

Title:

Aileron assembly manual

Document no.:

D2_W1_00

Revision:

R02

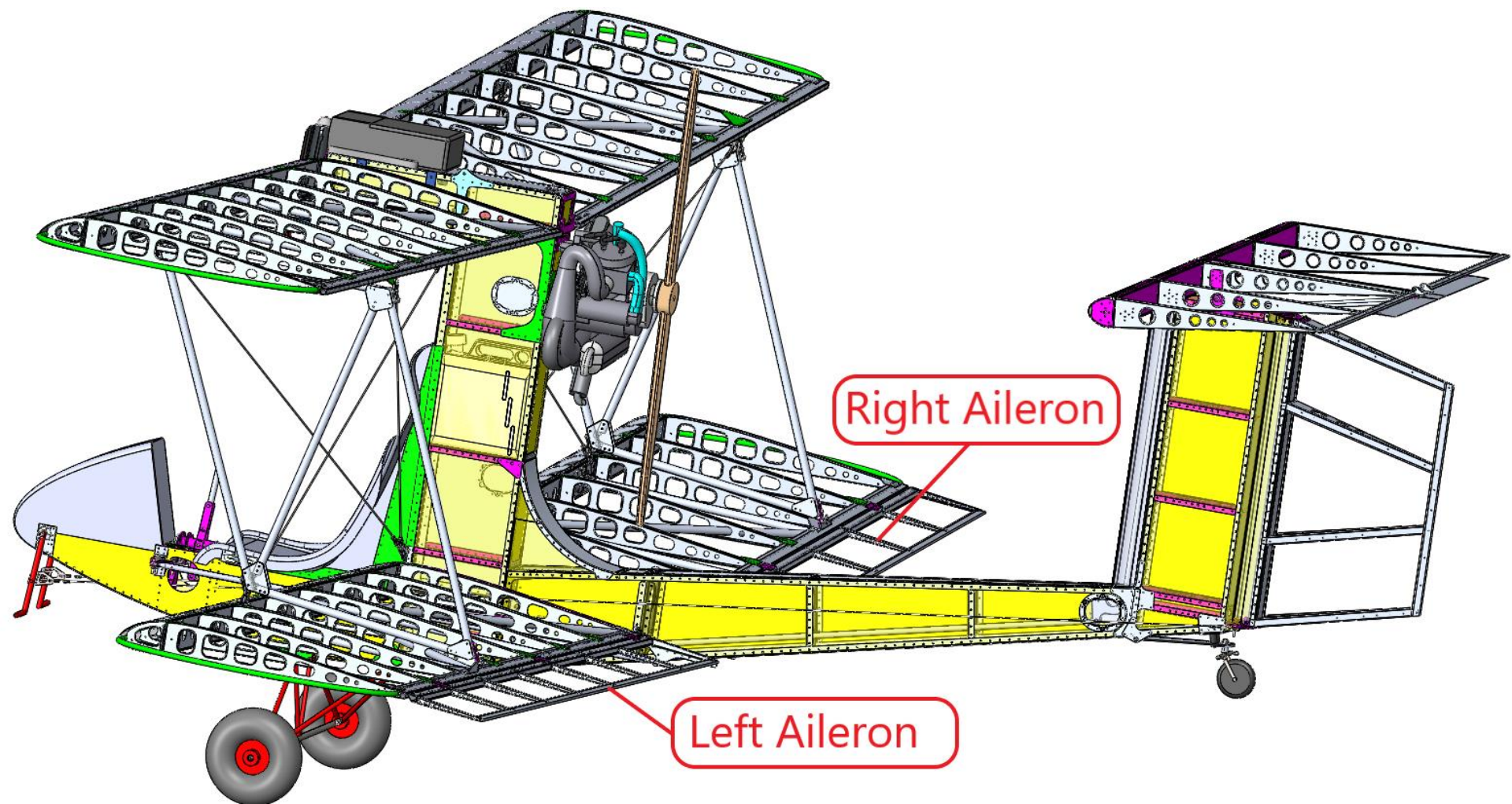
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Table of revisions

Revision	Affected pages	Short description of change
00	All	Original issue
01	2, 30	Table of revision added, riveting of aileron hinge corrected
02	30	Drilling pattern for aileron hinge added.

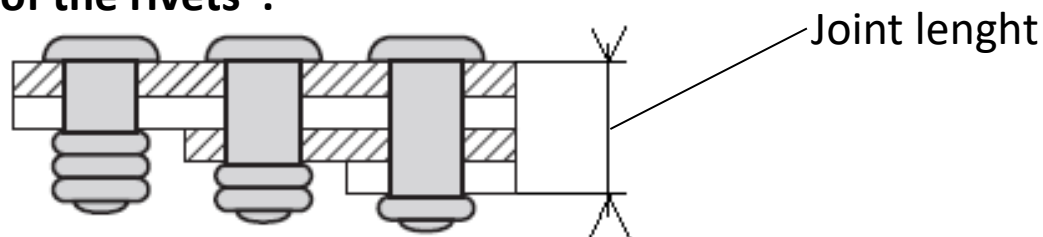
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General instructions:

- If there is no specific rivet shown or called in the assembly, use rivet AVEX 3,2x7,9 Al/St
- Use clecos for the preassembly, as shown in the video tutorial
- Use Polyurethan adhesive PU 50 Emfimastic, where shown in the manual
- It is the responsibility of each assembler, to check that the thickness of riveted parts matches the length of the rivet – follow

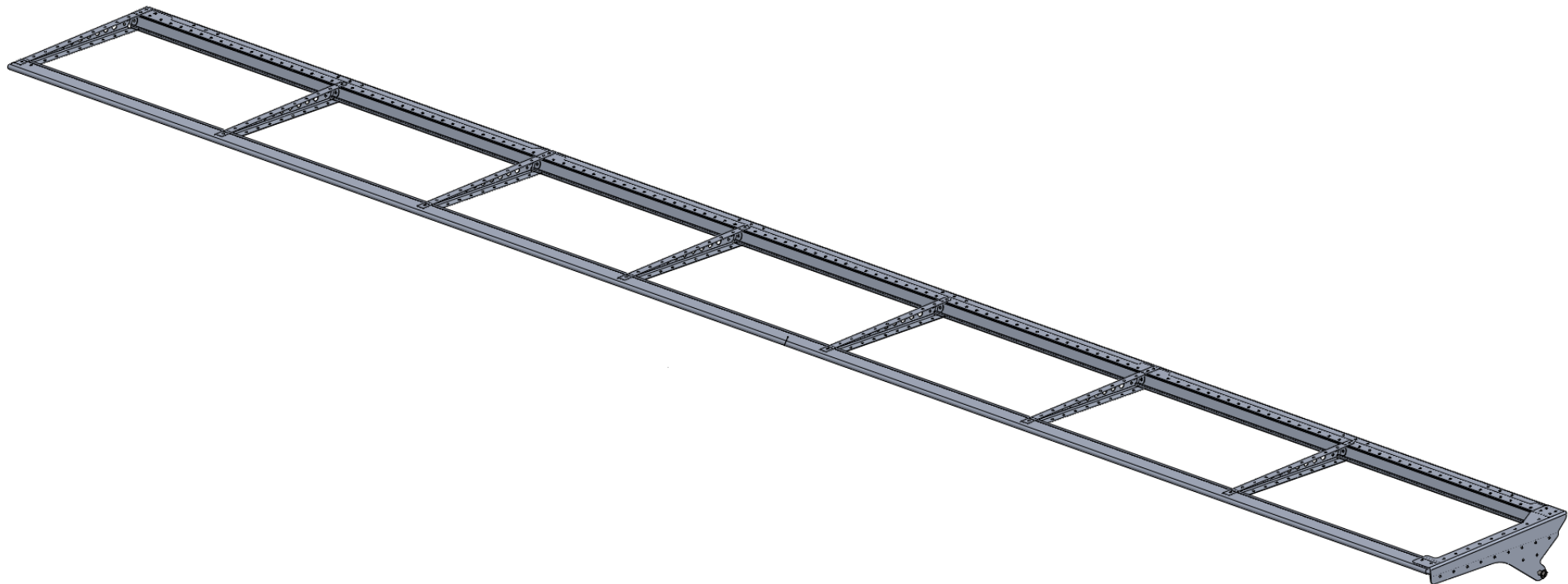
“Permissible joint length of the rivets“:


Blind rivet type:	Manufacturer part number:	Can be also marked as:		Min. length:	Max. length:
AVEX 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

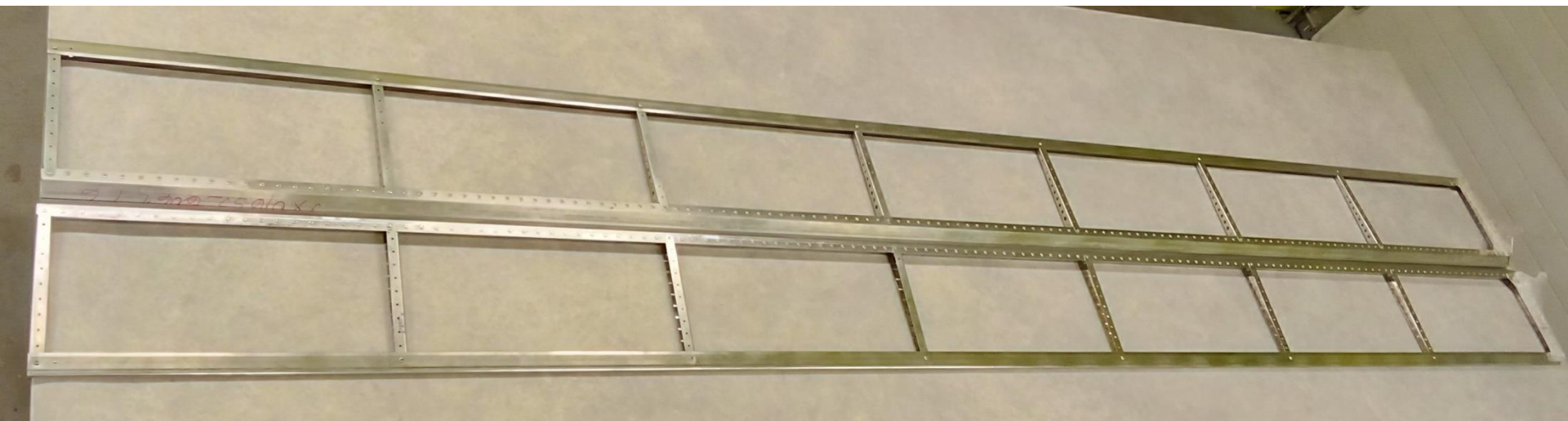
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Left Aileron - Right Aileron symmetrically



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Part: D2_W12_05
Quantity: 1+1 piece



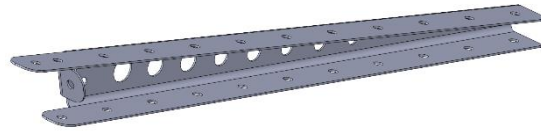
Part: D2_W12_07
Quantity: 1+1 piece



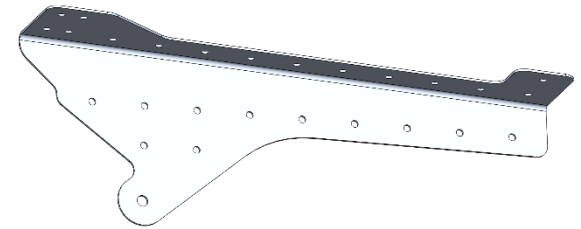
Part: D2_W12_08 L
Quantity: 13 piece



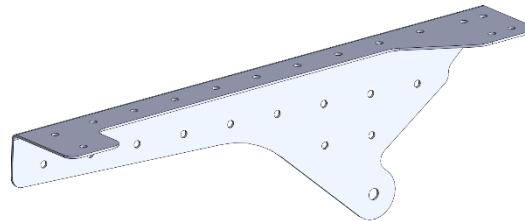
Right Aileron
Part: D2_W12_08 P
Quantity: 1 piece



Left Aileron
Part: D2_W12_09 L
Quantity: 1 piece



Right Aileron
Part: D2_W12_09 P
Quantity: 1 piece



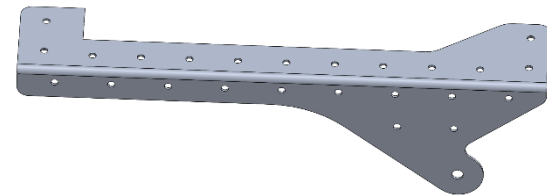
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Left Aileron

Part: D2_W12_10 L

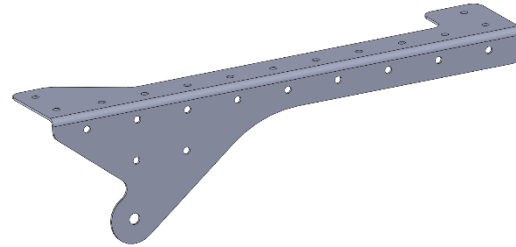
Quantity: 1 piece



Right Aileron

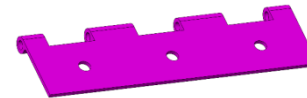
Part: D2_W12_10 P

Quantity: 1 piece



Part: D2_W11_13N_B

Quantity: 3+3 pieces



Standard parts	
Part	Quantity
Blind rivets AVEX Ø3,2x7,9 Al/St	332 / 1 aileron
Blind rivets AVEX Ø4x9,5 Al/St	3 / 1 aileron

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Assembly tool

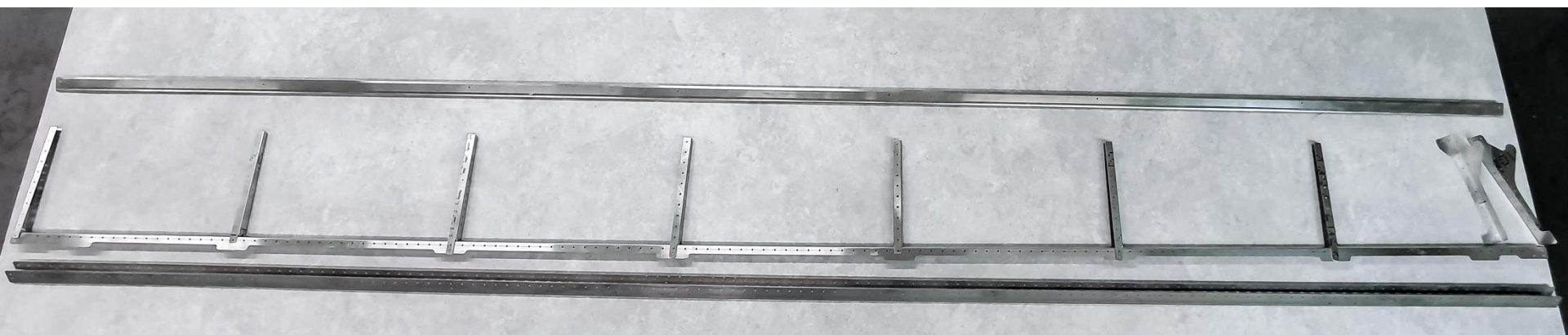


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Assembly diagram

Quantity: 1+1 piece

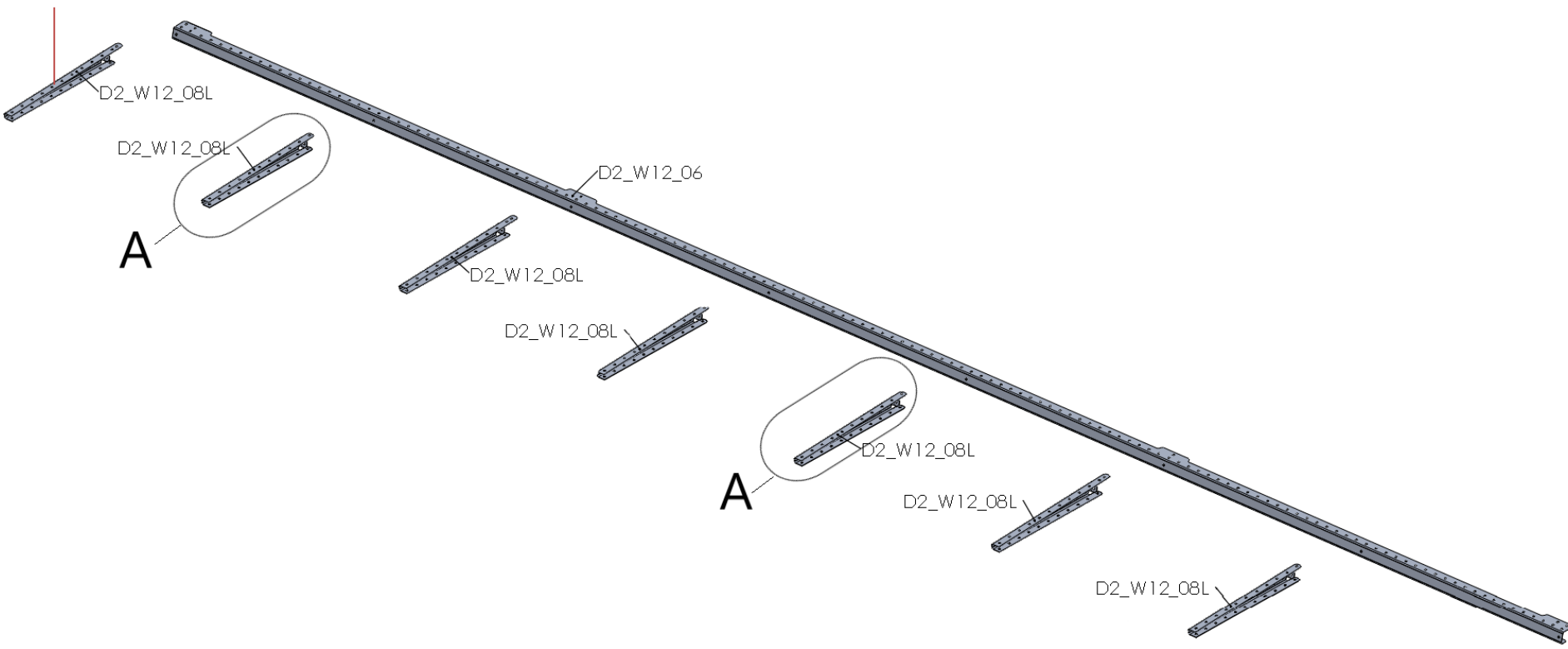


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Step 1

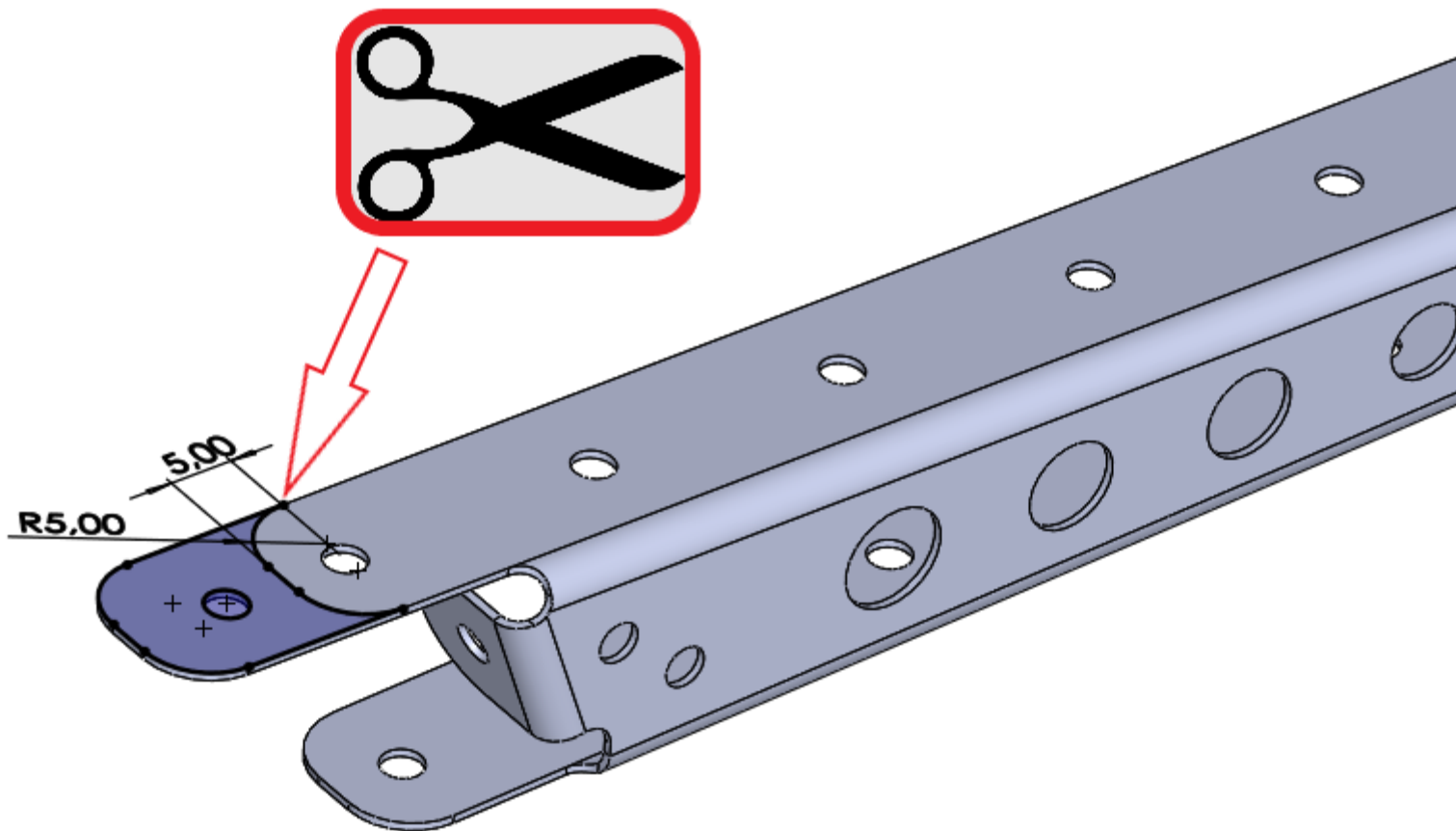
D2_W12_08 P
for right aileron



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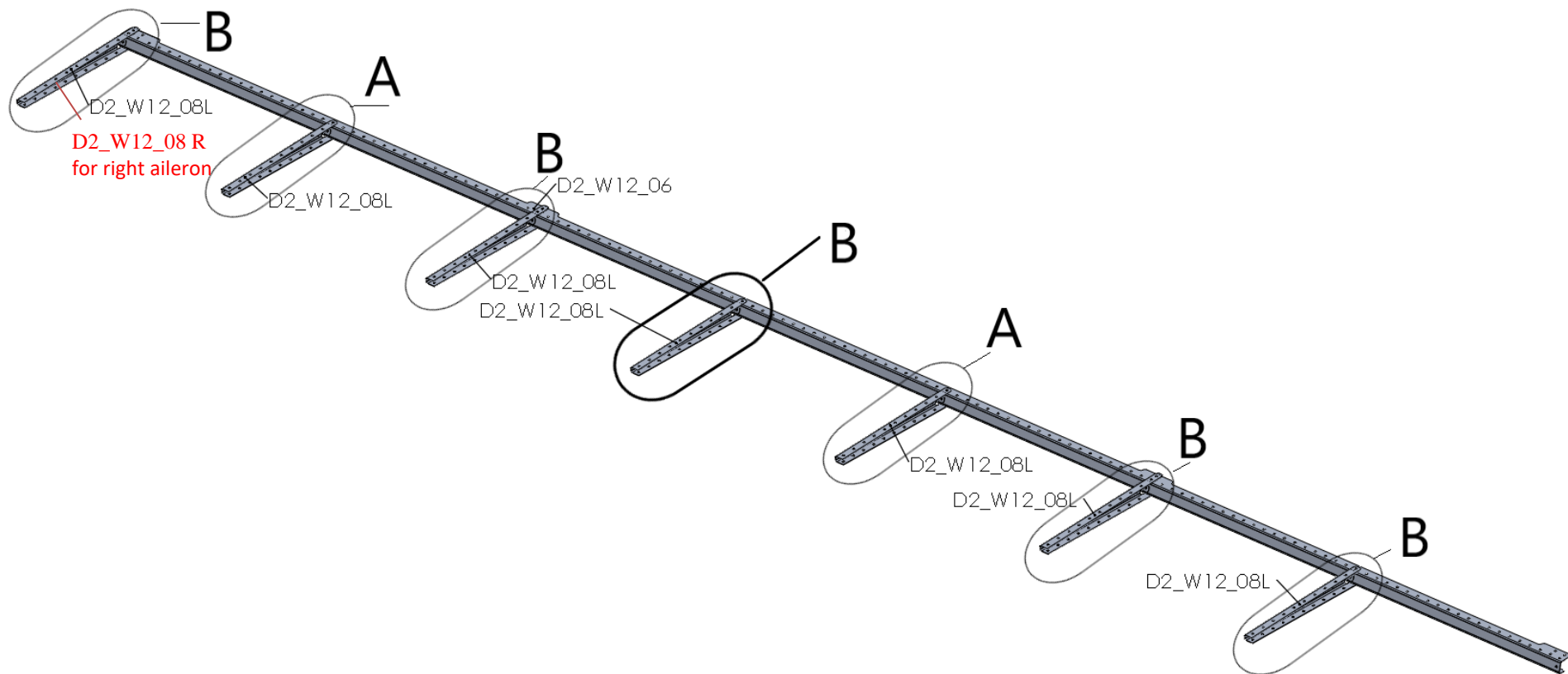
Step 1-A



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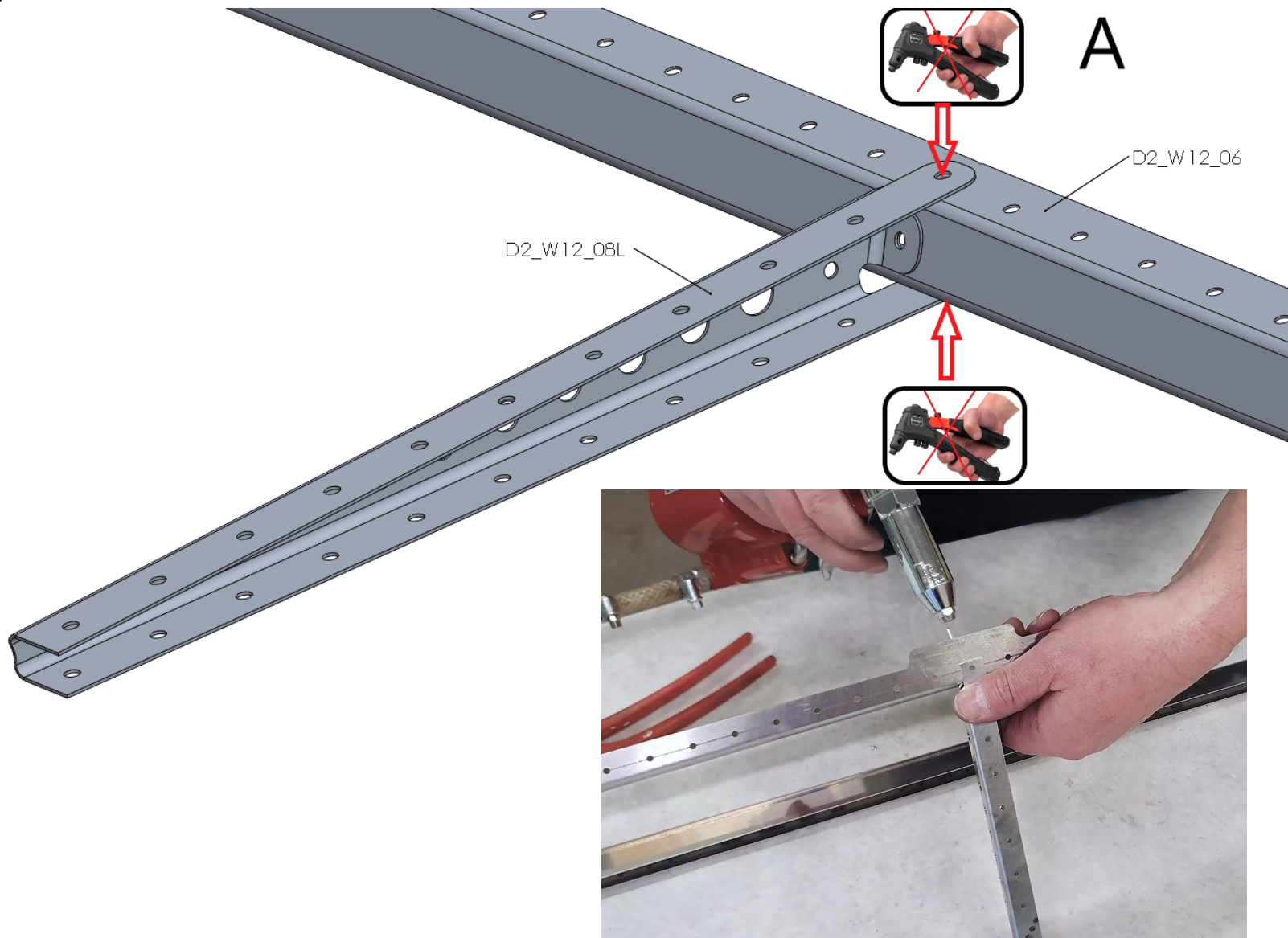
Step 2



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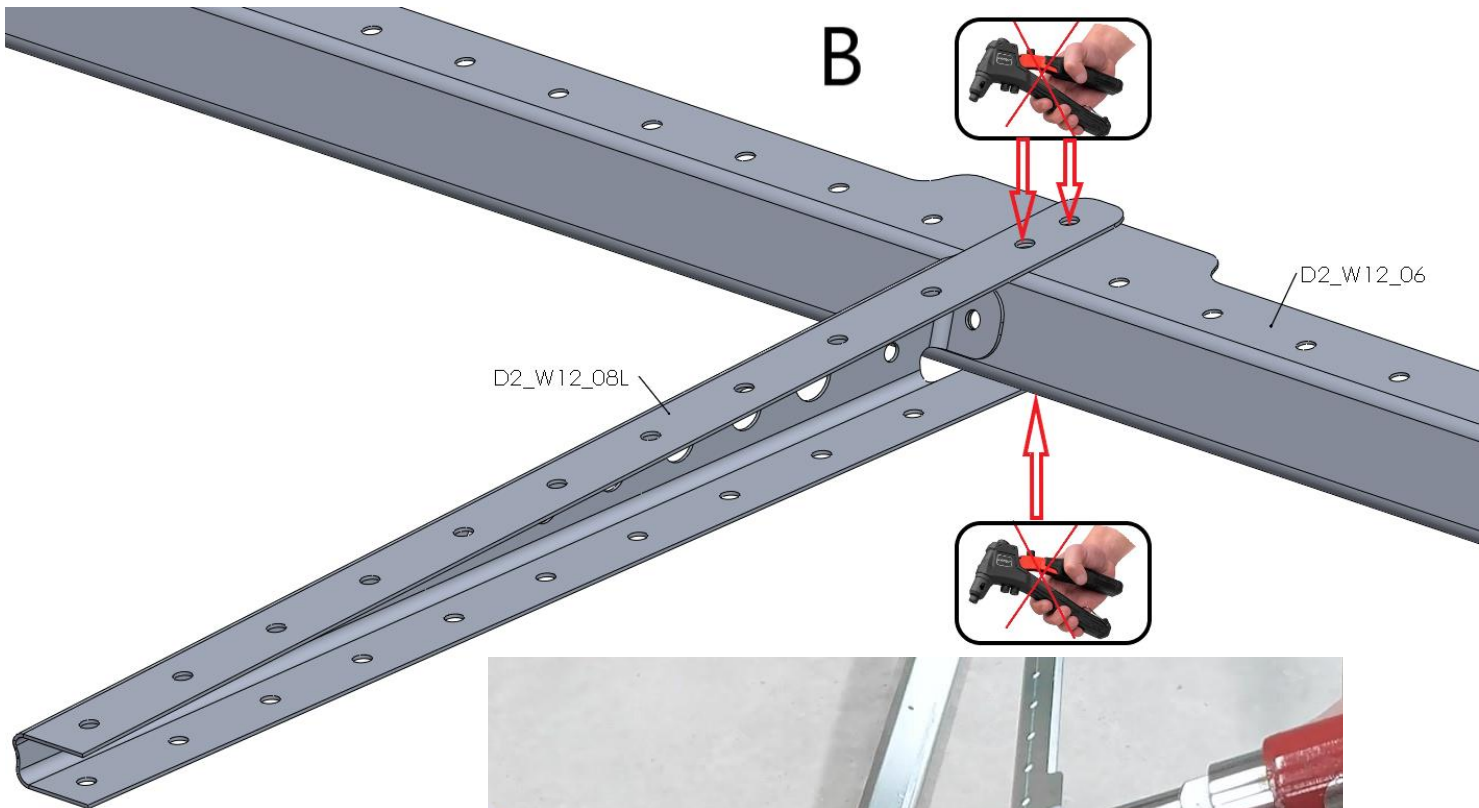
Step 2-A



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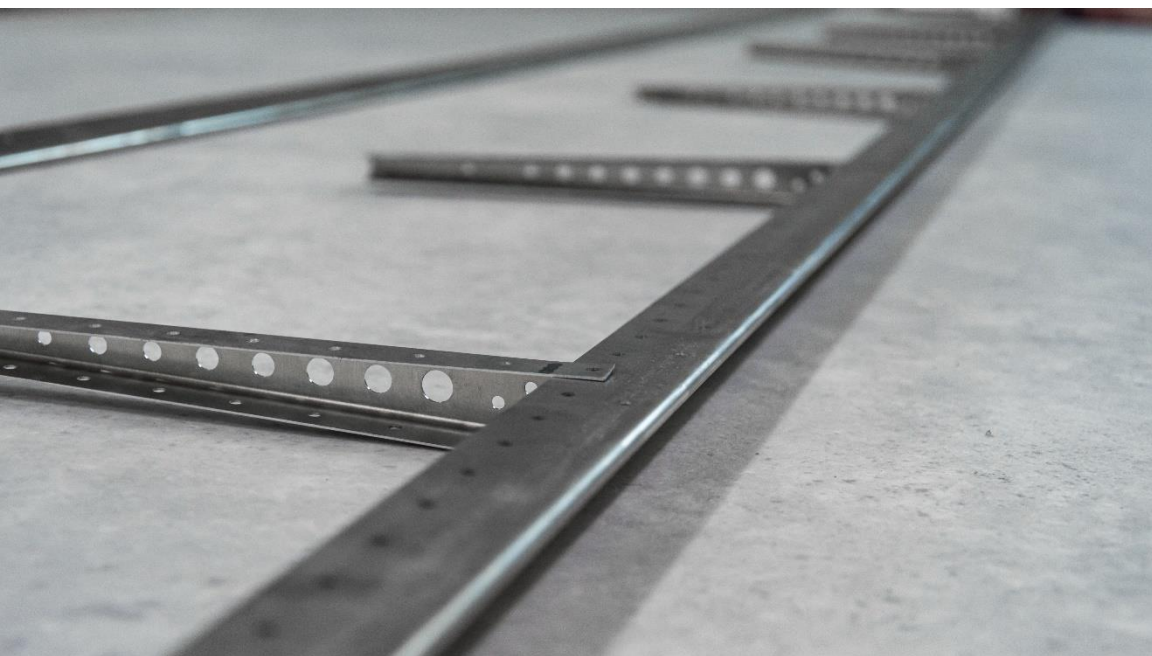
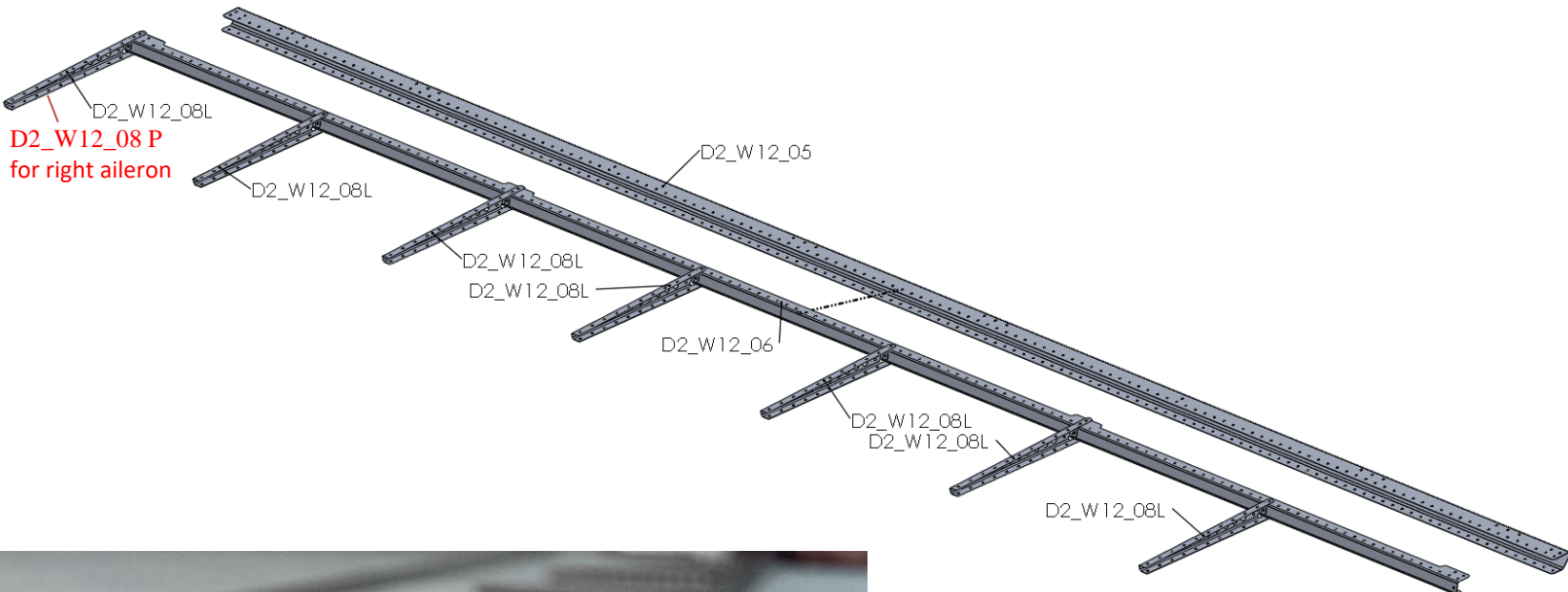
Step 2-B



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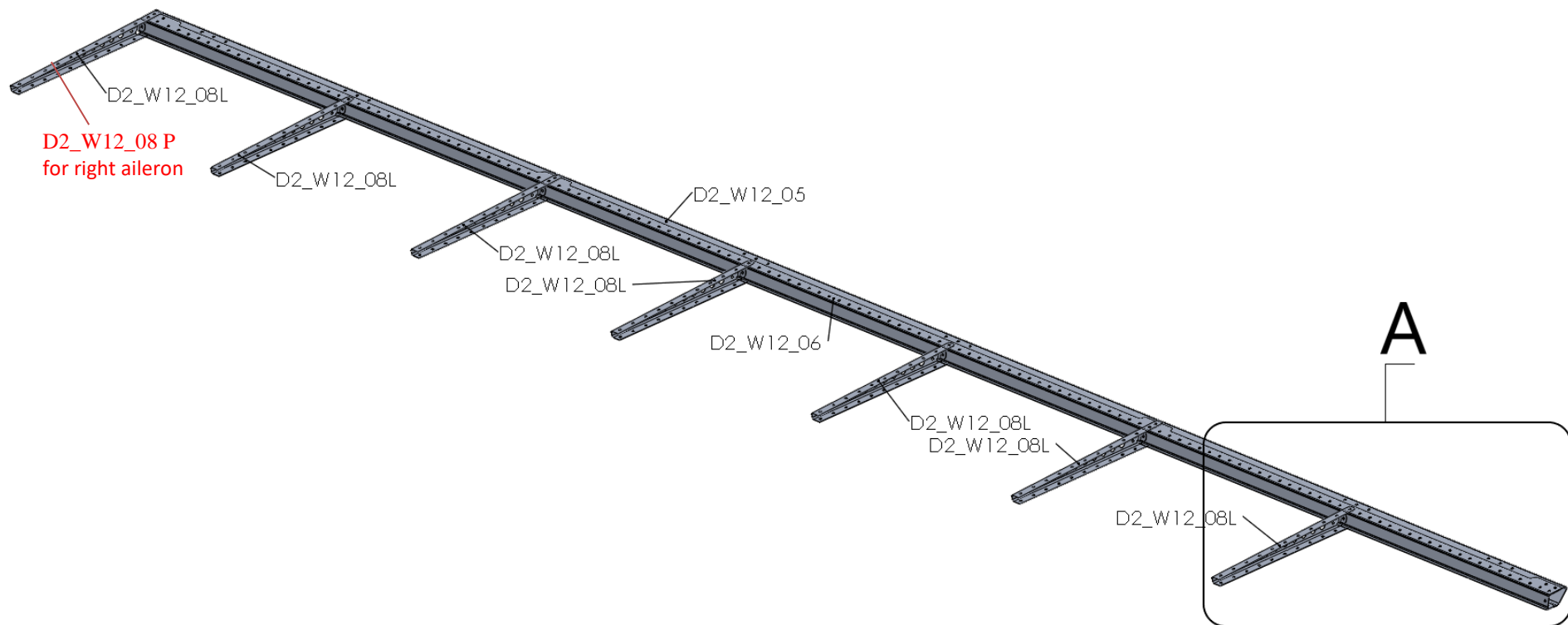
Step 3



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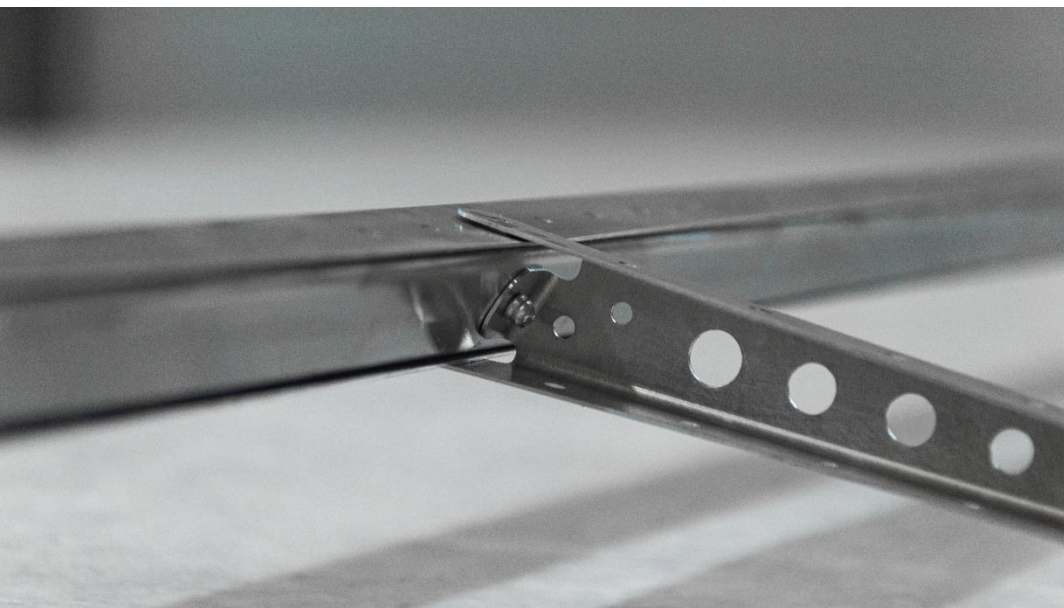
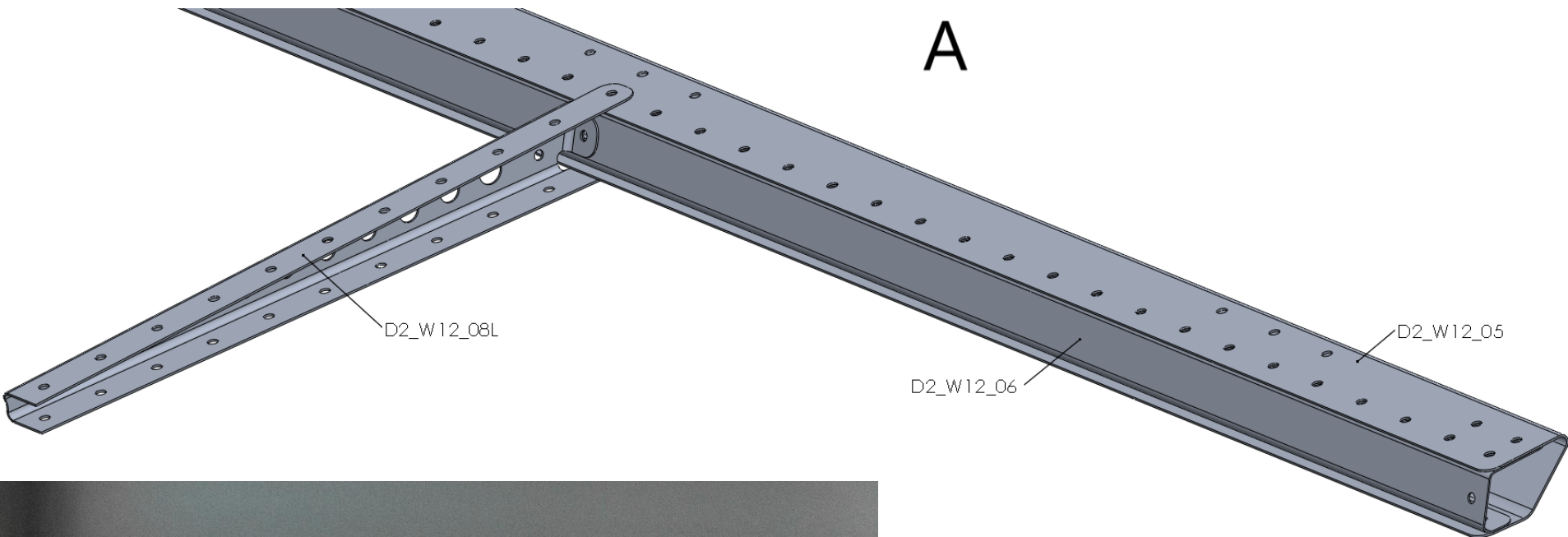
Step 4



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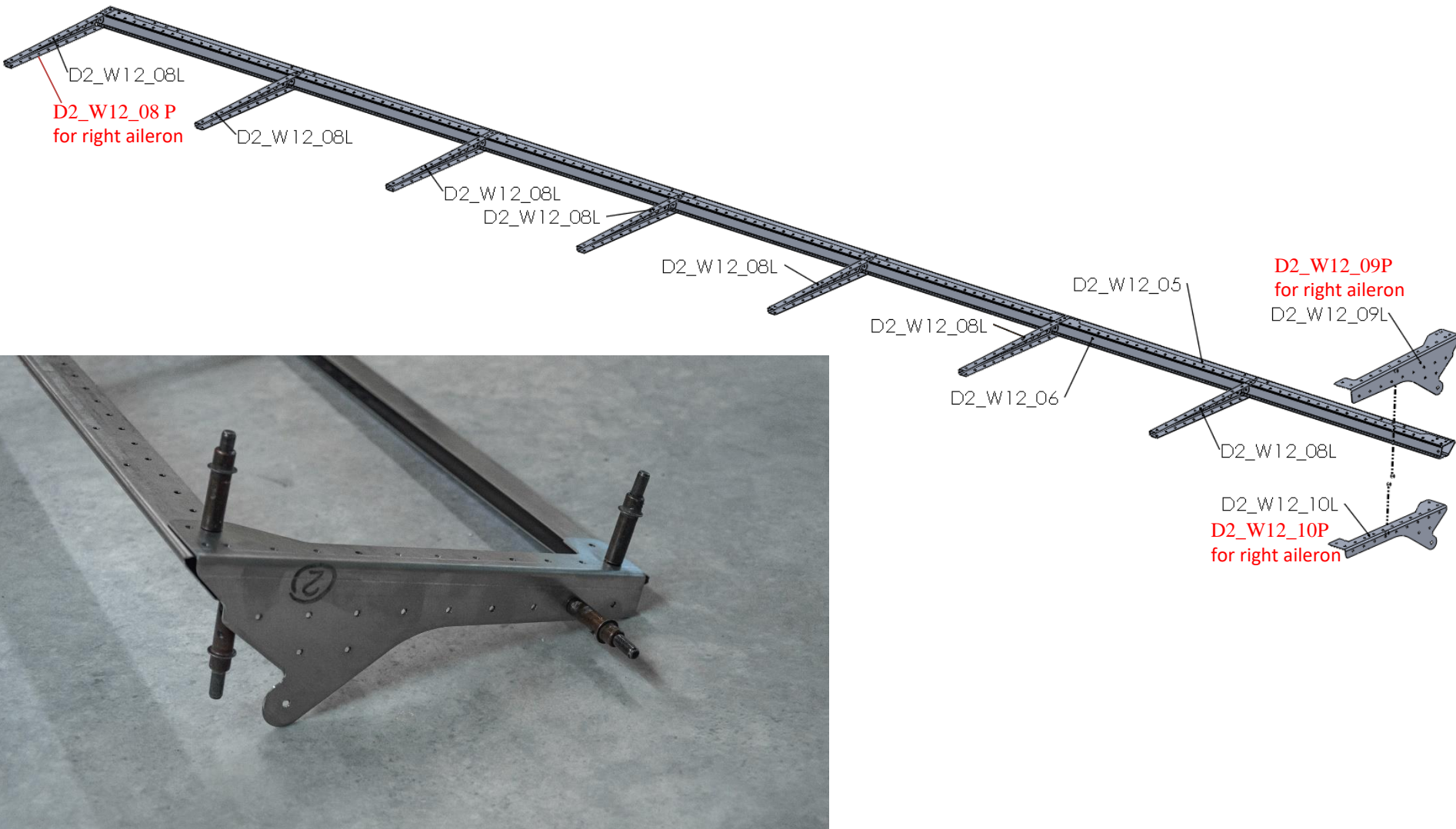
Step 4-A



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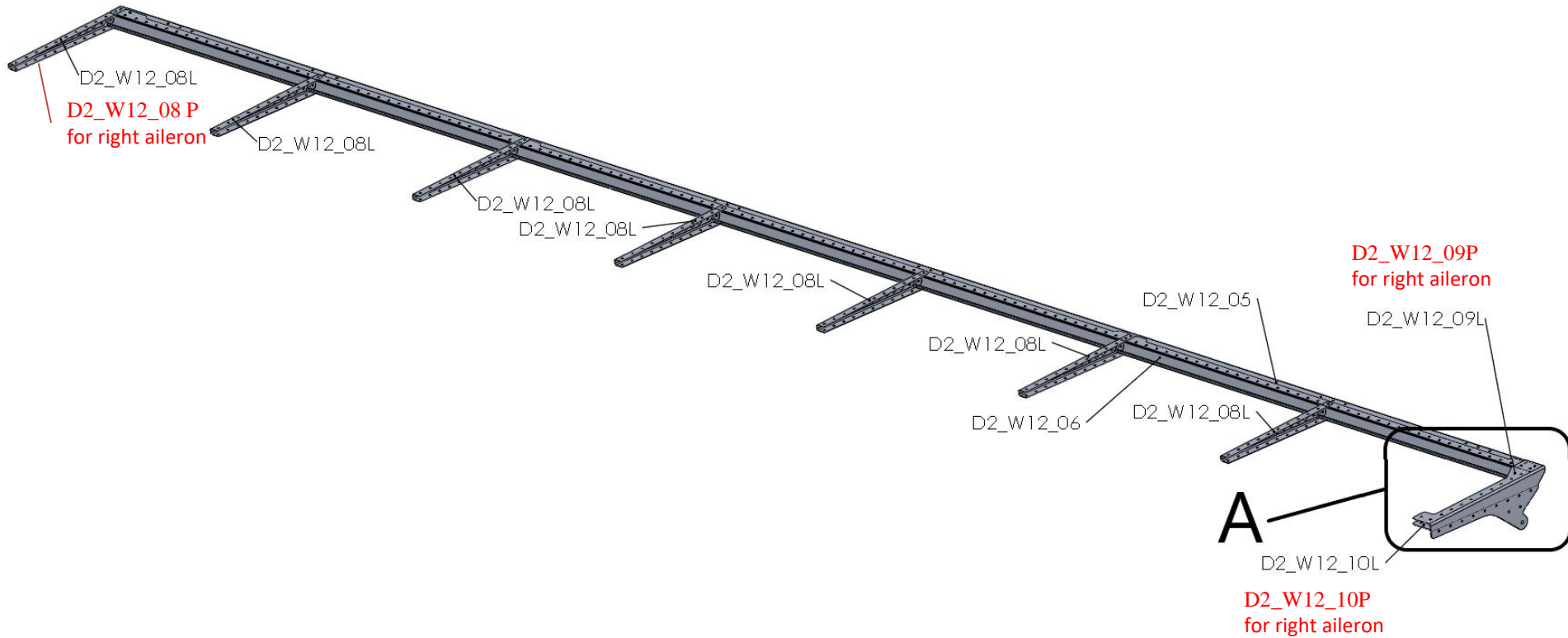
Step 5



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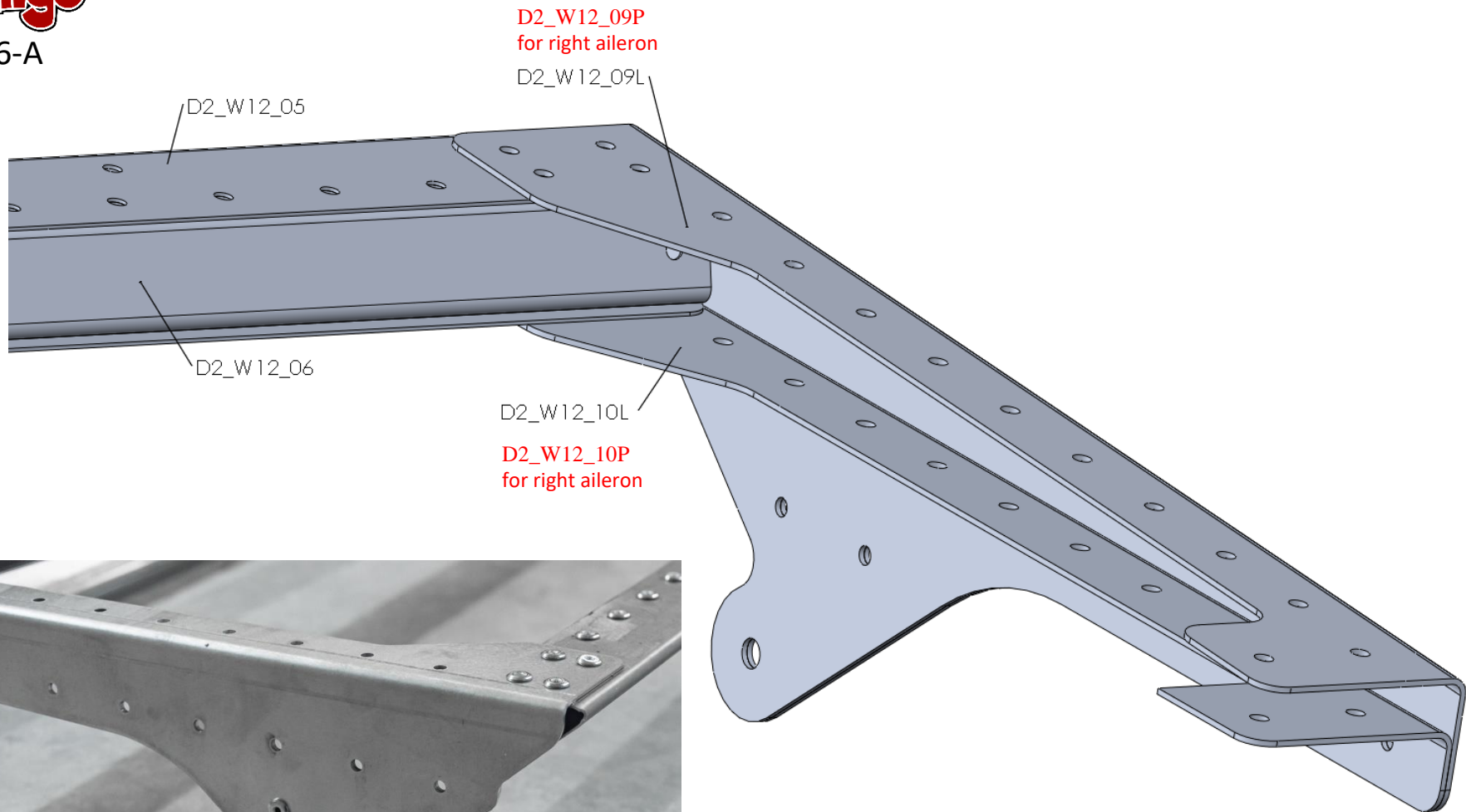
Step 6



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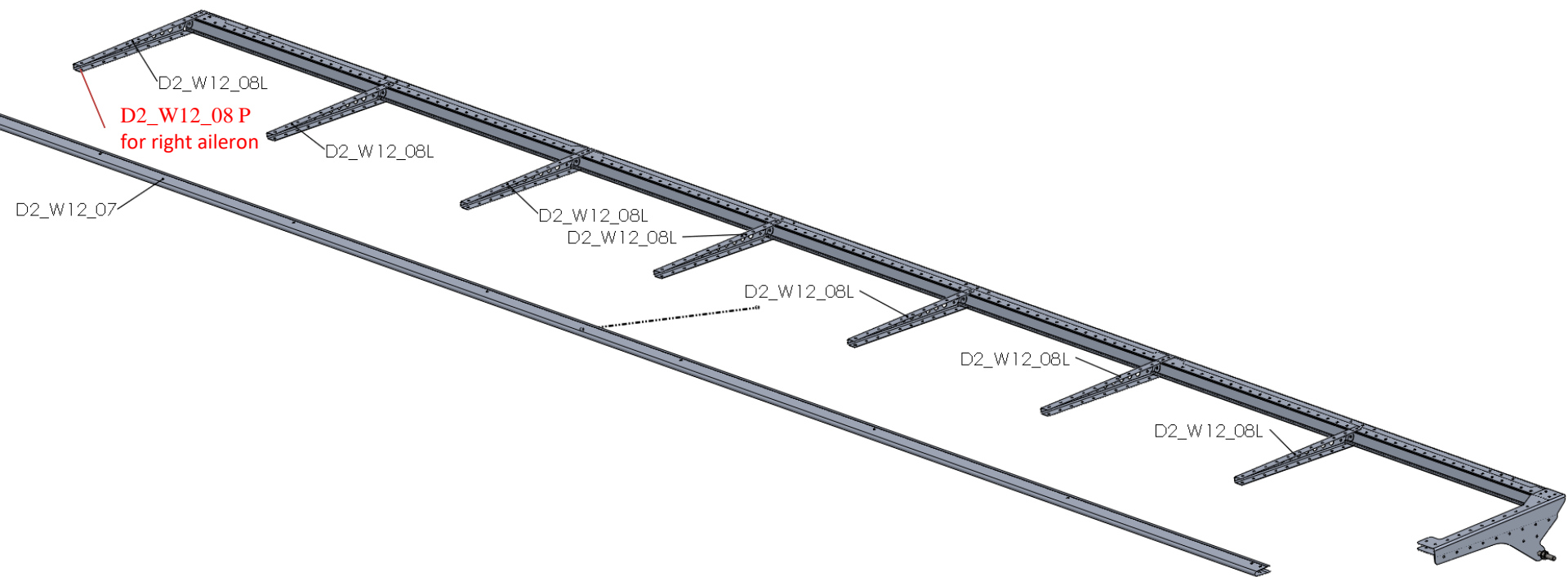
Step 6-A



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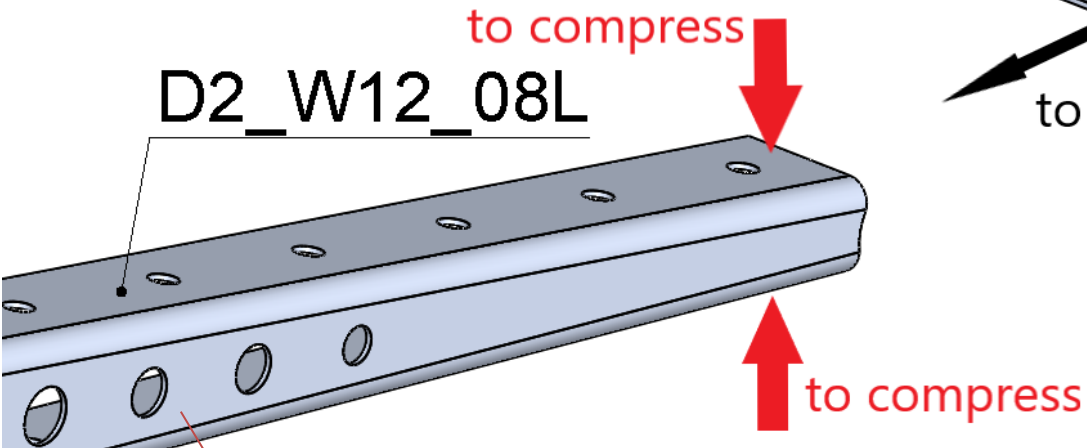
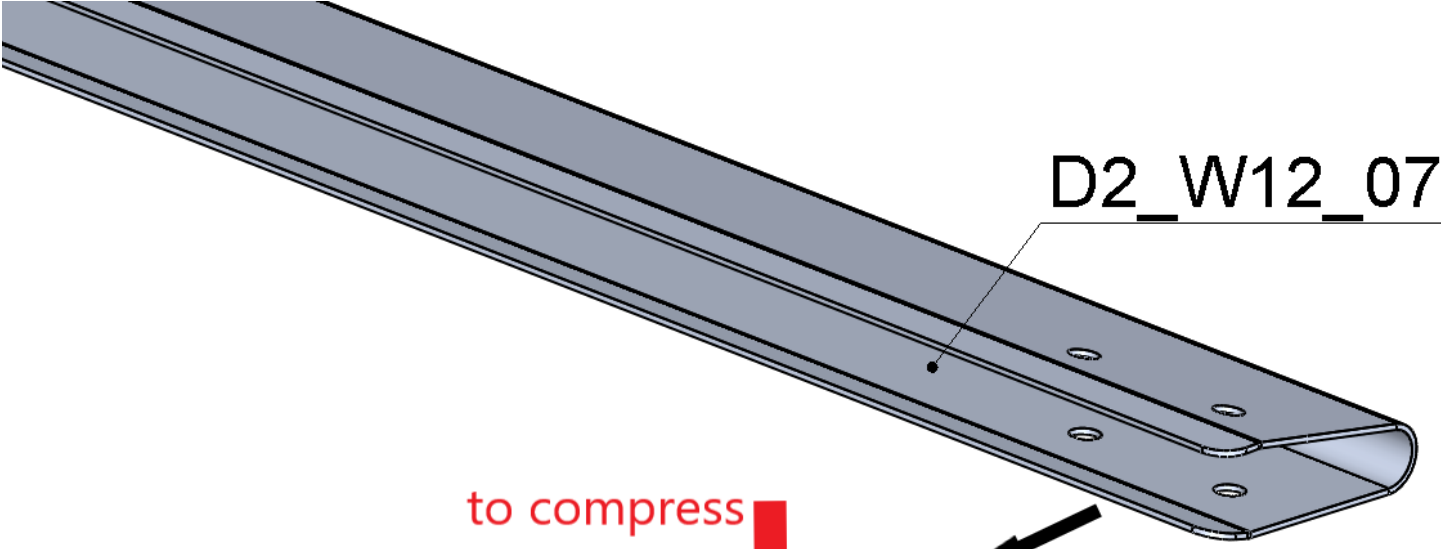
Step 7



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Step 8



D2_W12_08 P
for right aileron

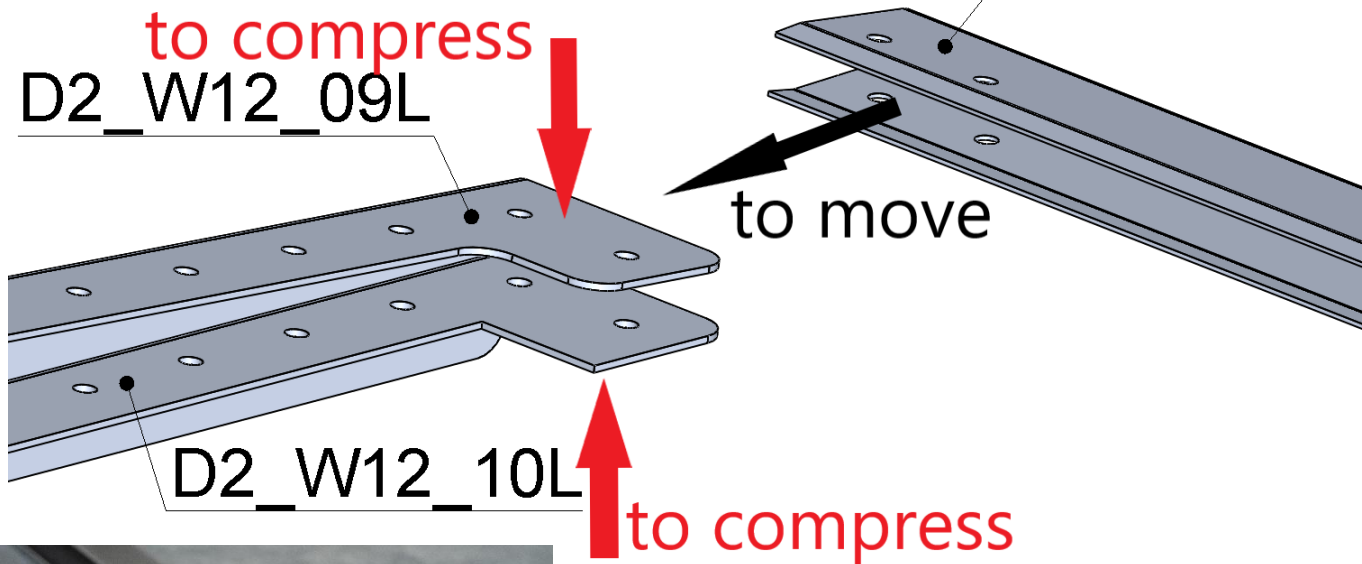


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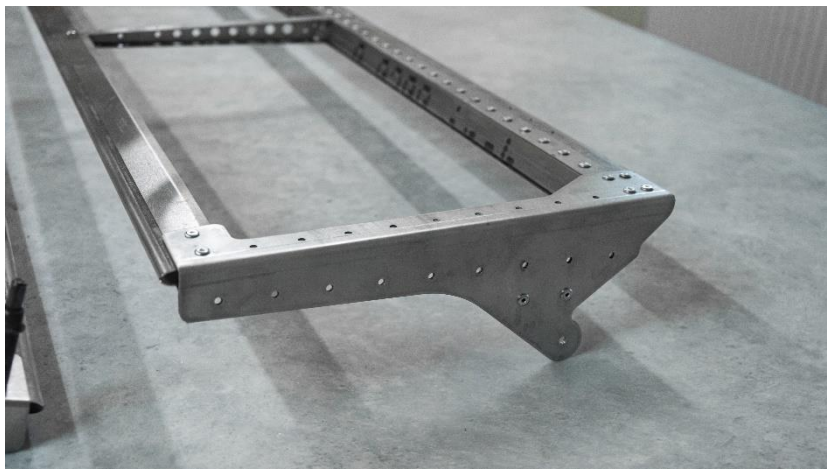
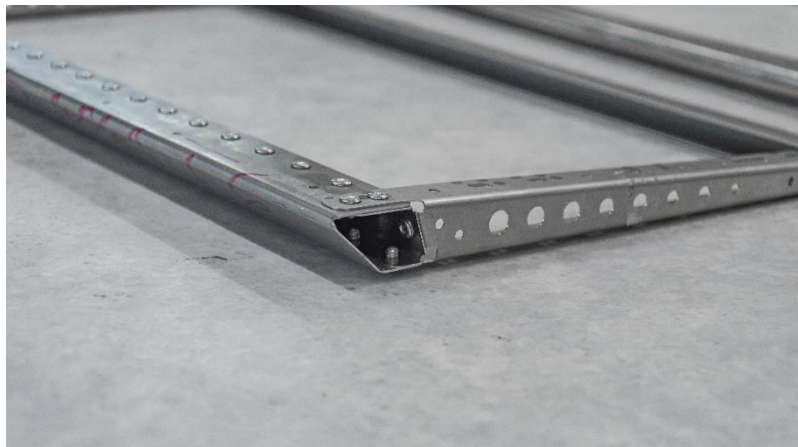
Step 9



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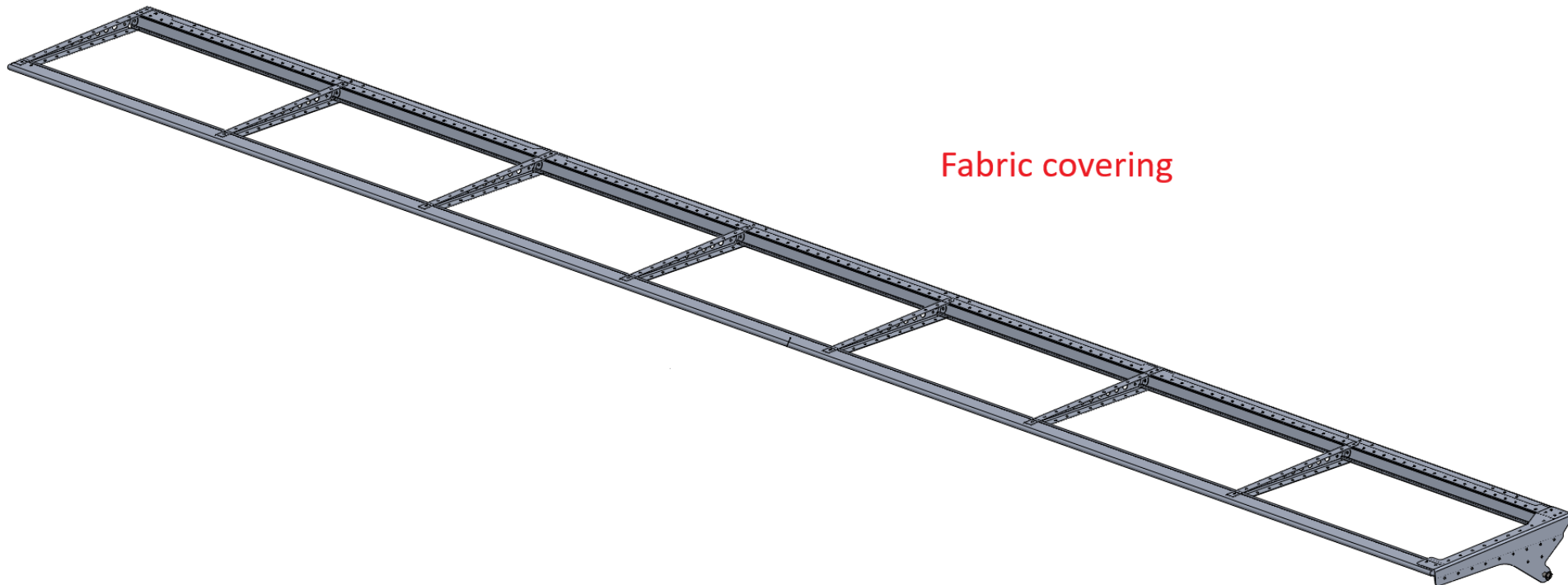
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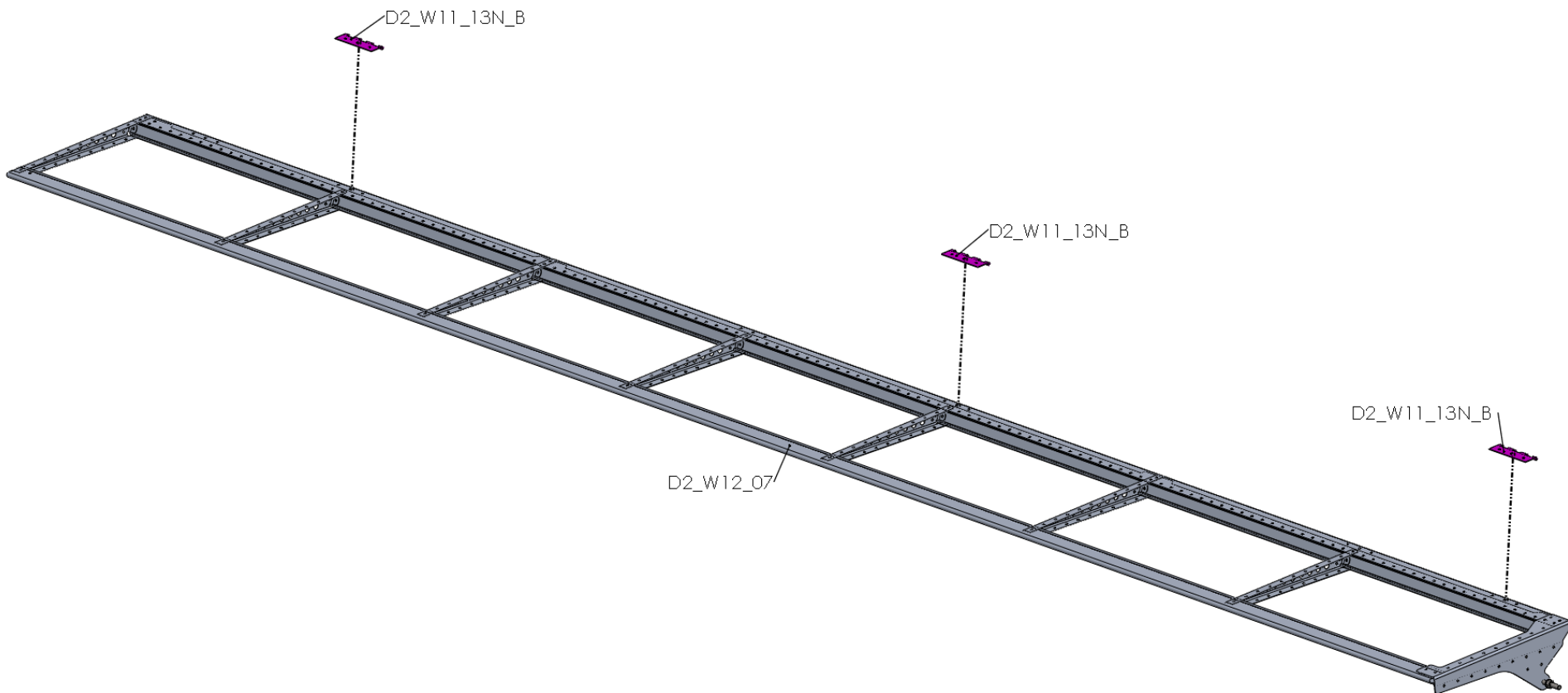
Step 11



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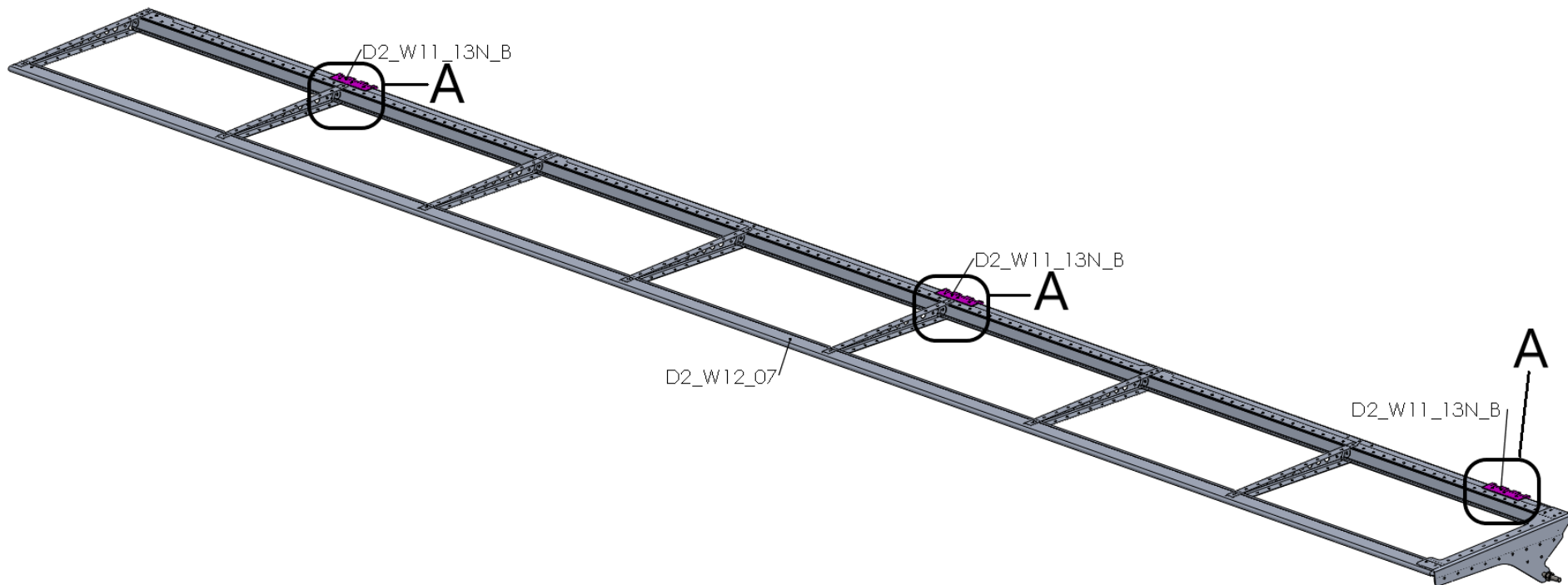
Step 12



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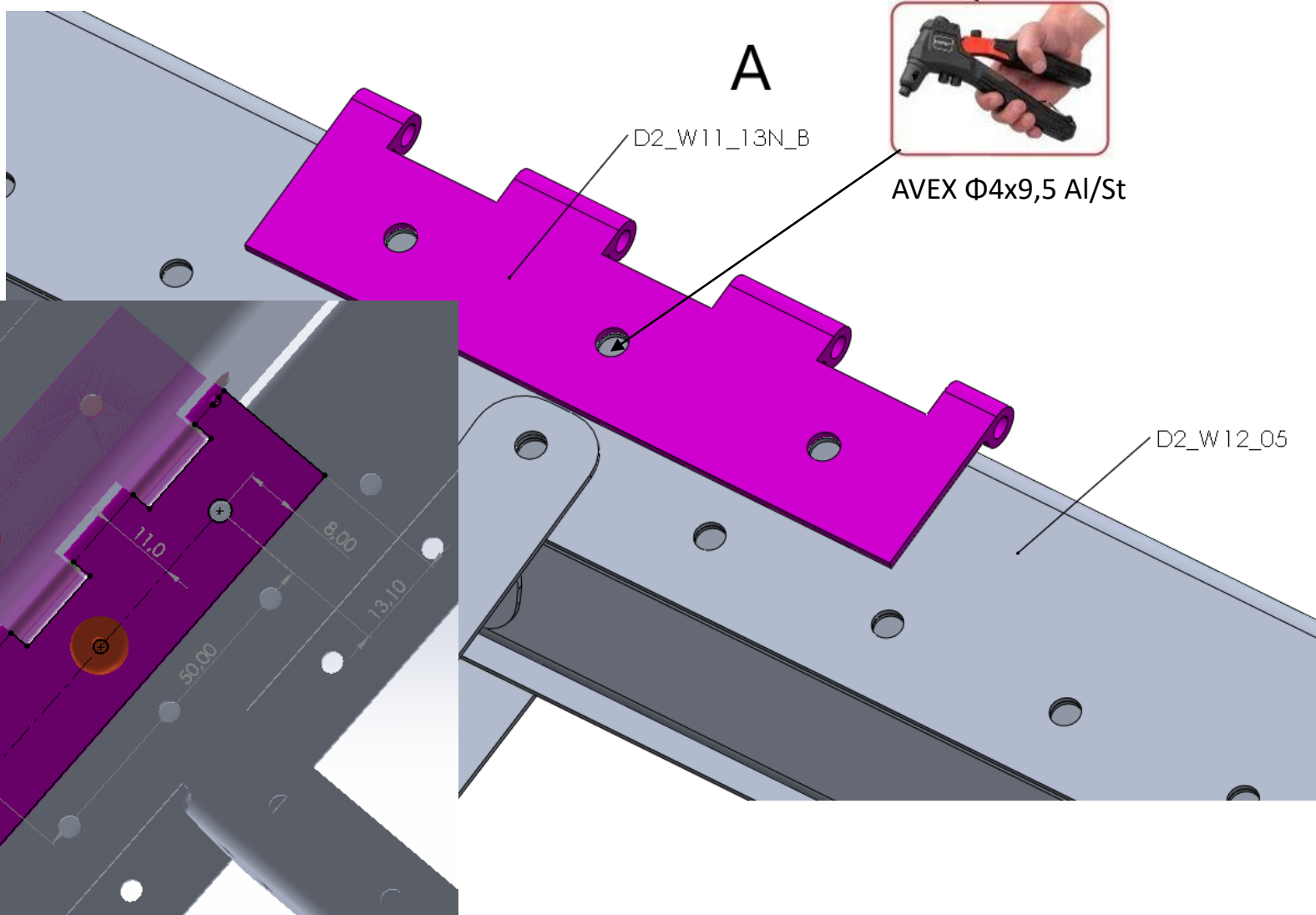
Step 13



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Step 13-A



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