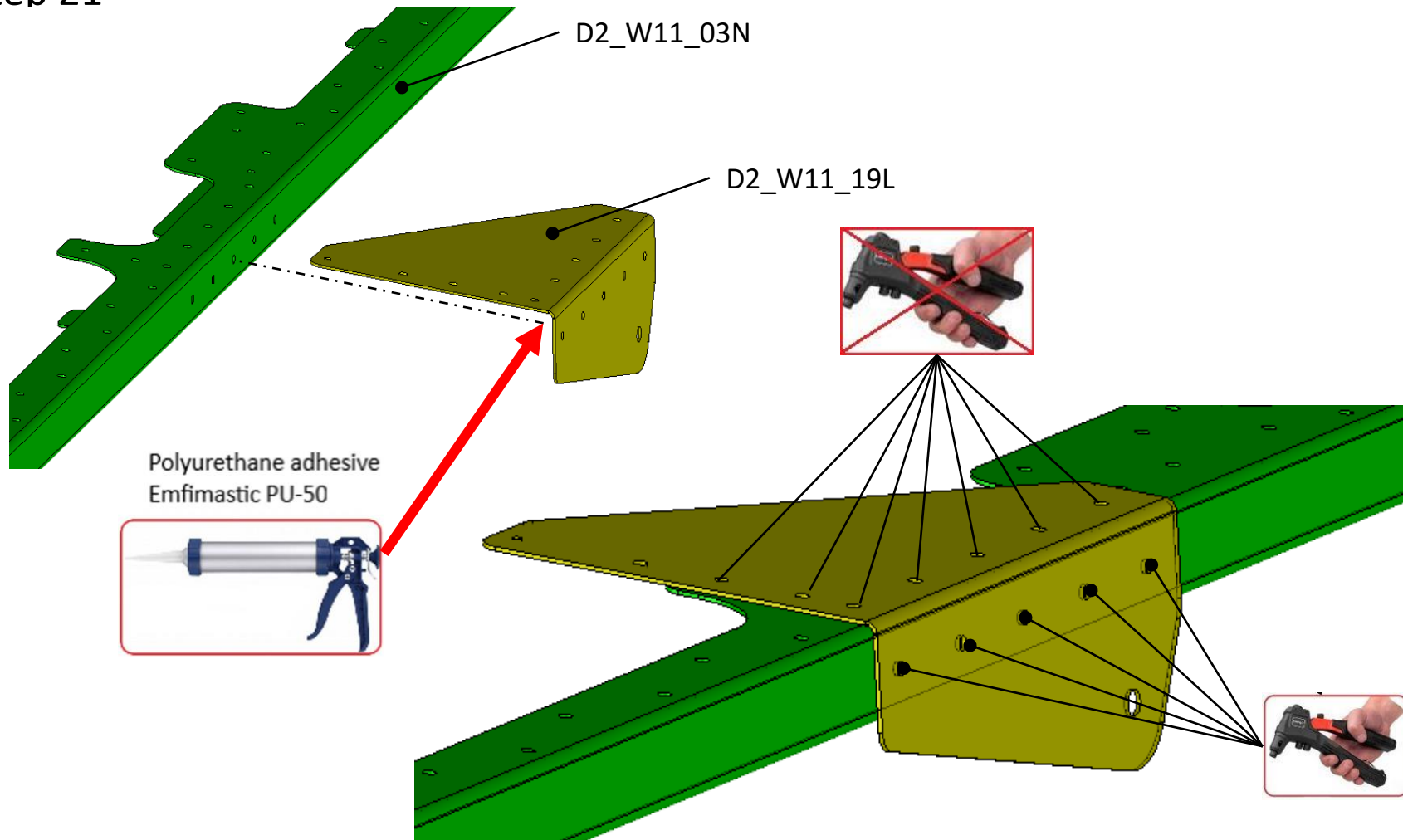
Al 3.2x11.2

D2_W21_10N



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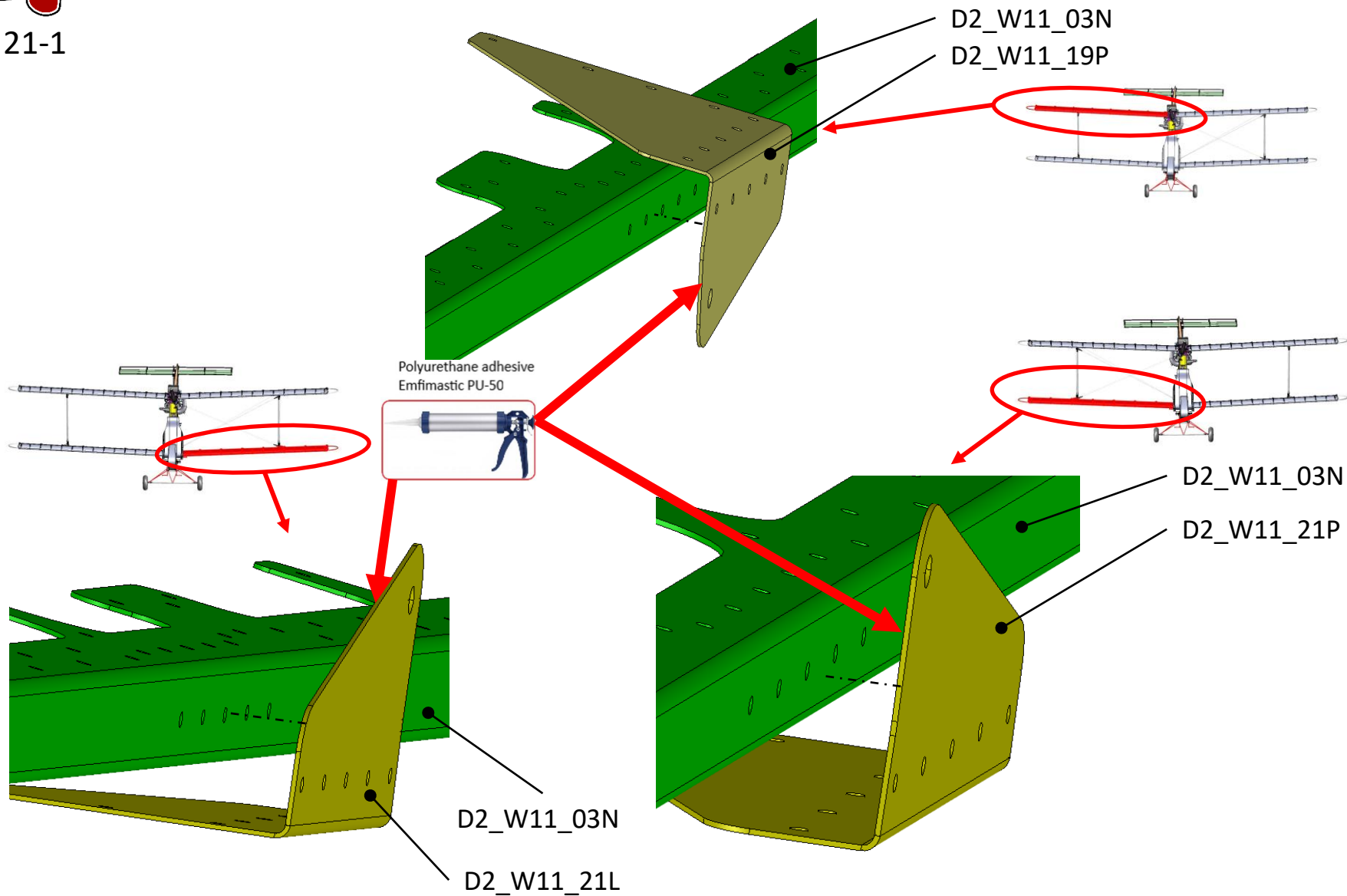
Step 21



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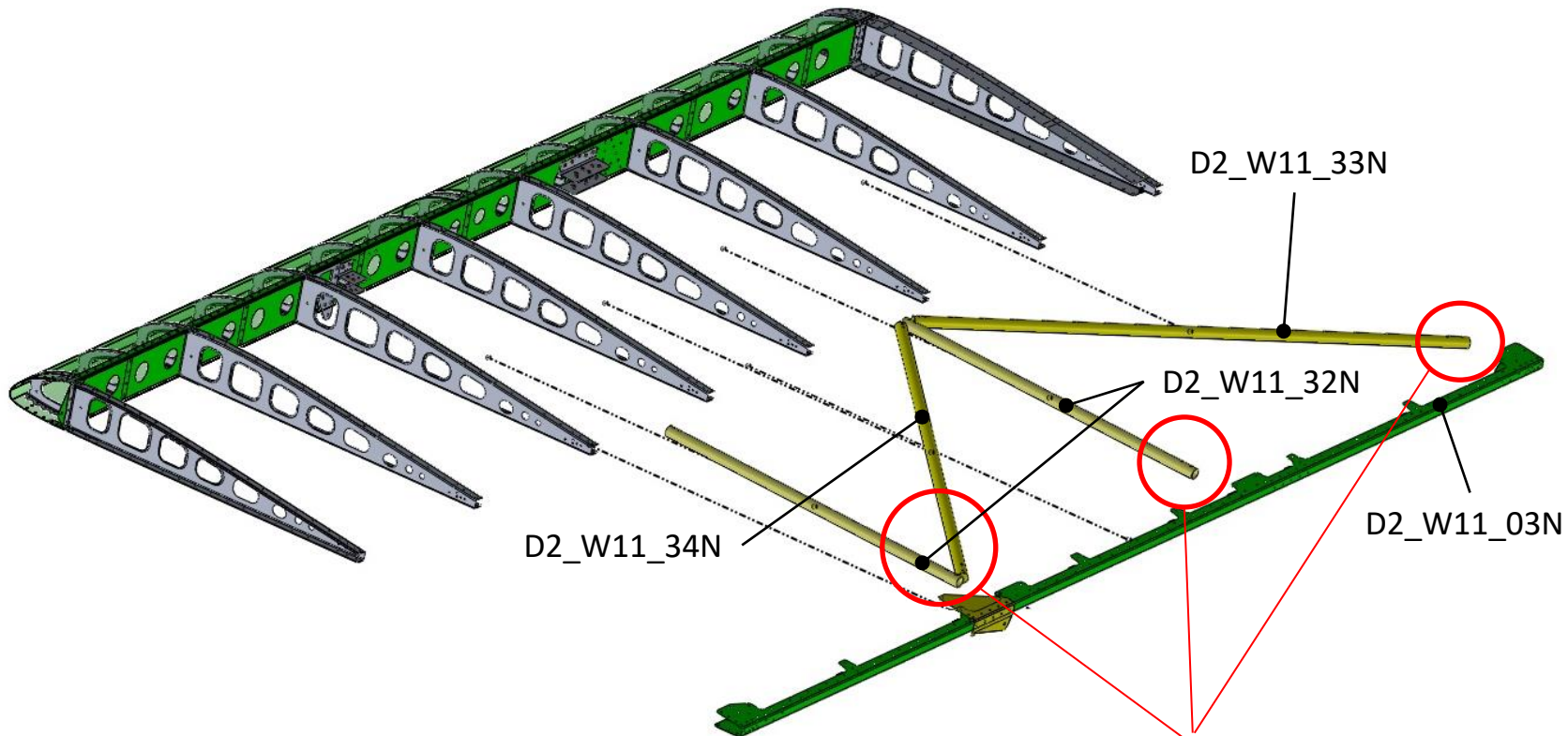
Step 21-1



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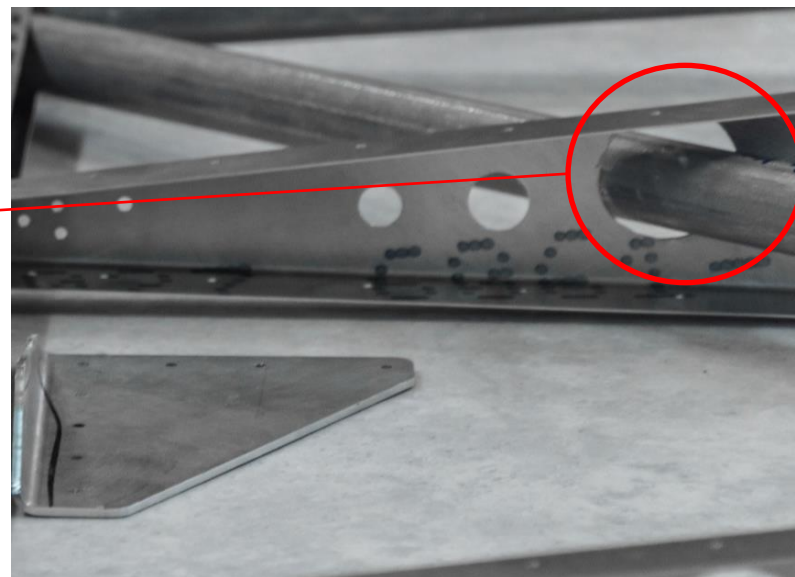
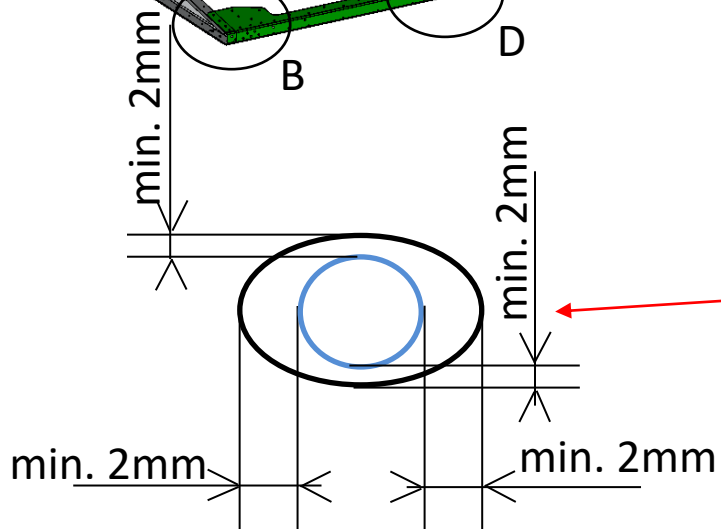
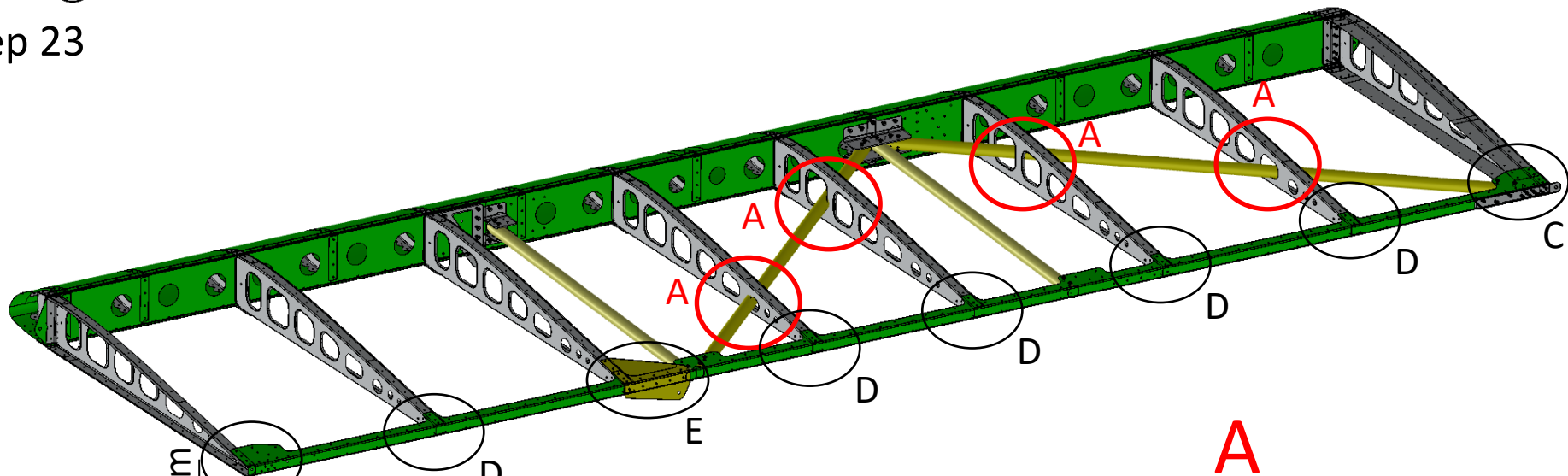
Step 22



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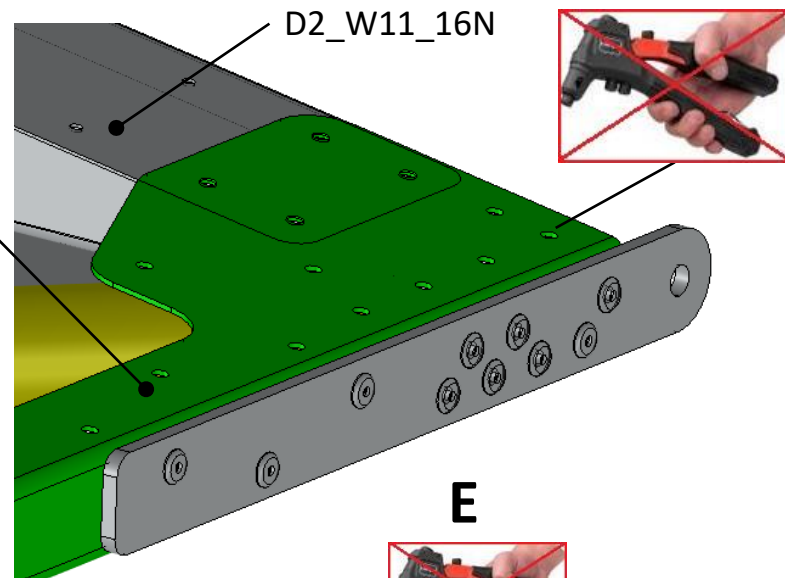
Step 23



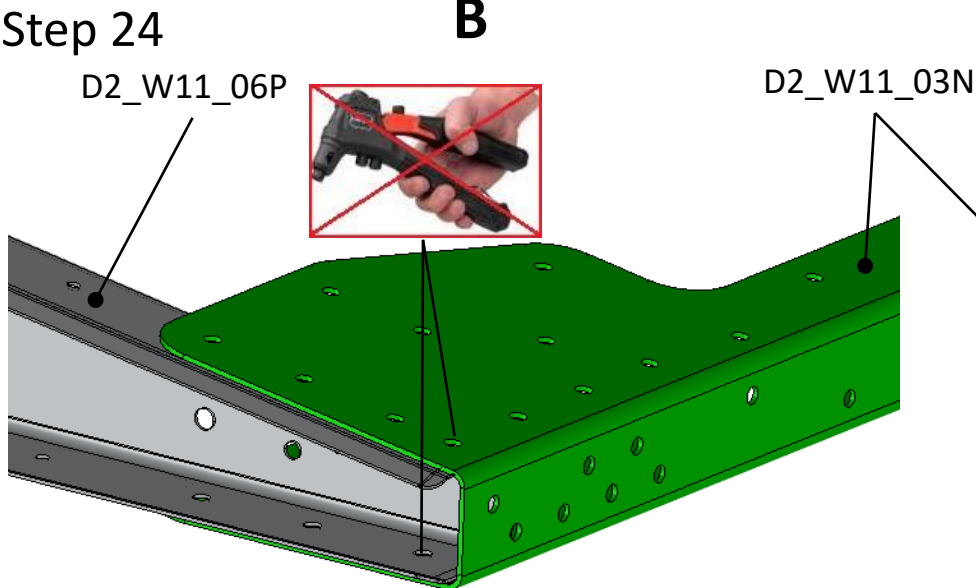
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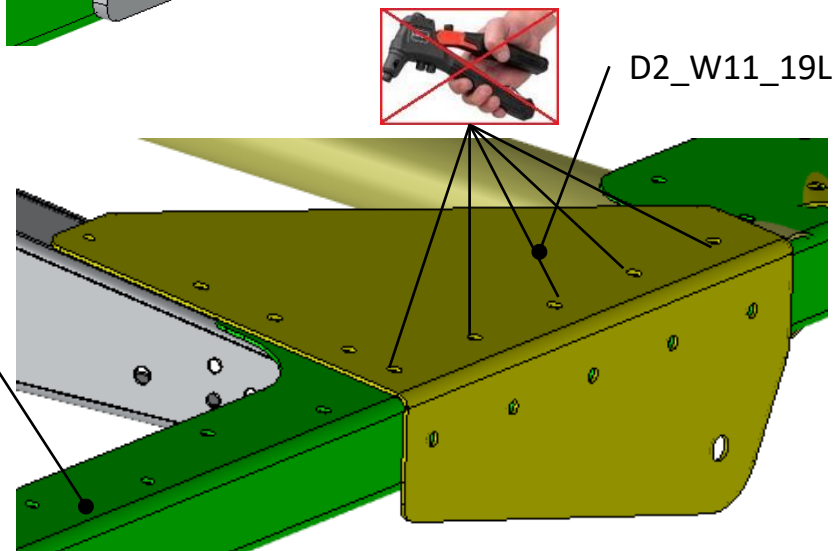
C



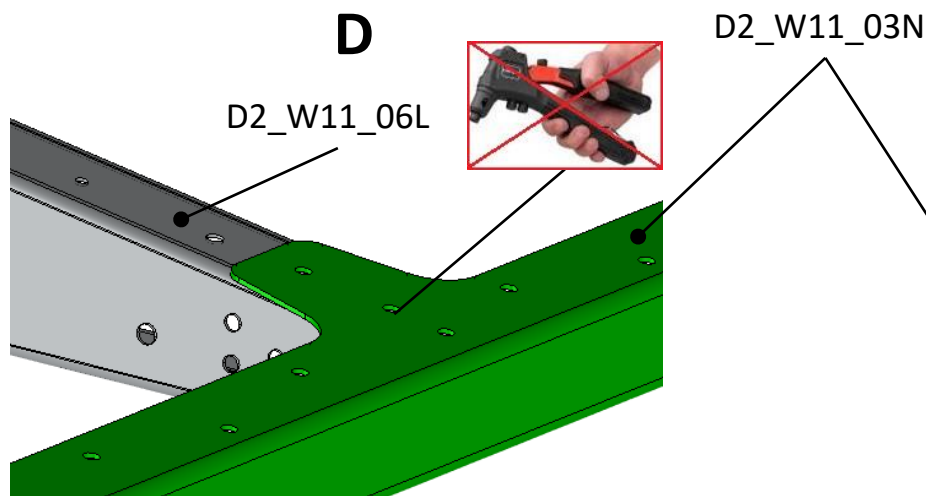
B



E



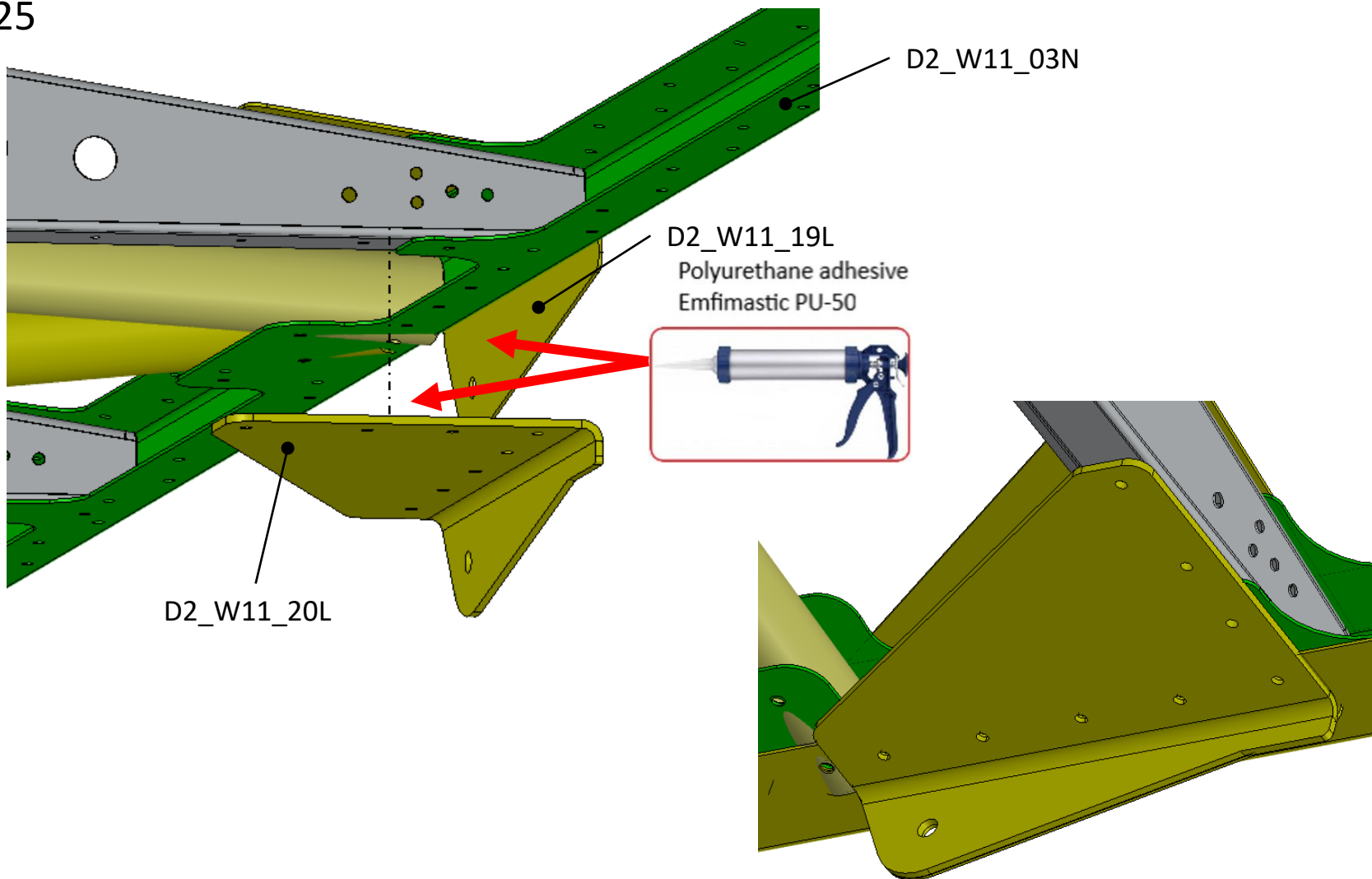
D



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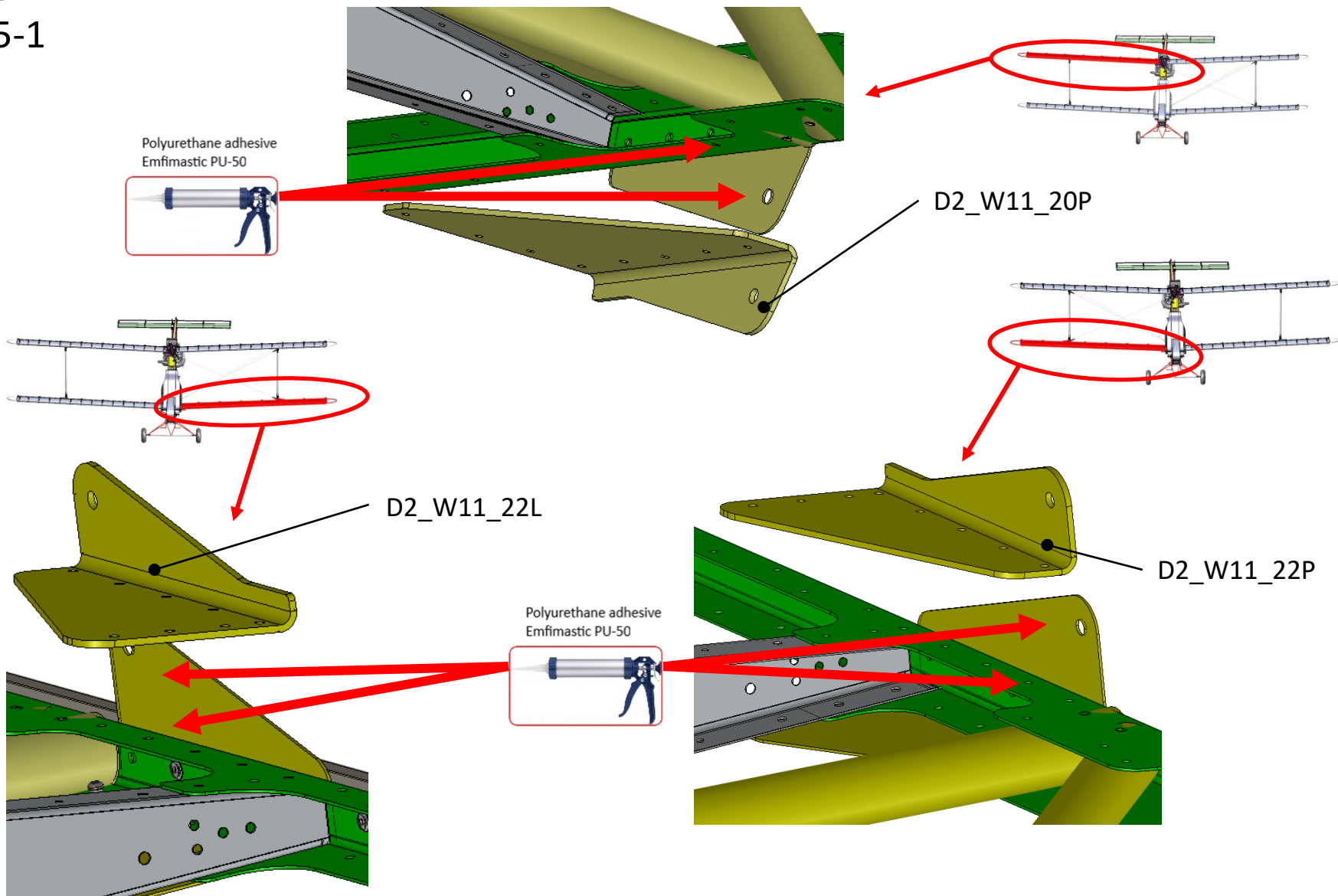
Step 25



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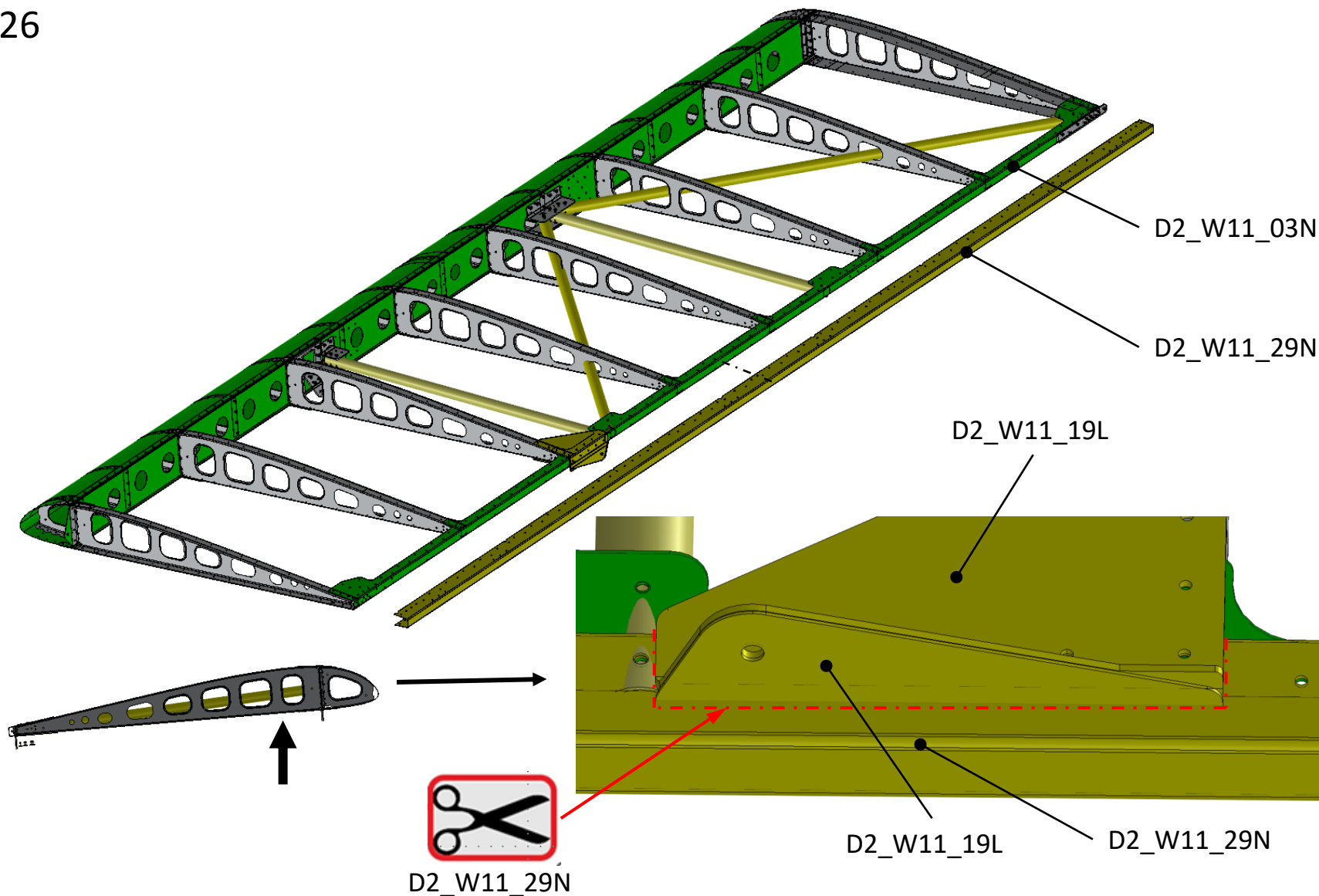
Step 25-1



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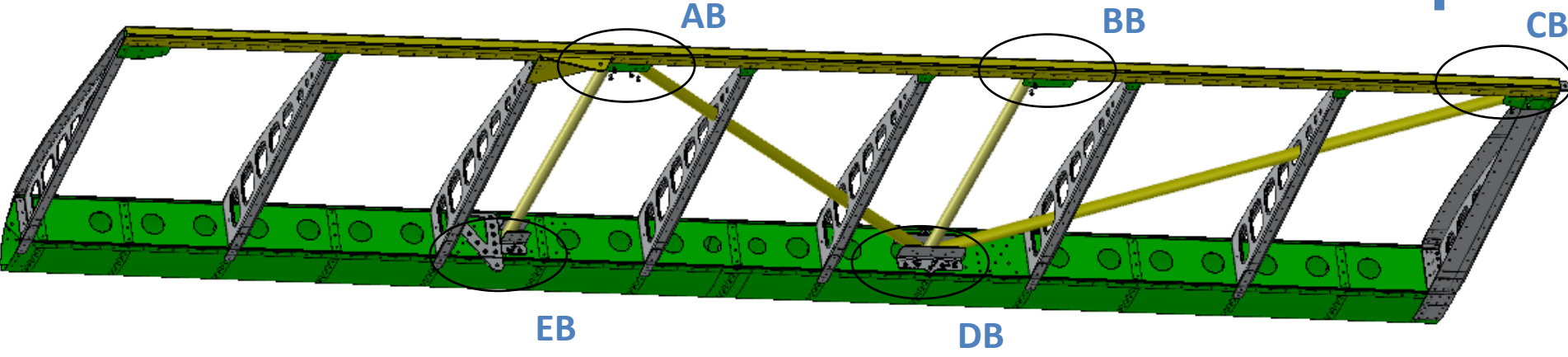
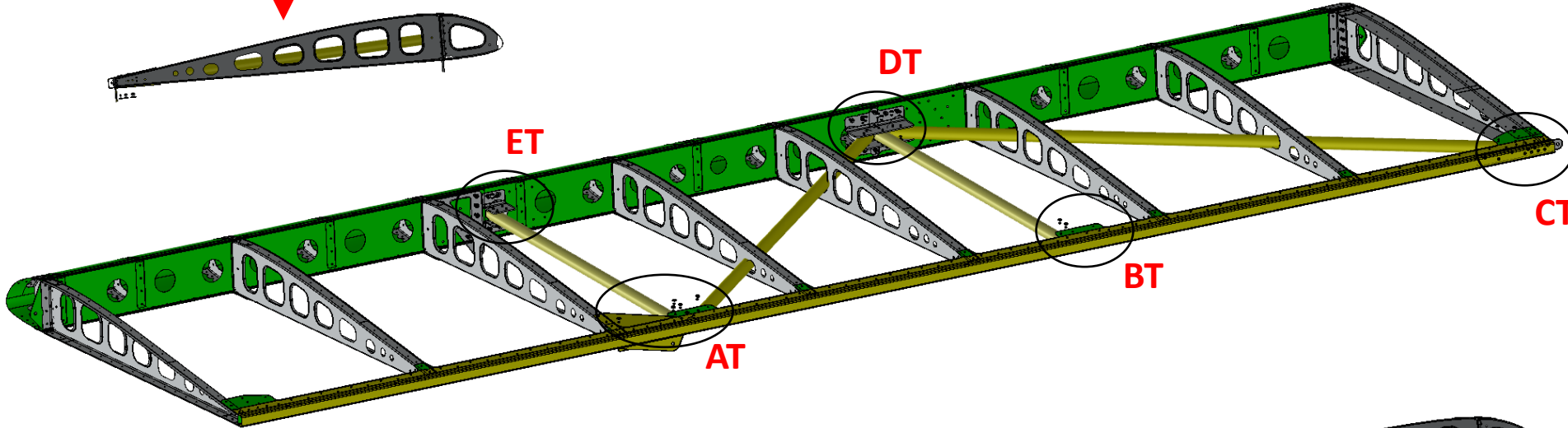
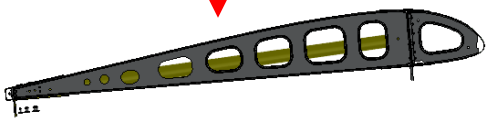
Step 26



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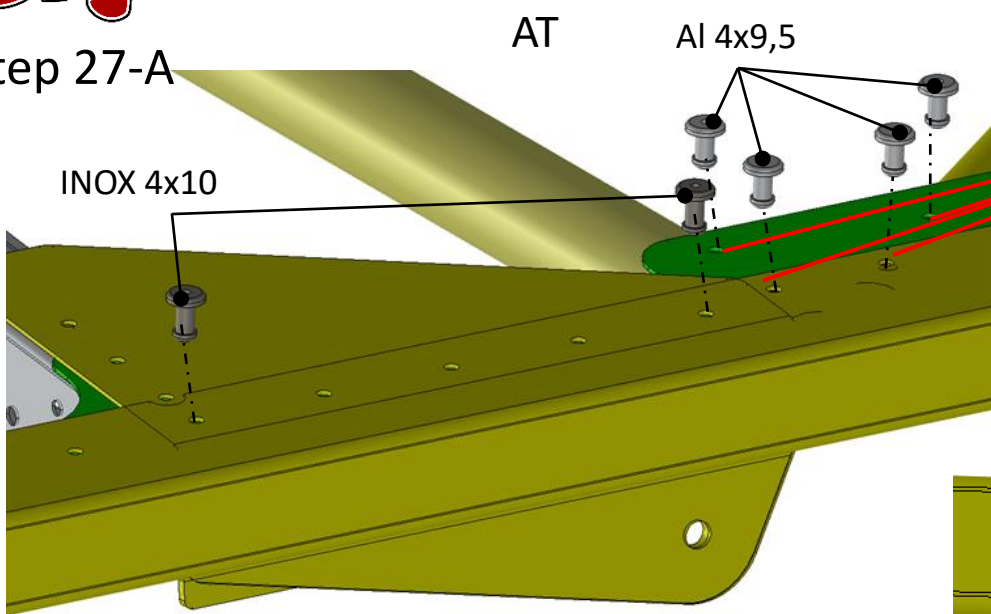
Step 27



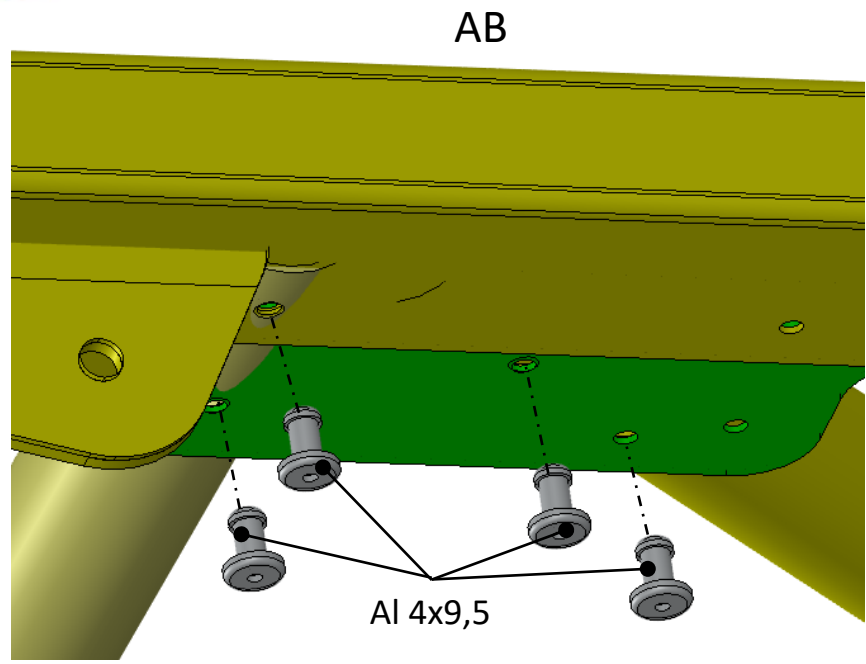
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Step 27-A



4x Ø4mm



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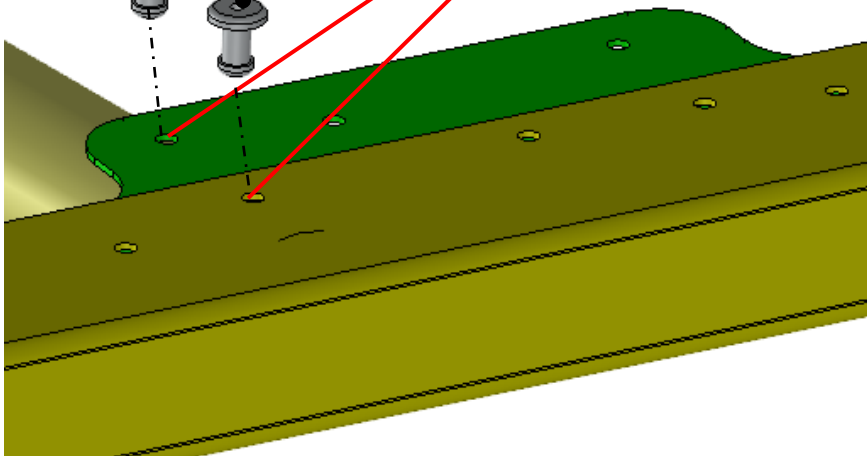
Step 27-B

BT

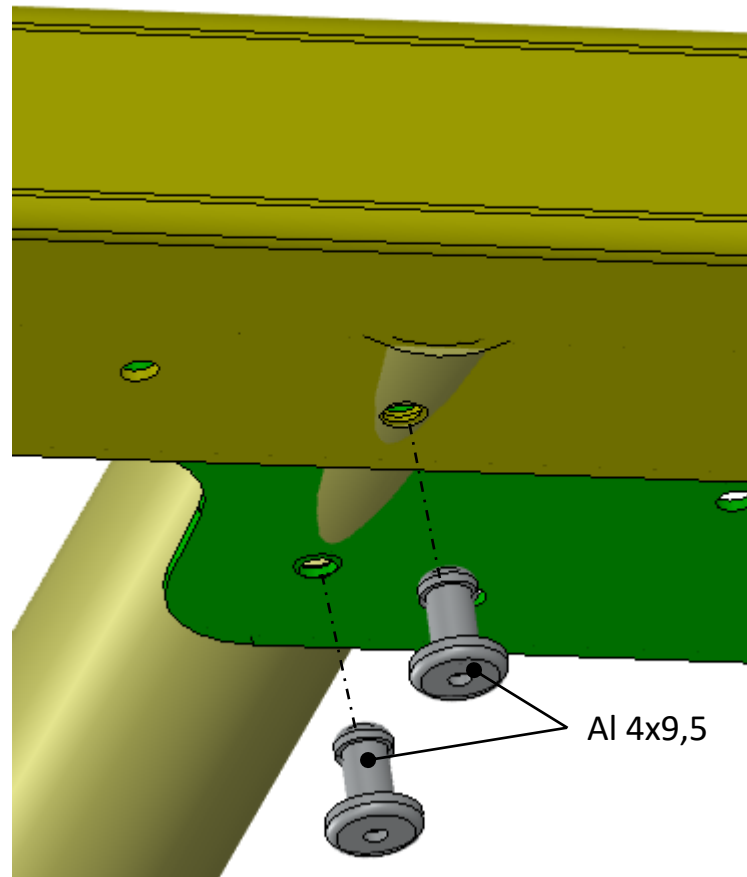


2x Ø4mm

Al 4x9,5



BB



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Step 27-C

CT

Al 4x9,5



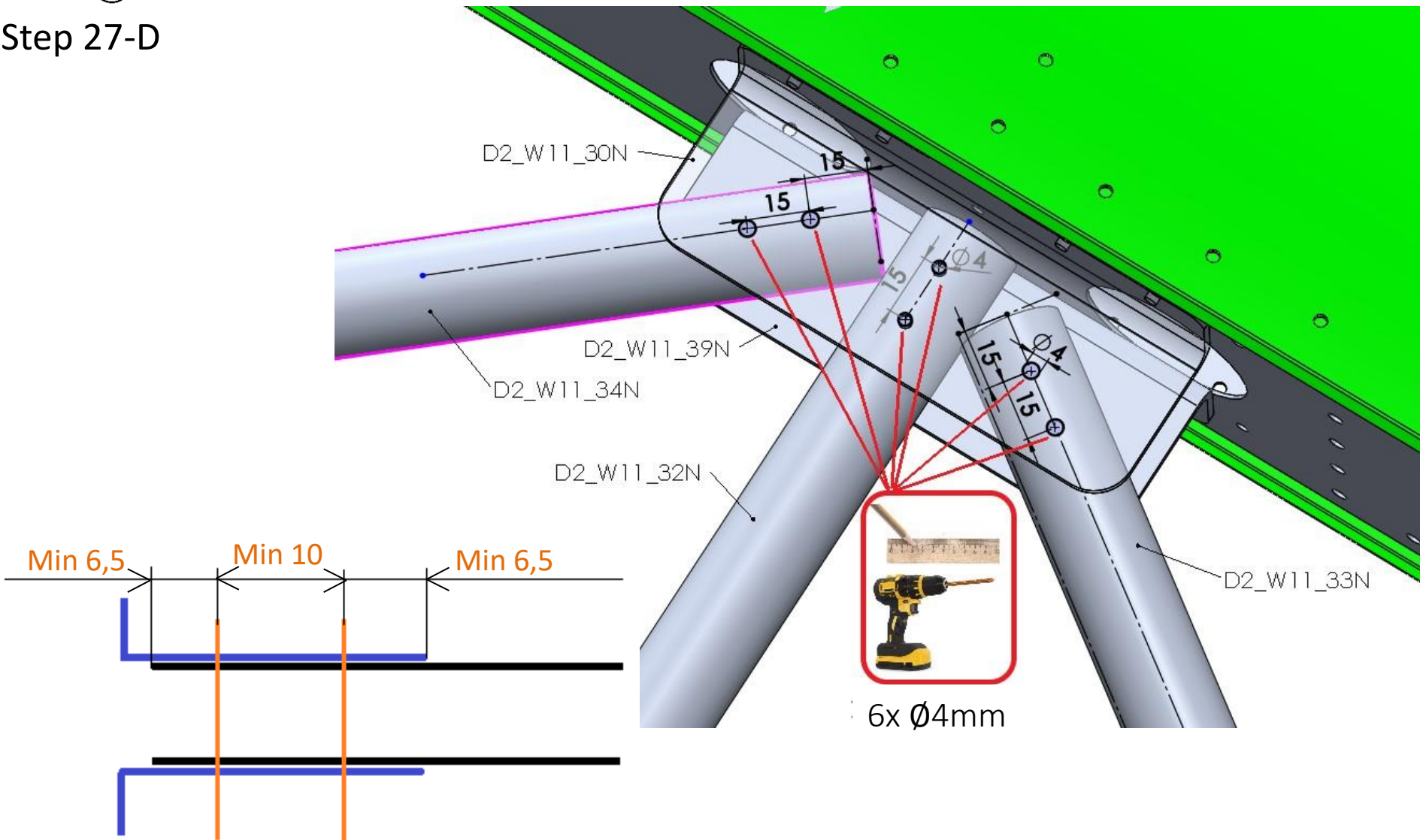
2x Ø4mm

CB

Al 4x9,5

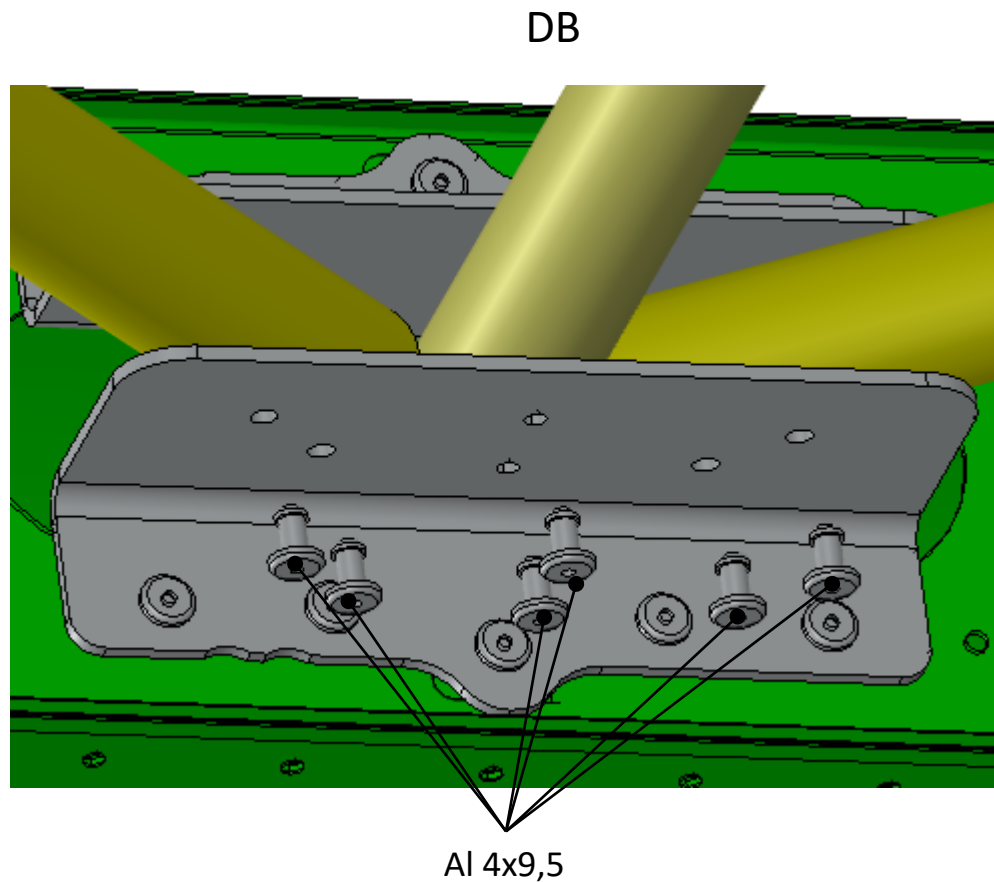
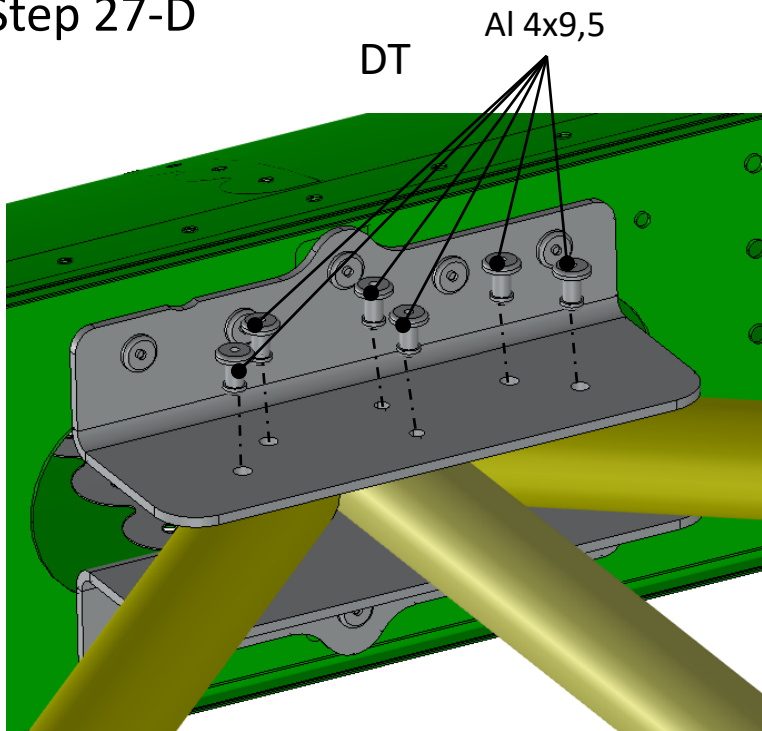
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Step 27-D



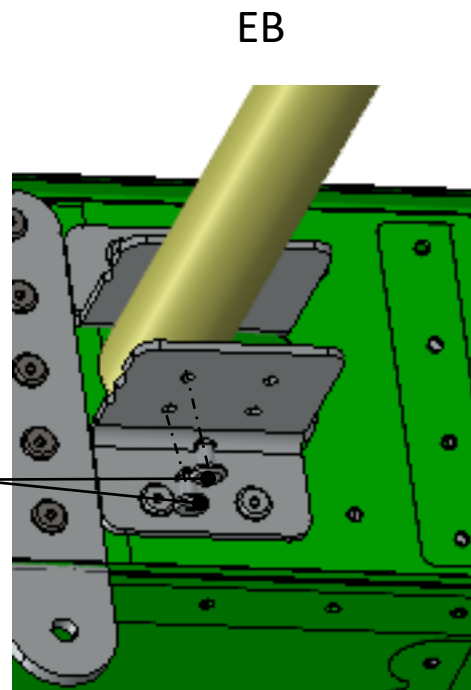
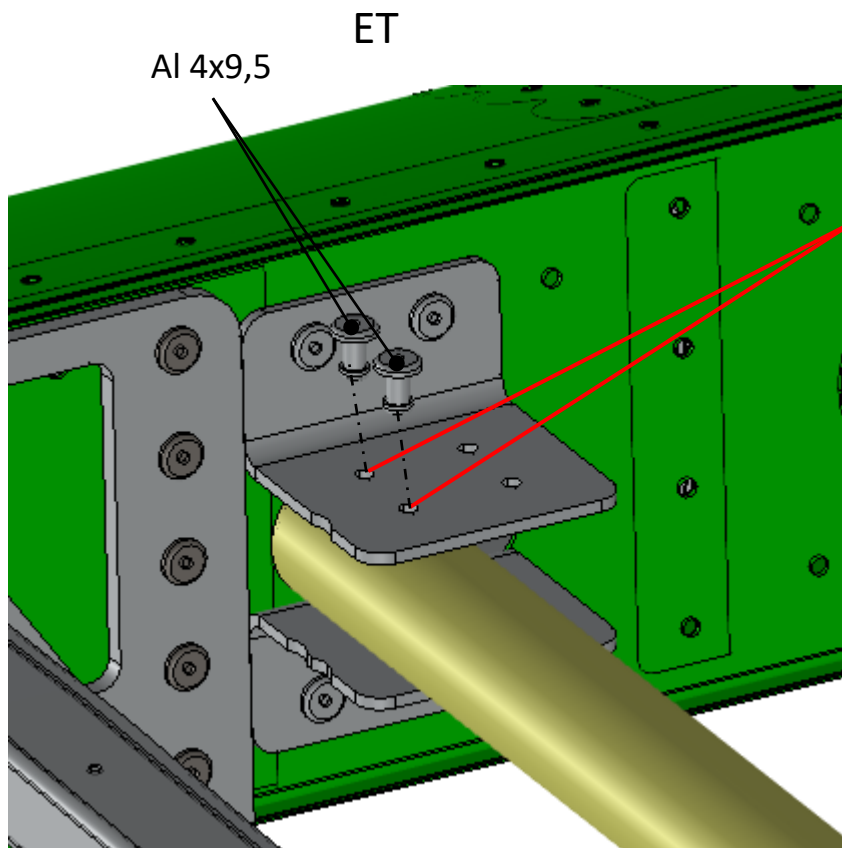
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Step 27-D



Title	Document no.	Revision	Page	Pages
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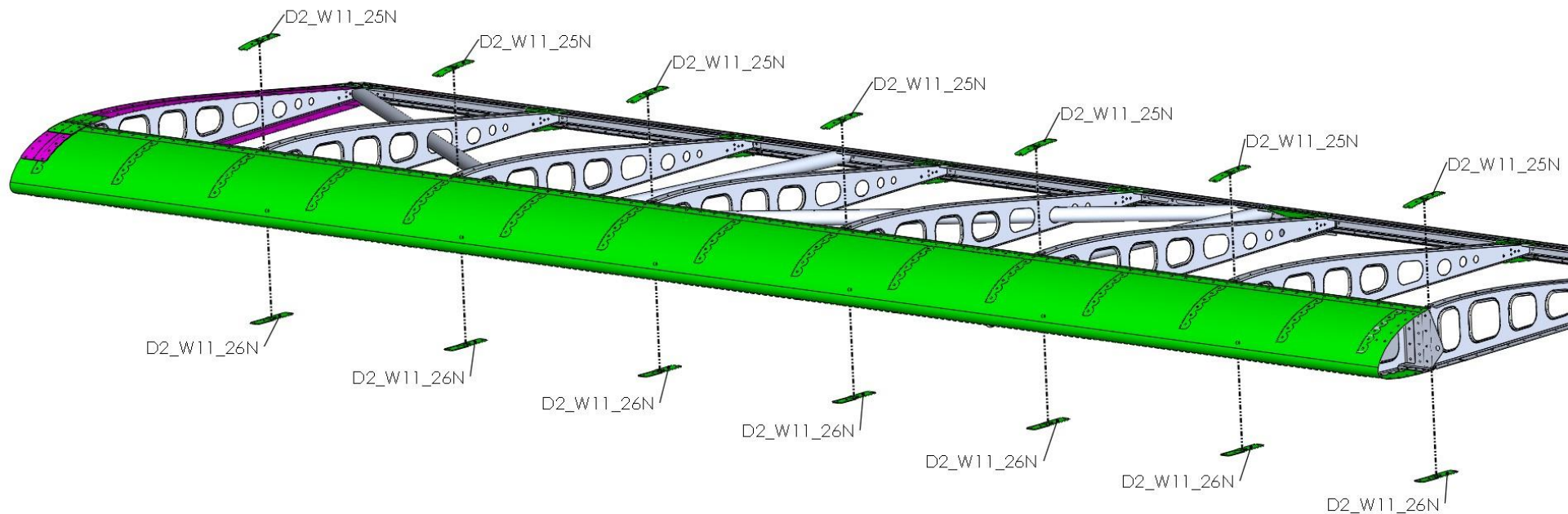
Step 27-E



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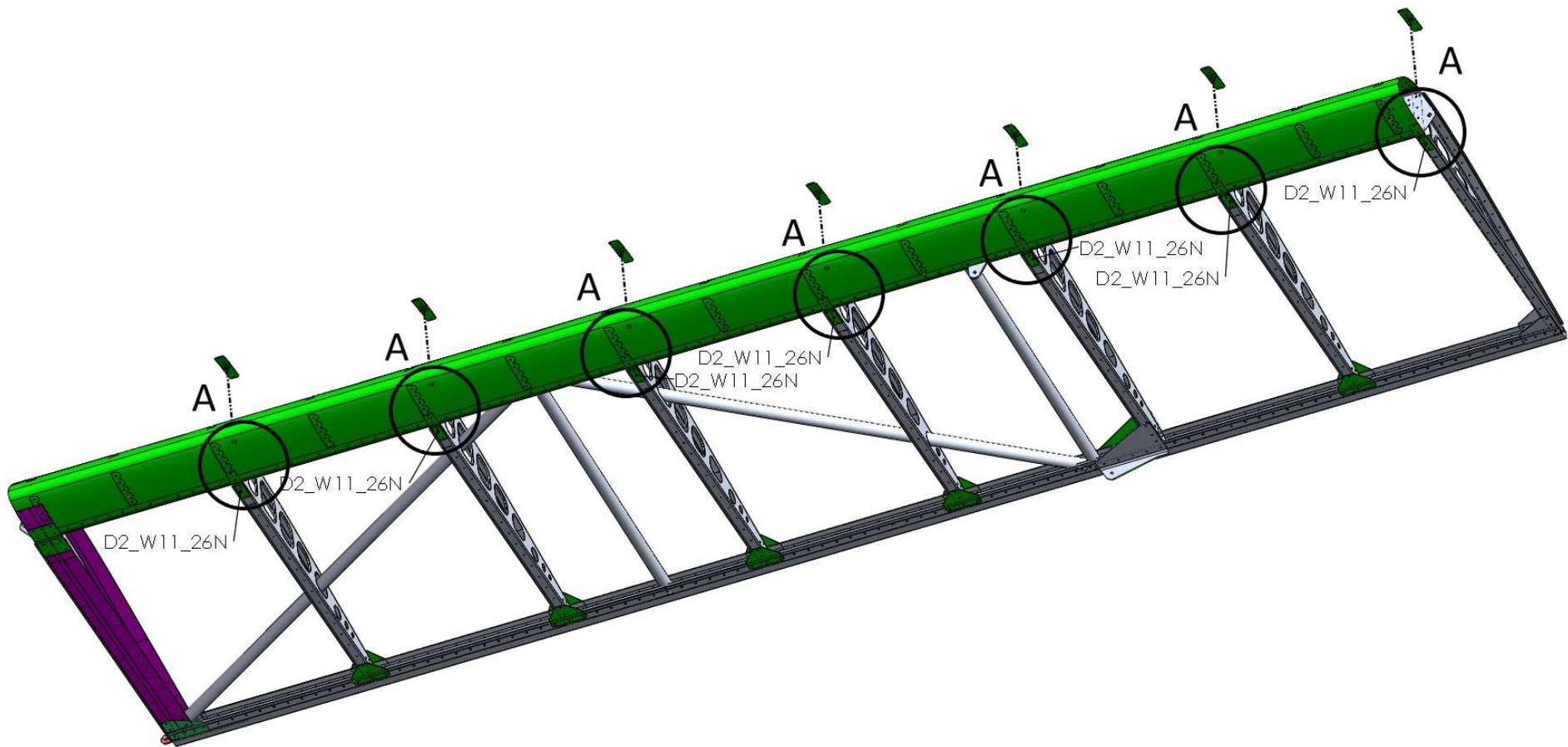
Step 28



Title	Document no.	Revision	Page	Pages
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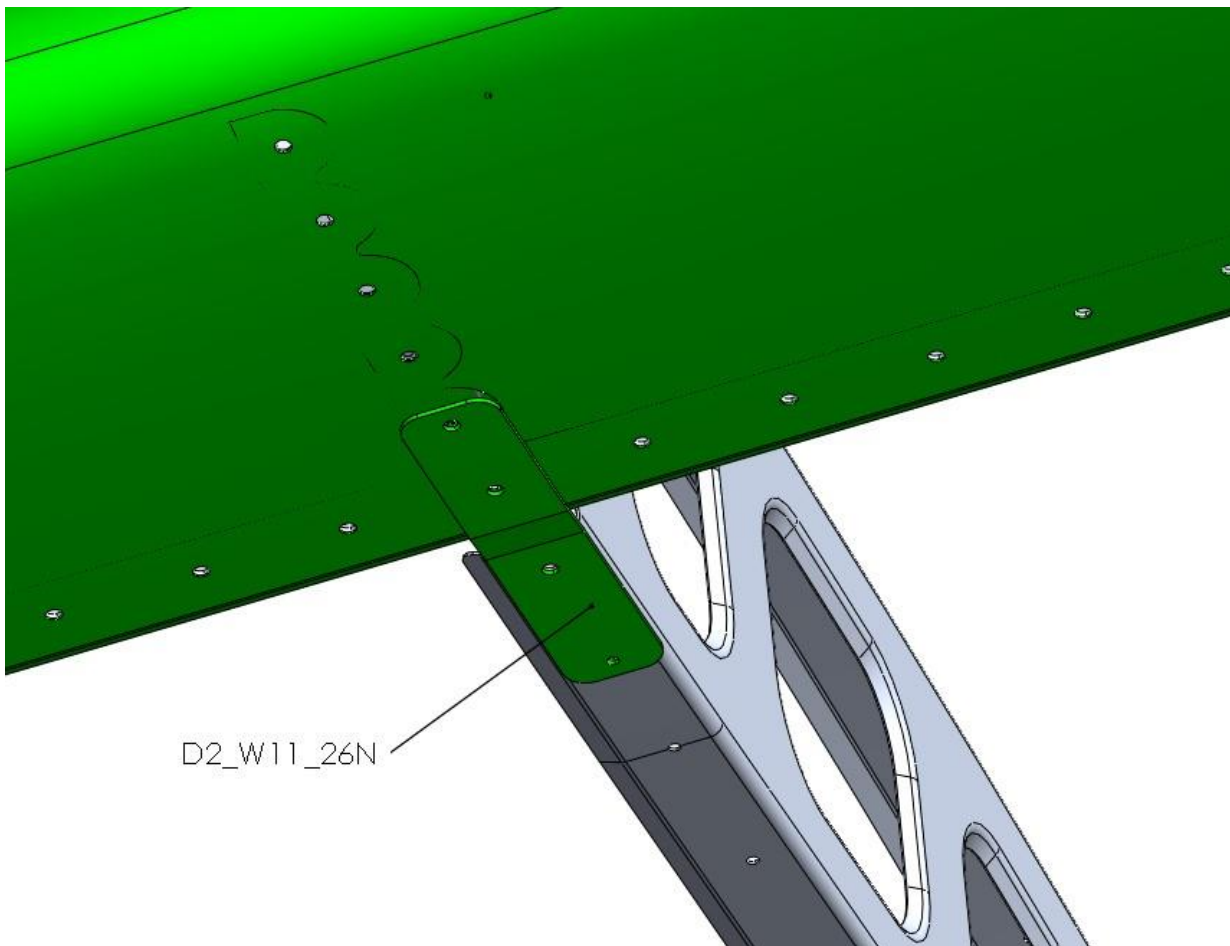
Step 29



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Step 29-A

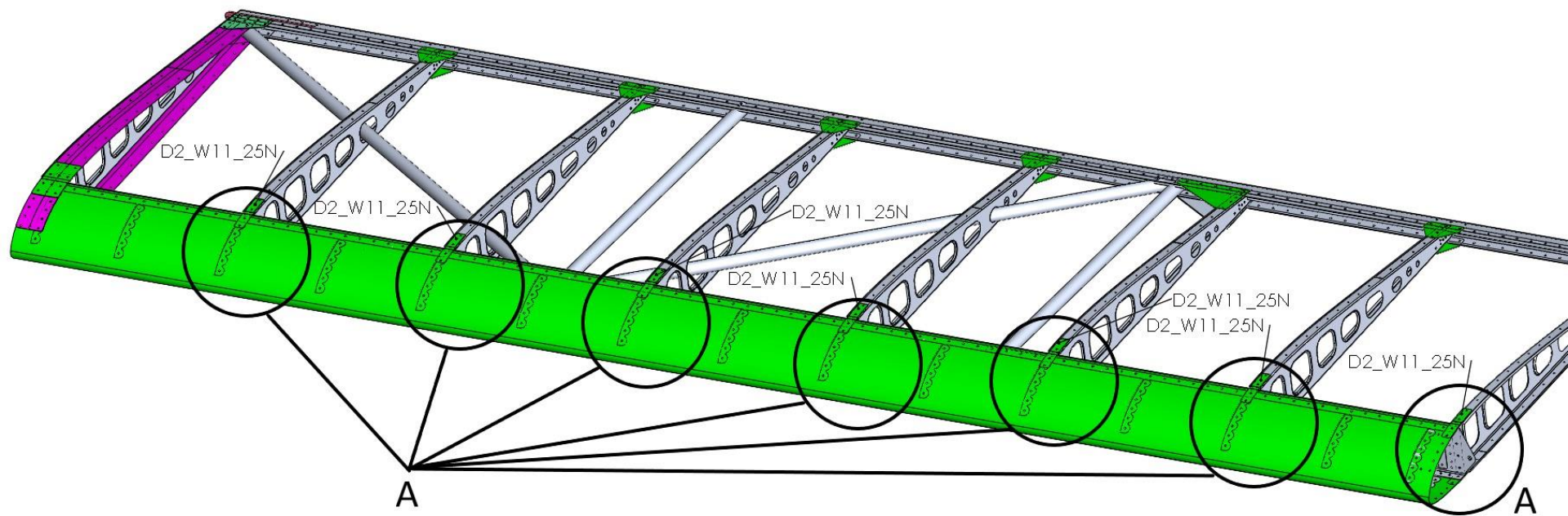


D2_W11_26N

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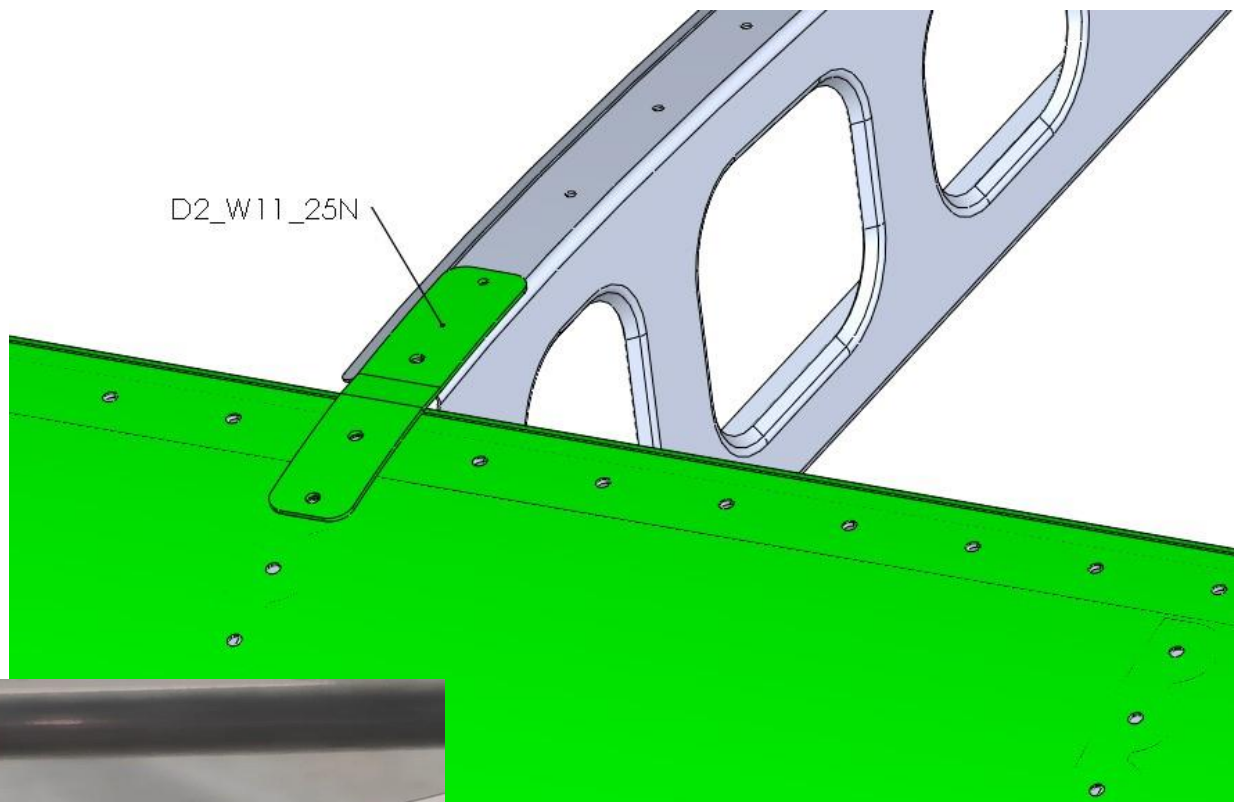
Step 30



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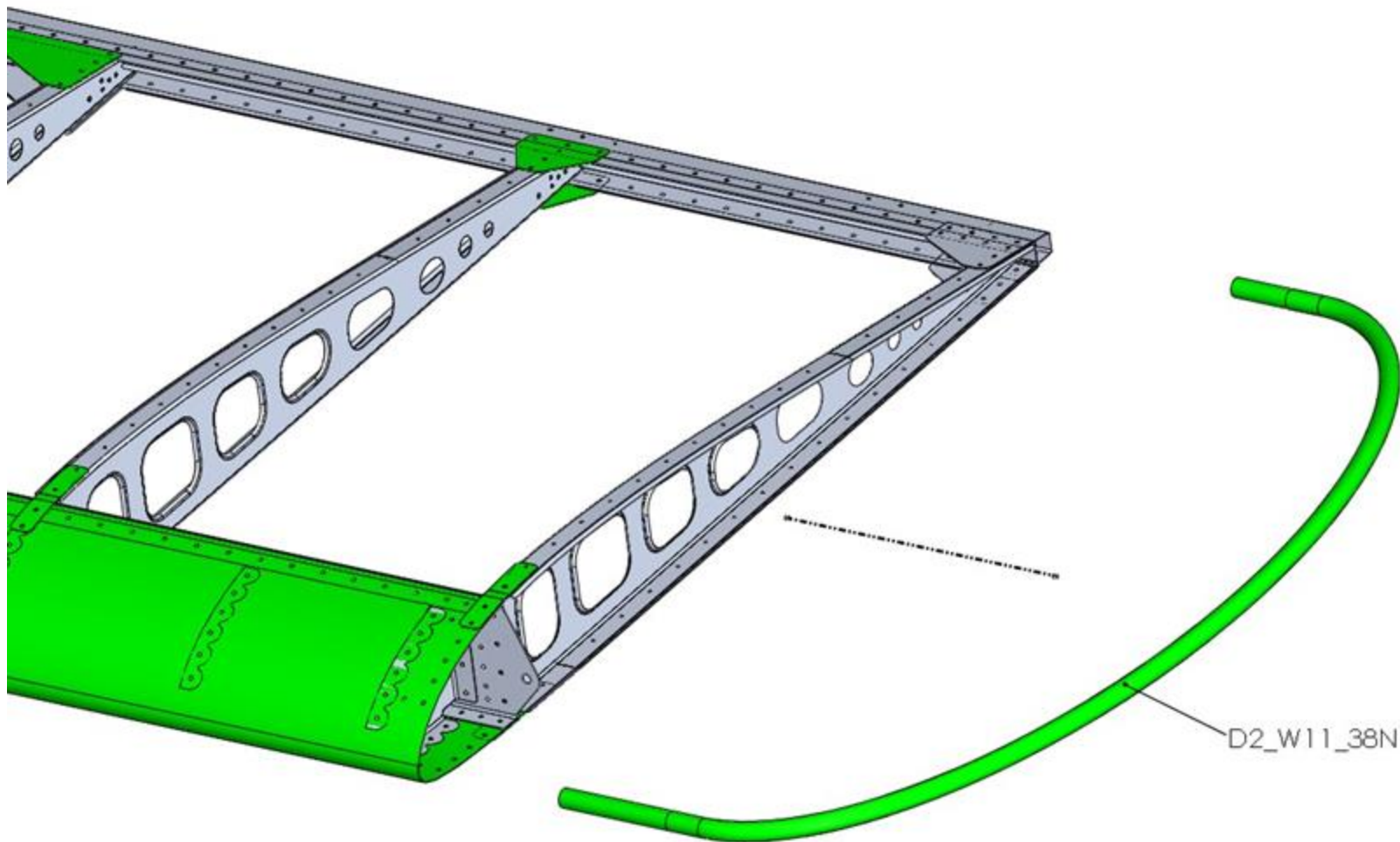
Step 30-A



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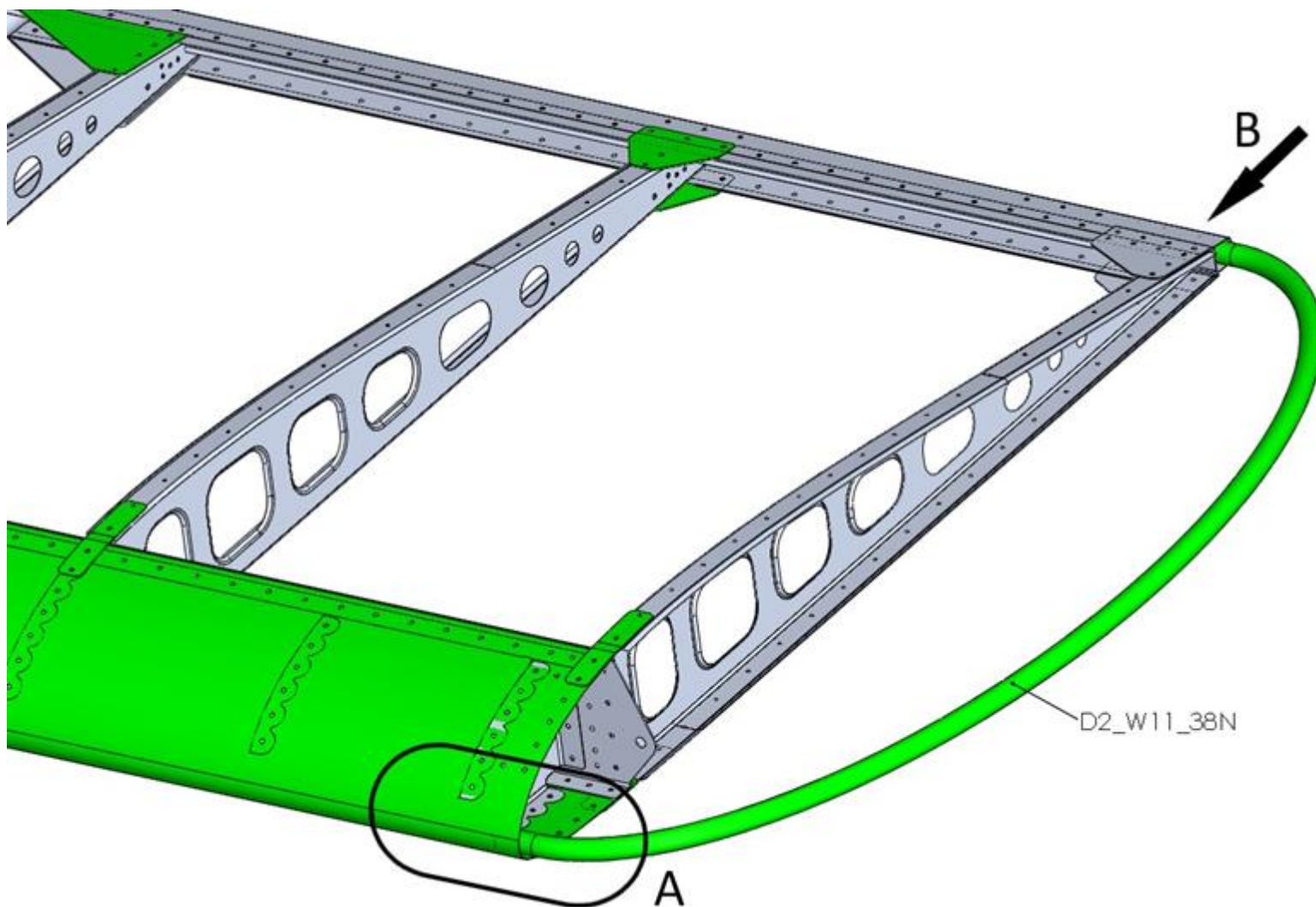
Step 31



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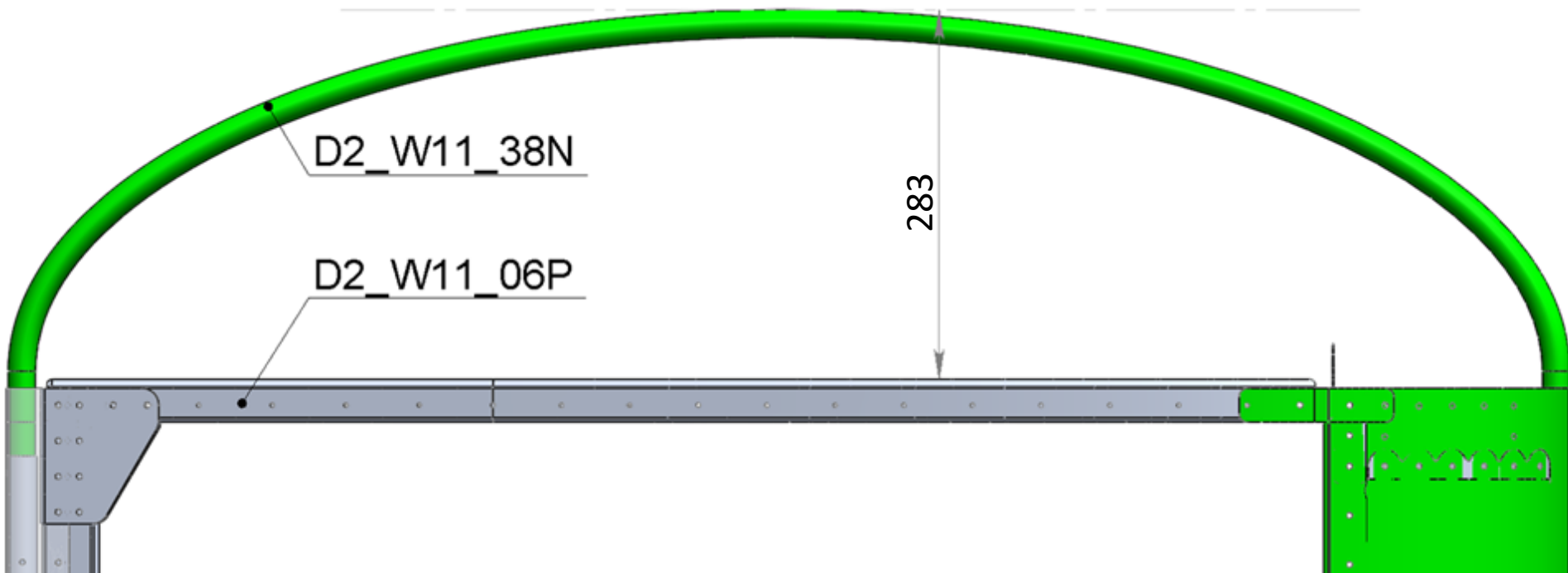
Step 32



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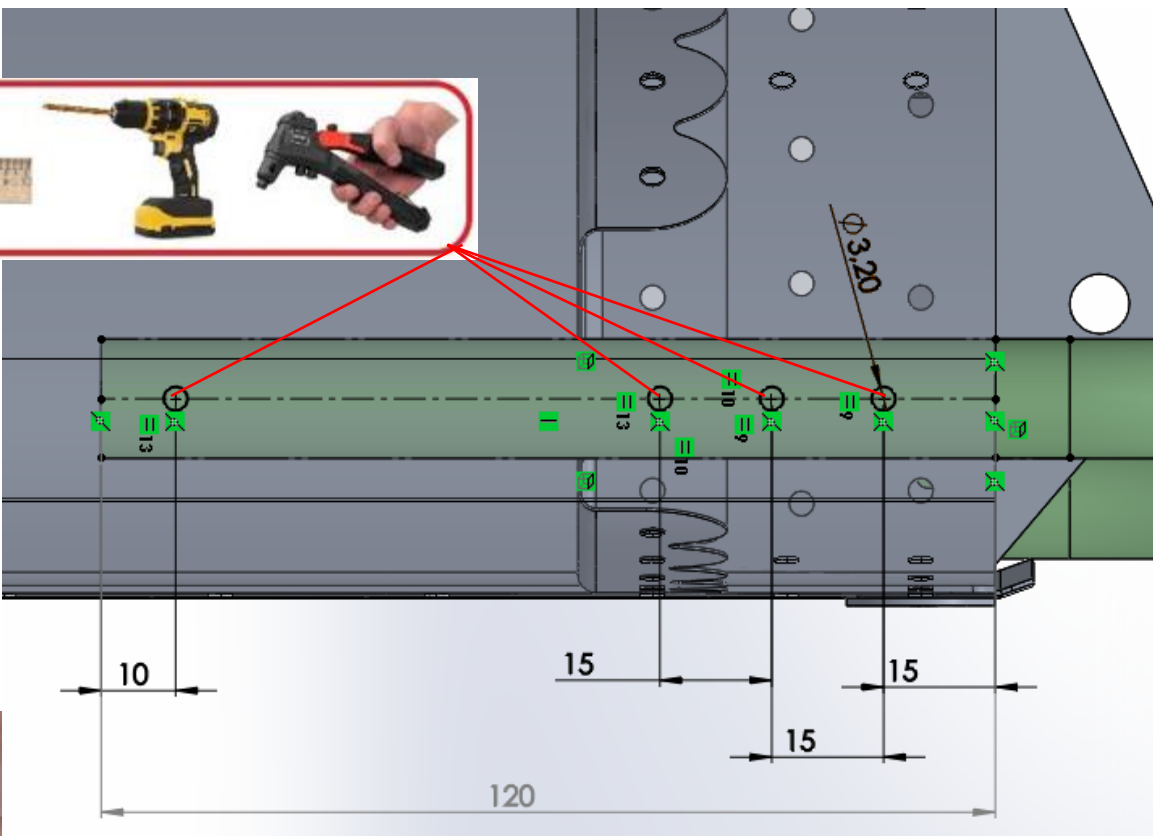
Step 33



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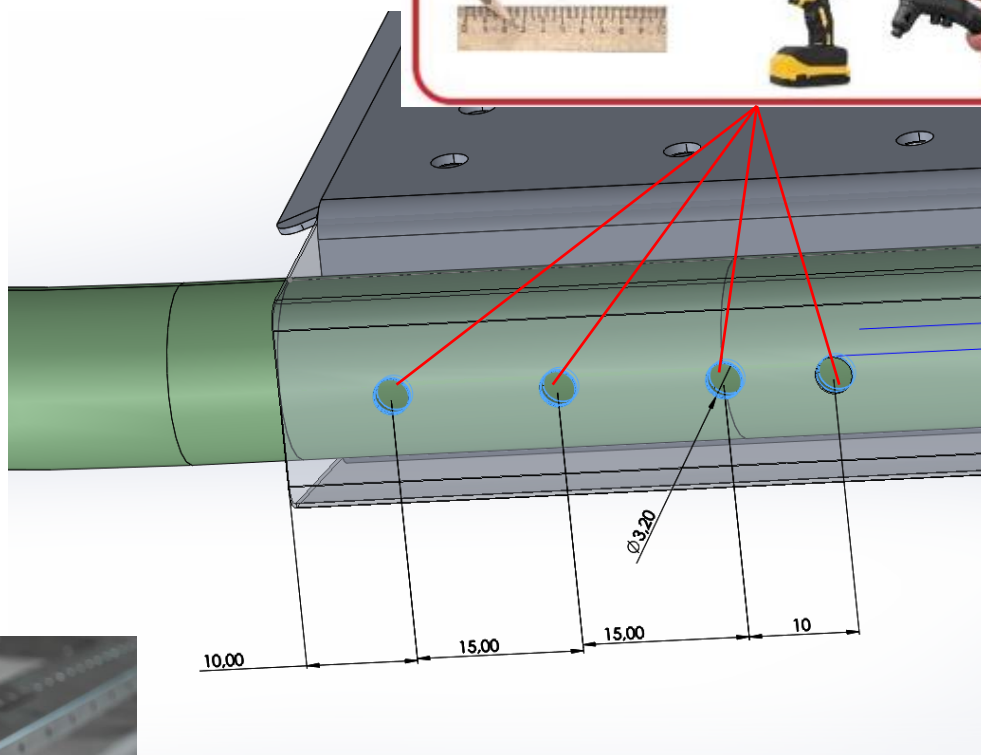
Step 32-A



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Step 32-B

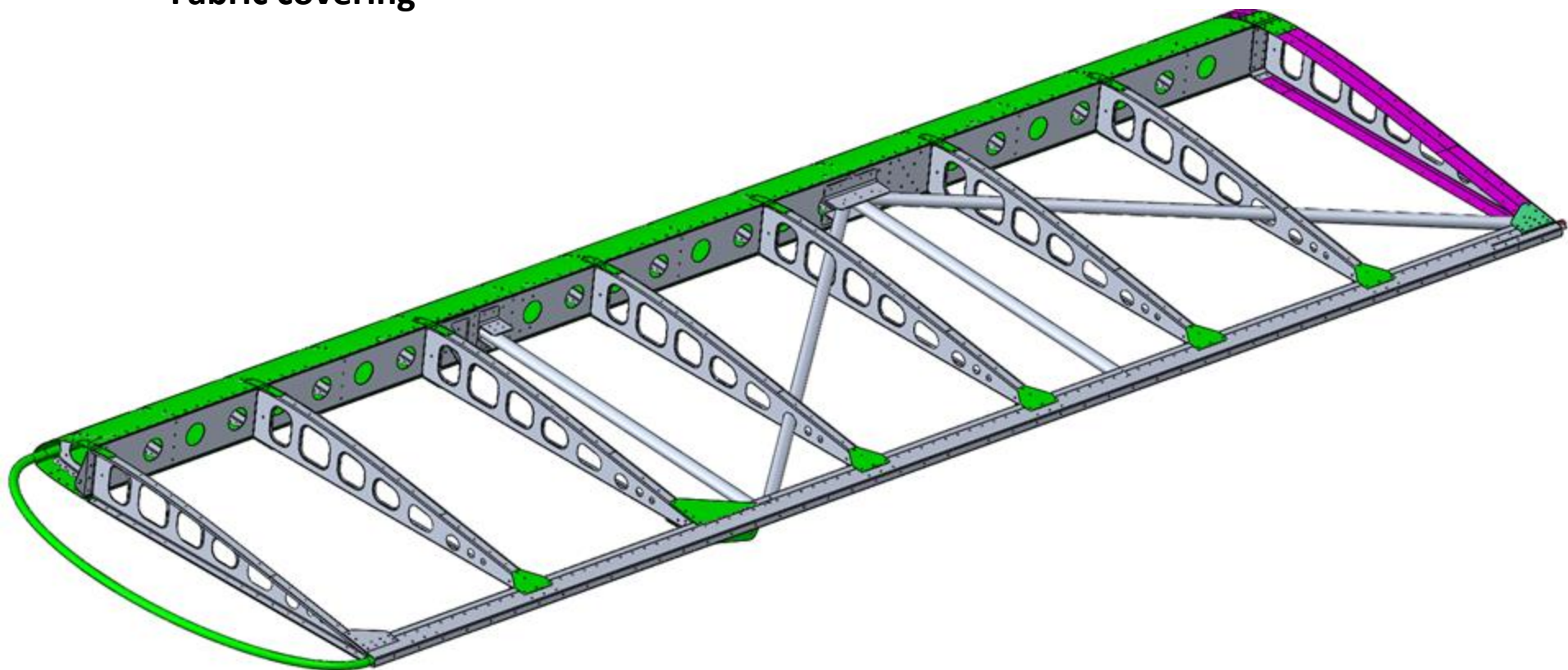


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Step 34

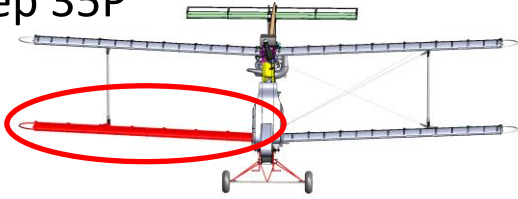
Fabric covering



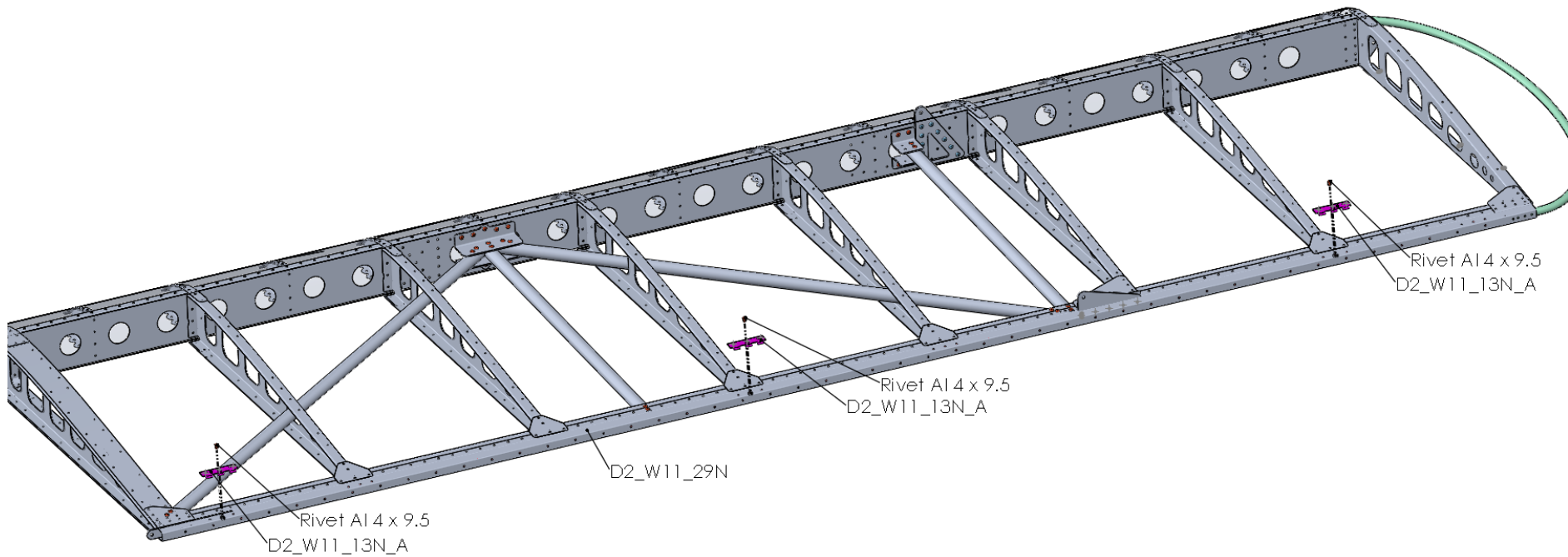
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Step 35P



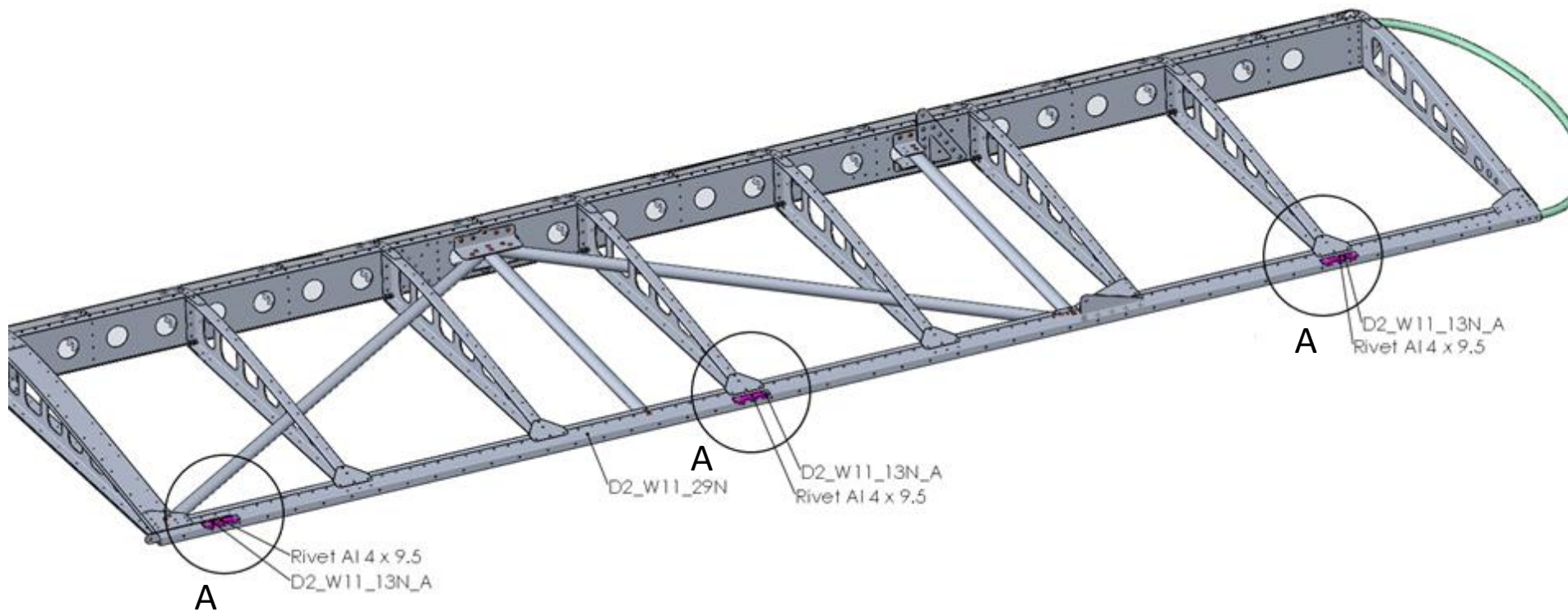
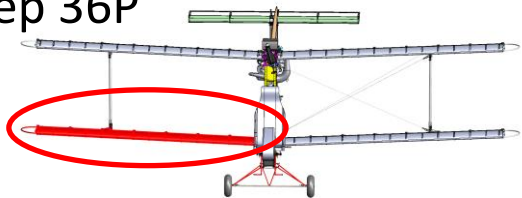
D2_W11_13N-A	3x
Rivet AVEX 3,2x7,9 Al/St	6x
Rivet AVEX 4x9,5 Al/St	3x



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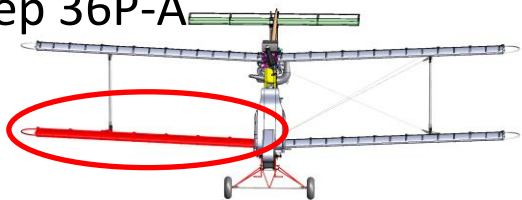
Step 36P



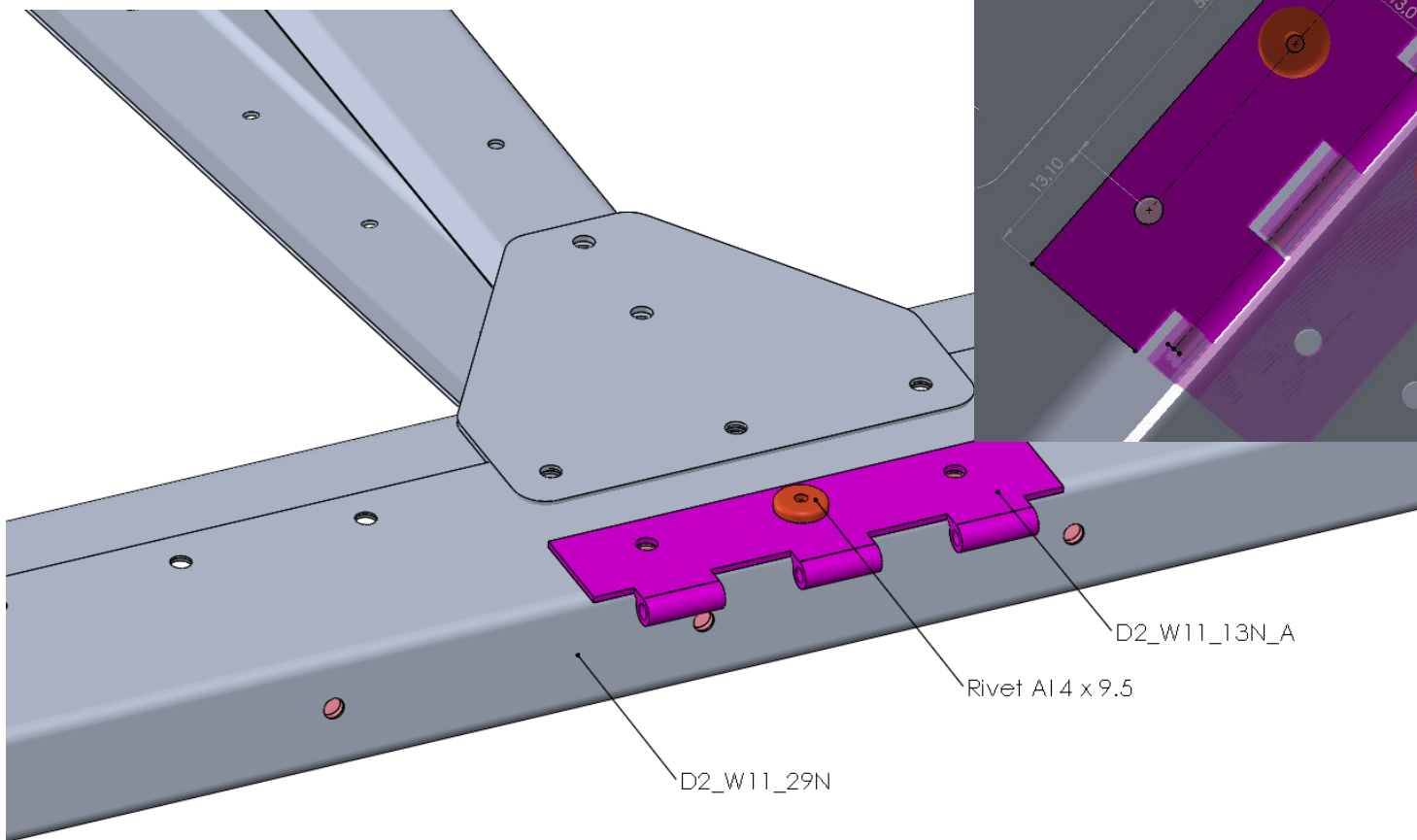
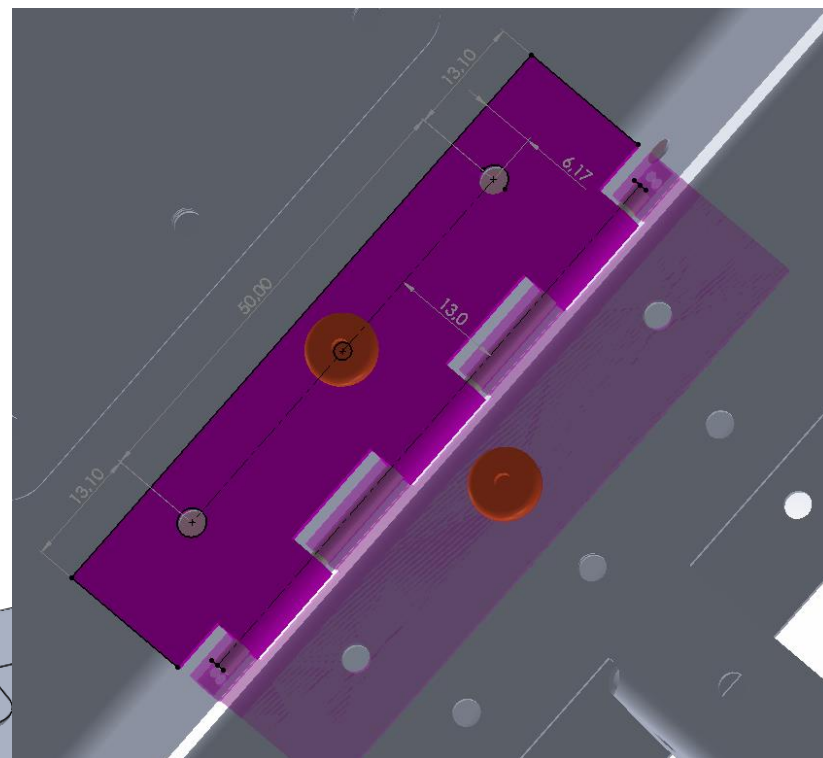
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Step 36P-A



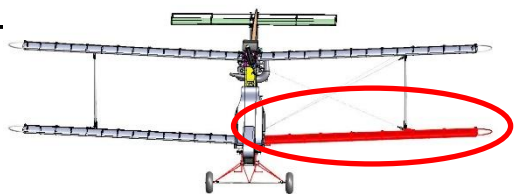
A



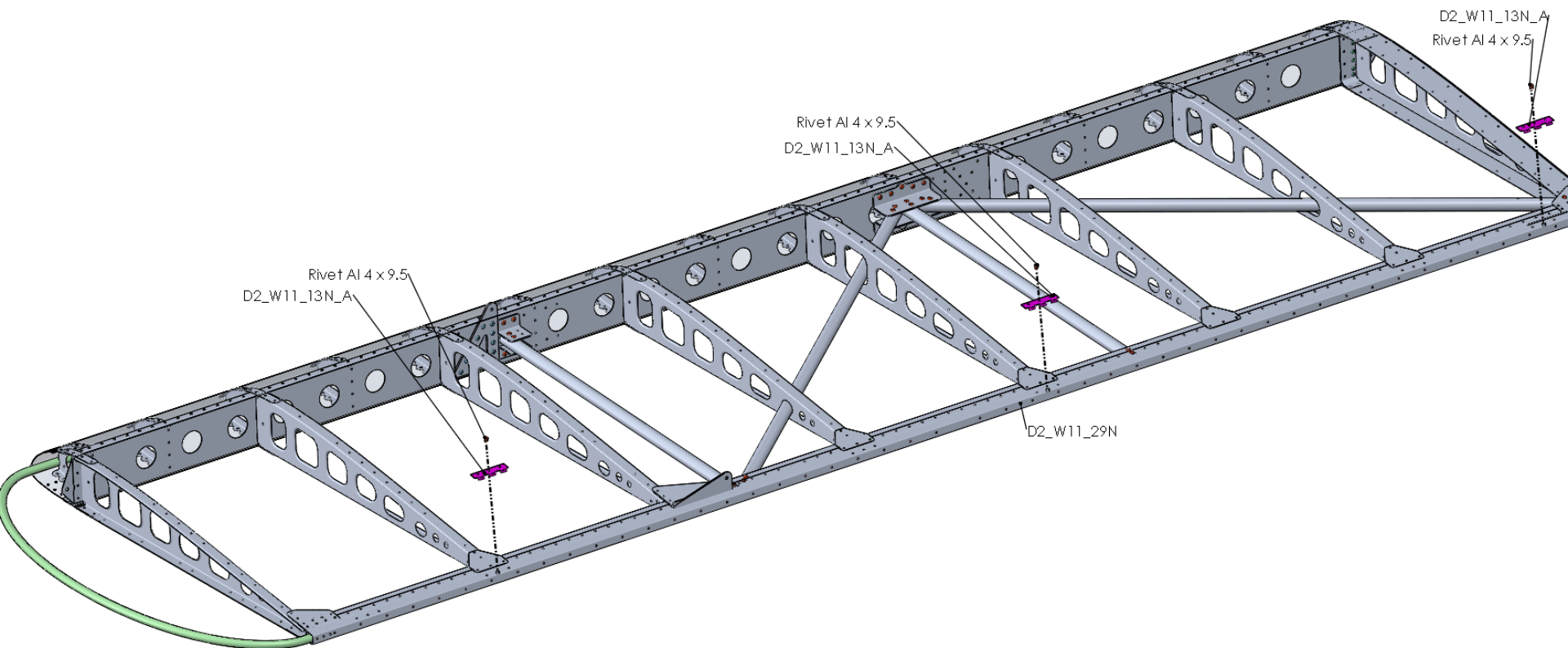
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Step 37L



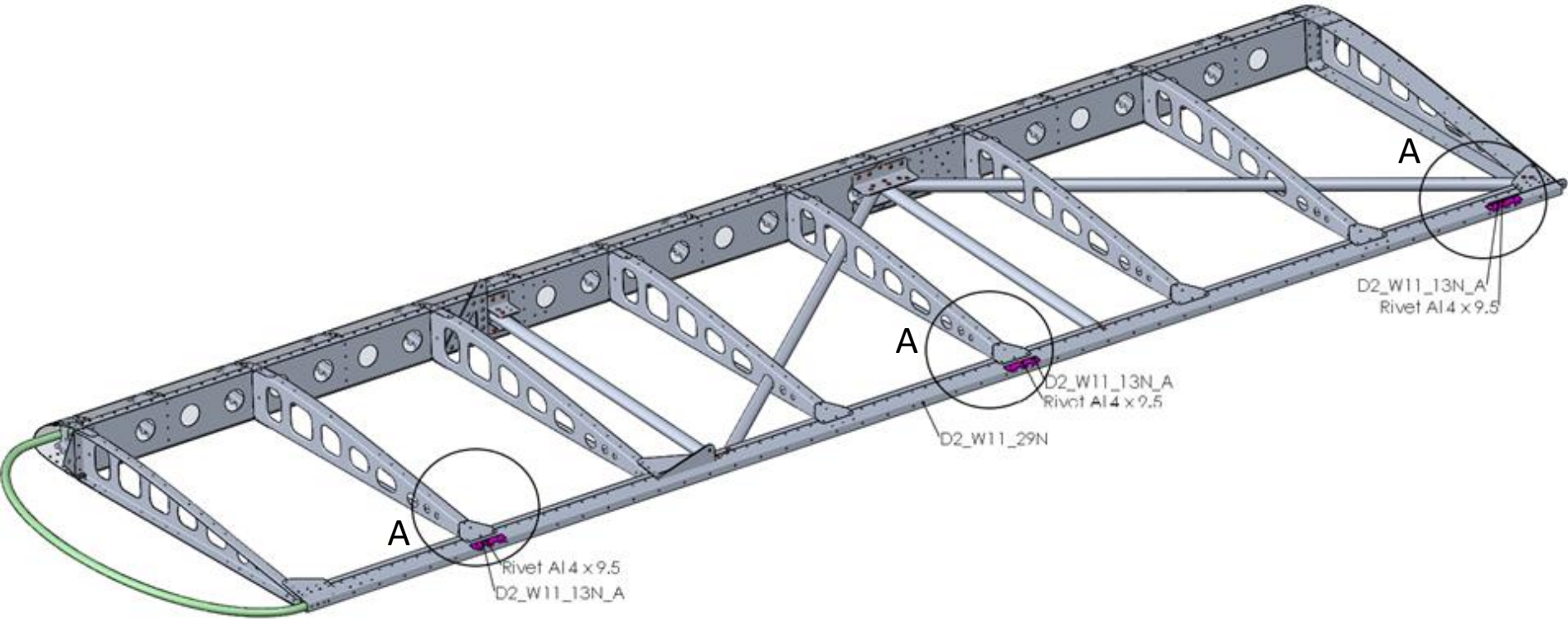
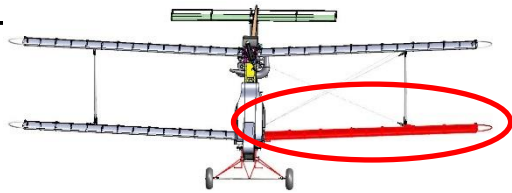
D2_W11_13N-A	3x
Rivet AVEX 3,2x7,9 Al/St	6x
Rivet AVEX 4x9,5 Al/St	3x



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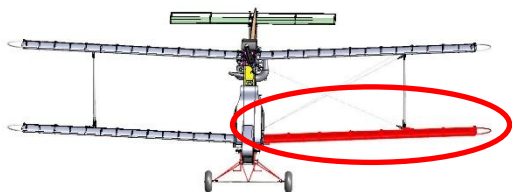
Step 38L



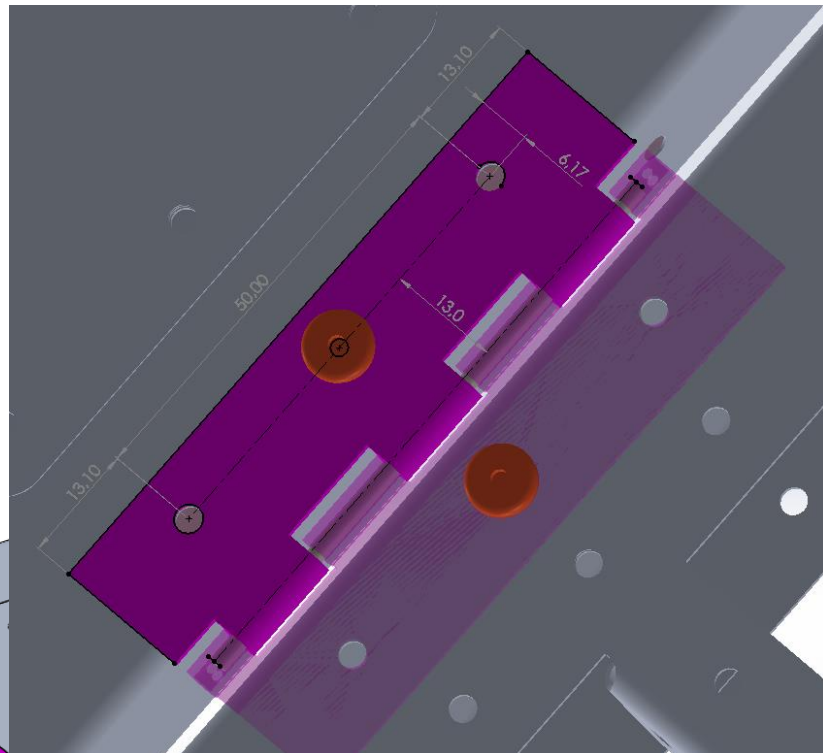
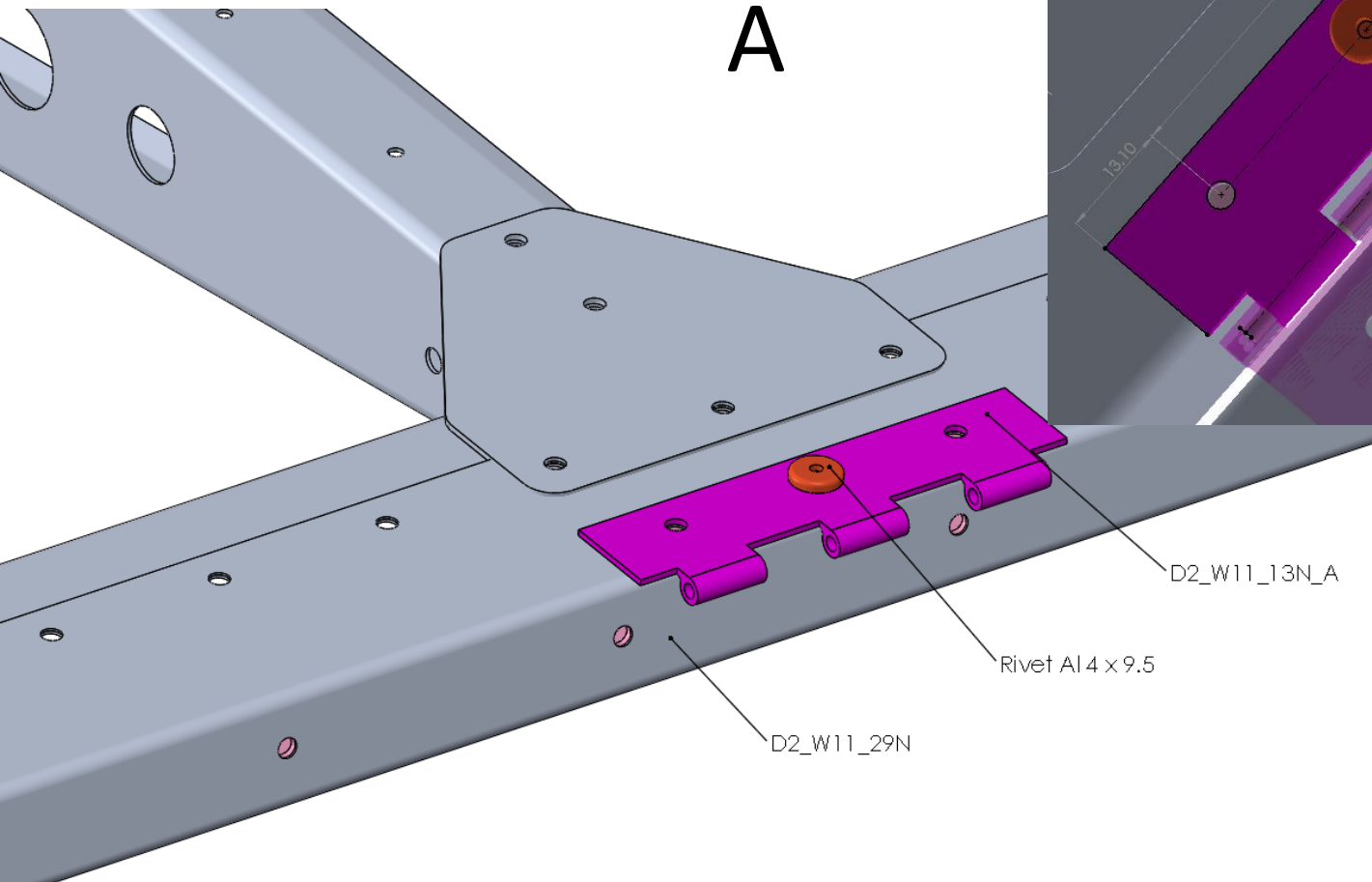
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Step 38L-A



A



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