



Title:

Control system assembly manual

Document no.:

D2_R0_00

Revision:

R06

Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	1	114



Table of revisions

Revision	Affected pages	Short description of change
00	All	Original issue
01	02, 60, 67, 76, 80, 84 104 – 107 deleted 124 – 126 deleted 156,157 deleted	Table of revision added, nuts in pushrod BOMs corrected, connection of pushrods to ailerons (pages 105 – 108) and elevator (pages 121 – 123) and rudder cables to rudder (pages 150, 151) removed – as it's a part of final assembly manual – D2_00_00.
02	150 – added	Added a step with the installation of a foot rest to the rudder pedals.
03	03, 88, 89, 91, 92, 93, 94	General instructions updated, bushing PCMF was replaced with a bushing D2_SP_01.
04	04 – added	General instructions updated
05	All	Bolt lengths corrected. Heat-shrinkable tube added to rudder cables. Pages reduced.
06	22 - 40	Bellcranks rivets changed and bellcrank rivetting corrected. Pages reduced.

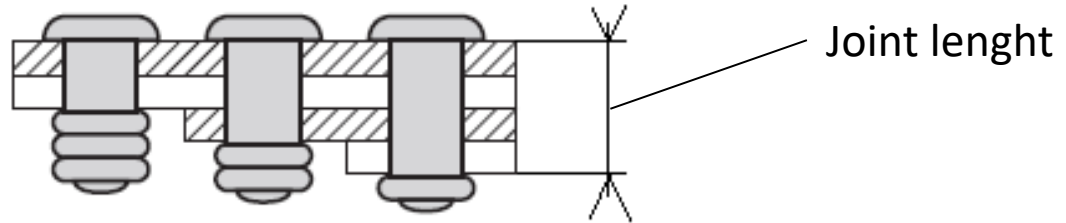
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General instructions:



- Mark all bolt connections
- It is the responsibility of each assembler, to check that the thickness of riveted parts matches the length of the rivet – follow **“Permissible joint length of the rivets“**:



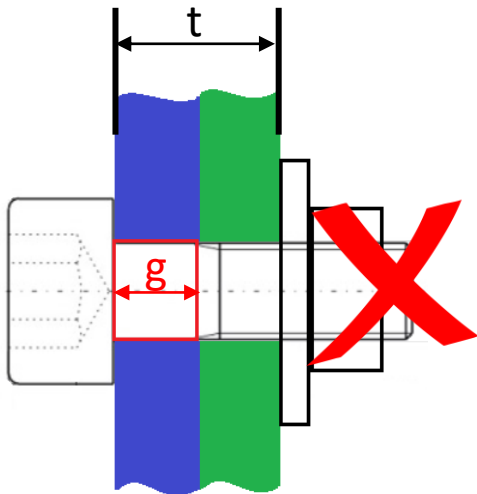
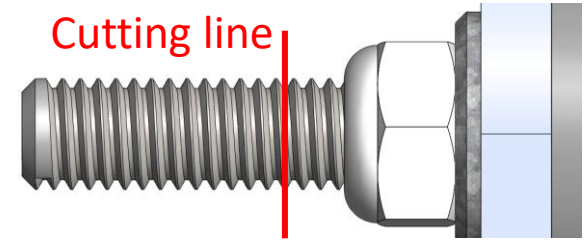
Blind rivet type:	Manufacturer part number:	Can be also marked as:		Min. length:	Max. length:
AVEX $\Phi 3,2 \times 7,9$ Al/St	16910410	Al 3,2x7,9	AVEX $\Phi 3,2 \times 7,9$ Al/Fe	0,8mm	4,8mm
AVEX $\Phi 3,2 \times 9,5$ Al/St	10013209	Al 3,2x9,5	AVEX $\Phi 3,2 \times 9,5$ Al/Fe	2,0mm	6,5mm
AVEX $\Phi 3,2 \times 11,2$ Al/St	16910414	Al 3,2x11,2	AVEX $\Phi 3,2 \times 11,2$ Al/Fe	4,0mm	7,9mm
AVEX $\Phi 4 \times 9,5$ Al/St	16910512	Al 4x9,5	AVEX $\Phi 4 \times 9,5$ Al/Fe	1,0mm	6,0mm
AVEX $\Phi 4 \times 12,7$ Al/St	16910516	Al 4x12,7	AVEX $\Phi 4 \times 12,7$ Al/Fe	4,0mm	9,6mm

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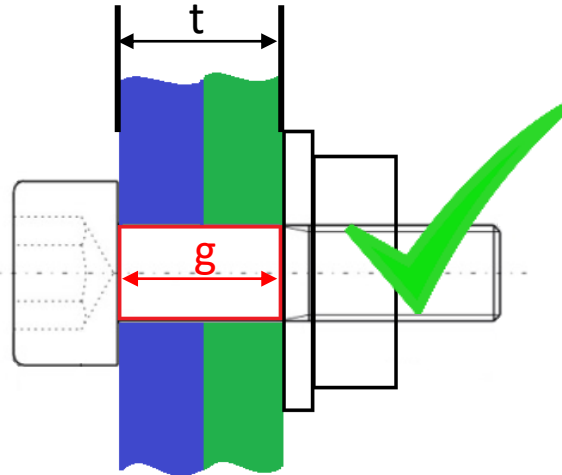


General instructions:

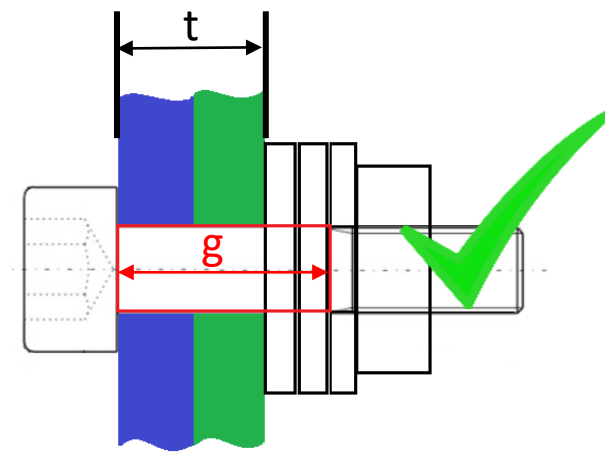
- It is the responsibility of each assembler, to check the grip length of the bolt and ensure, that the grip length (g) matches, or exceeds the thickness (t) of connected parts.
- If you will need to get some extra bolts, **always use 8.8 grade.**
- Cut bolts 1-3 threads behind the nut.



$g < t$

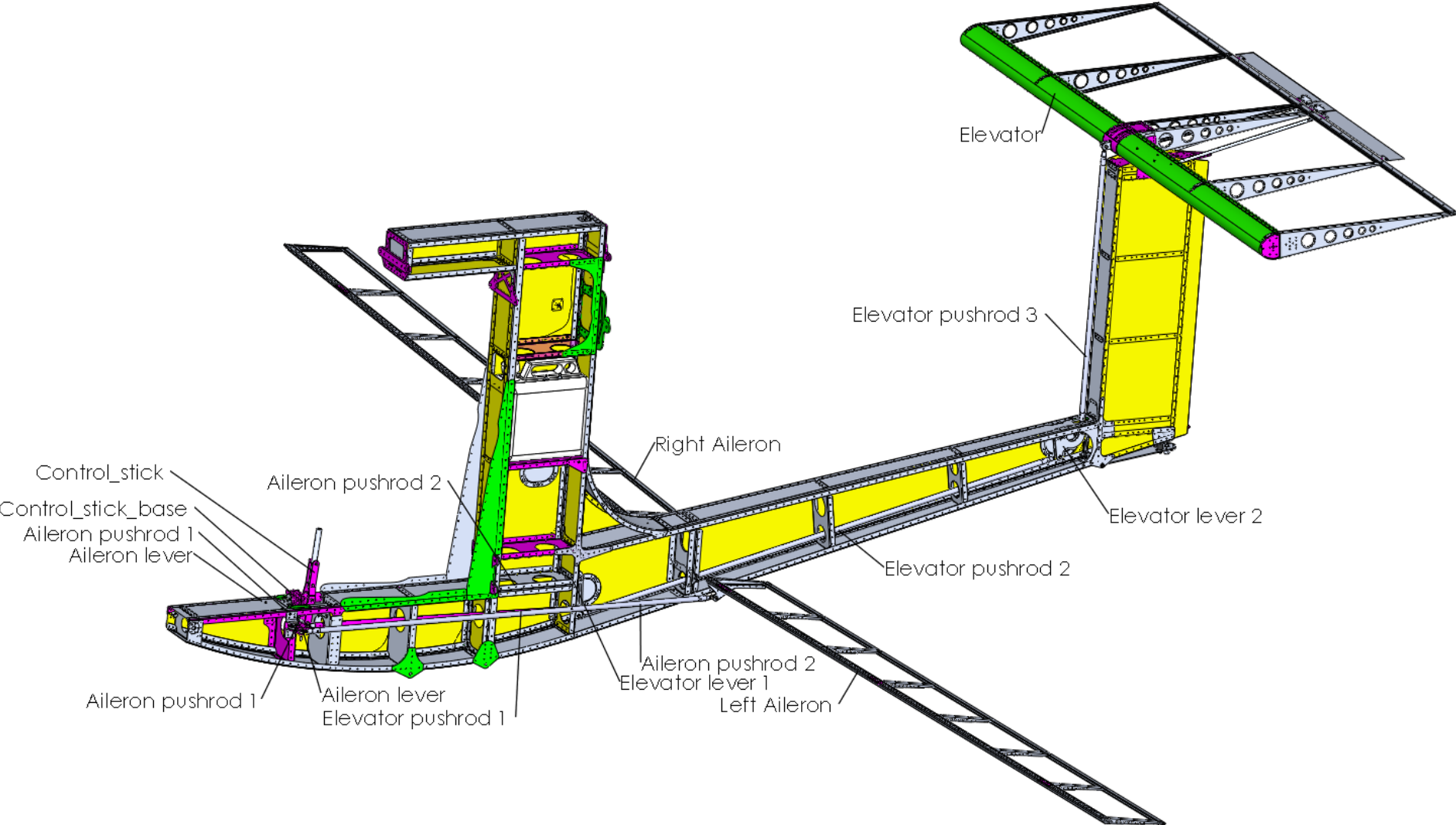


$g = t$

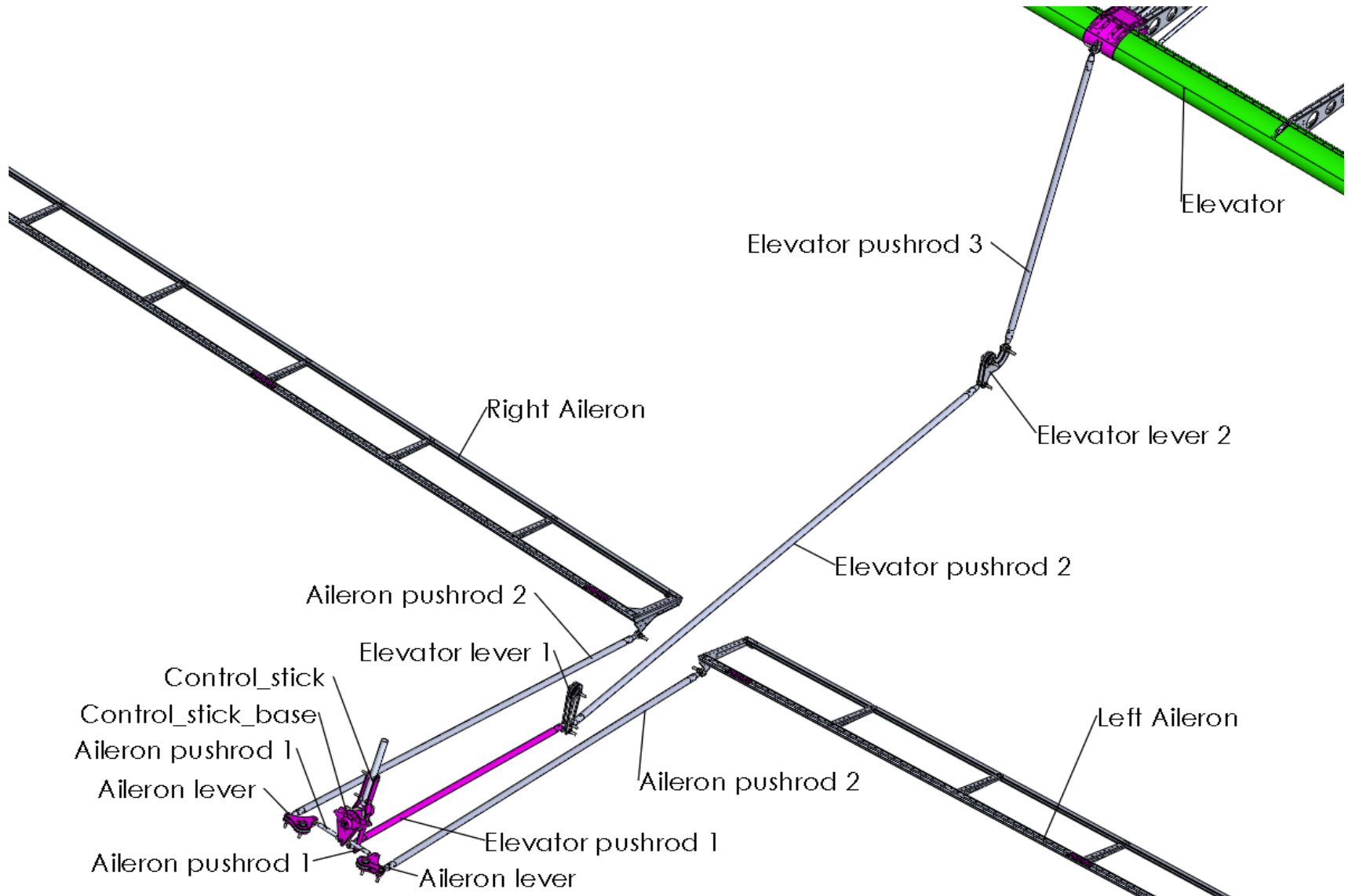


$g > t$

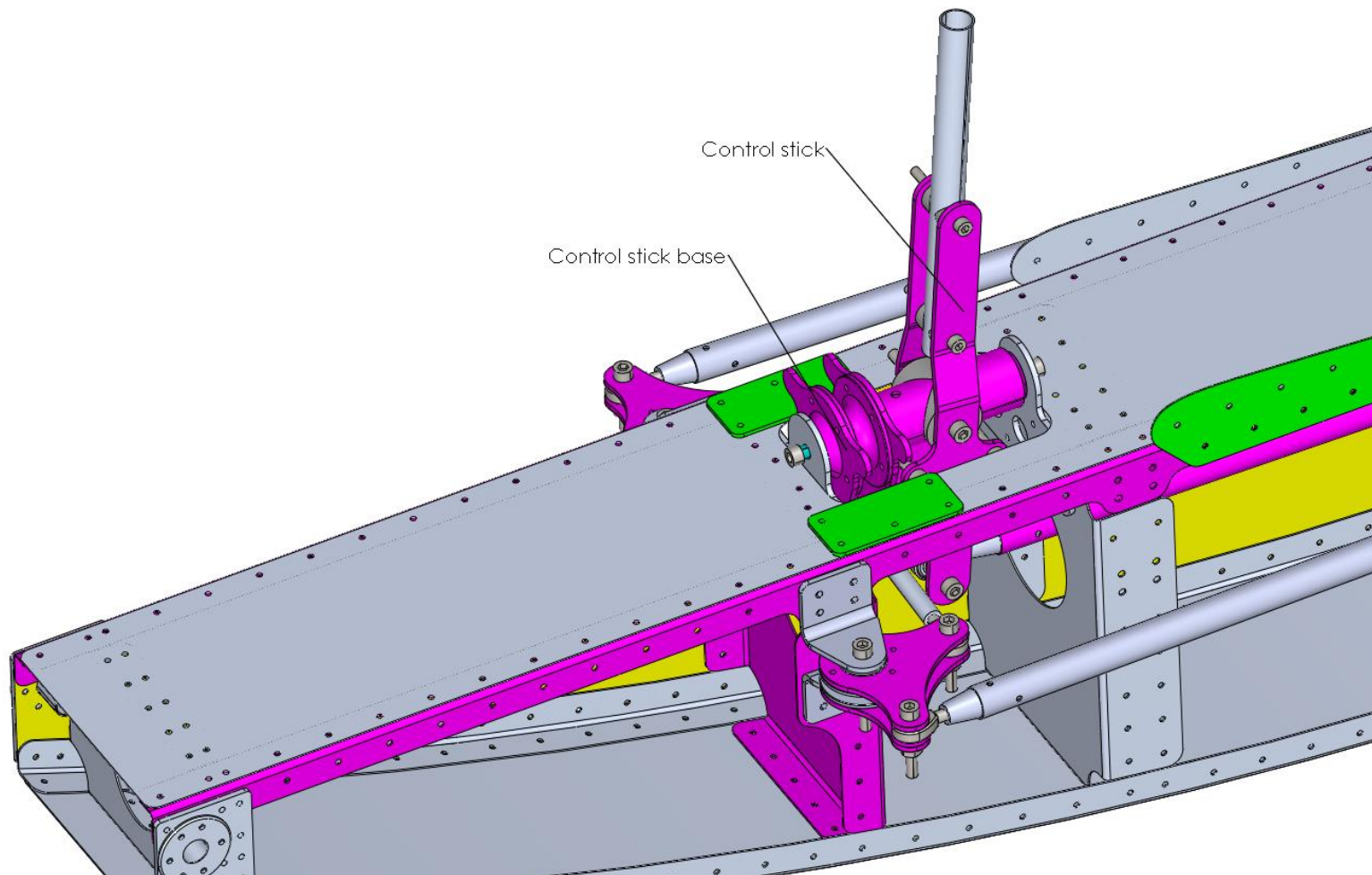
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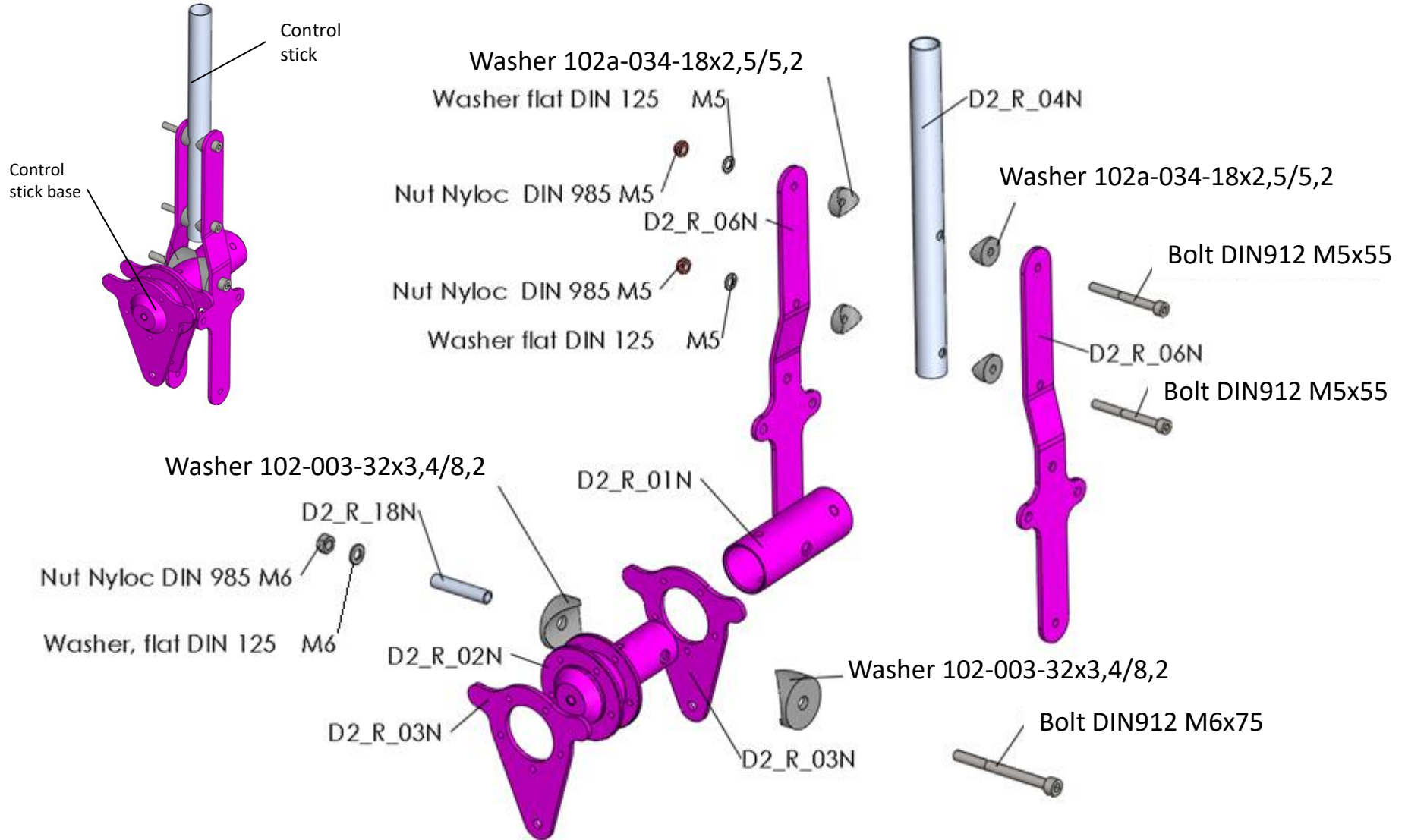
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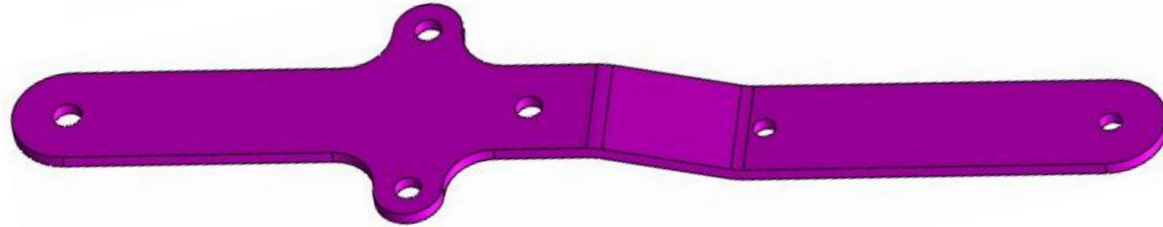
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Part: D2_R_04
Quantity: 1 piece



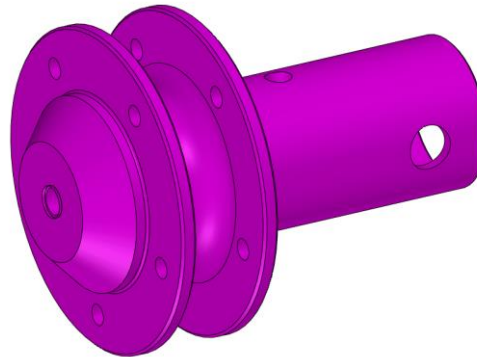
Part: D2_R_06
Quantity: 2 piece



Part: D2_R_18
Quantity: 1 piece



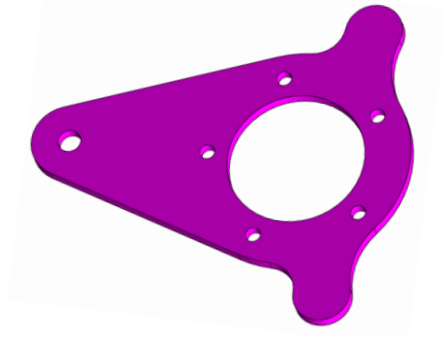
Part: D2_R_02N
Quantity: 1 piece



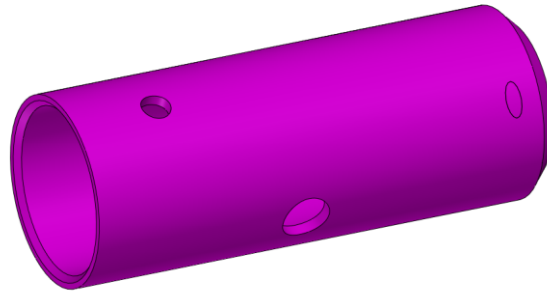
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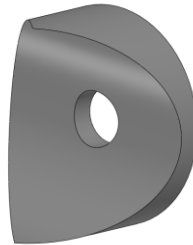
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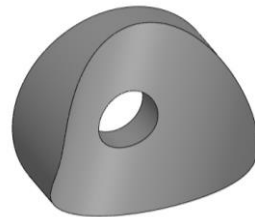
Part: D2_R_01N
Quantity: 1 piece



Part: Washer 102-003-32x3,4/8,3
Quantity: 2 piece










Part: Washer 102a-034-18x2,5/5,2
Quantity: 4 piece



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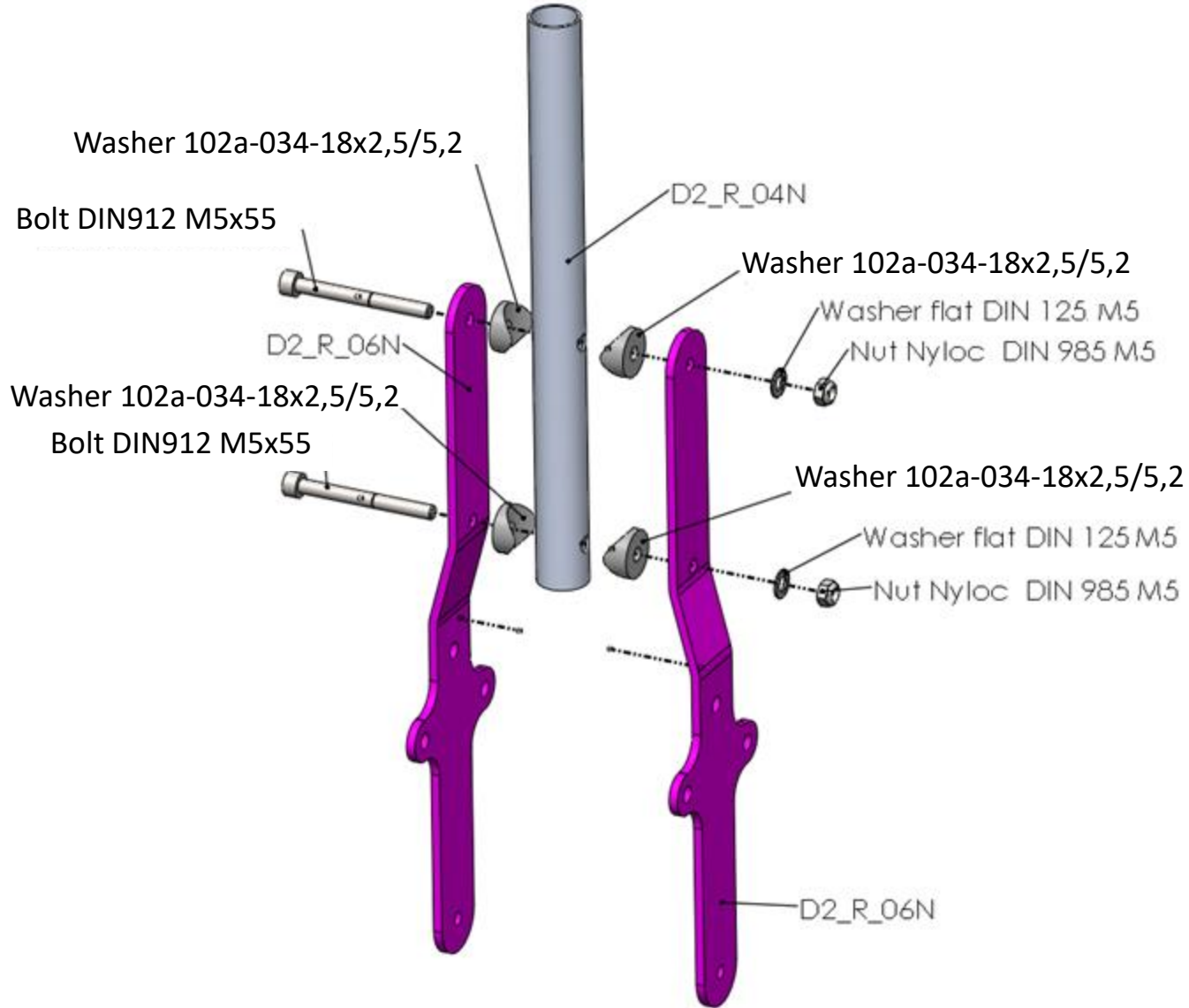


Standard Parts		
Detail picture	Part	Quantity
	Nut Nyloc DIN 985 M5	2
	Bolt DIN 912 M6x75	1
	Washer flat DIN 125 M6	1
	Bolt DIN 912 M5x55	2
	Nut Nyloc DIN 985 M6	1
	Washer flat DIN 125 M5	2
	Blind rivets AVEX Ø 4,0x9,5 AL/St	10

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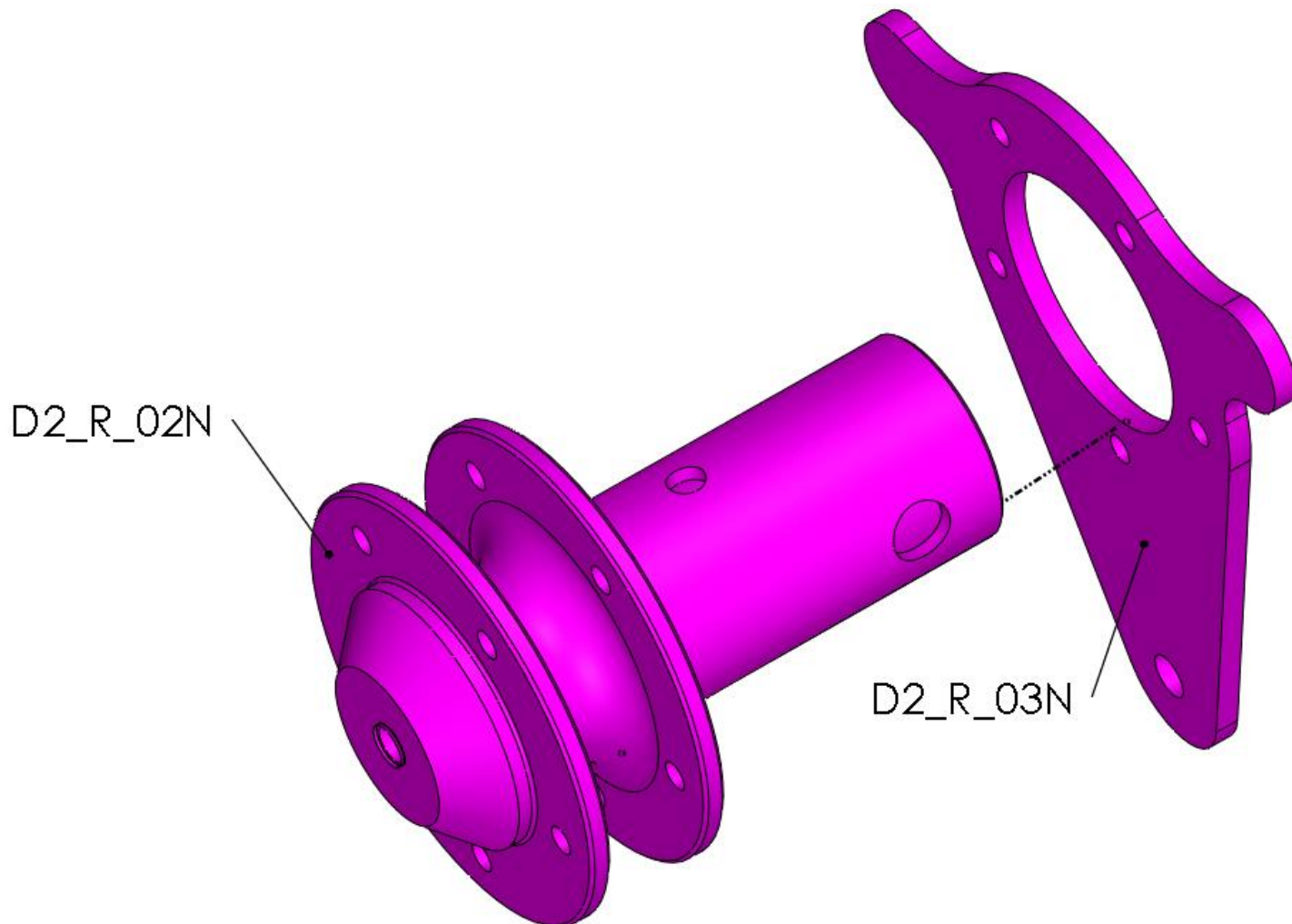
Step 1



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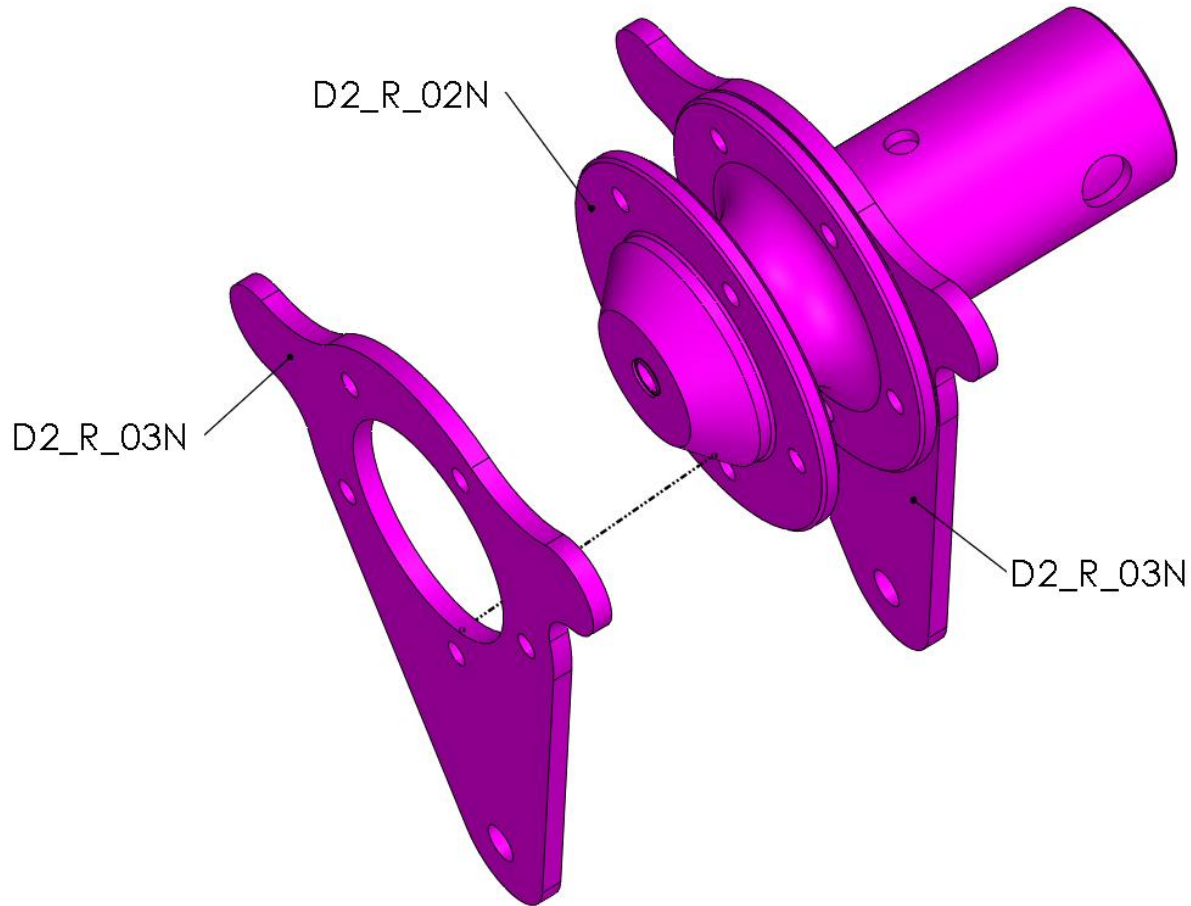
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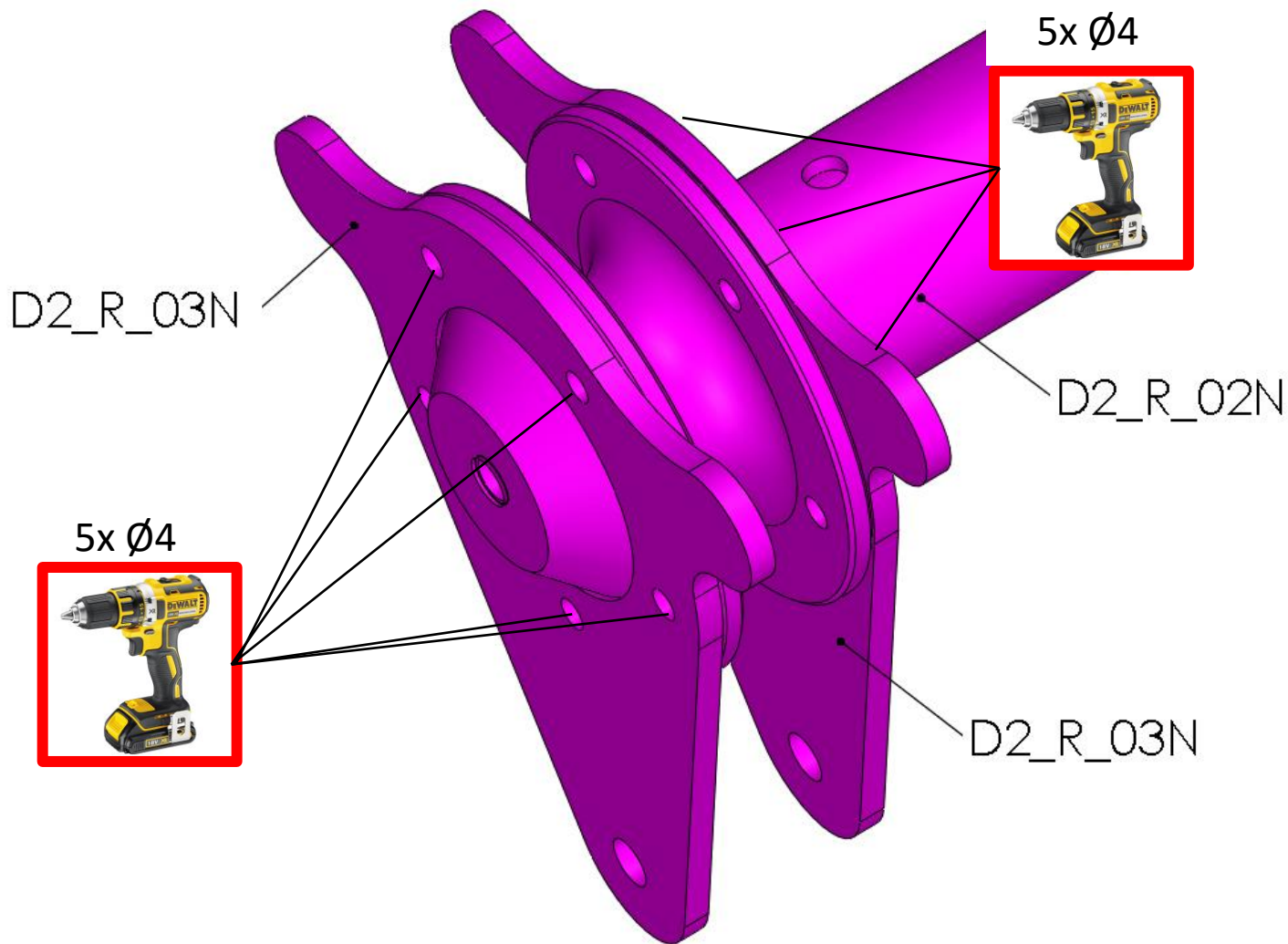
Step 3



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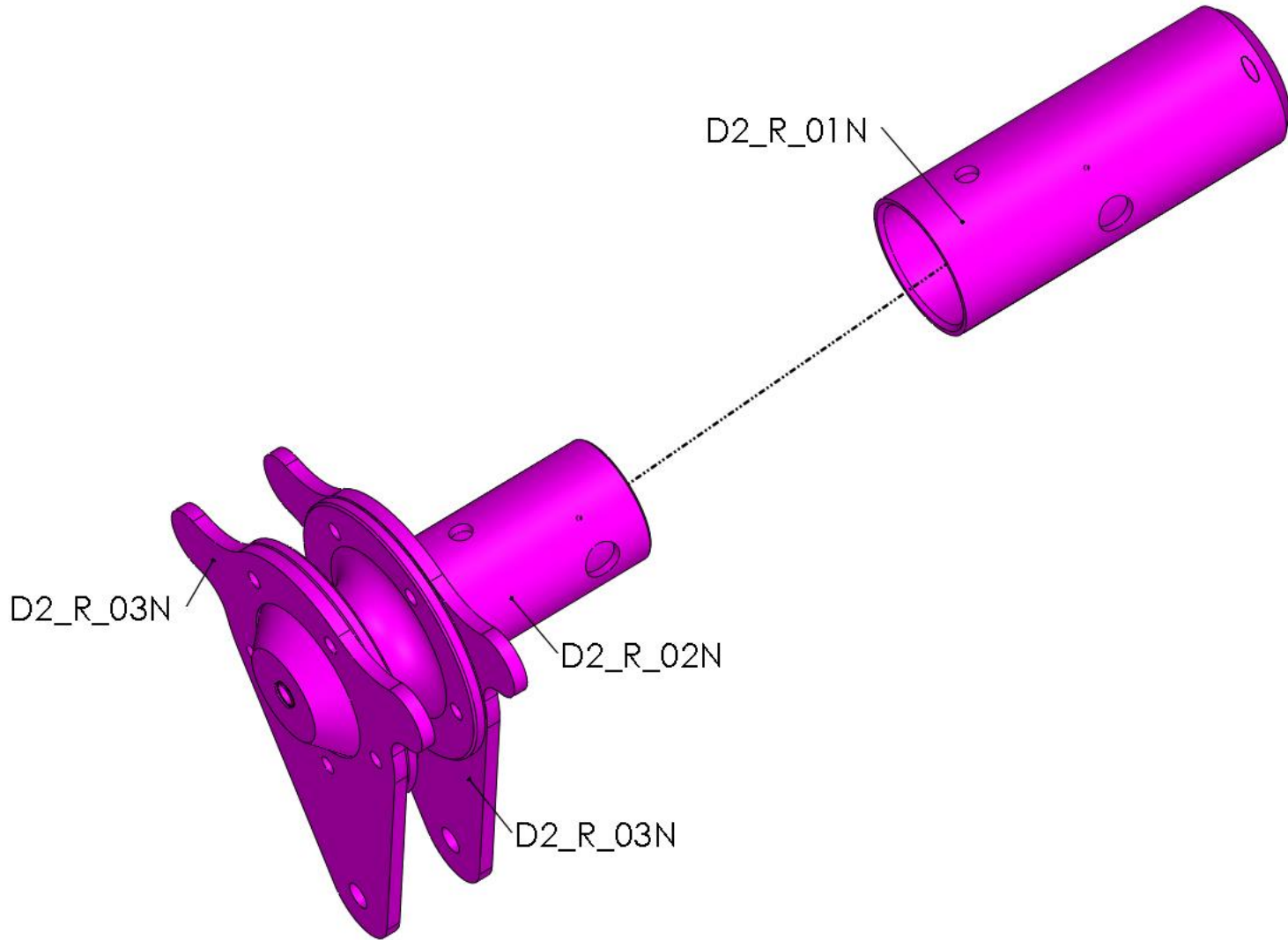
Step 4



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Step 5



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Step 6

5x Rivet
AVEX 4x9,5 Al/St



D2_R_02N

D2_R_03N

5x Rivet
AVEX 4x9,5 Al/St



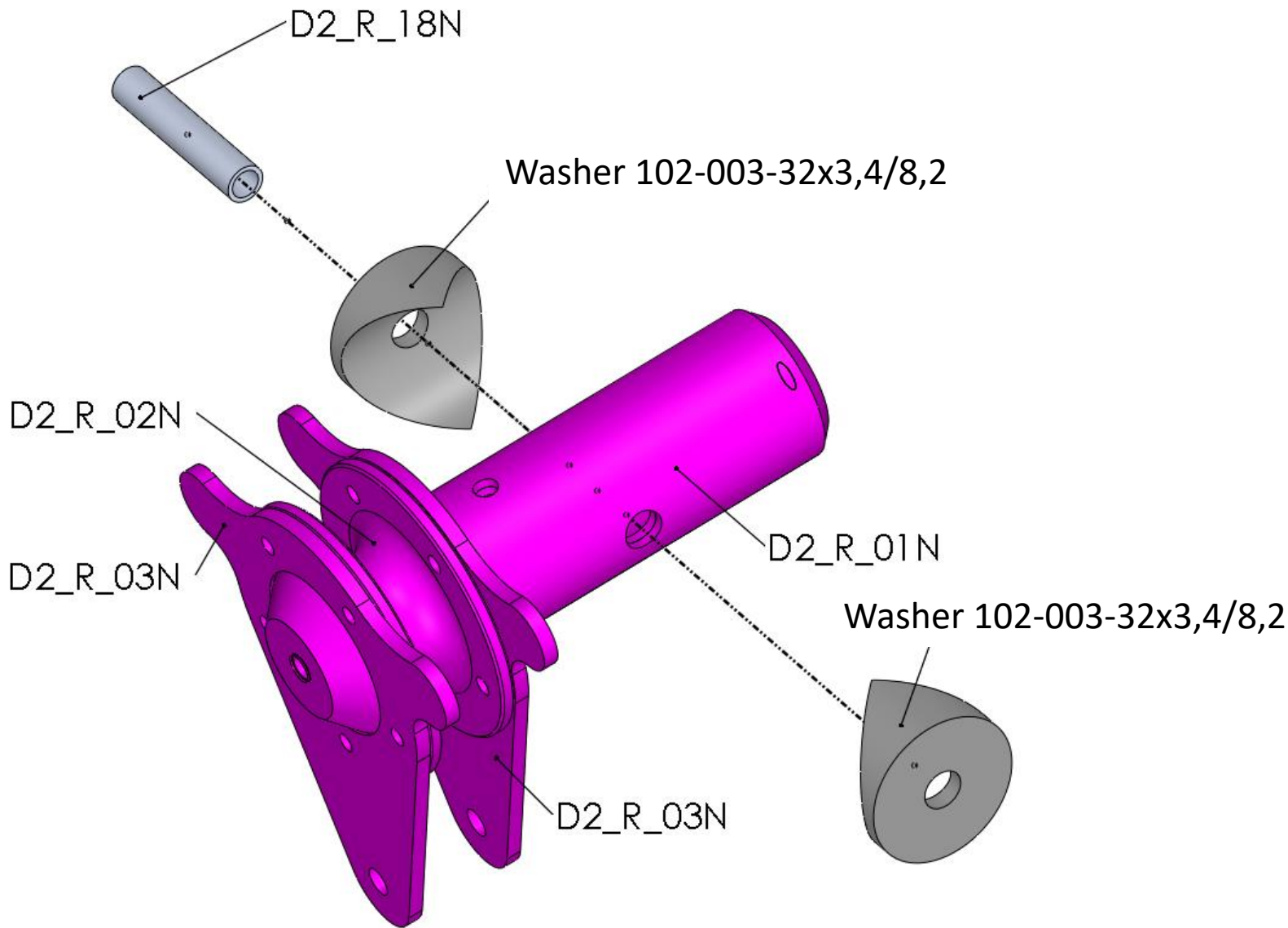
D2_R_03N

D2_R_01N

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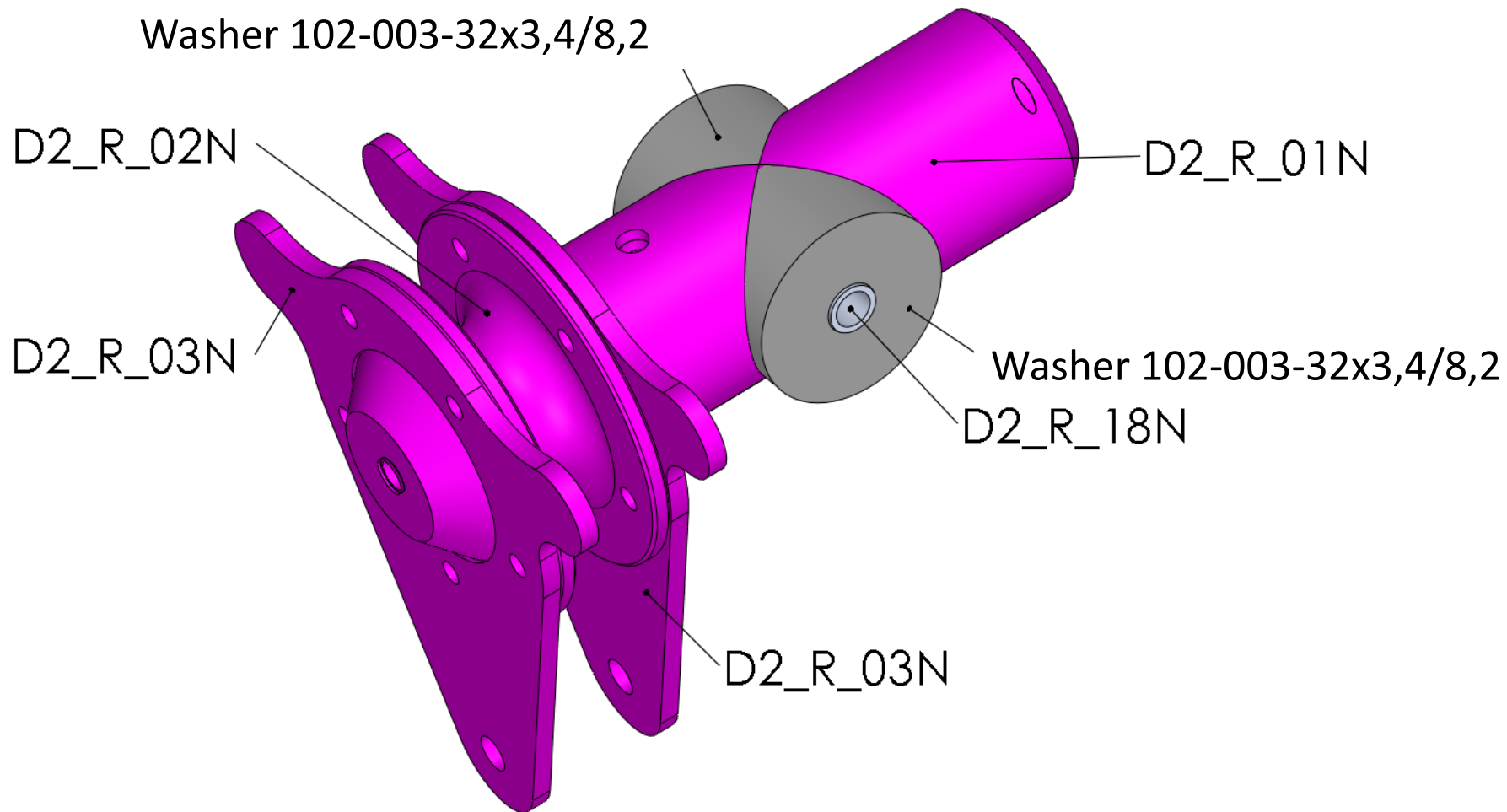
Step 7



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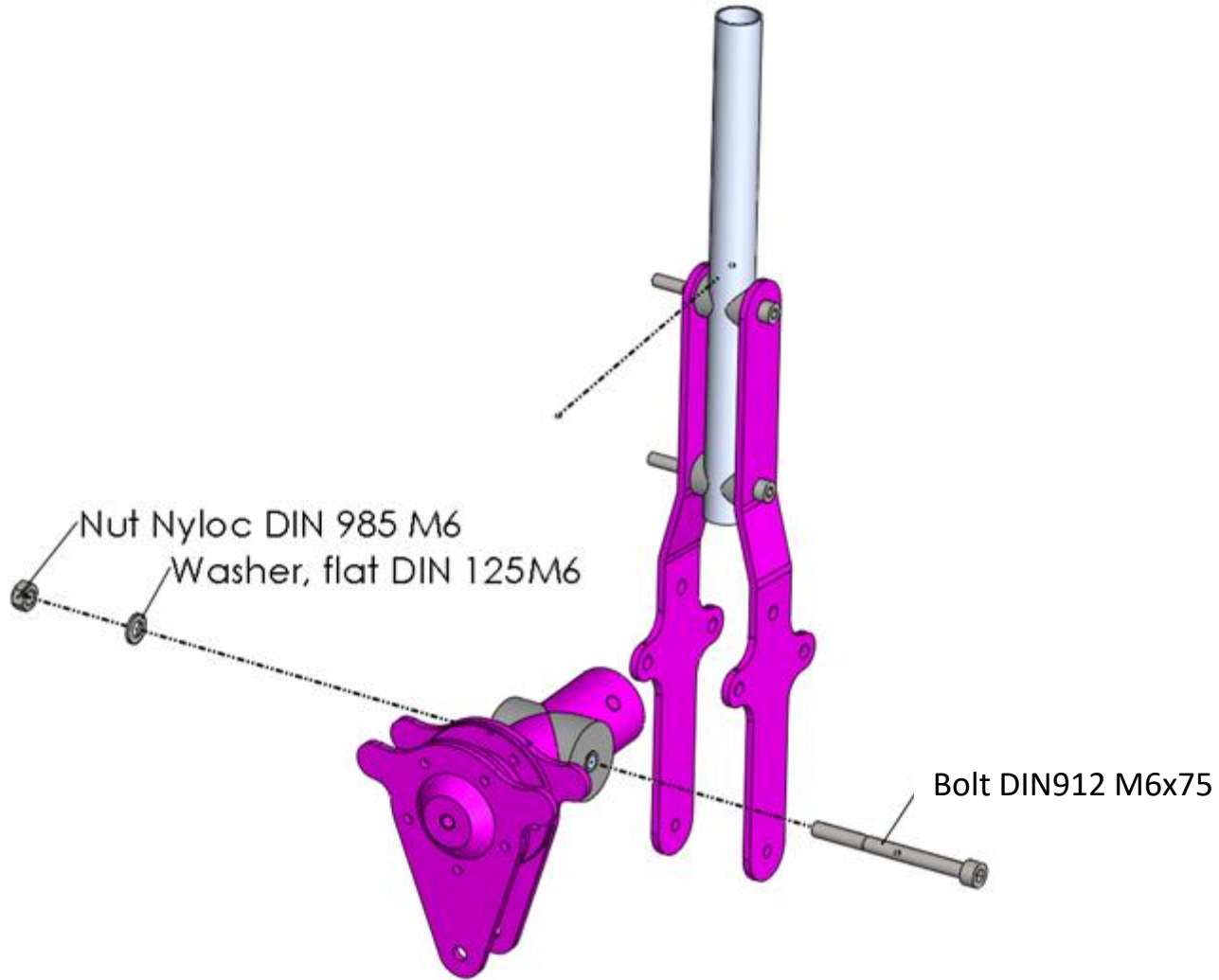
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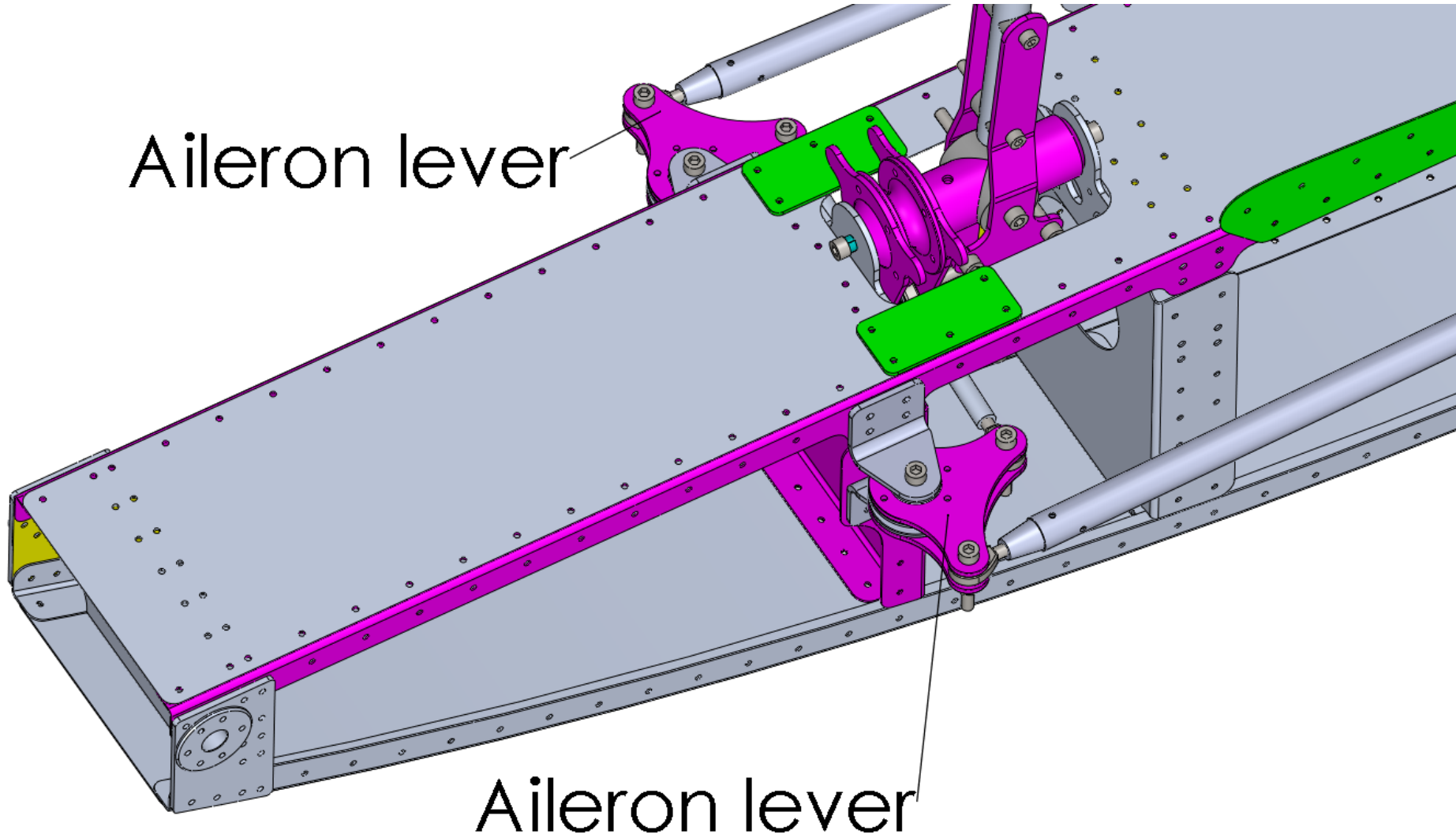
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Step 9



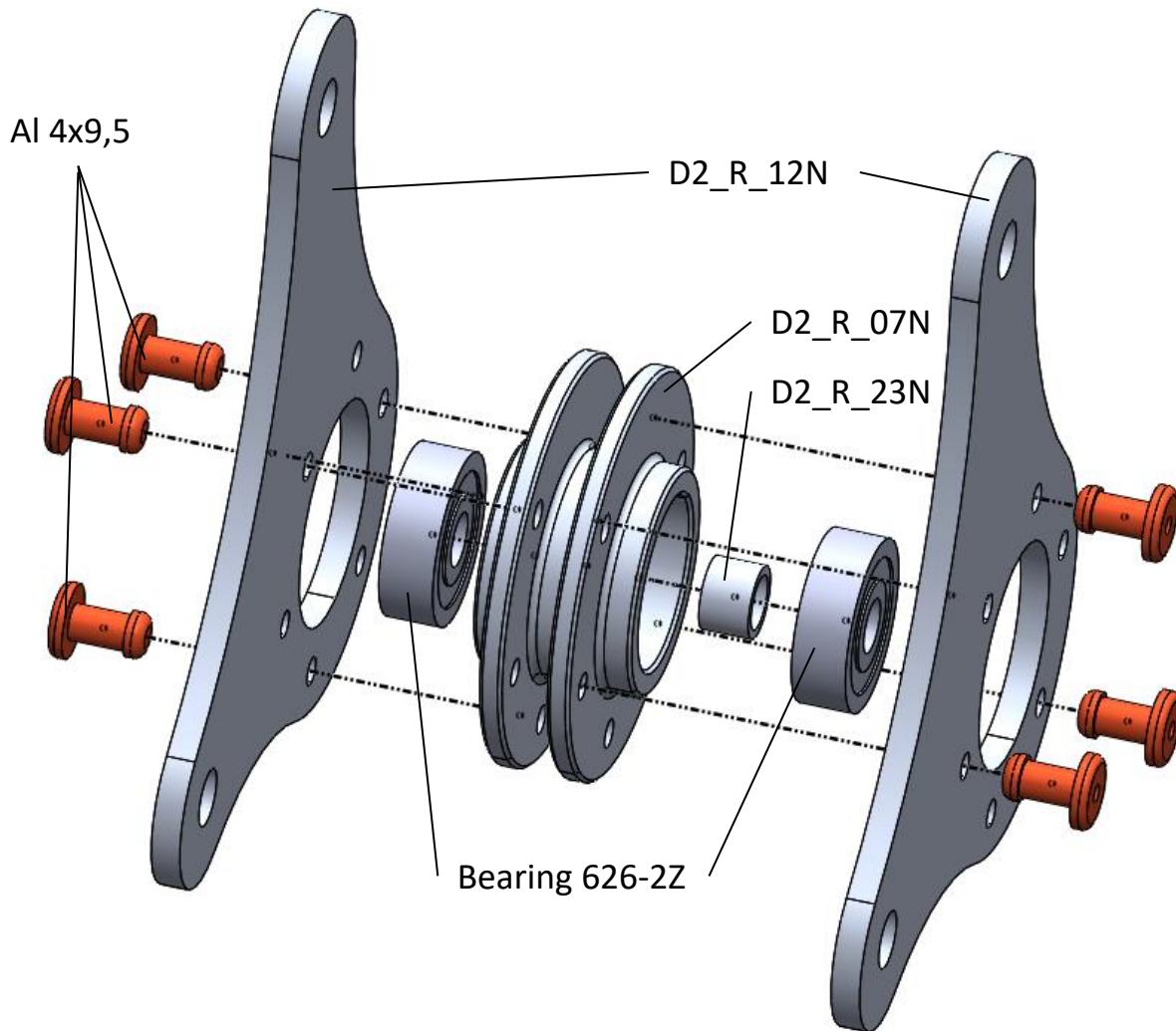
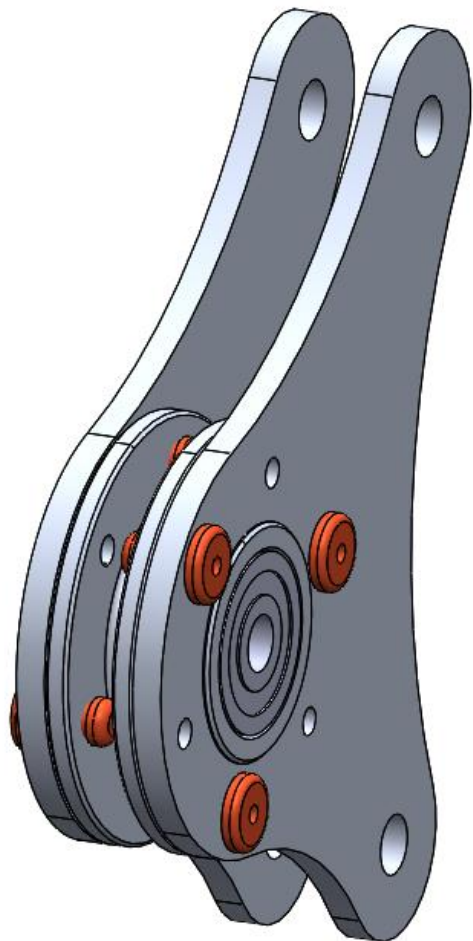
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Aileron lever
Quantity: 2



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Part: D2_R_12N
Quantity: 2+2





Part: D2_R_07N
Quantity: 1+1



Part: D2_R_23N
Quantity: 1+1

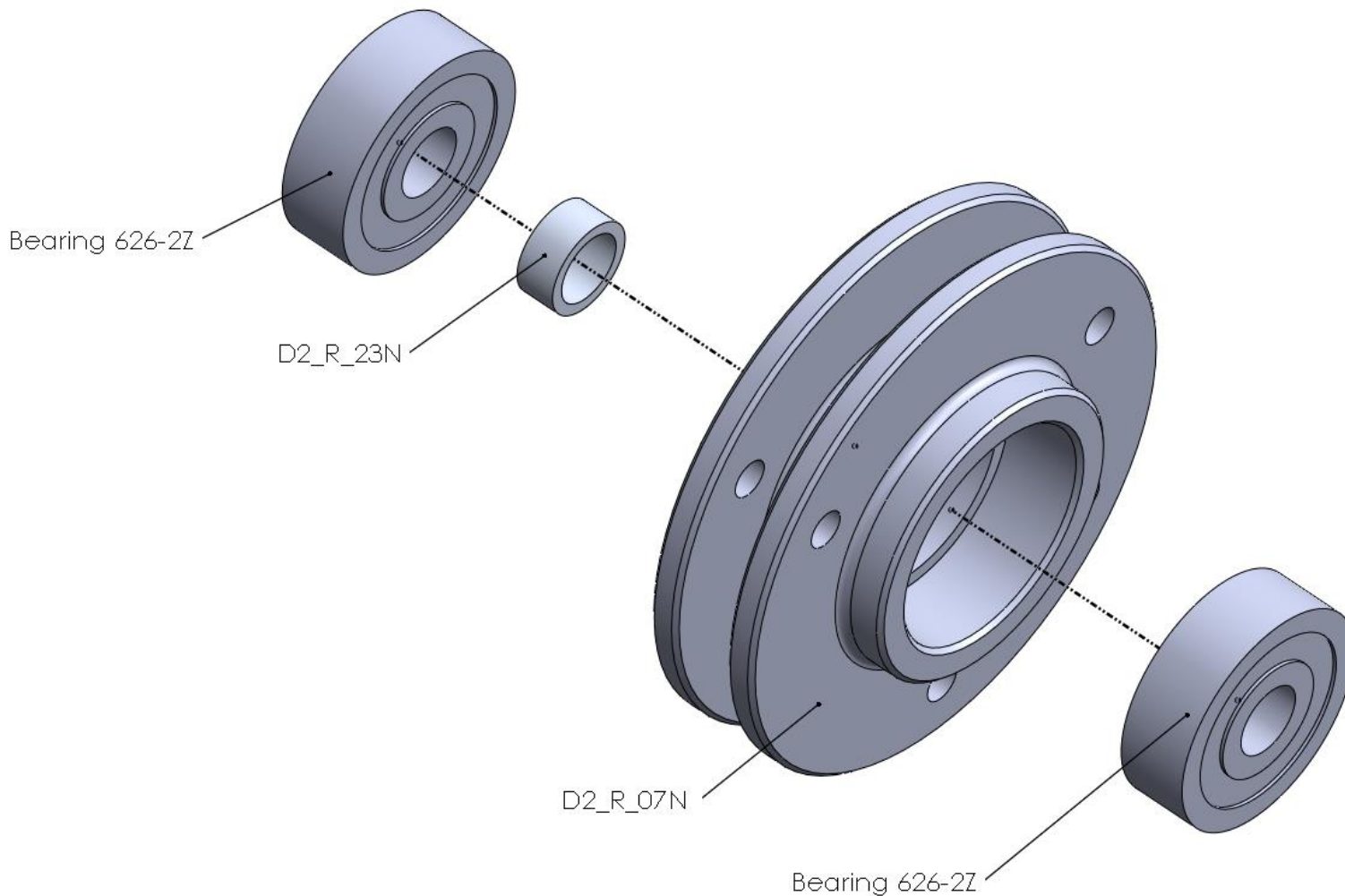


Standard Parts		
Detail picture	Part	Quantity
	Bearing 626-2Z	2+2
	Blind rivets AVEX Ø 4x9,5 AL/st	6+6

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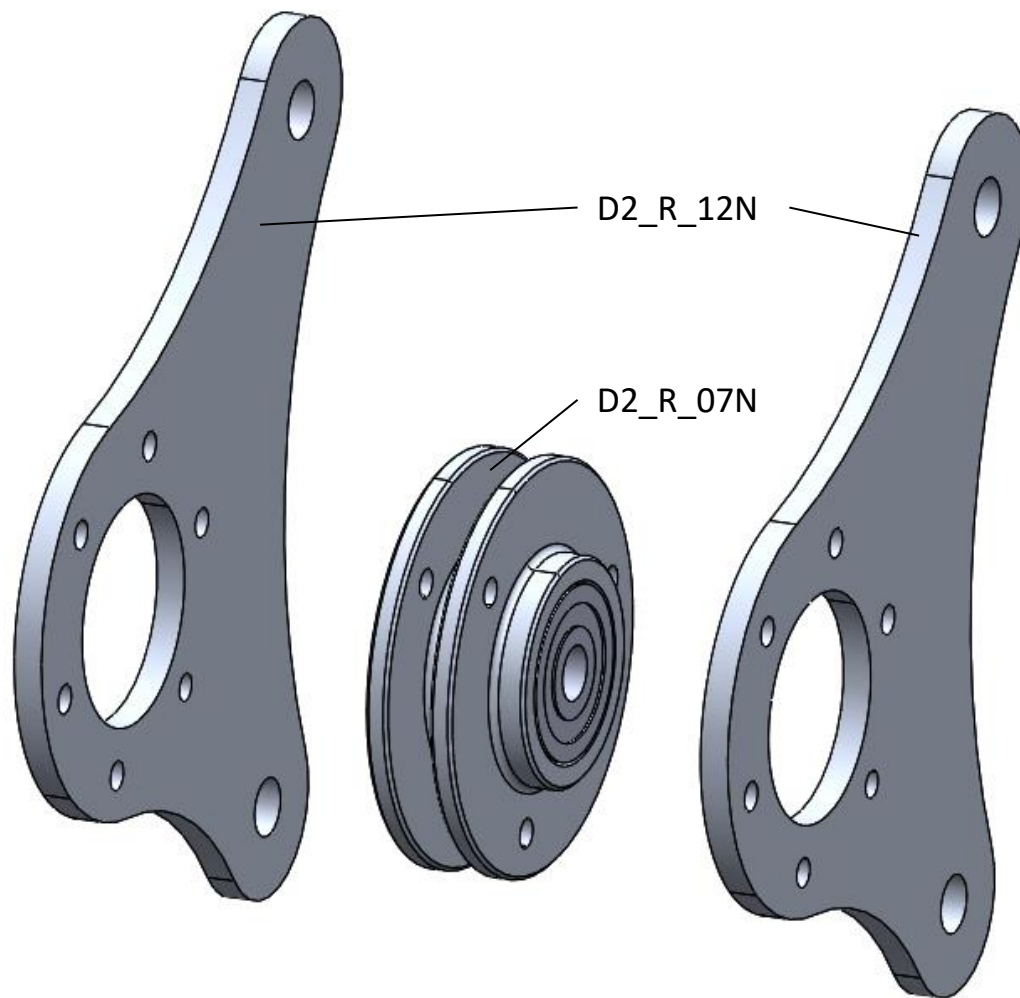
Step 1



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Step 2



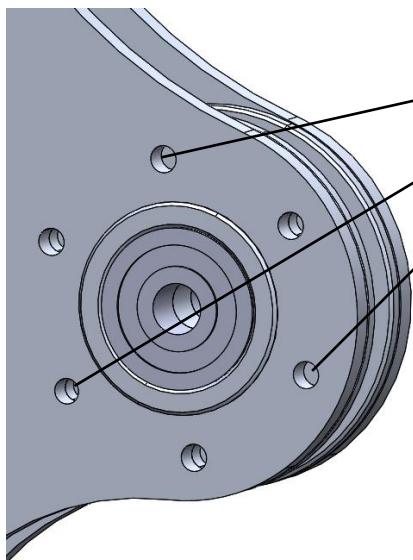
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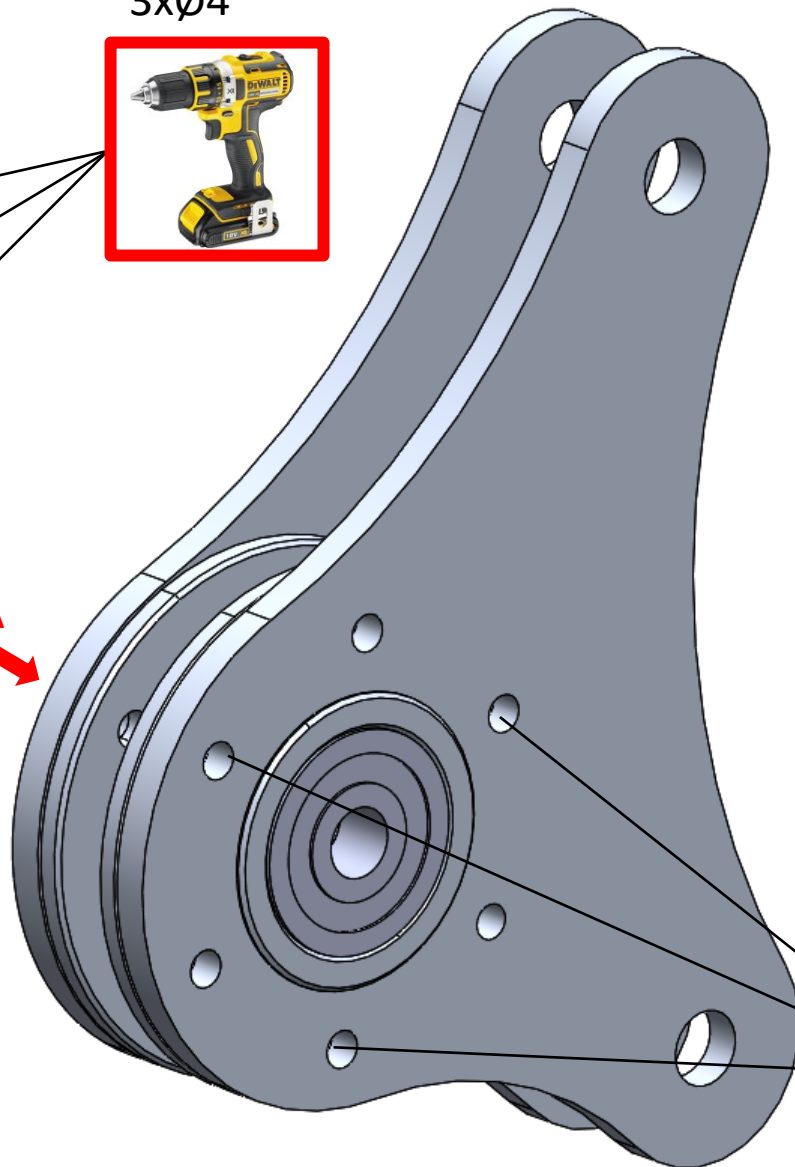
Step 3

A

3xØ4



A



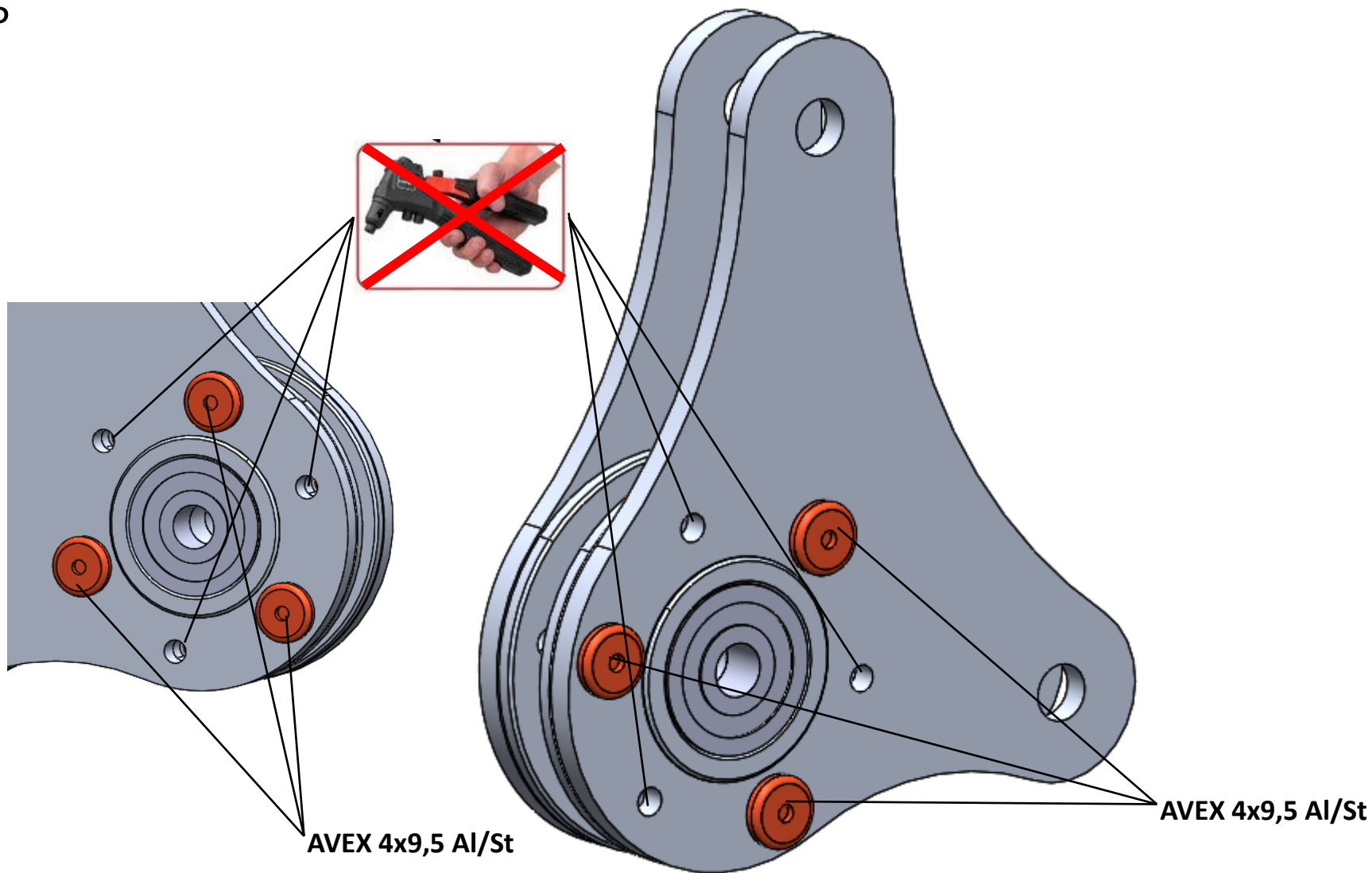
3xØ4



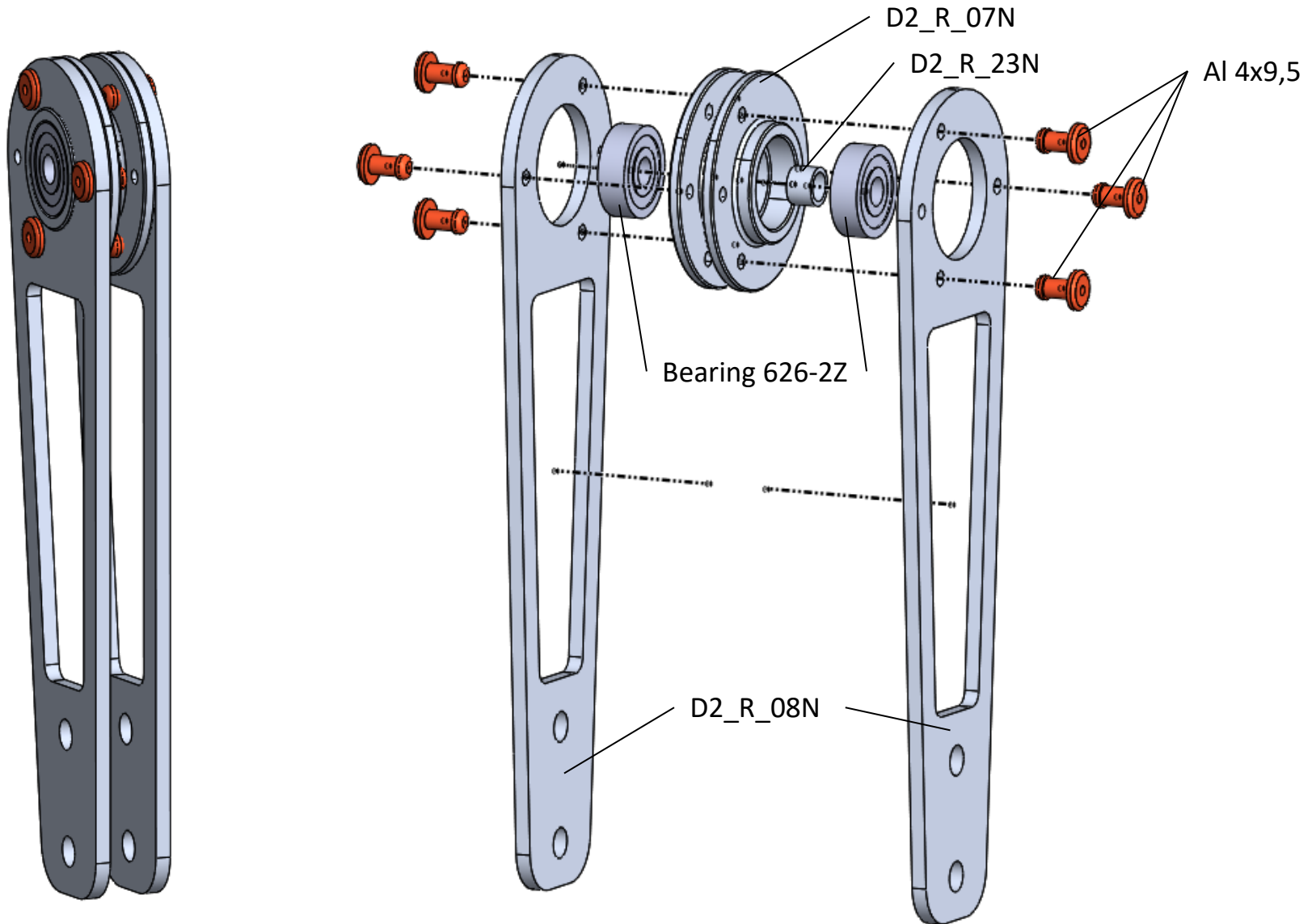
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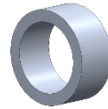
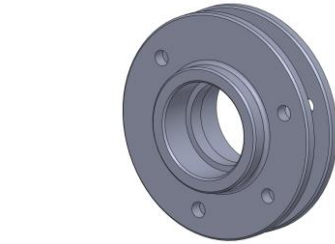
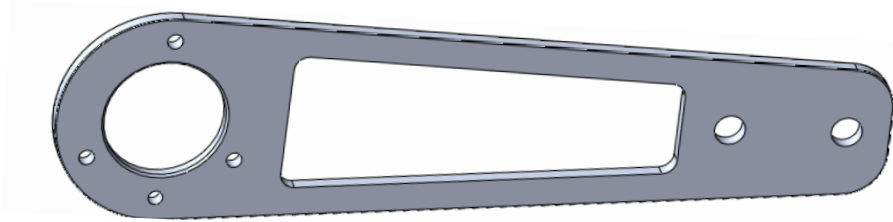
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Part: D2_R_08N
Quantity: 2 piece

Part: D2_R_07N
Quantity: 1 piece

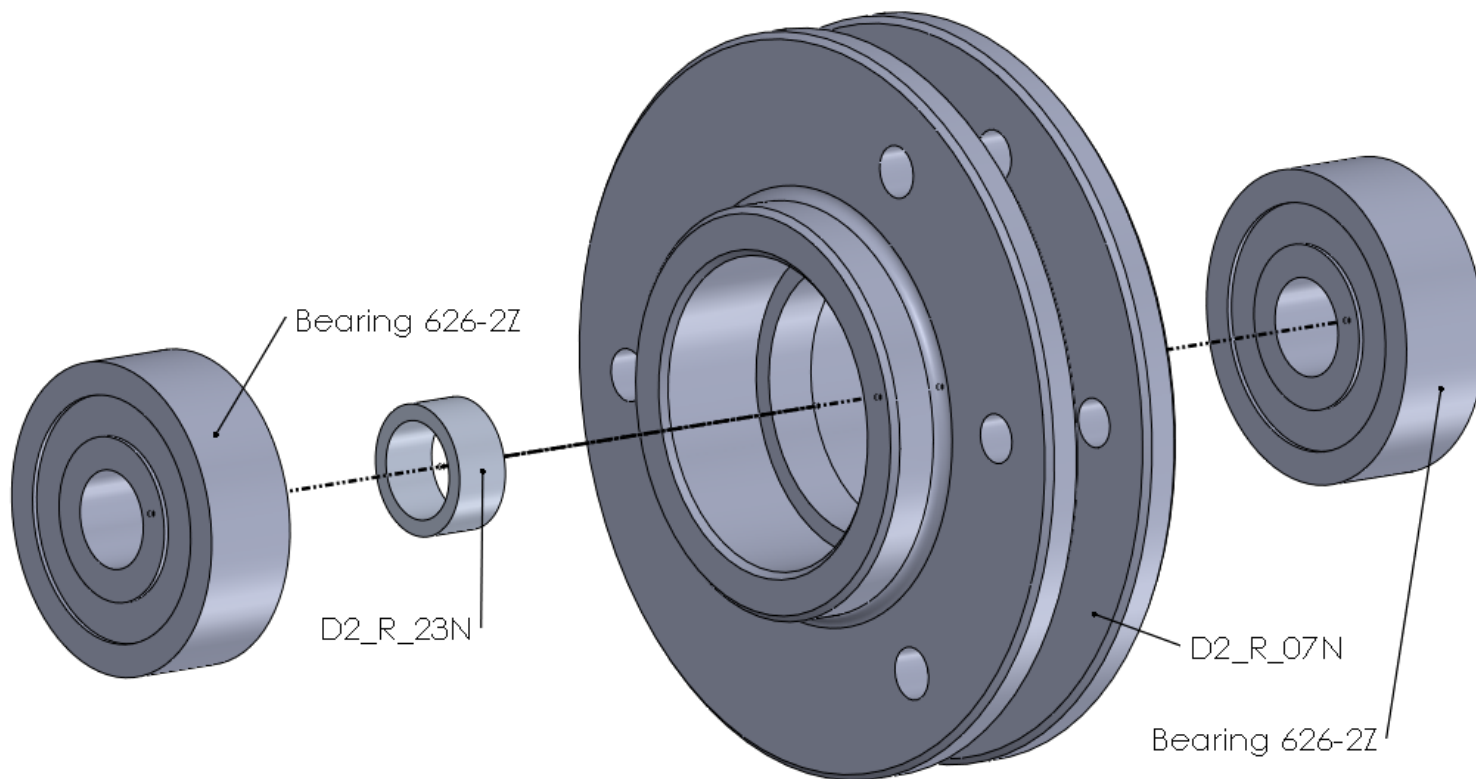
Part: D2_R_23N
Quantity: 1 piece

Standard Parts		
Detail picture	Part	Quantity
	Bearing 626-2Z	2
	Blind rivets AVEX Ø 4x9,5 AL/st	6

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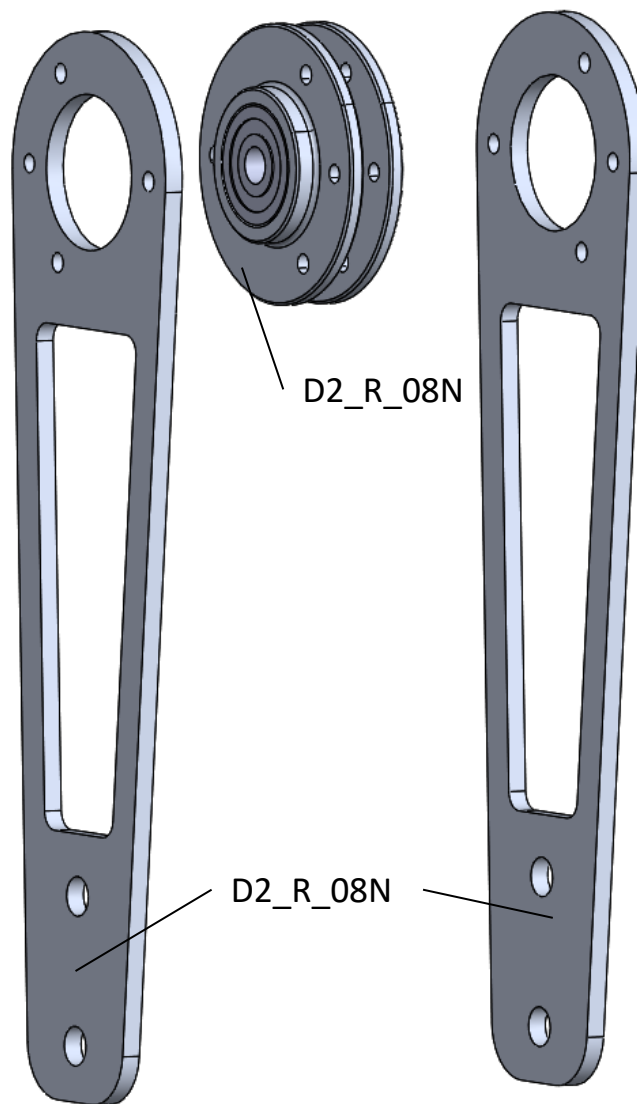
Step 1



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Step 2



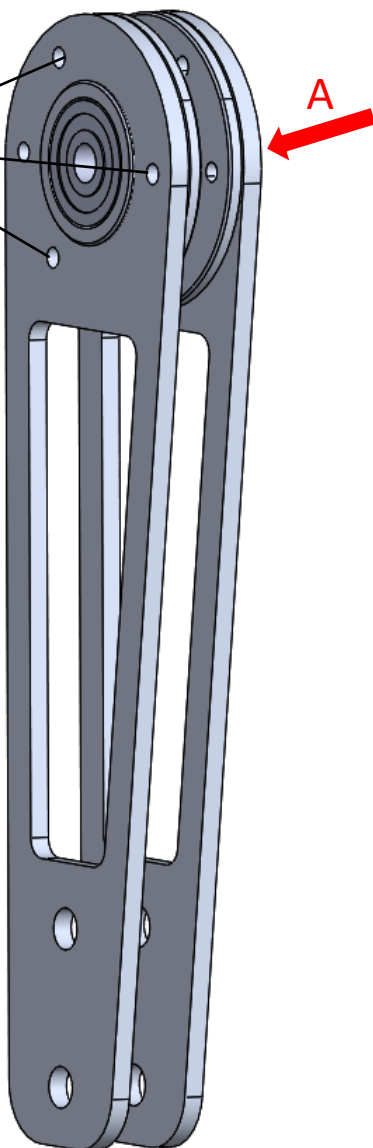
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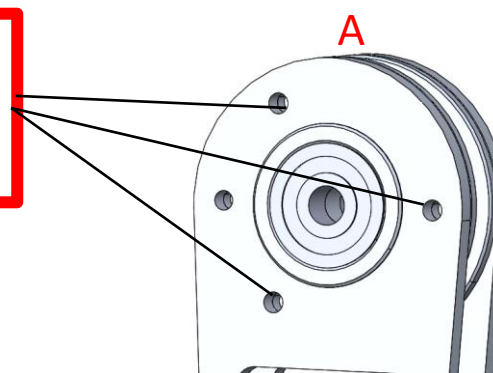
Step 3



3xØ4



3xØ4



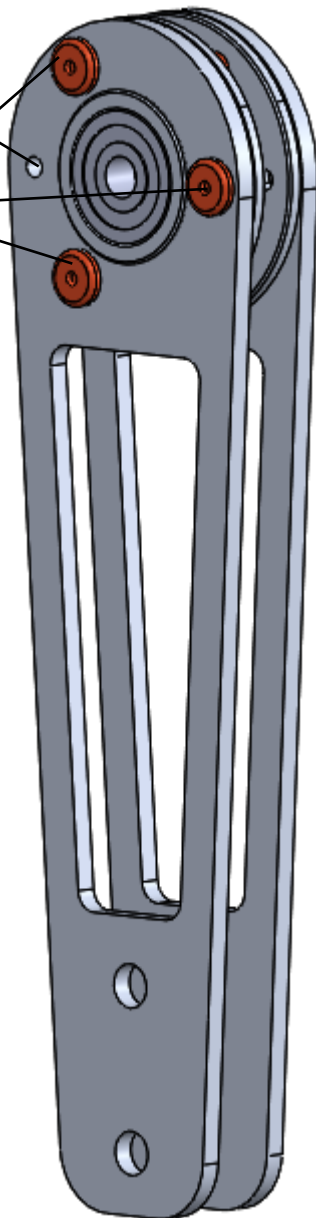
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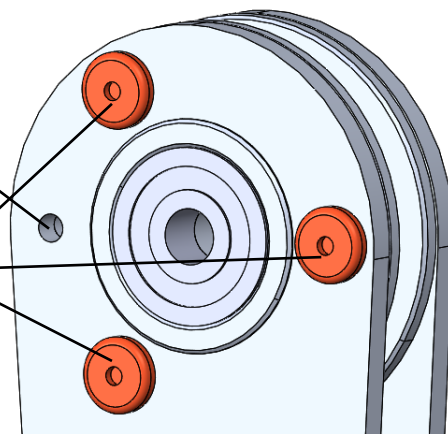
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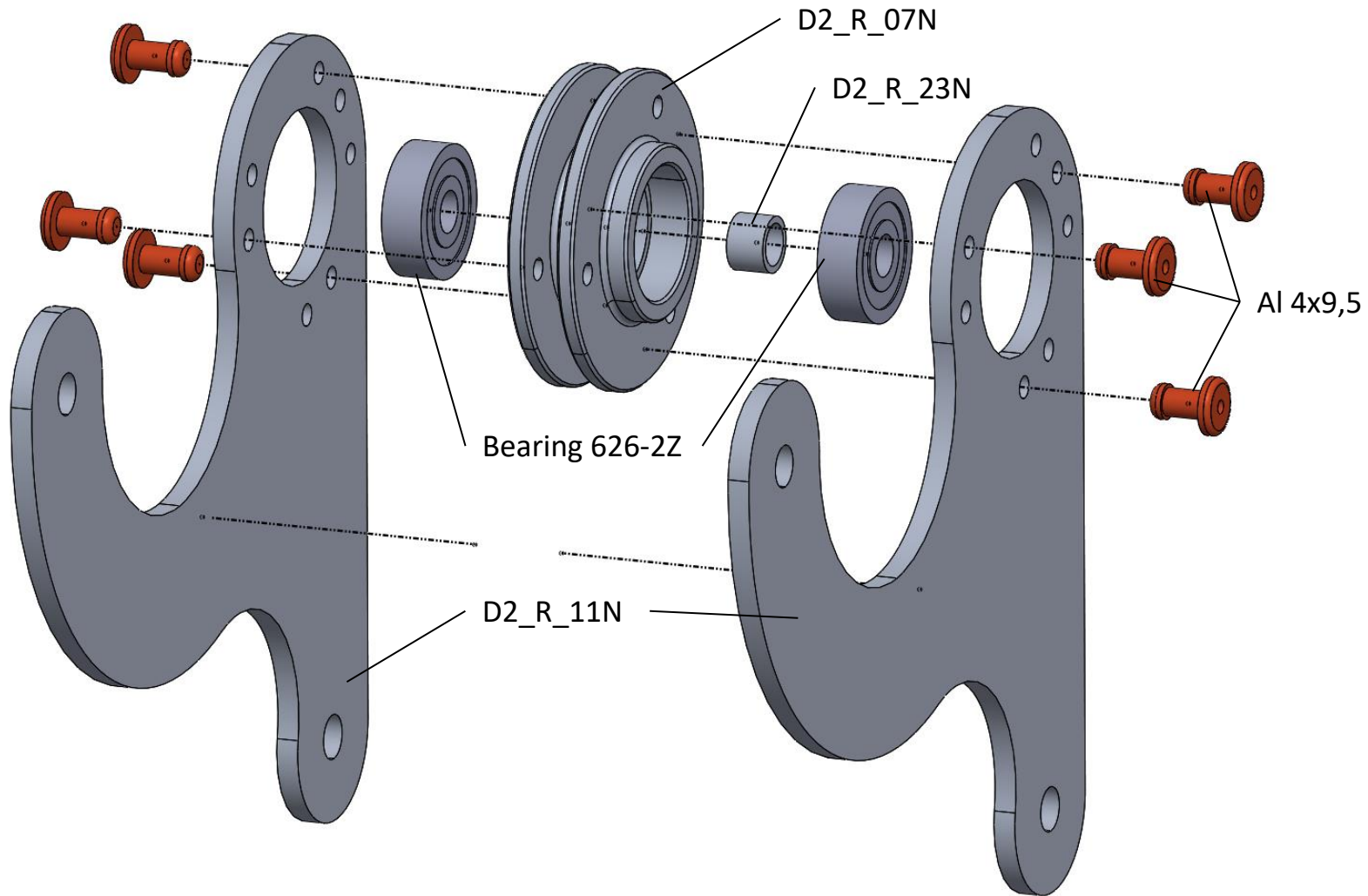
AVEX 4x9,5 Al/St



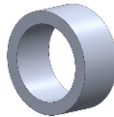
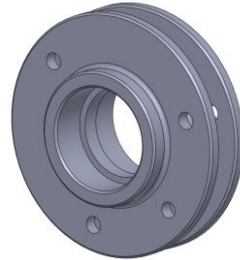
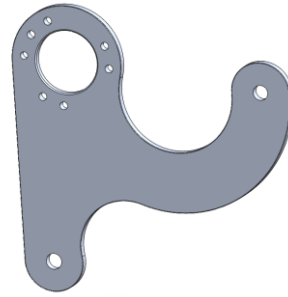
AVEX 4x9,5 Al/St



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Part: D2_R_11N
Quantity: 2

Part: D2_R_07N
Quantity: 1

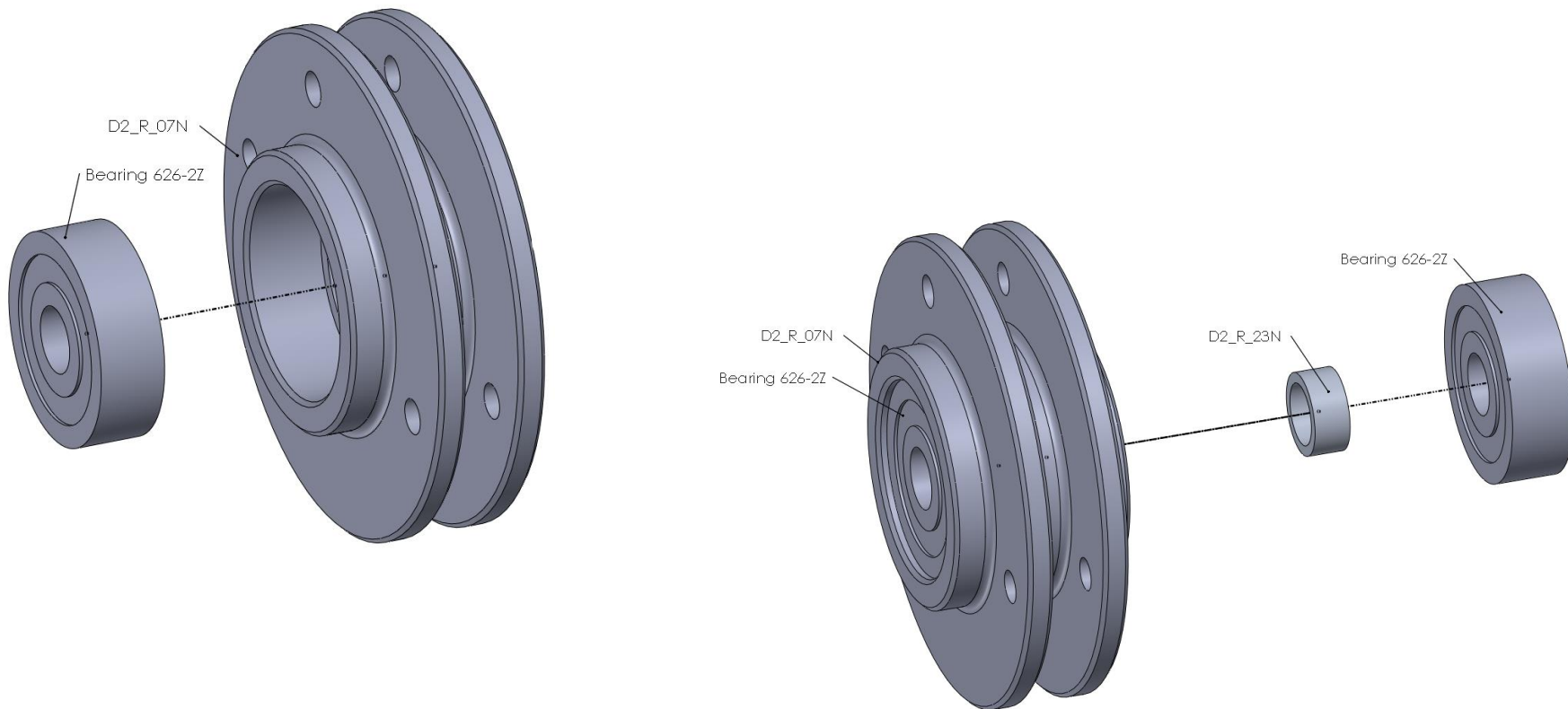
Part: D2_R_23N
Quantity: 1

Standard Parts		
Detail picture	Part	Quantity
	Bearing 626-2Z	2
	Blind rivets AVEX Ø 4x9,5 AL/st	6

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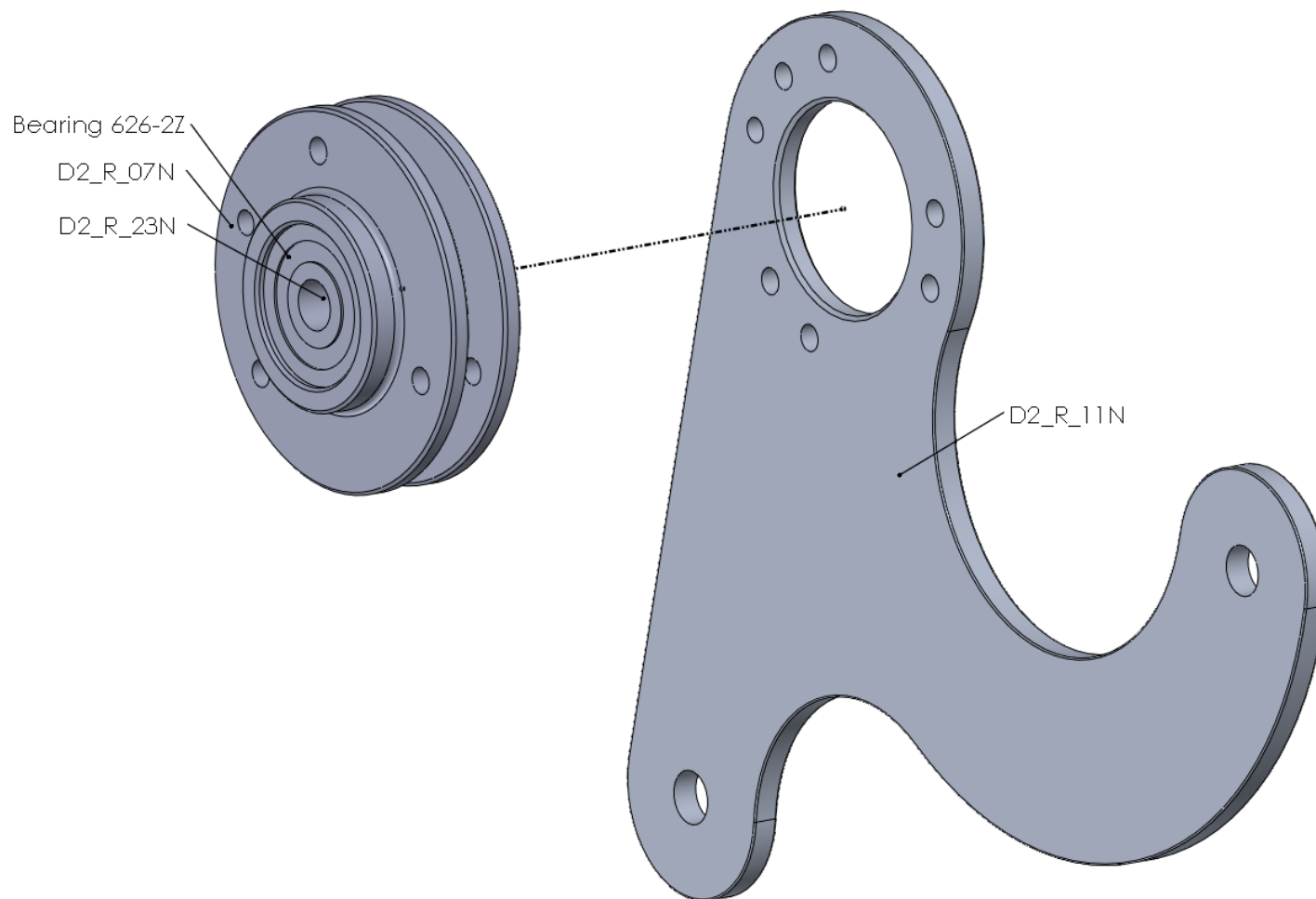
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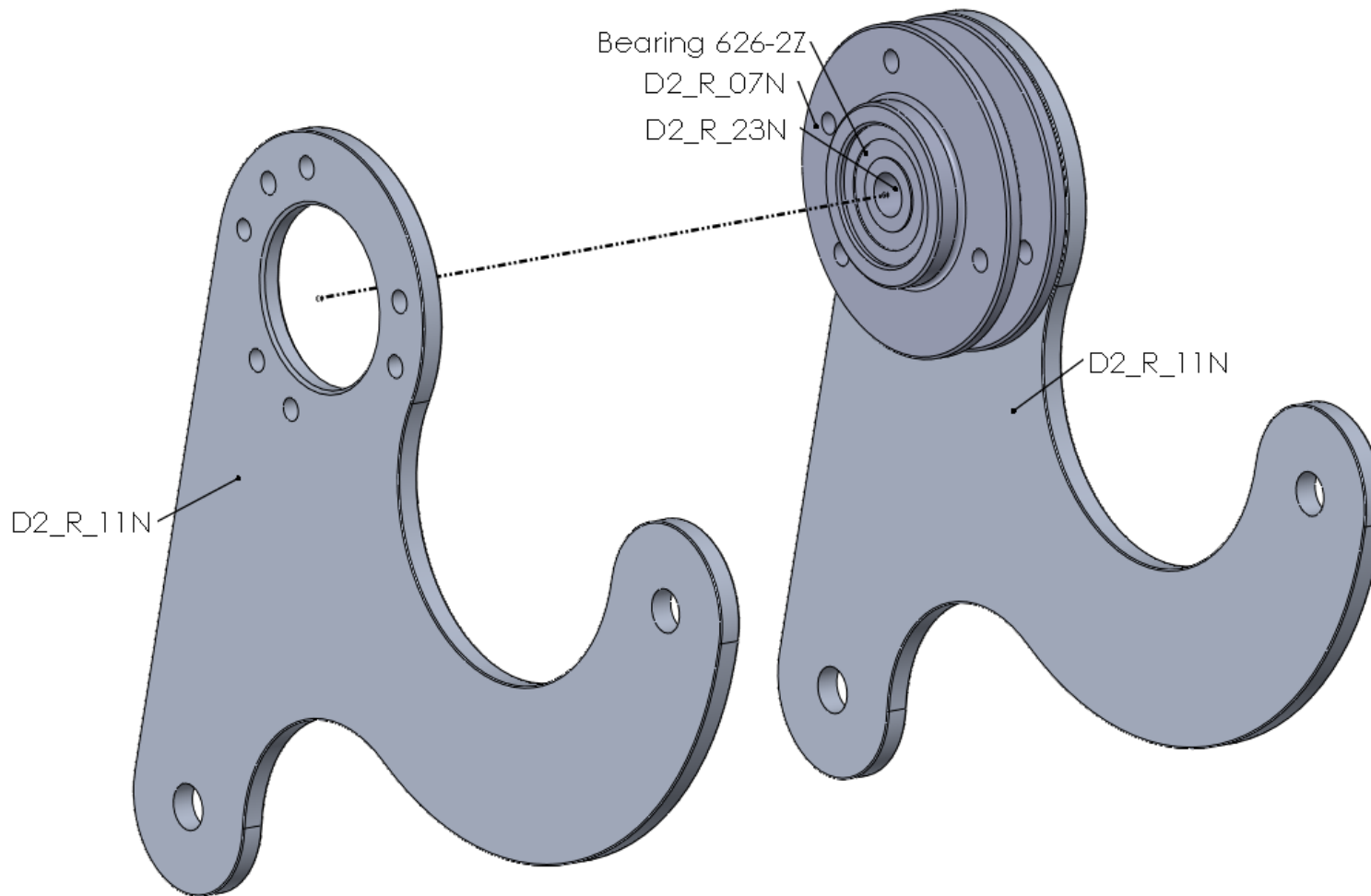
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Step 3



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Step 4

A



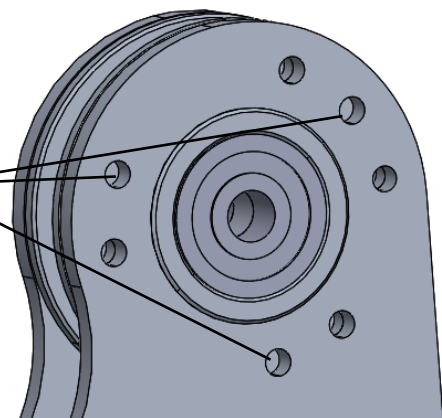
D2_R_07N

Bearing 626-2Z

D2_R_23N



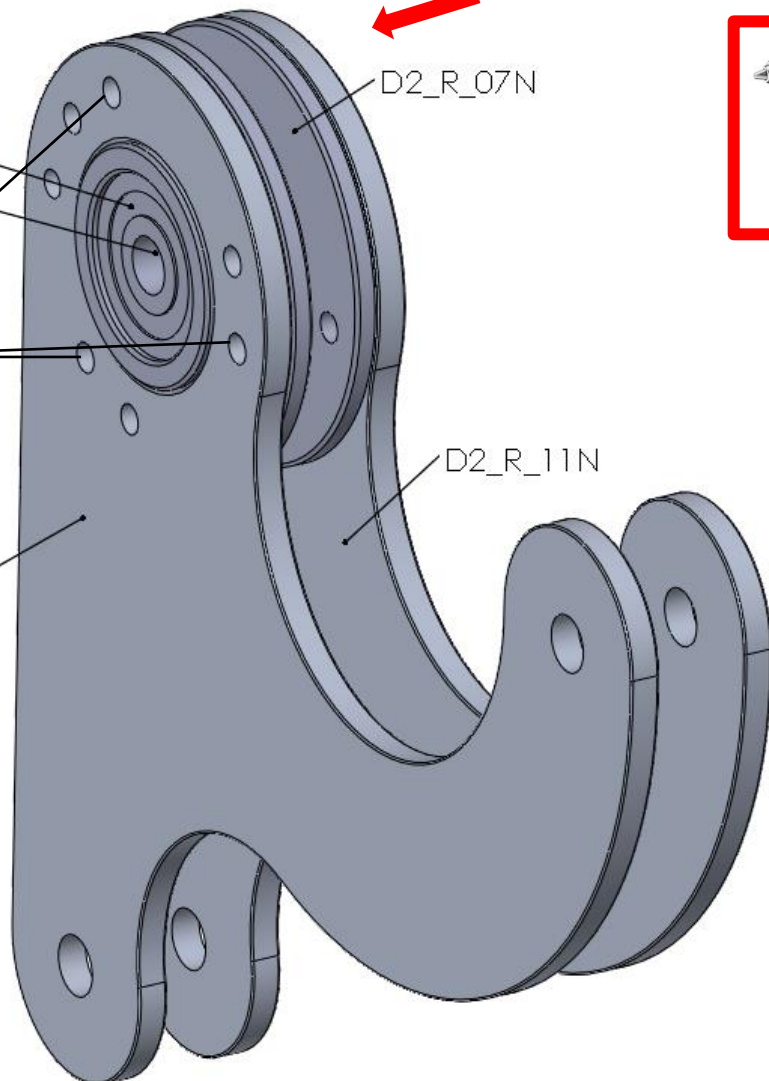
3xØ4



3xØ4

D2_R_11N

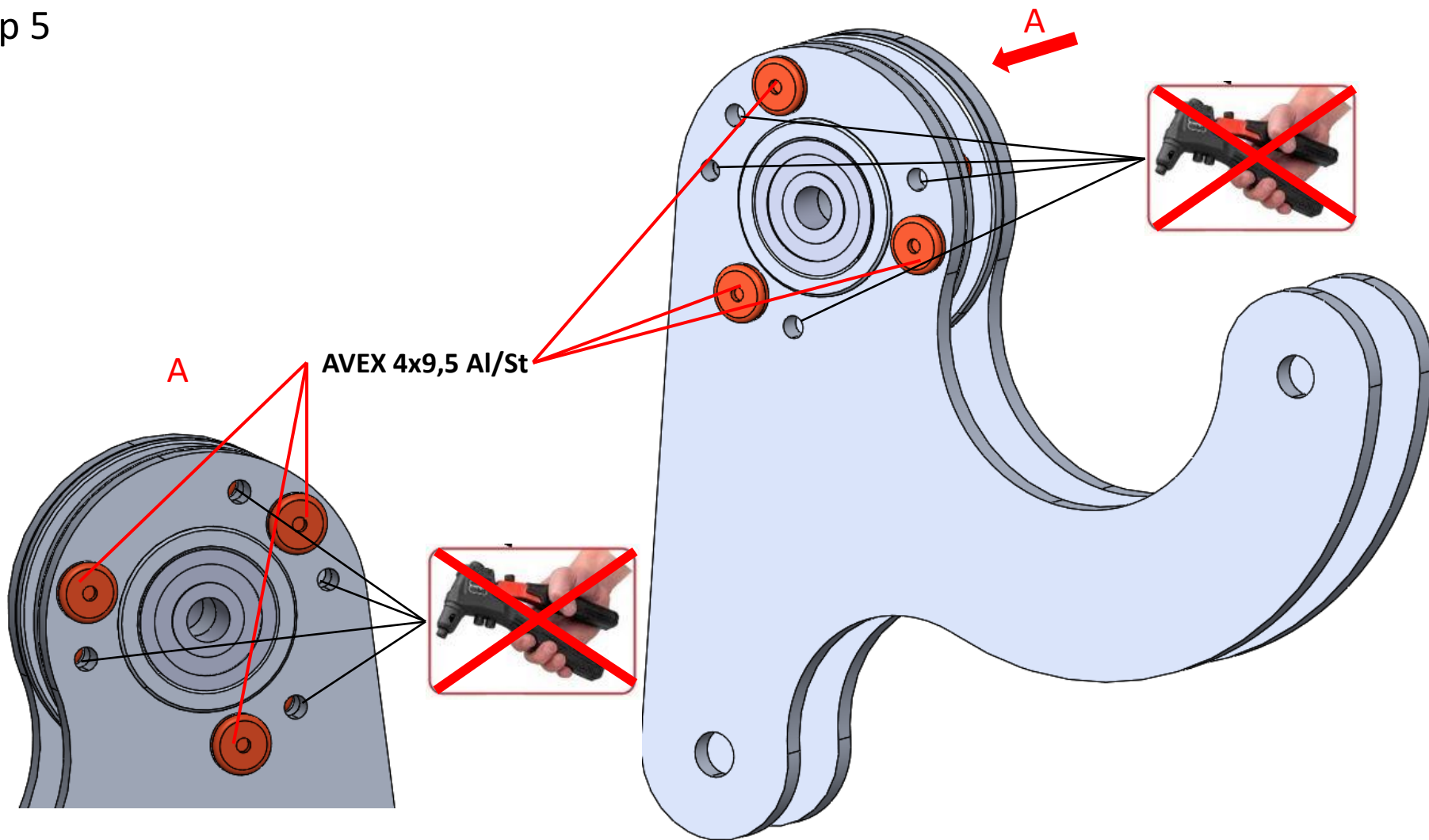
D2_R_11N



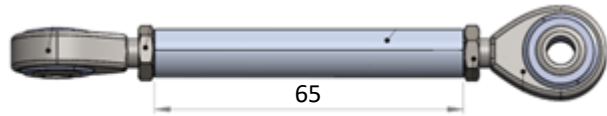
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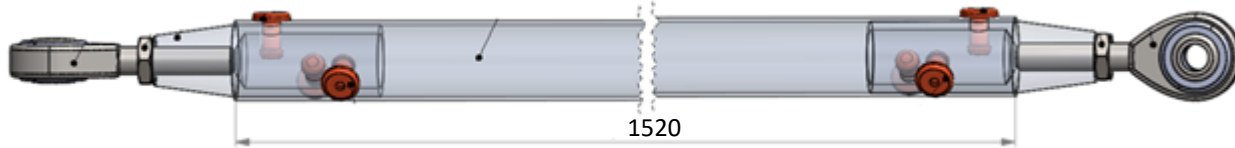
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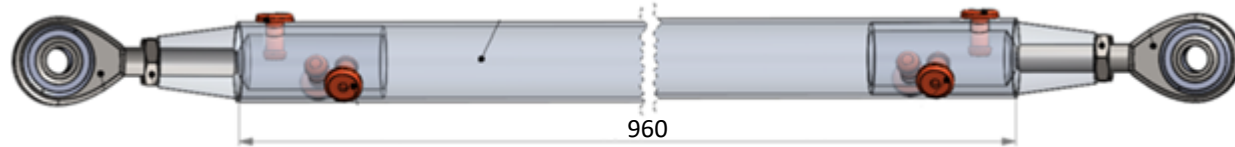
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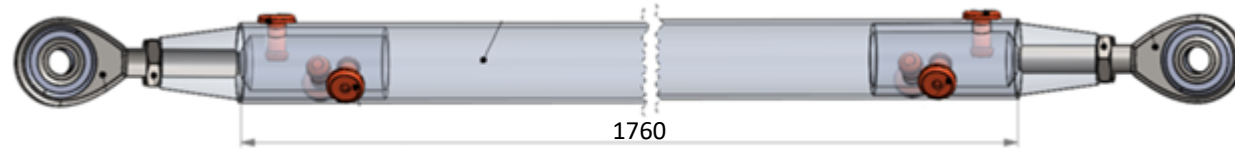
Aileron pushrod 1



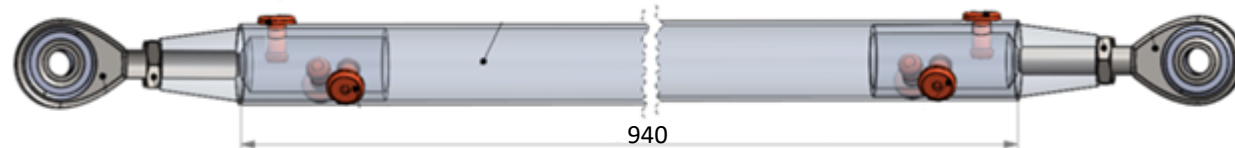
Aileron pushrod 2



Elevator pushrod 1



Elevator pushrod 2

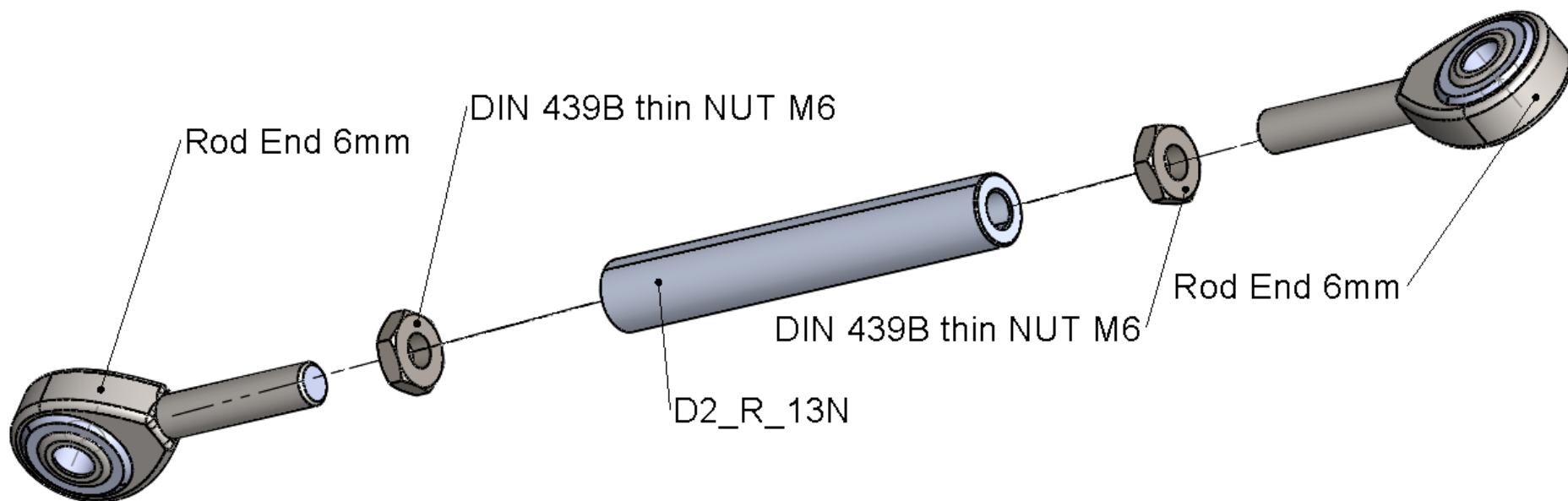


Elevator pushrod 3

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Aileron pushrod 1
Quantity: 2

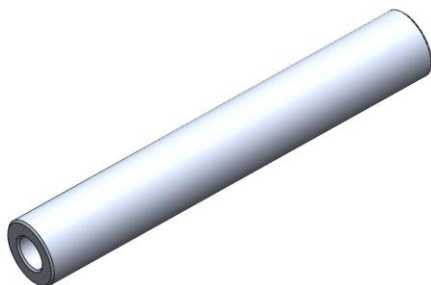


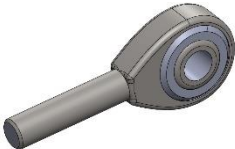
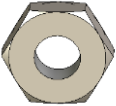
Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	42	114



Part: D2_R_13N

Quantity: 1+1

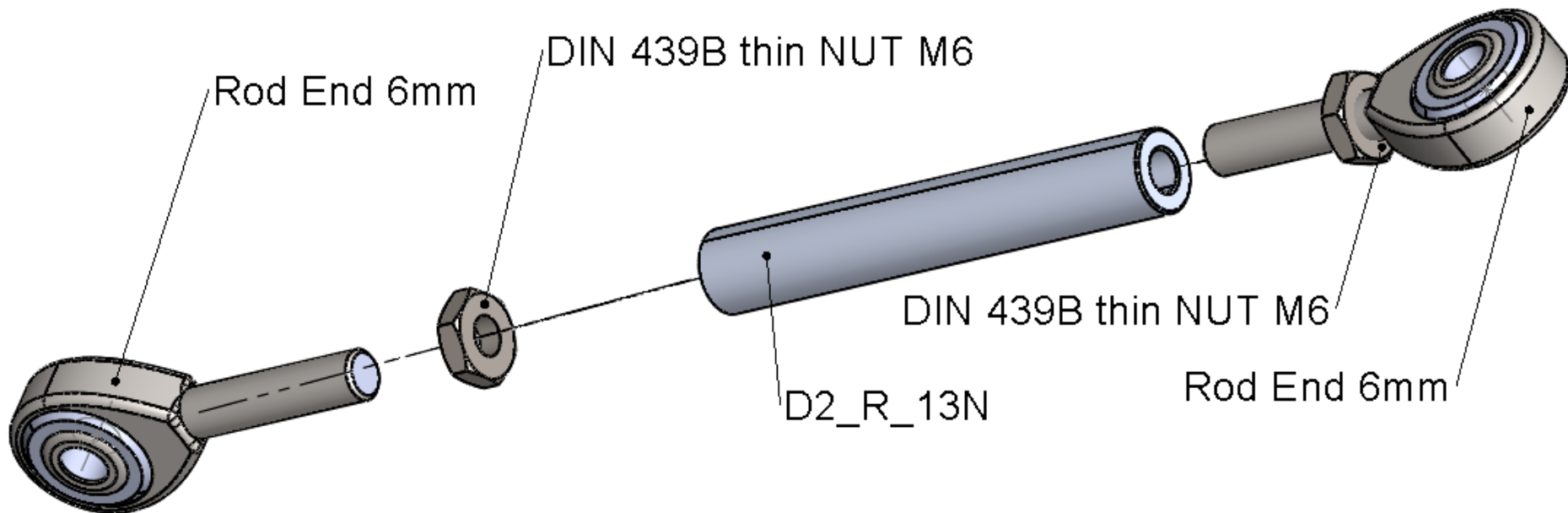


Standard Parts		
Detail picture	Part	Quantity
	MM4	2+2
	DIN 439B M6	2+2

Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	43	114



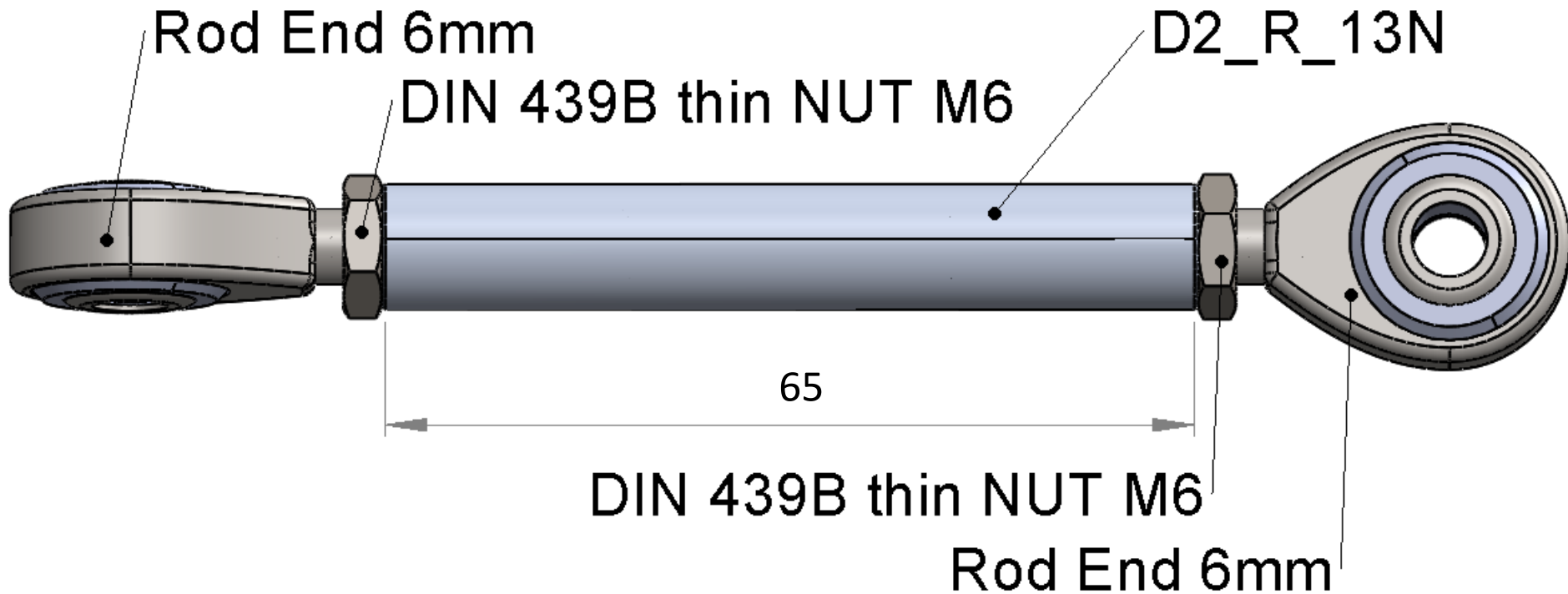
Step 1



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	44	114



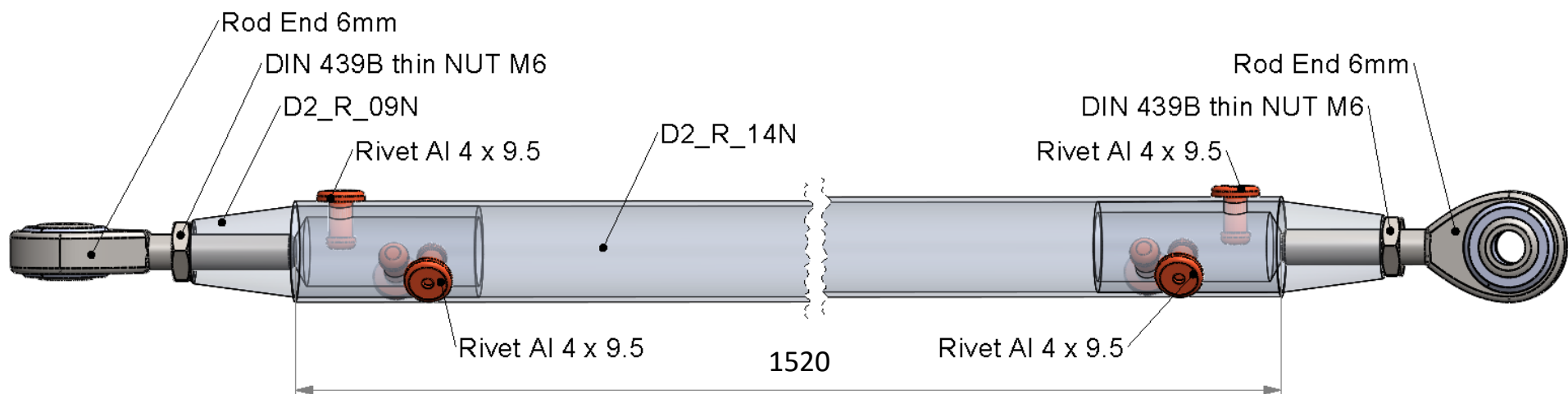
Step 2



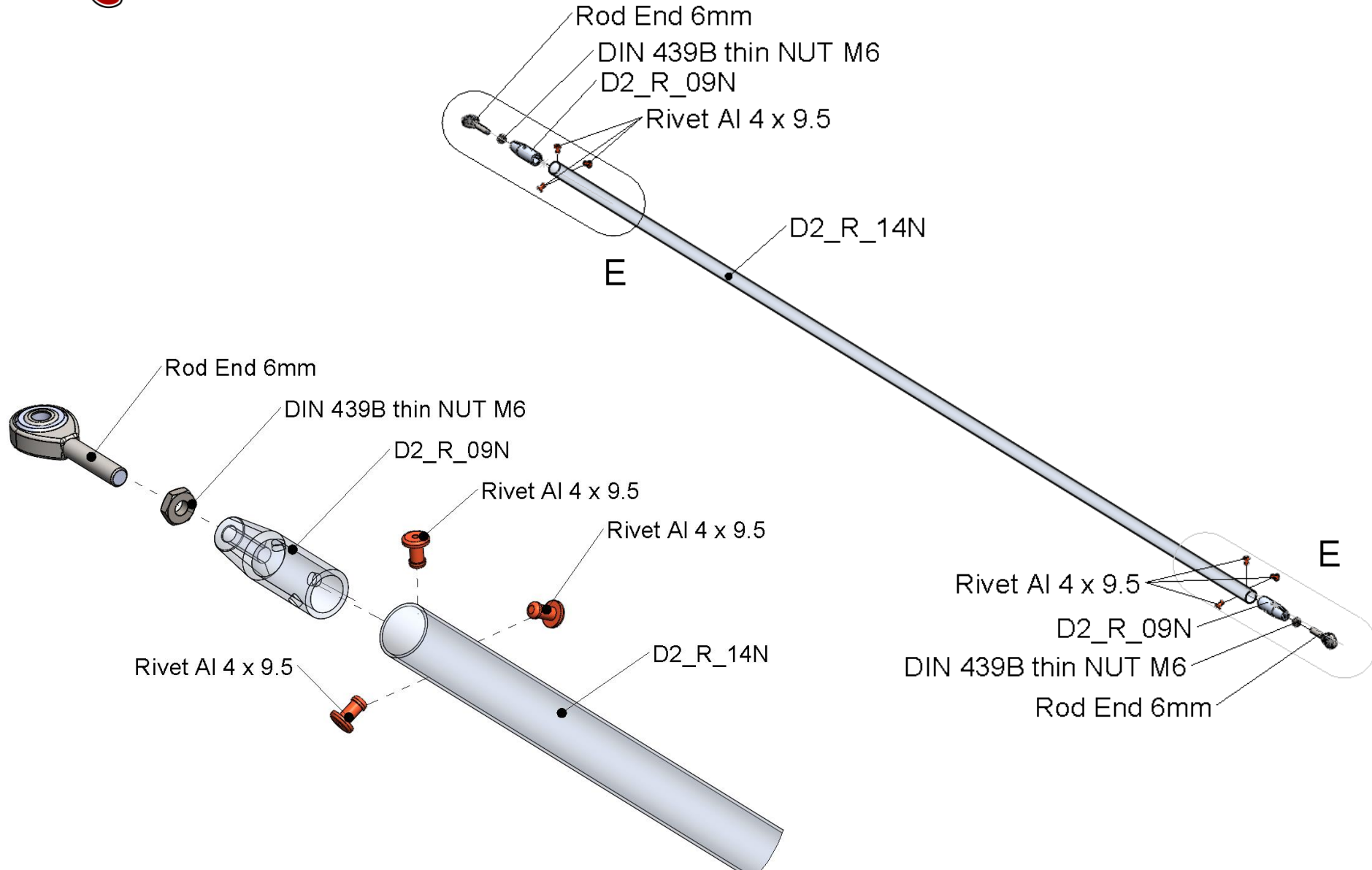
Title	Document no.	Revision	Page	Pages
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Aileron pushrod 2
Quantity: 2



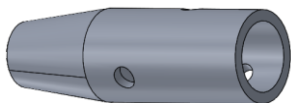
Title	Document no.	Revision	Page	Pages
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Title	Document no.	Revision	Page	Pages
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Part: D2_R_09N
Quantity: 2+2



Part: D2_R_14N
Quantity: 1+1

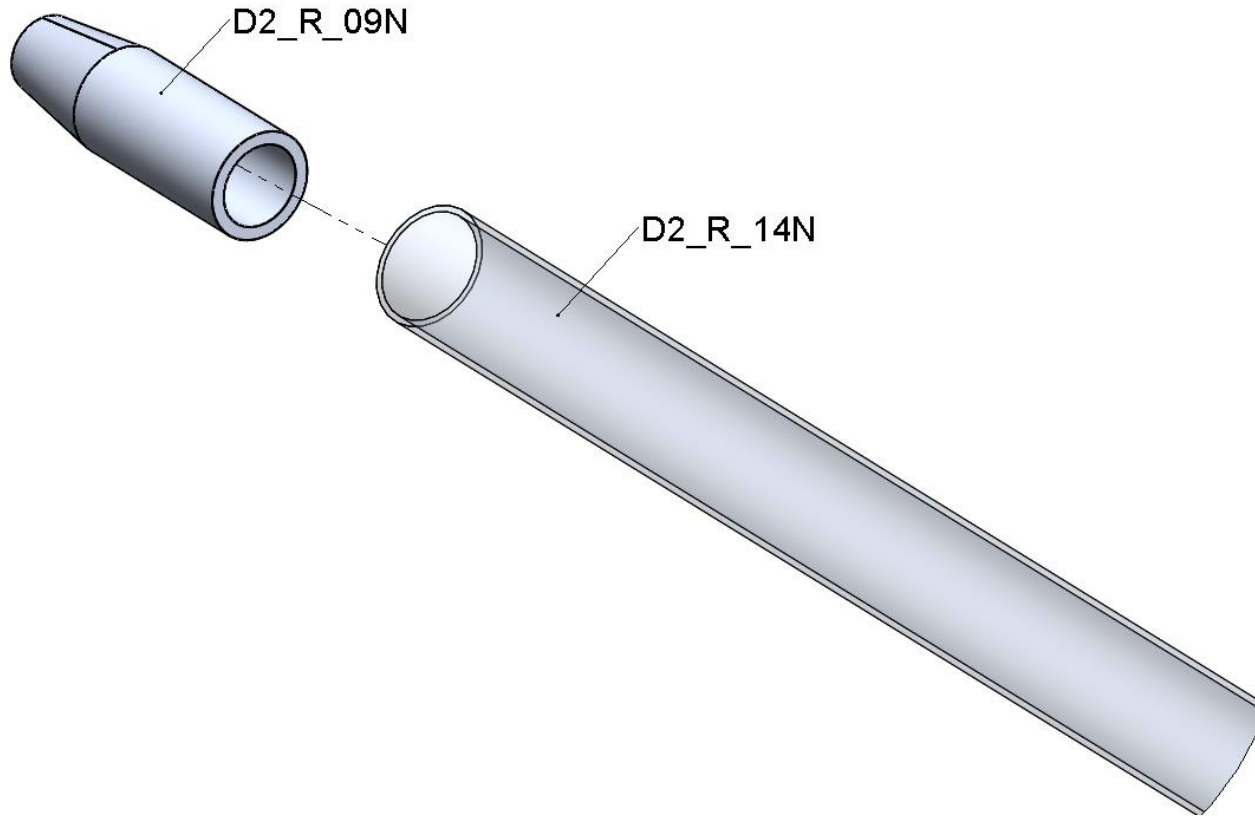


Standard Parts		
Detail picture	Part	Quantity
	MM4	2+2
	Blind rivets AVEX Ø 4x9,5 Al/St	6+6
	DIN 439B M6	2+2

Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	48	114



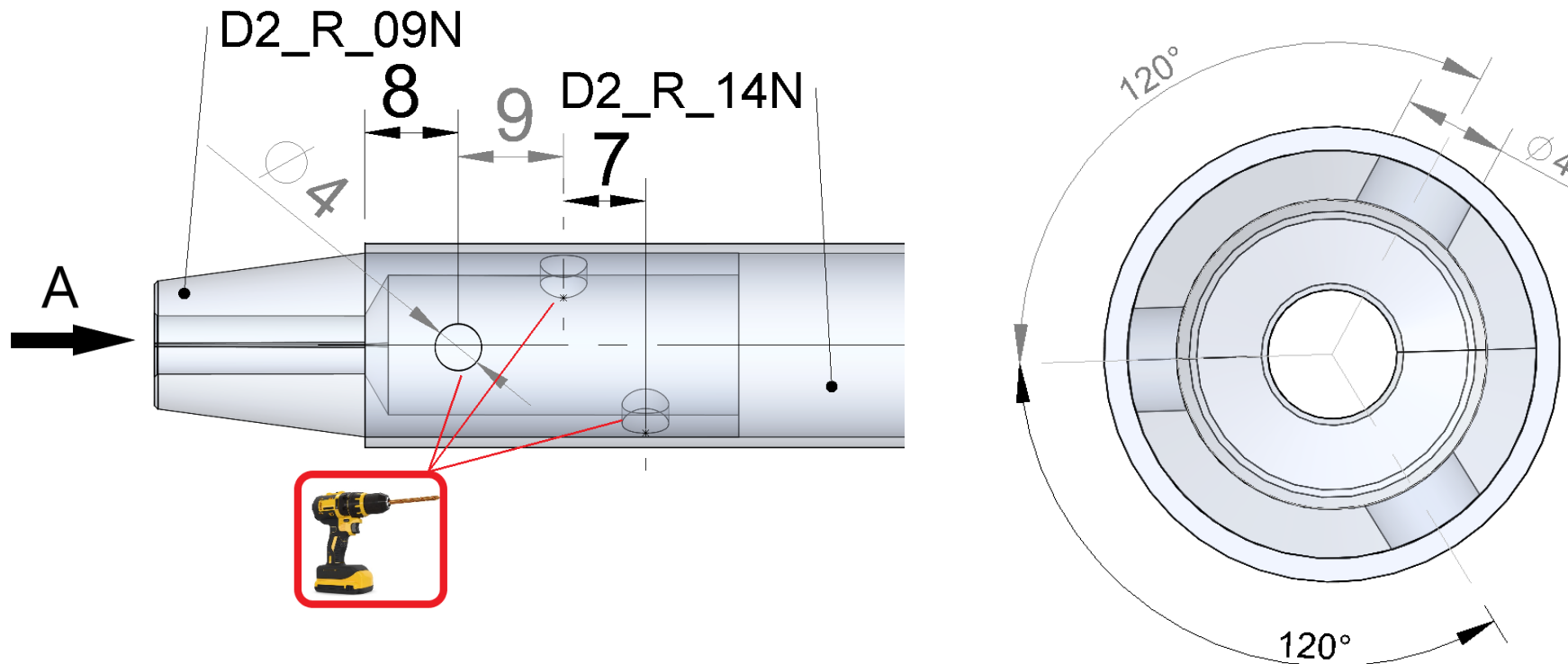
Step 1



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	49	114



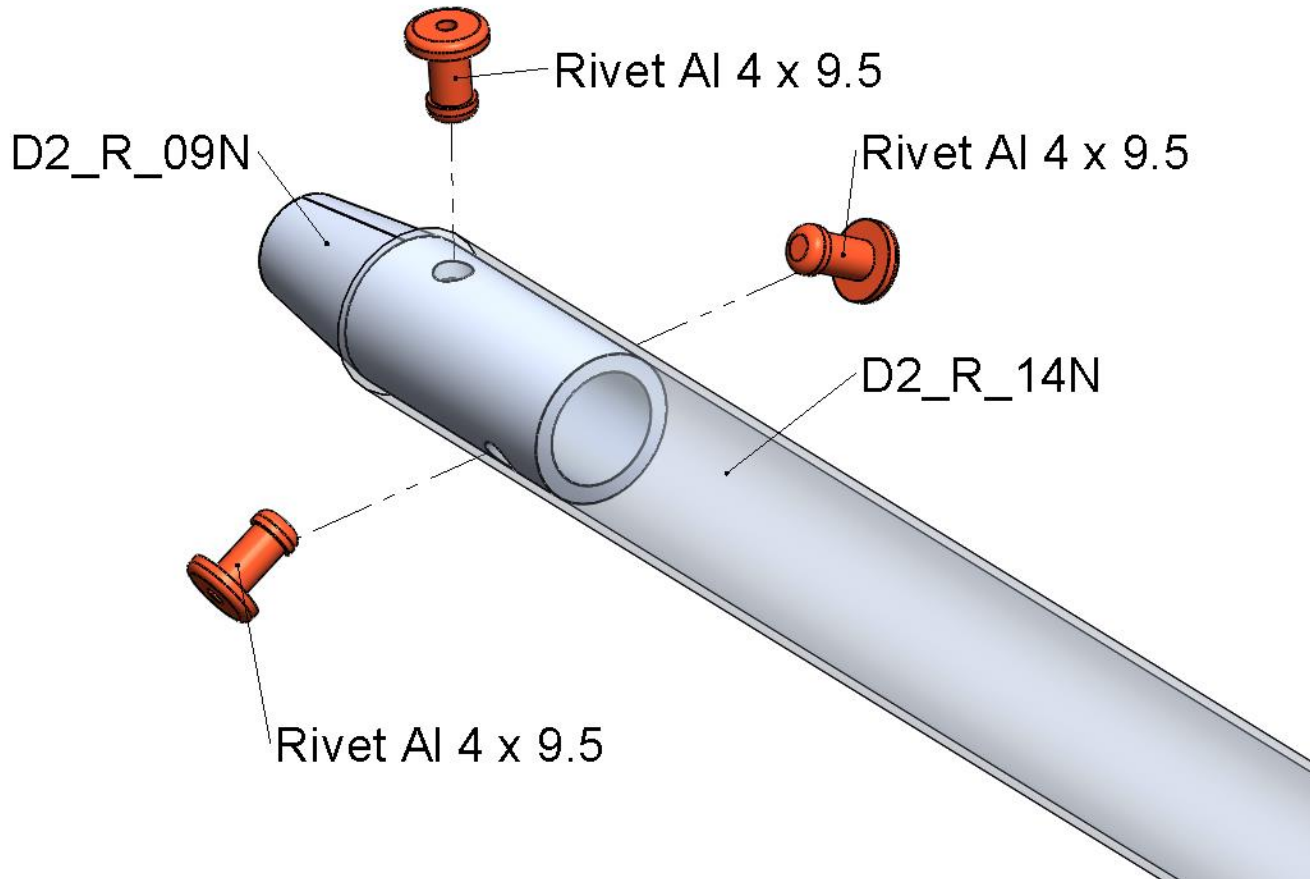
Step 2



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	50	114



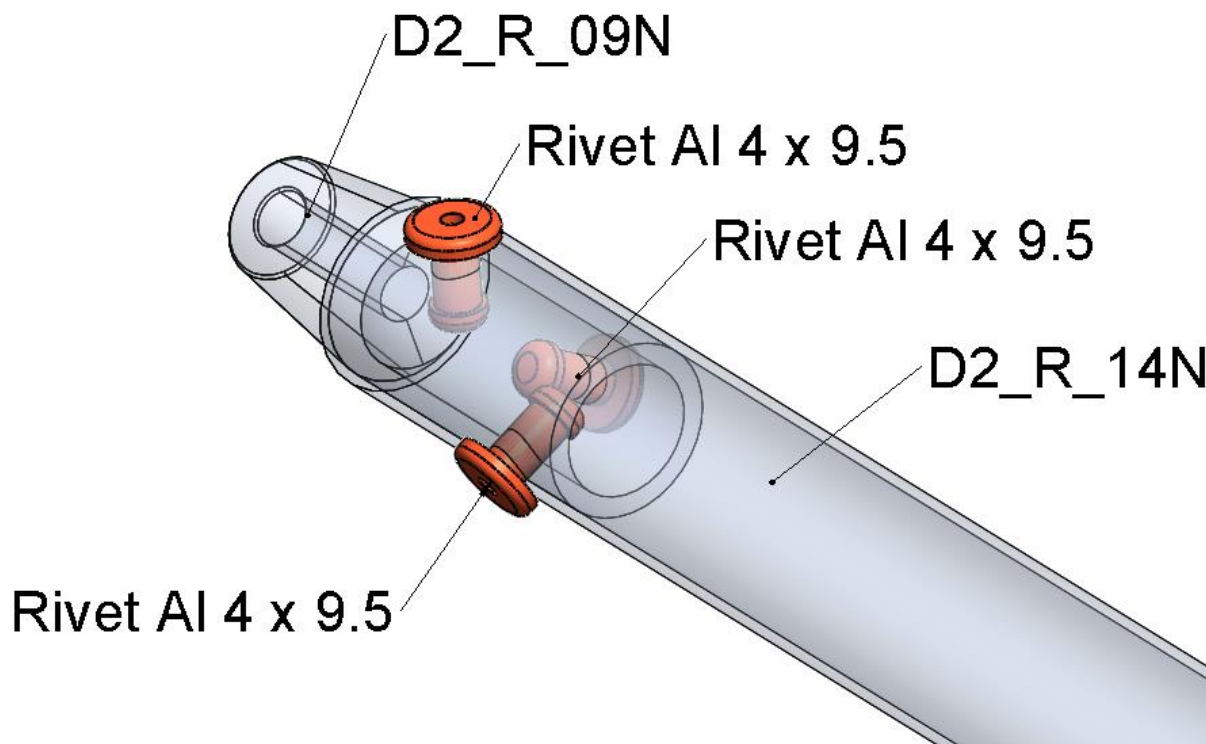
Step 3



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	51	114



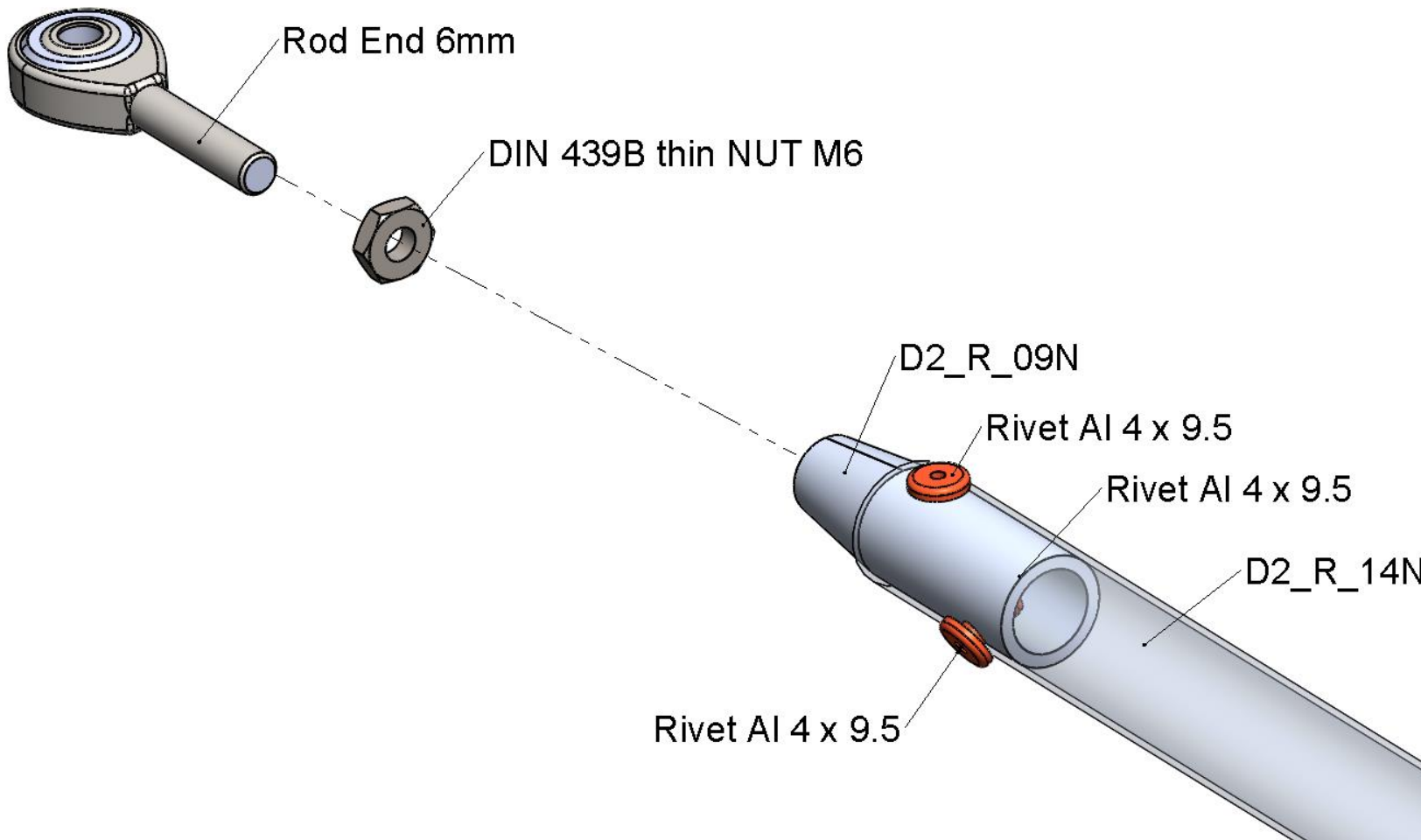
Step 4



Title	Document no.	Revision	Page	Pages
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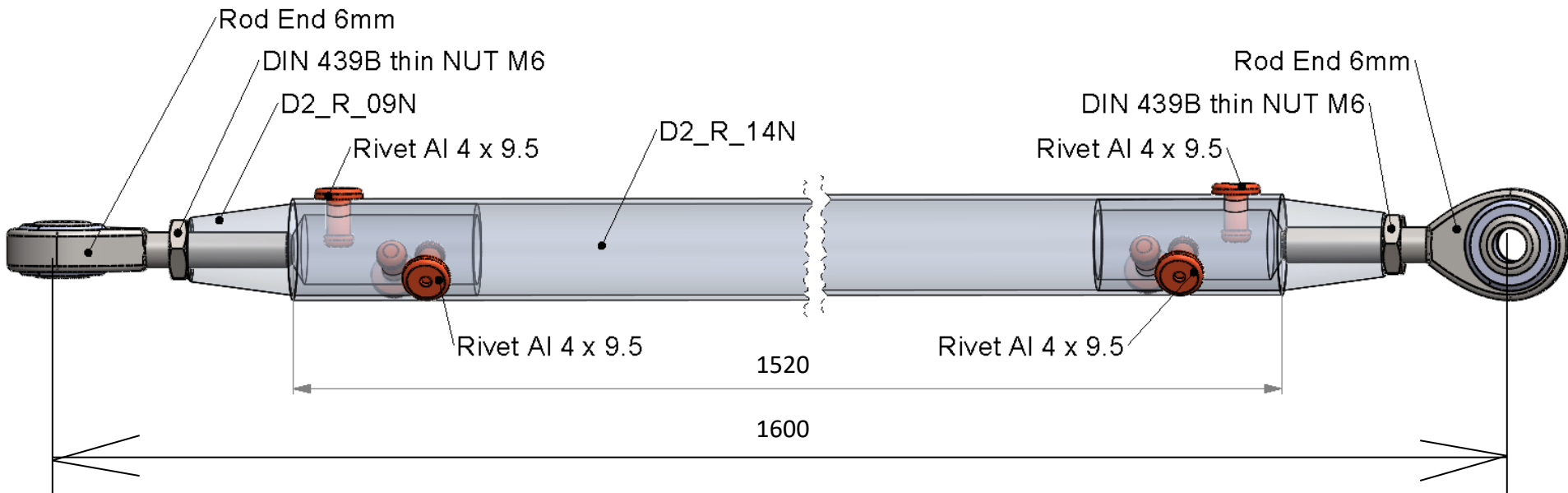
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Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	53	114



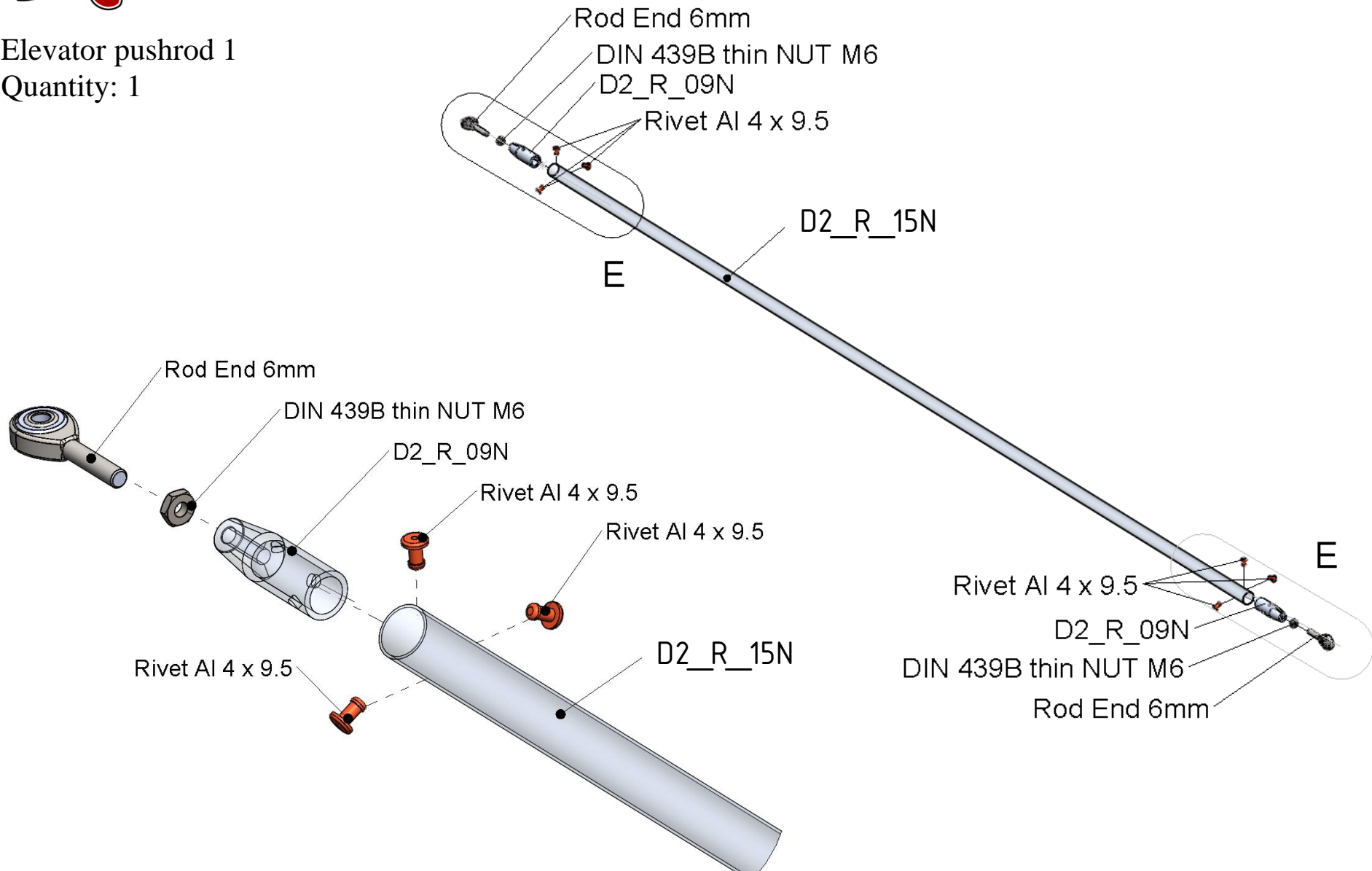
Step 6



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	54	114



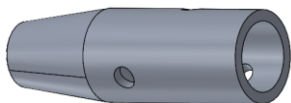
Elevator pushrod 1
Quantity: 1



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	55	114



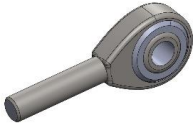


Part: D2_R_09N
Quantity: 2



Part: D2_R_15N
Quantity: 1

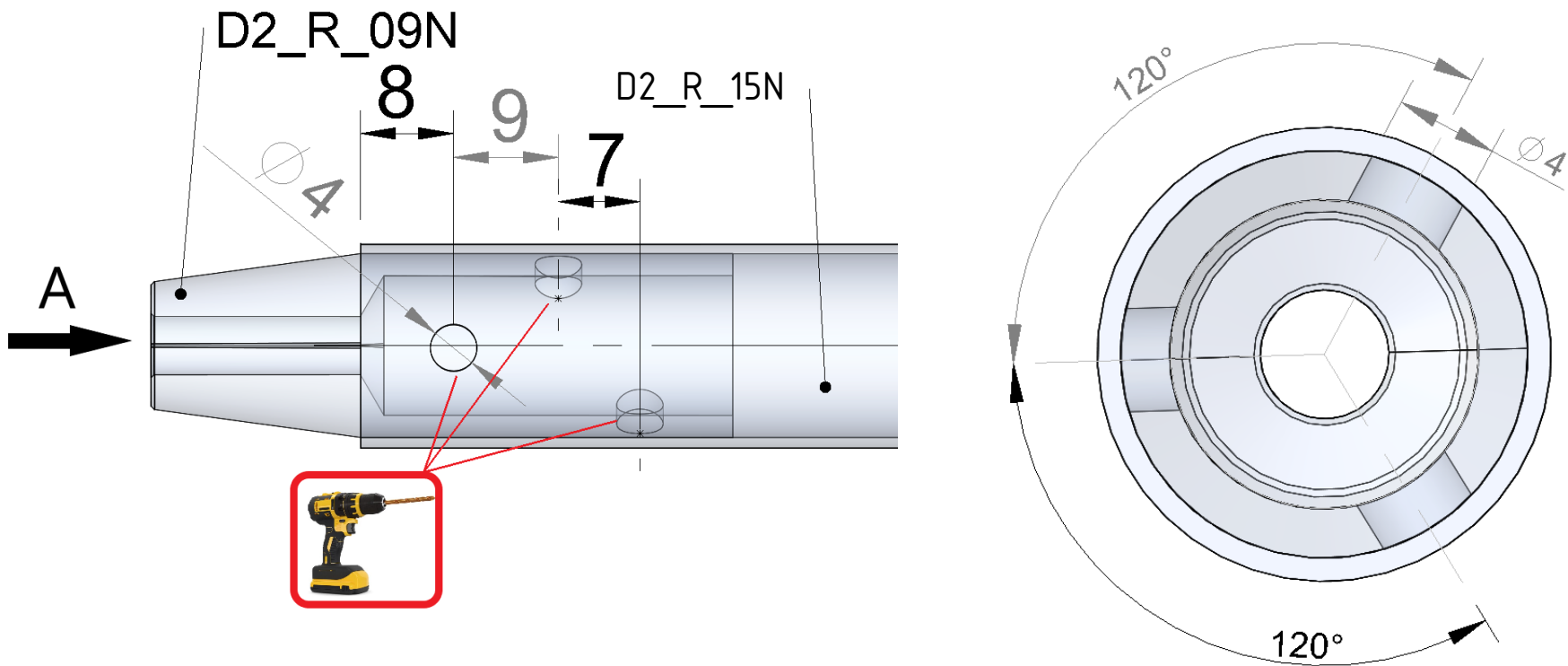


Standard Parts

Detail picture	Part	Quantity
	MM4	2
	Blind rivets AVEX Ø 4x9,5 Al/St	6
	DIN 439B M6	2

Title	Document no.	Revision	Page	Pages
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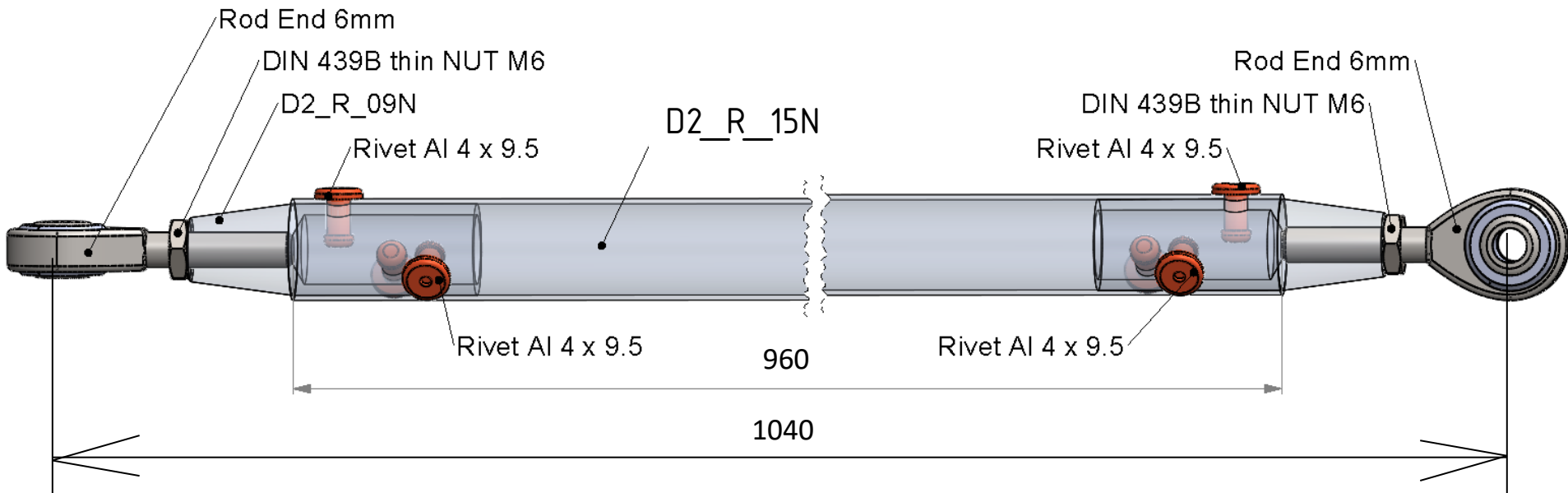
Step 1



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	57	114



Step 2

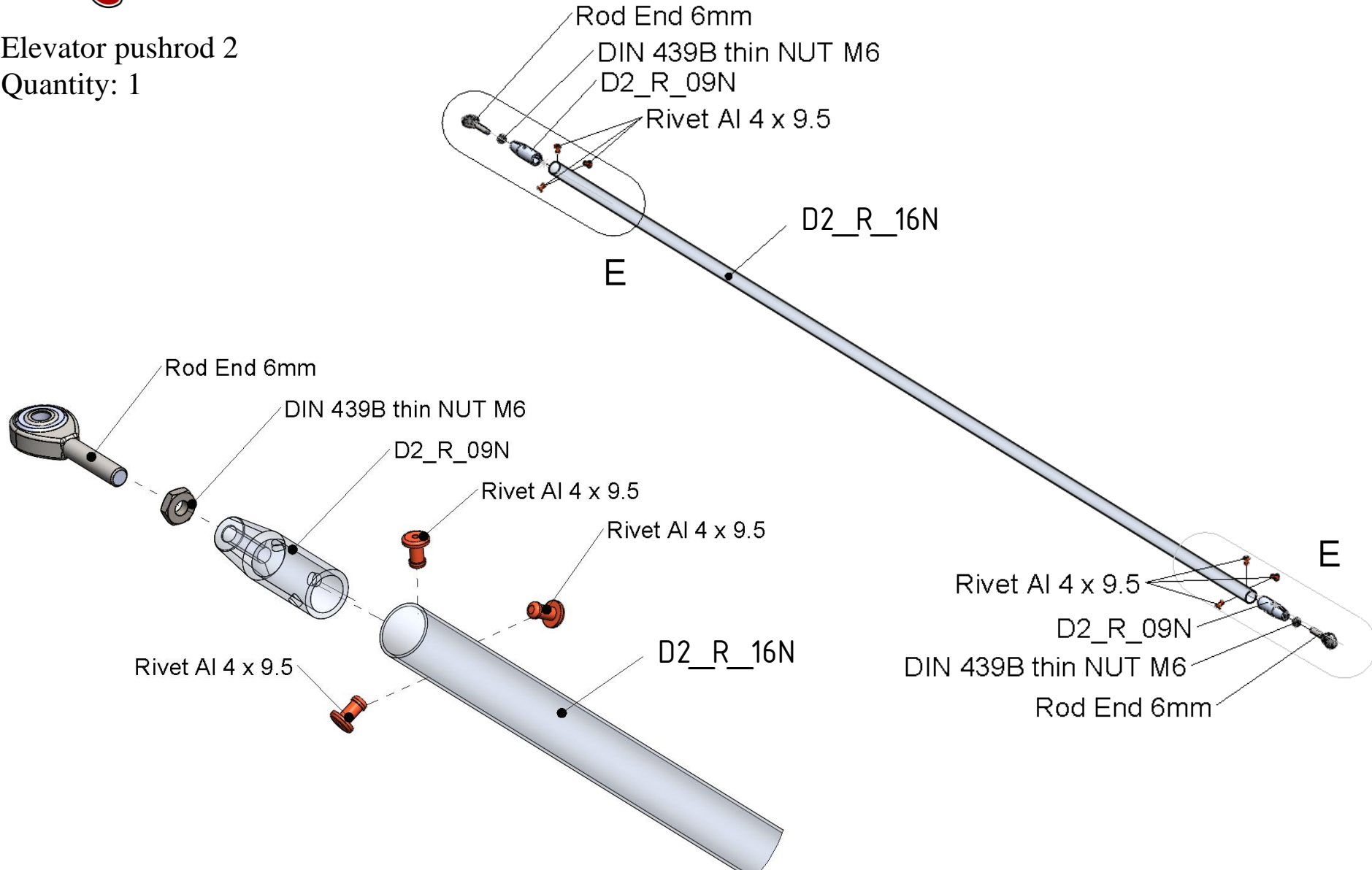


Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	58	114



Elevator pushrod 2

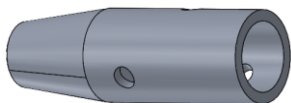
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Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	59	114



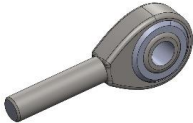


Part: D2_R_09N
Quantity: 2



Part: D2_R_16N
Quantity: 1



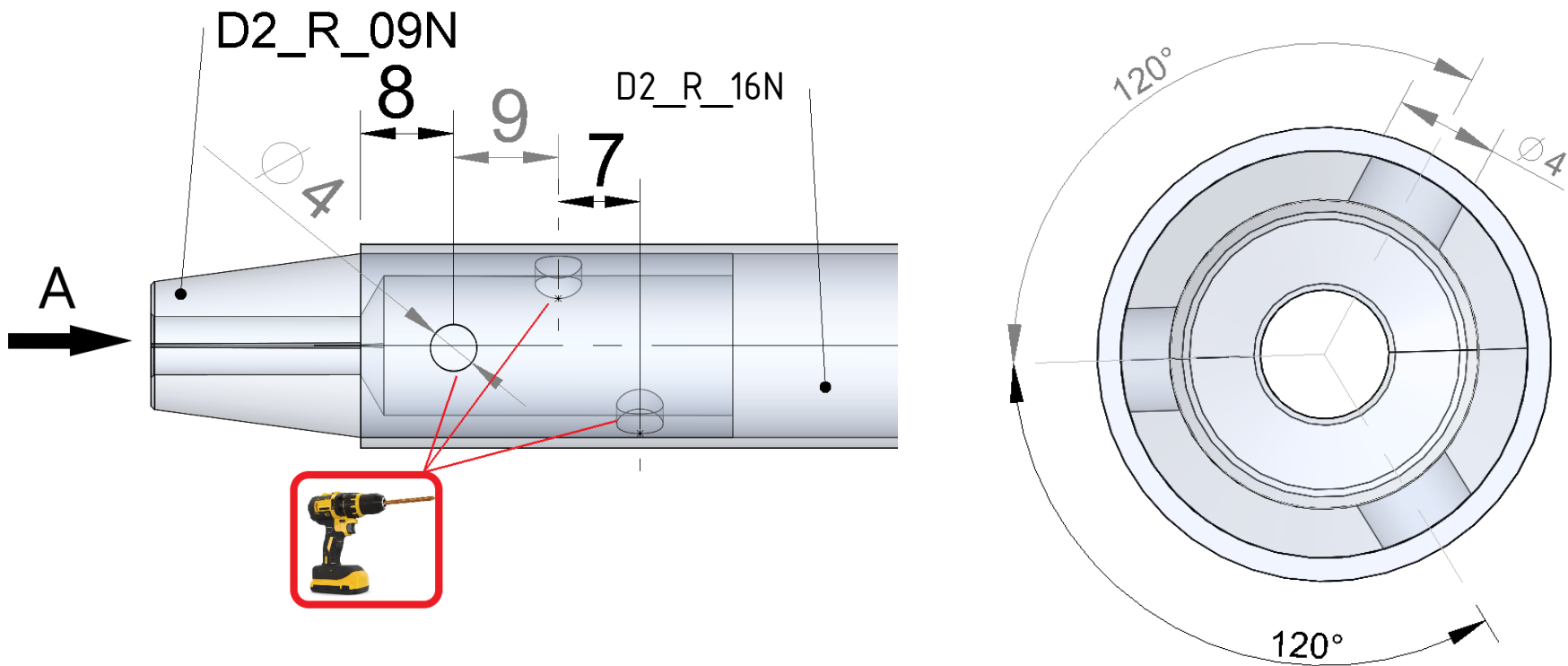
Standard Parts

Detail picture	Part	Quantity
	MM4	2
	Blind rivets AVEX Ø 4x9,5 Al/St	6
	DIN 439B M6	2

Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	60	114



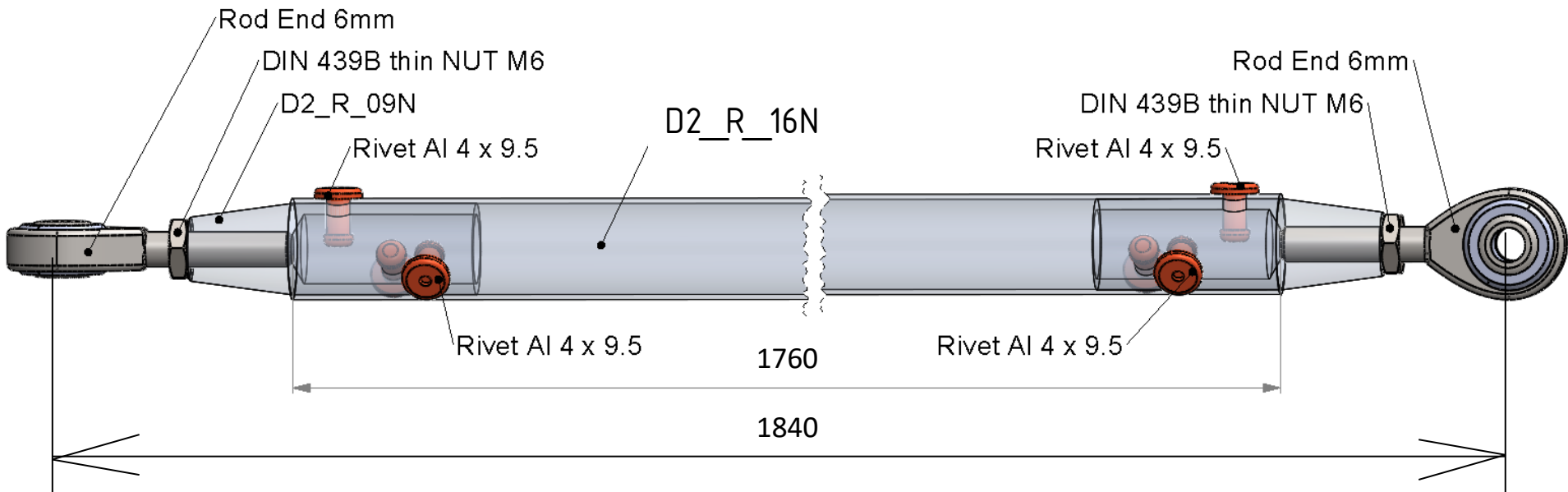
Step 1



Title	Document no.	Revision	Page	Pages
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Step 2

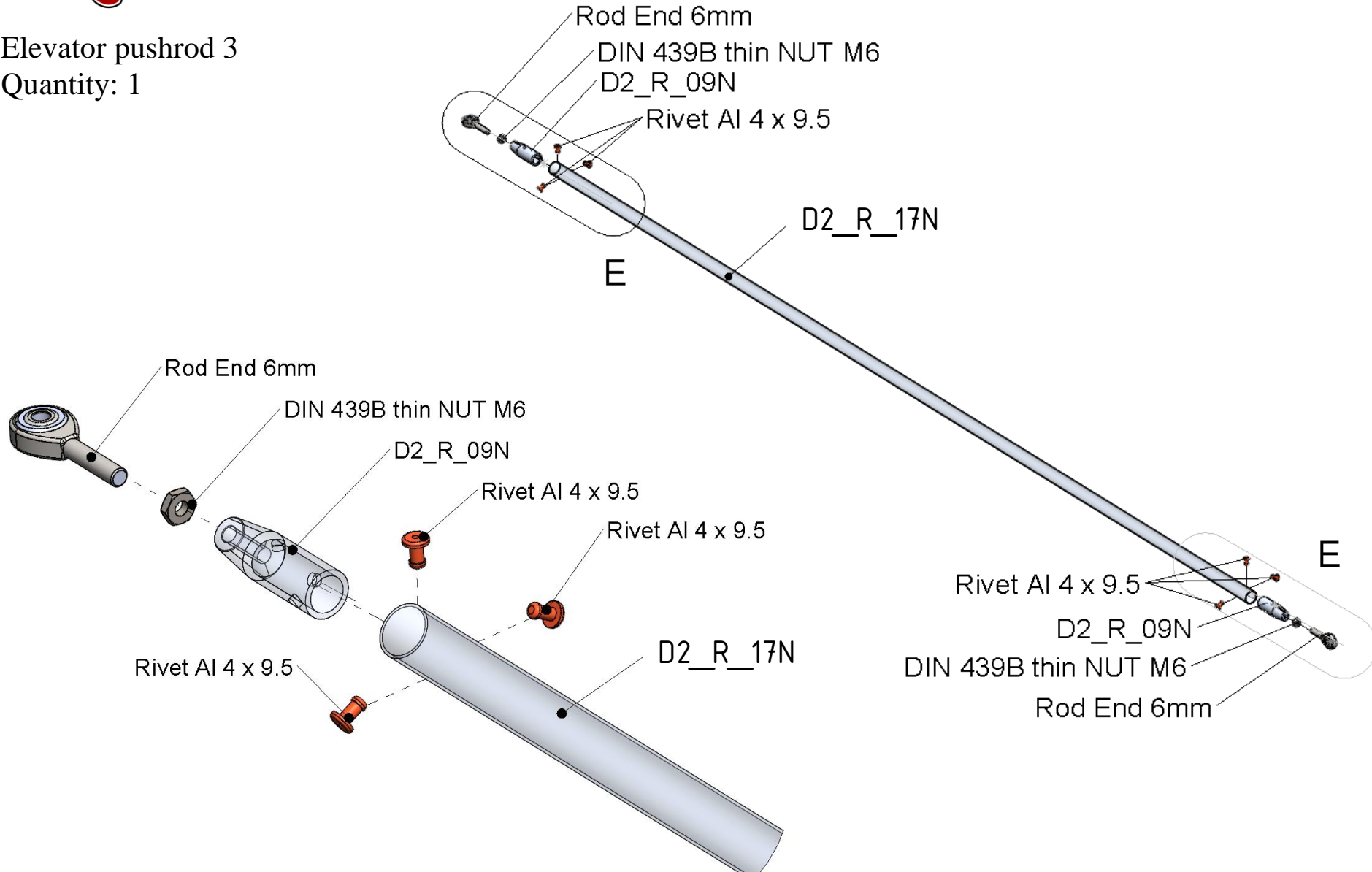


Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	62	114



Elevator pushrod 3

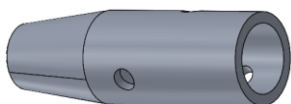
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Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	63	114



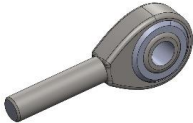


Part: D2_R_09N
Quantity: 2



Part: D2_R_17N
Quantity: 1



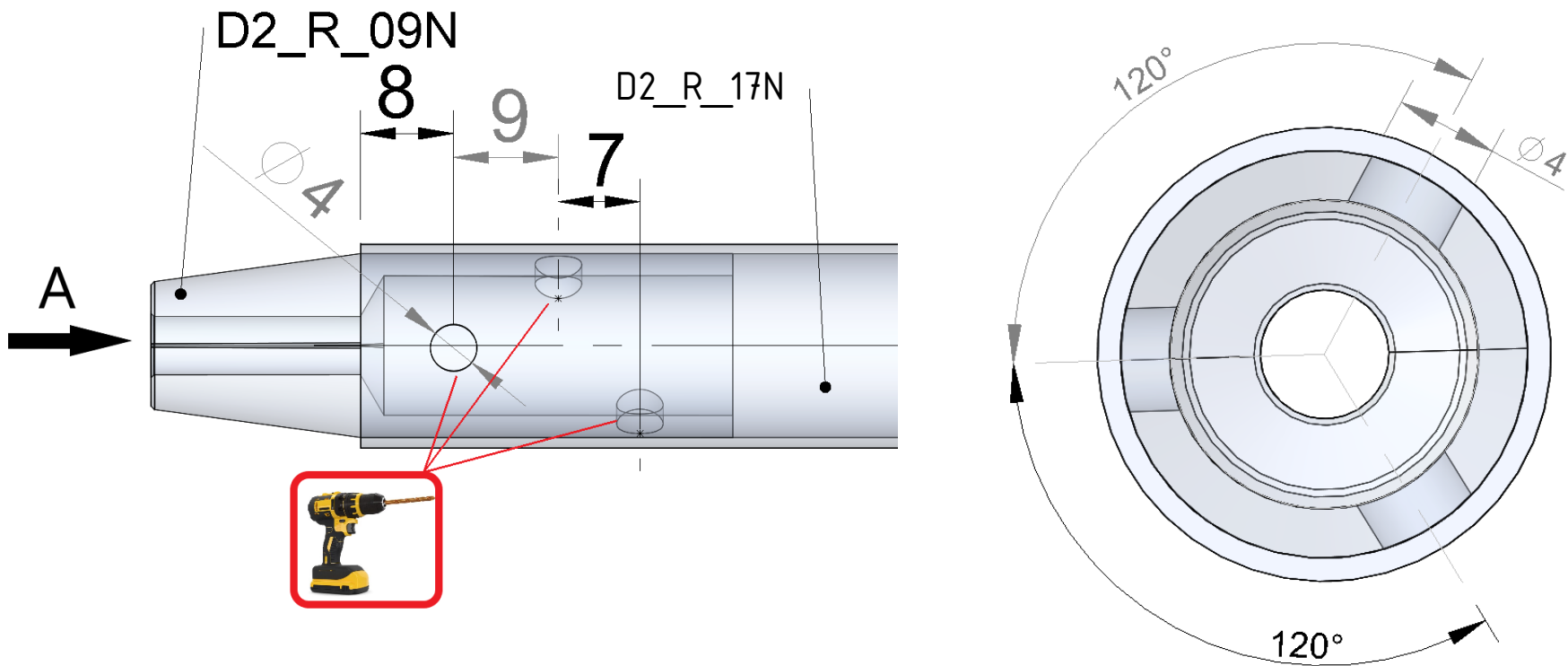
Standard Parts

Detail picture	Part	Quantity
	MM4	2
	Blind rivets AVEX Ø 4x9,5 Al/St	6
	DIN 439B M6	2

Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	64	114



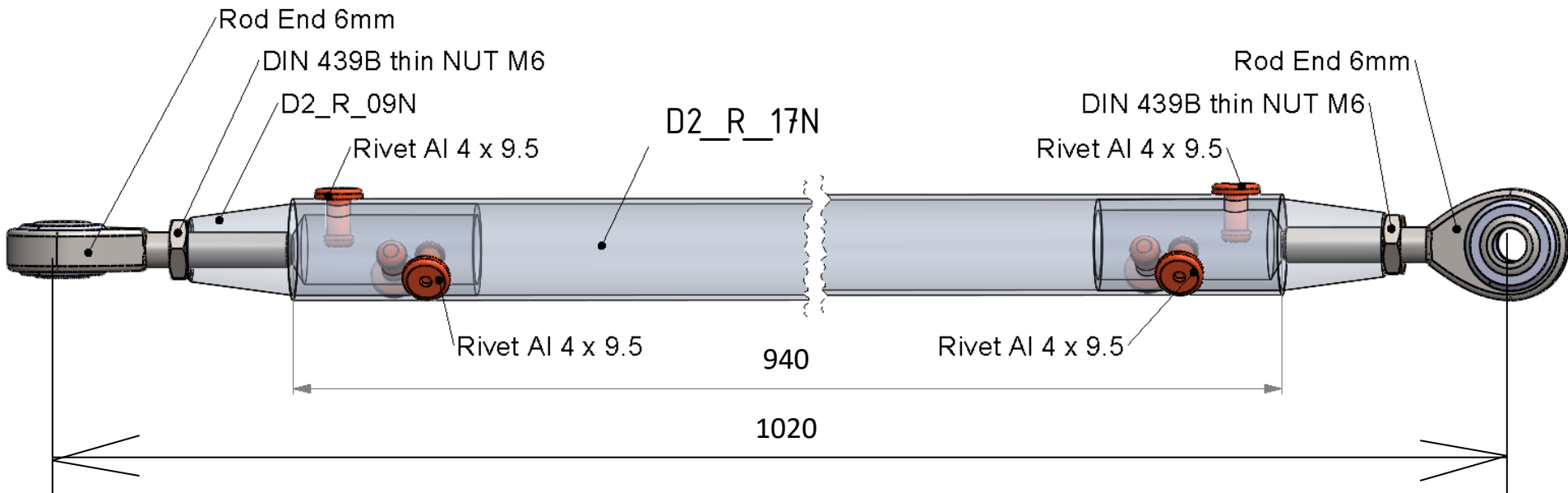
Step 1



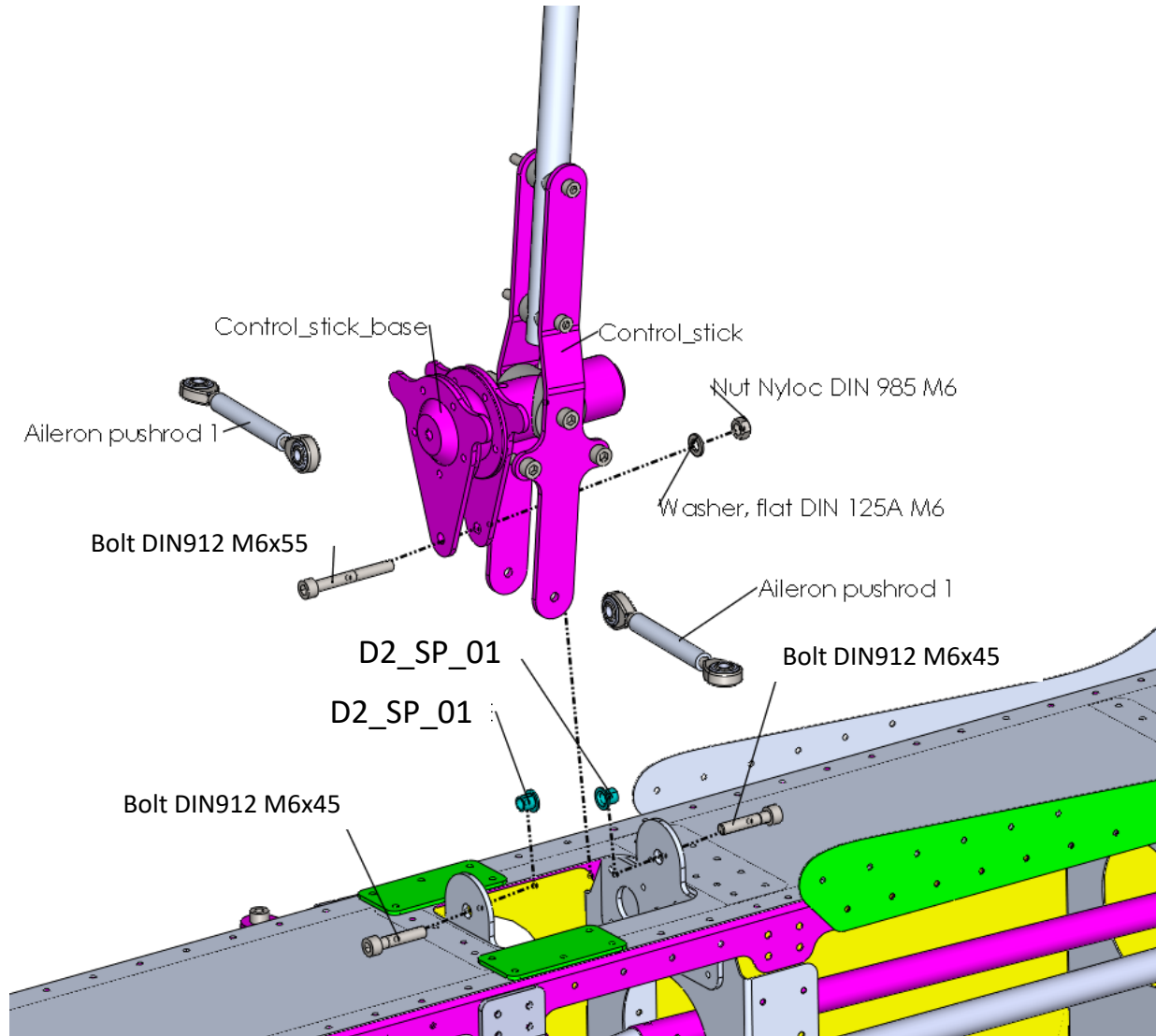
Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	65	114



Step 2



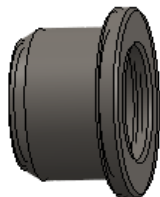
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Control system assembly manual	D2_R0_00	Rev. 06	66	114







Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	67	114



D2_SP_01
2 pcs

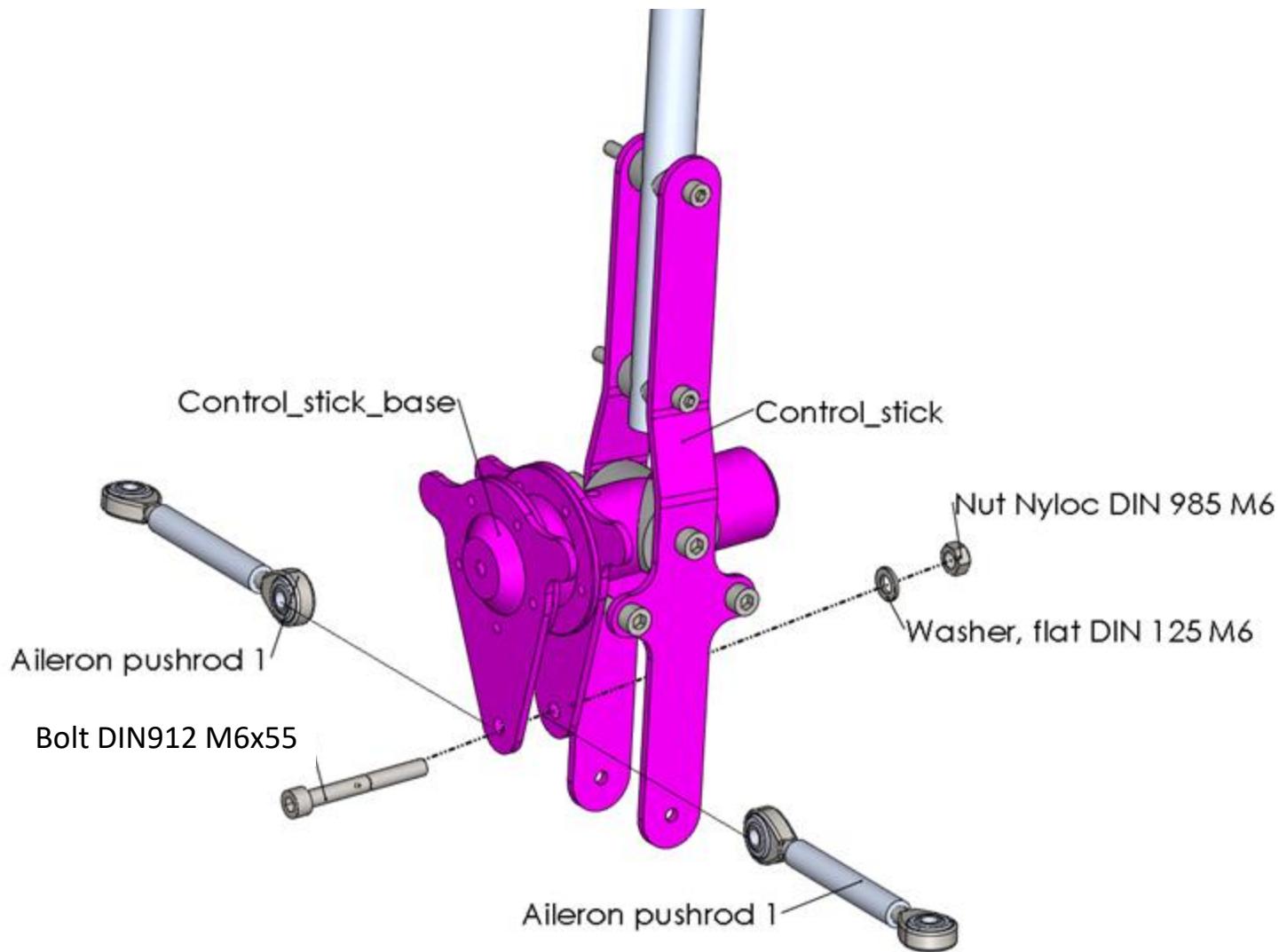


Standard Parts		
Detail picture	Part	Quantity
	Bolt DIN 912 M6x55	1
	Nut Nyloc DIN 985 M6	1
	Washer, flat DIN 125 M6	1
	Bolt DIN 912 M6x45	2

Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	68	114



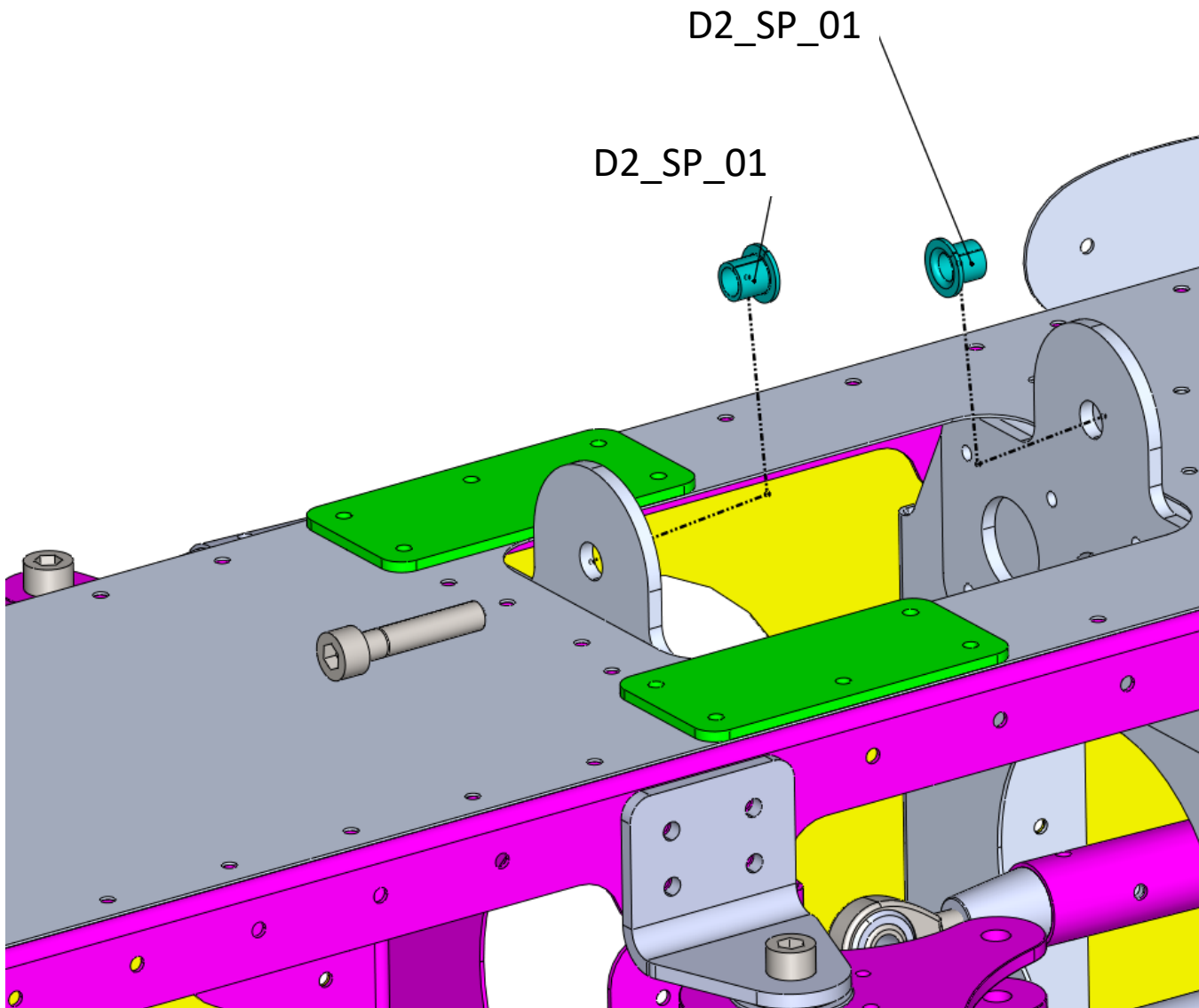
Step 1



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Control system assembly manual	D2_R0_00	Rev. 06	69	114



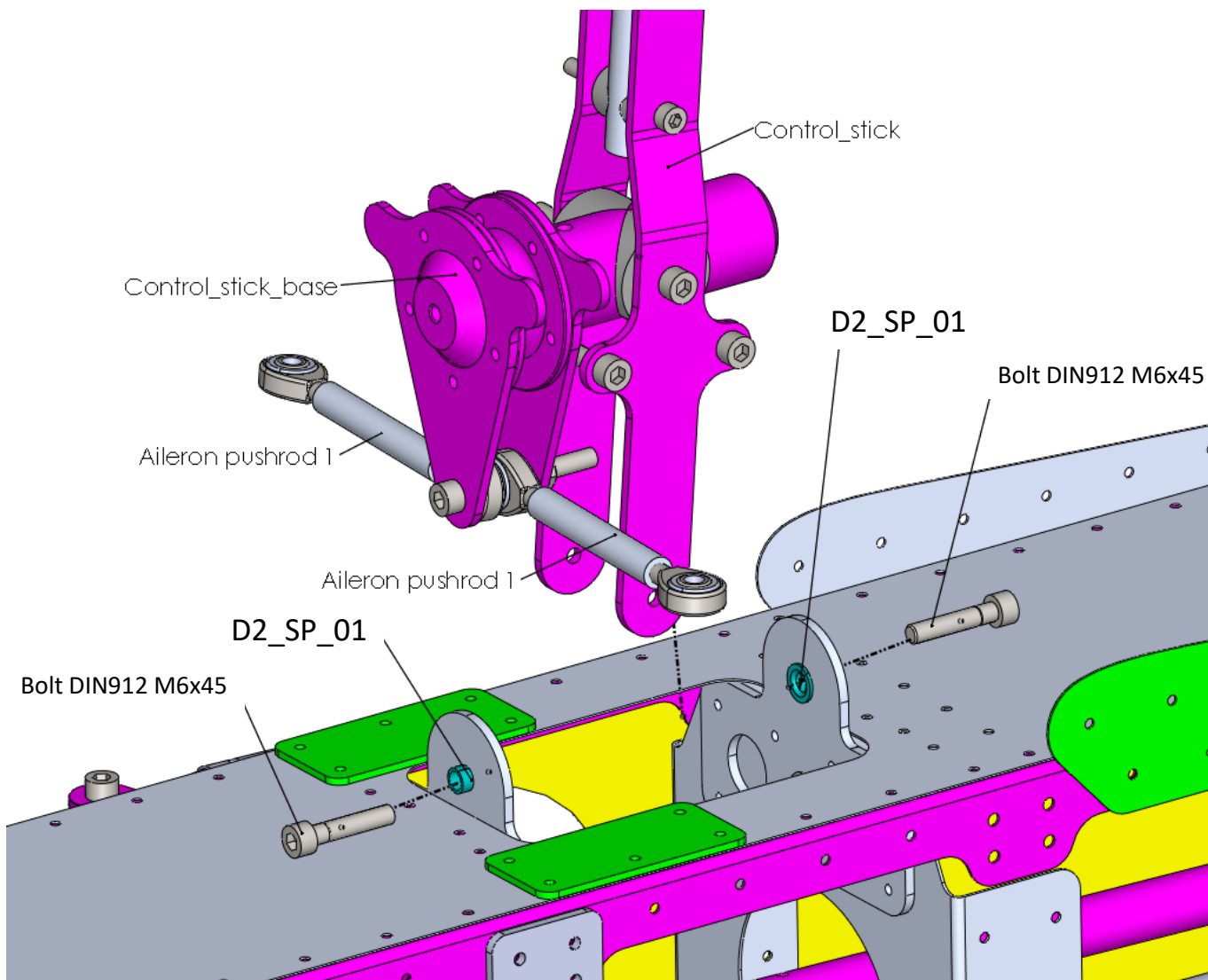
Step 2



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Control system assembly manual	D2_R0_00	Rev. 06	70	114



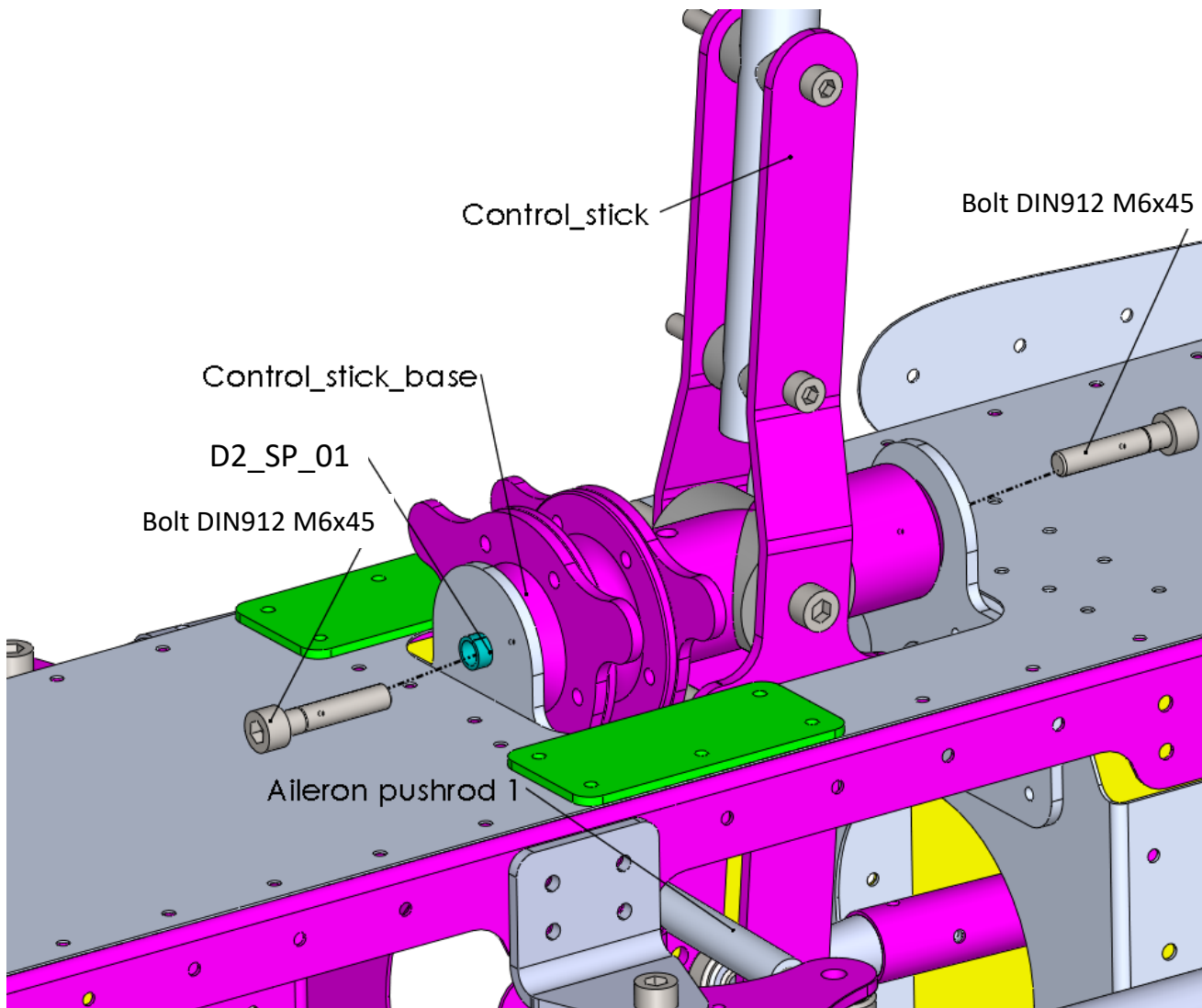
Step 3



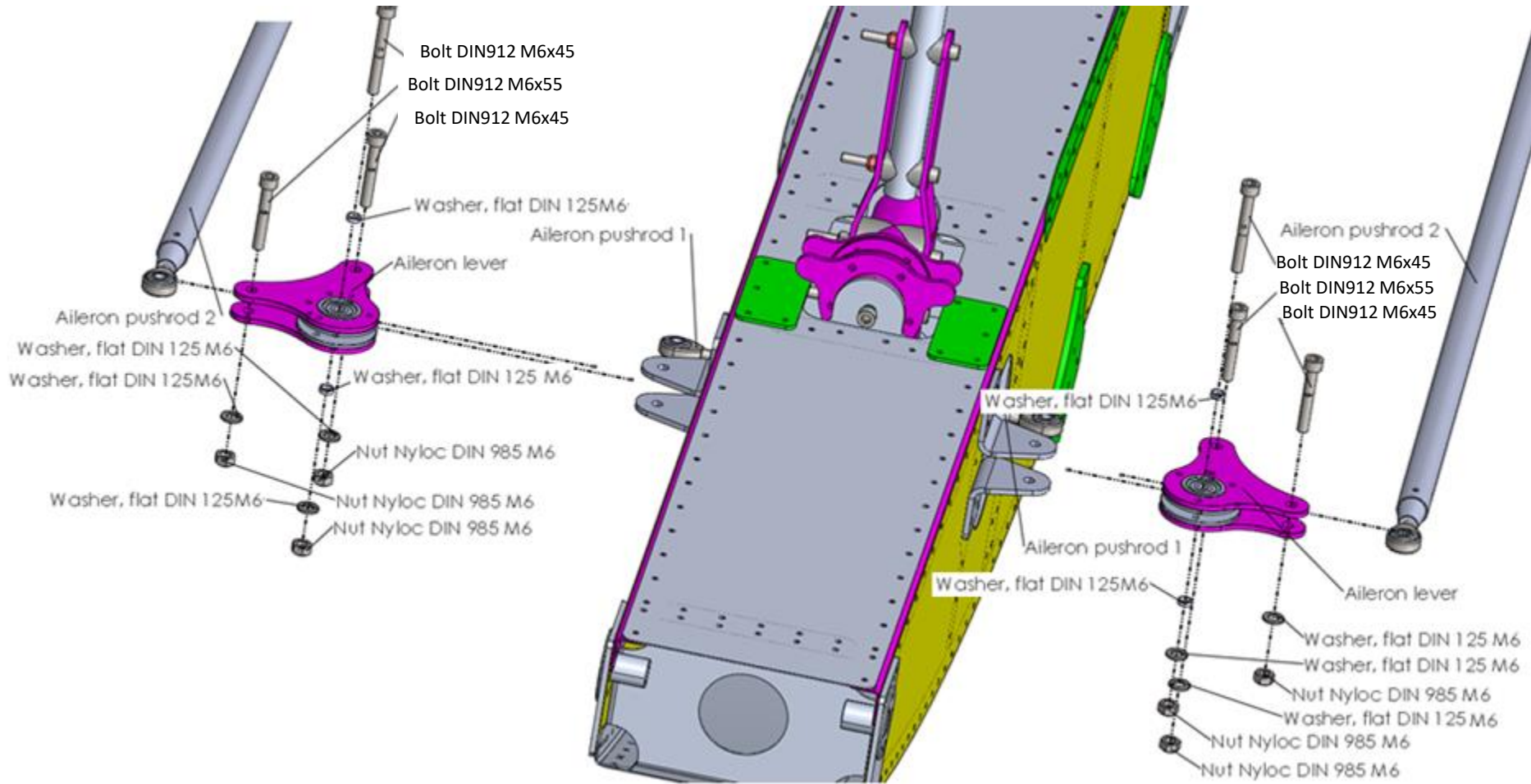
Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	71	114



Step 4







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Control system assembly manual	D2_R0_00	Rev. 06	72	114



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	73	114

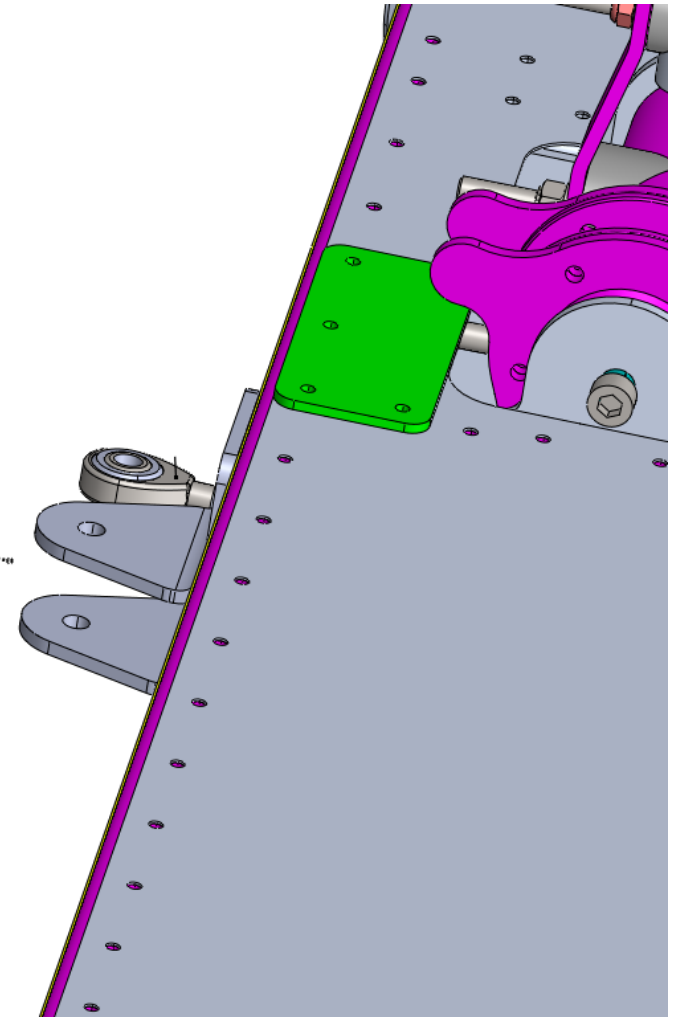
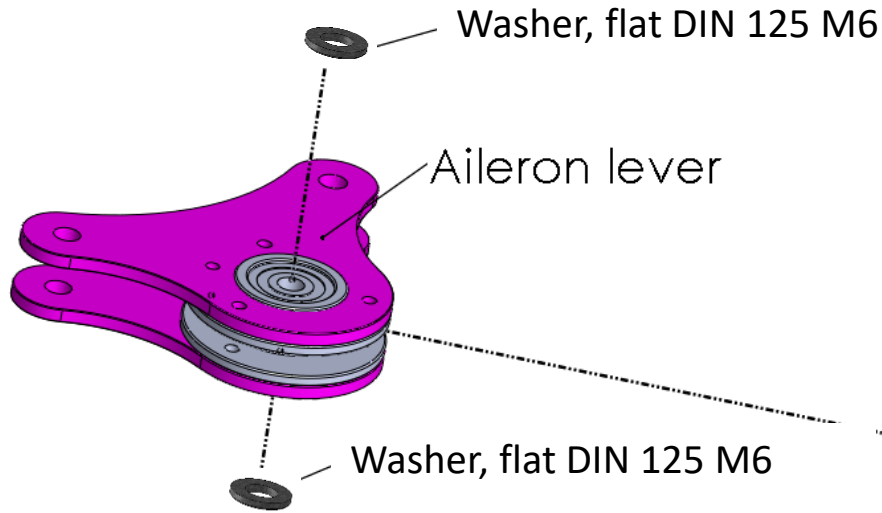


Standard Parts		
Detail picture	Part	Quantity
	Bolt DIN 912 M6x55	2
	Bolt DIN 912 M6x45	4
	Nut Nyloc DIN 985 M6	6
	Washer, flat DIN 125A M6	10

Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	74	114



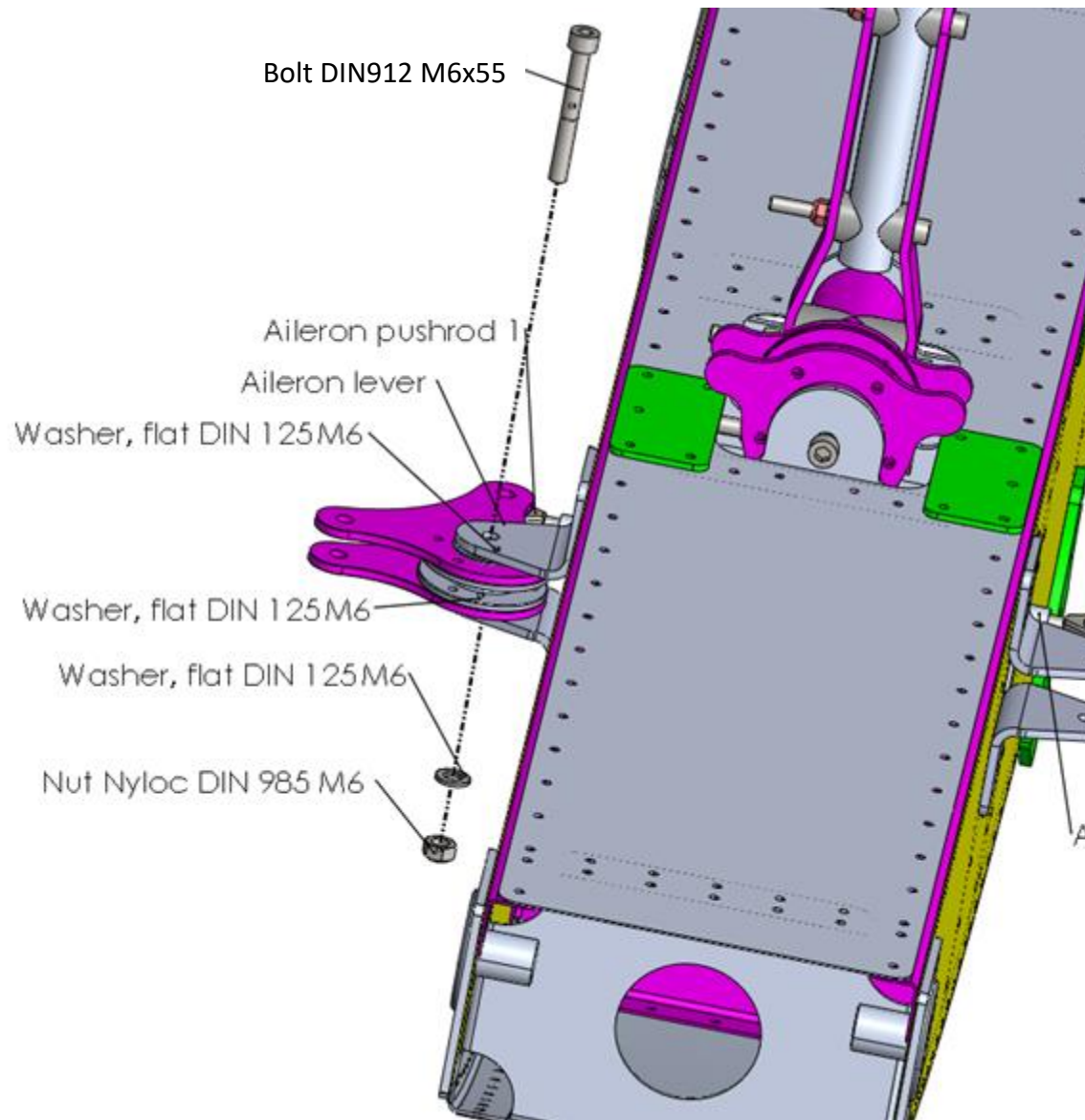
Step 1



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Control system assembly manual	D2_R0_00	Rev. 06	75	114



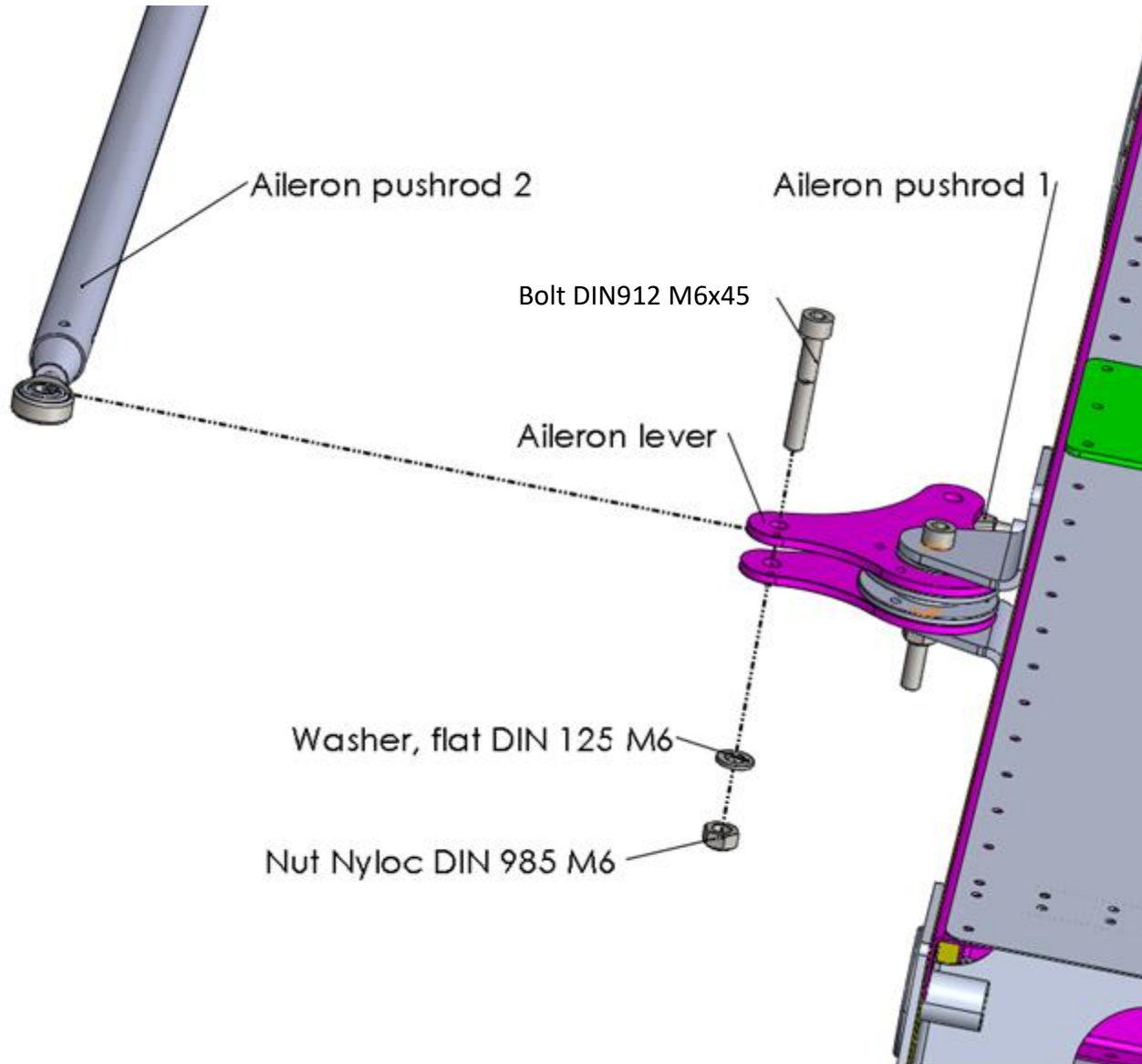
Step 2



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Control system assembly manual	D2_R0_00	Rev. 06	76	114



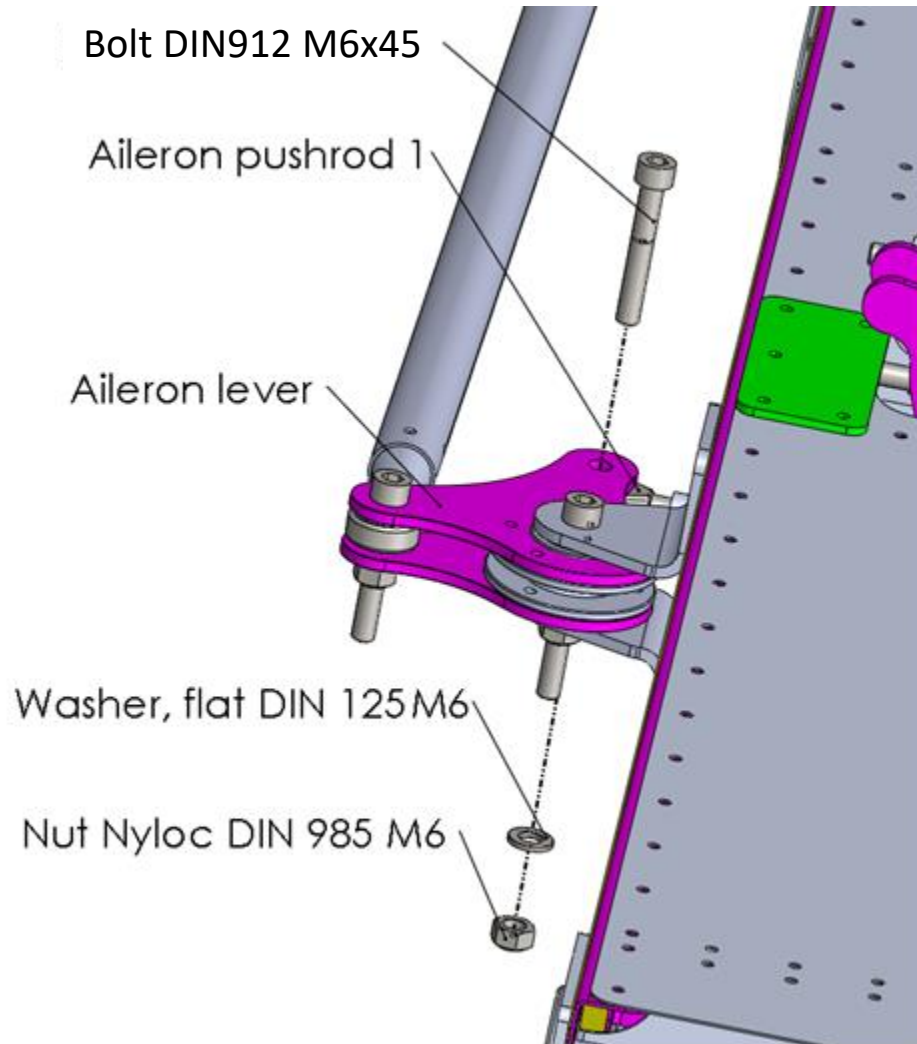
Step 3



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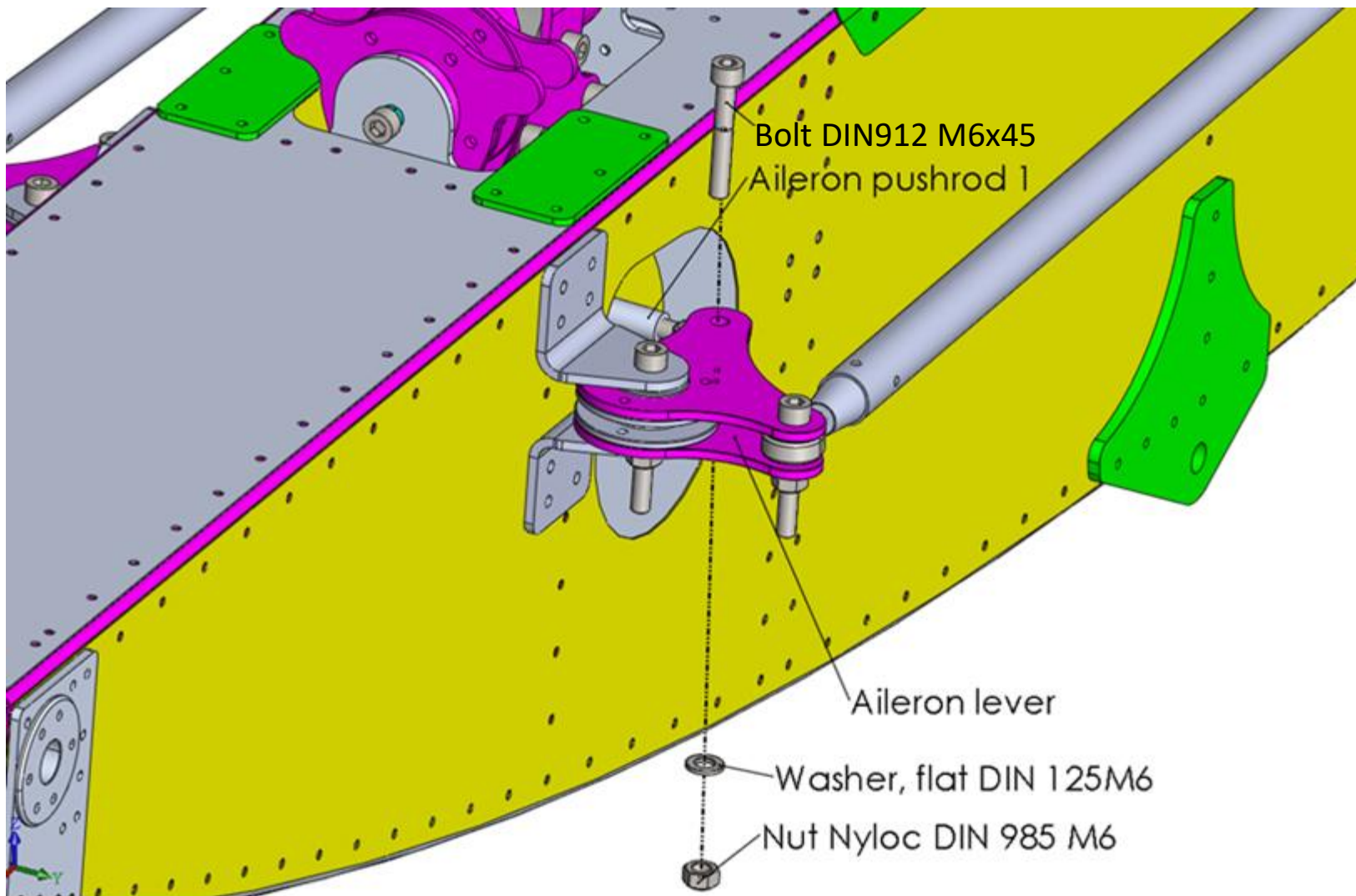
Step 4



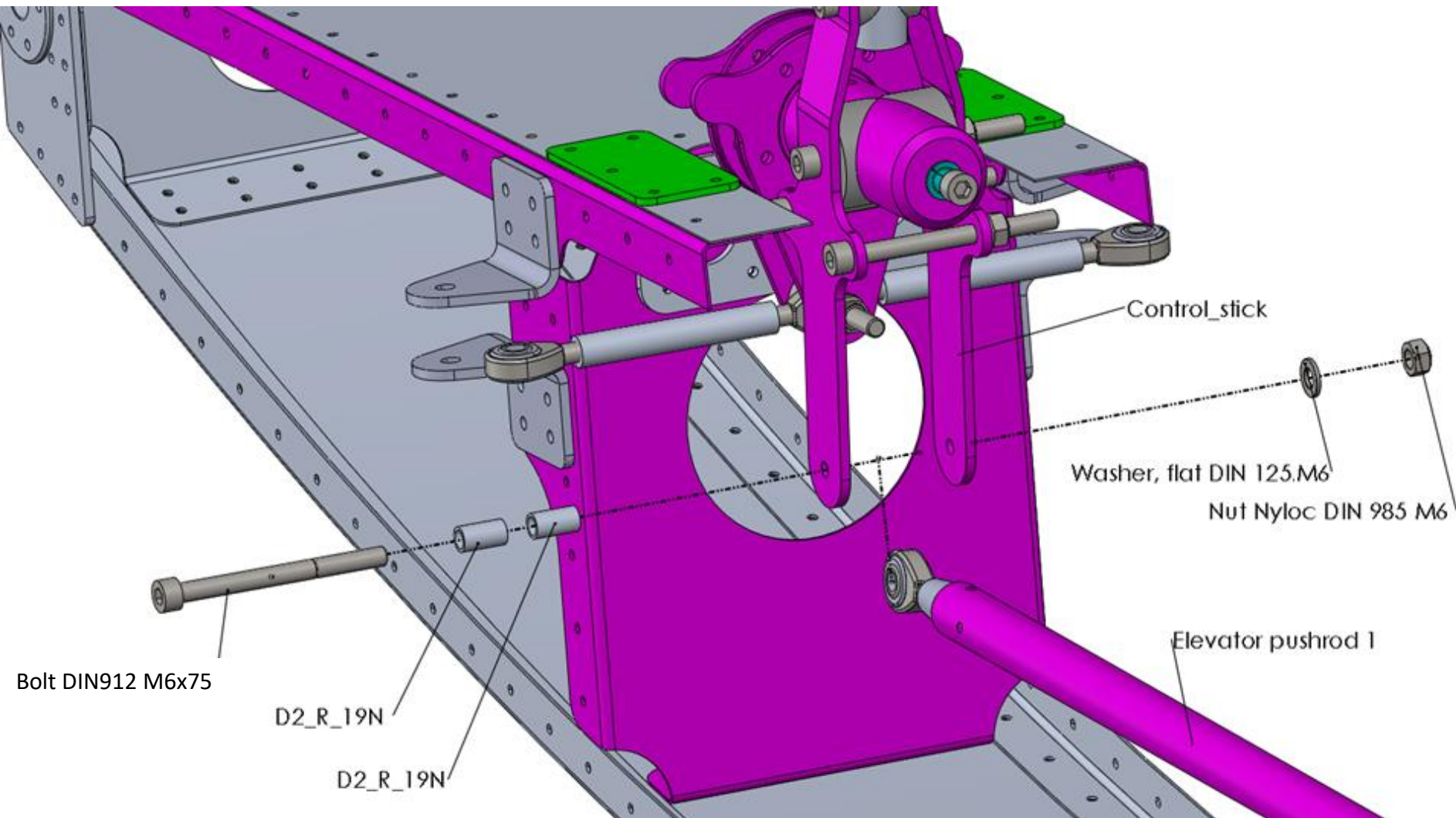
Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	78	114



Step 5



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Control system assembly manual	D2_R0_00	Rev. 06	79	114

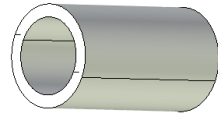





Title	Document no.	Revision	Page	Pages
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D2_R_19N

Quantity: 2

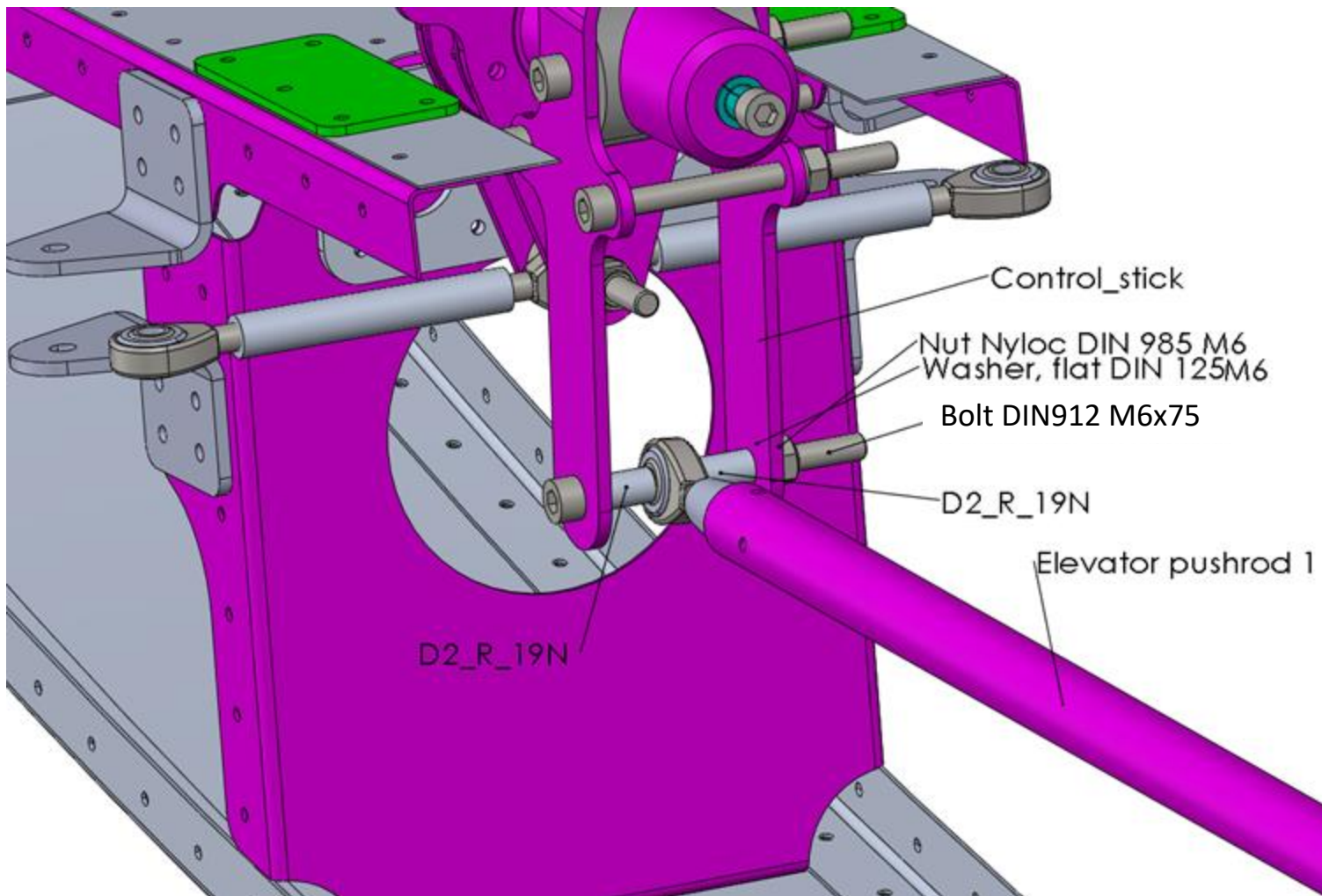


Standard Parts		
Detail picture	Part	Quantity
	Bolt DIN 912 M6x75	1
	Nut Nyloc DIN 985 M6	1
	Washer, flat DIN 125 M6	1

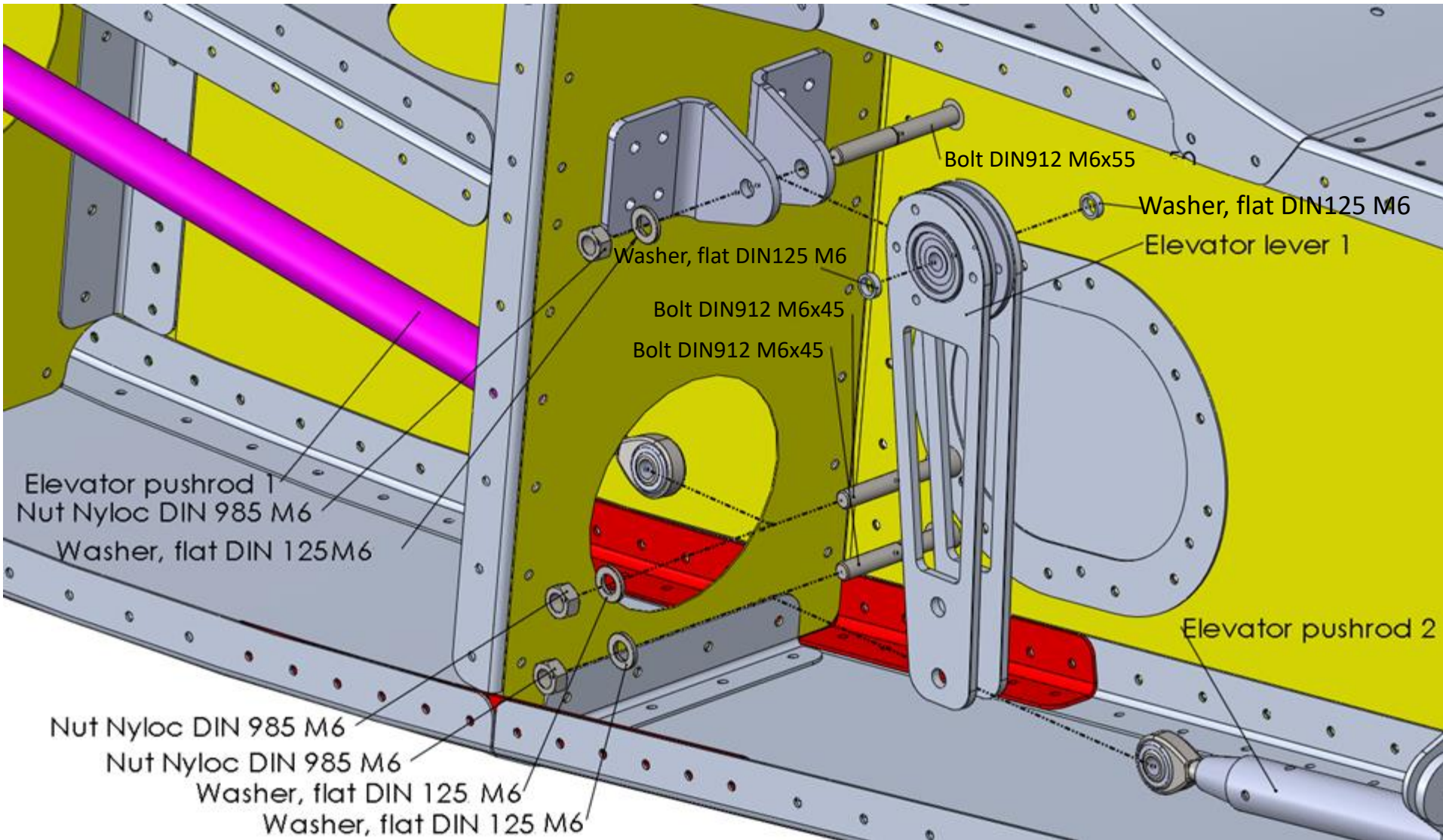
Title	Document no.	Revision	Page	Pages
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Step 1







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Control system assembly manual	D2_R0_00	Rev. 06	82	114



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	83	114

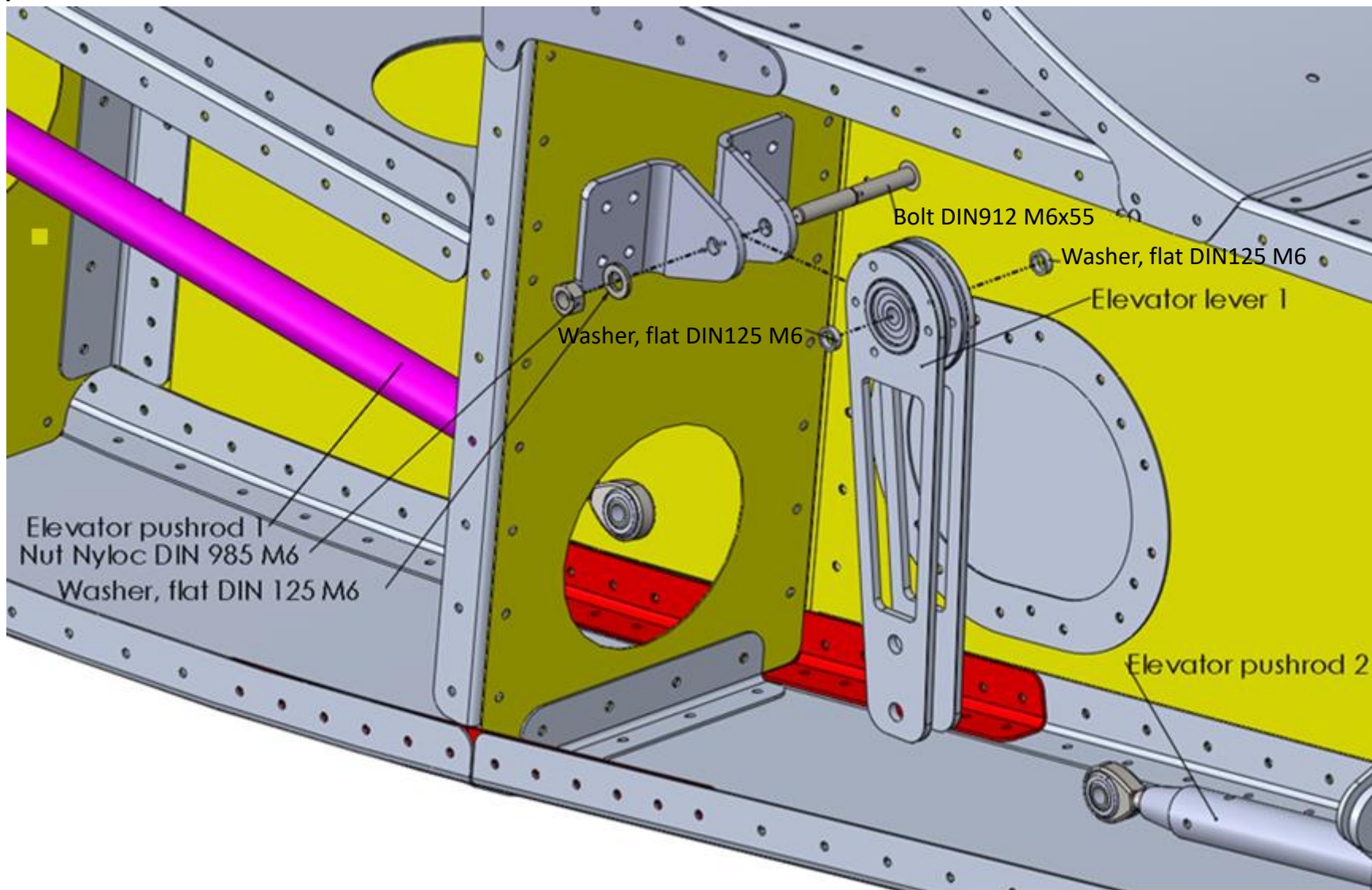


Standard Parts		
Detail picture	Part	Quantity
	Bolt DIN 912 M6x55	1
	Bolt DIN 912 M6x45	2
	Nut Nyloc DIN 985 M6	3
	Washer, flat DIN 125 M6	5

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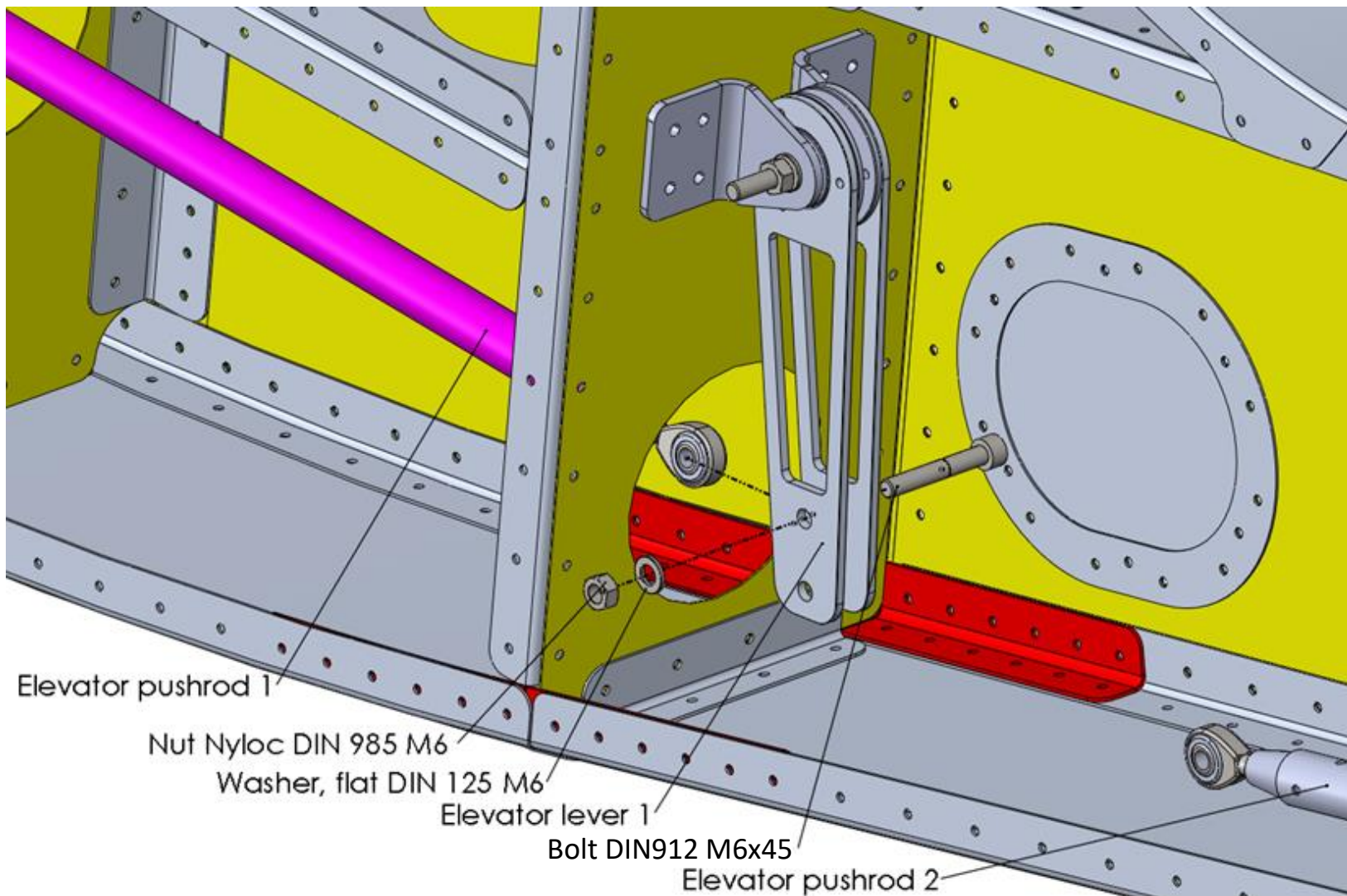
Step 1



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Control system assembly manual	D2_R0_00	Rev. 06	85	114



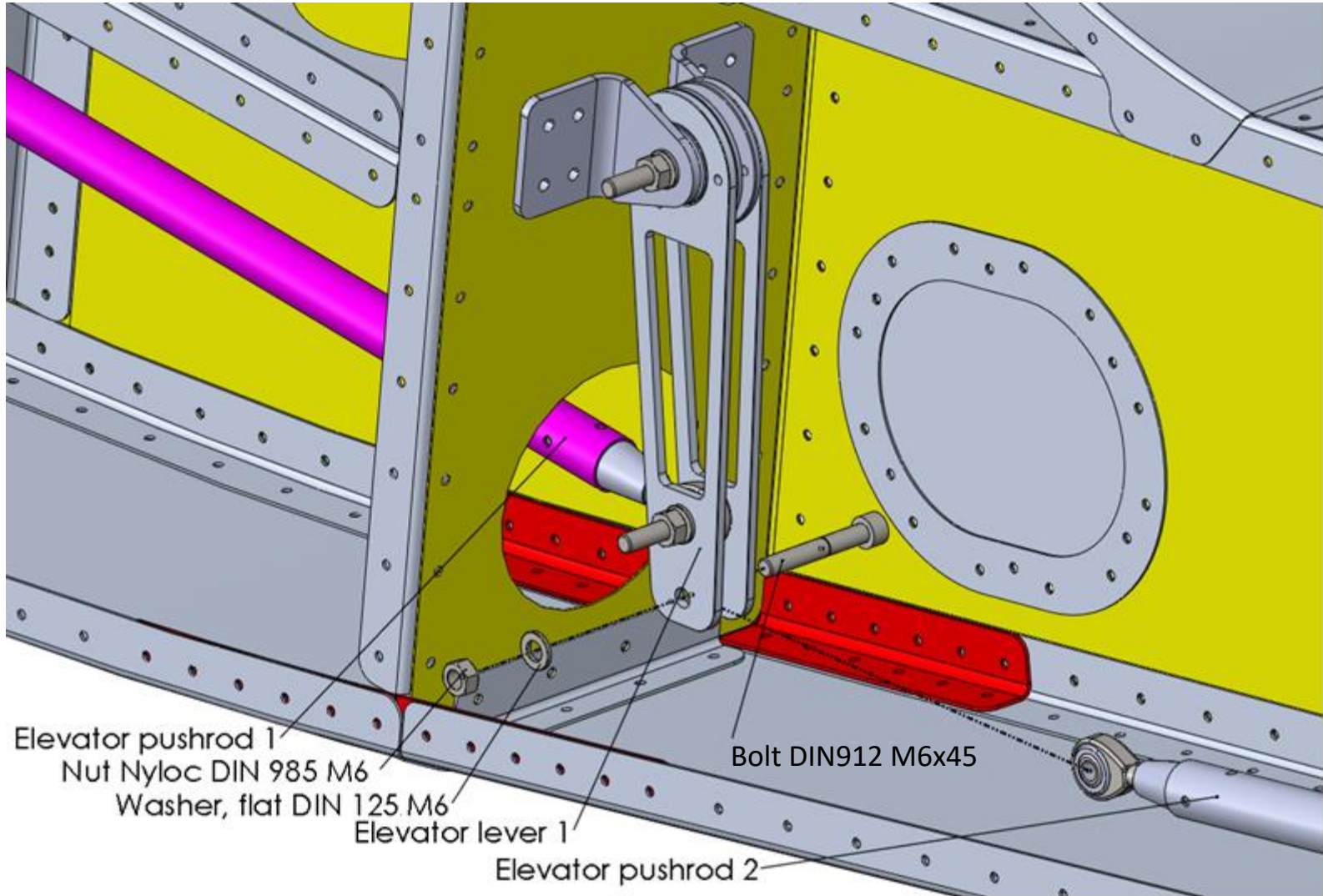
Step 2



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Step 3



Elevator pushrod 1

Nut Nyloc DIN 985 M6

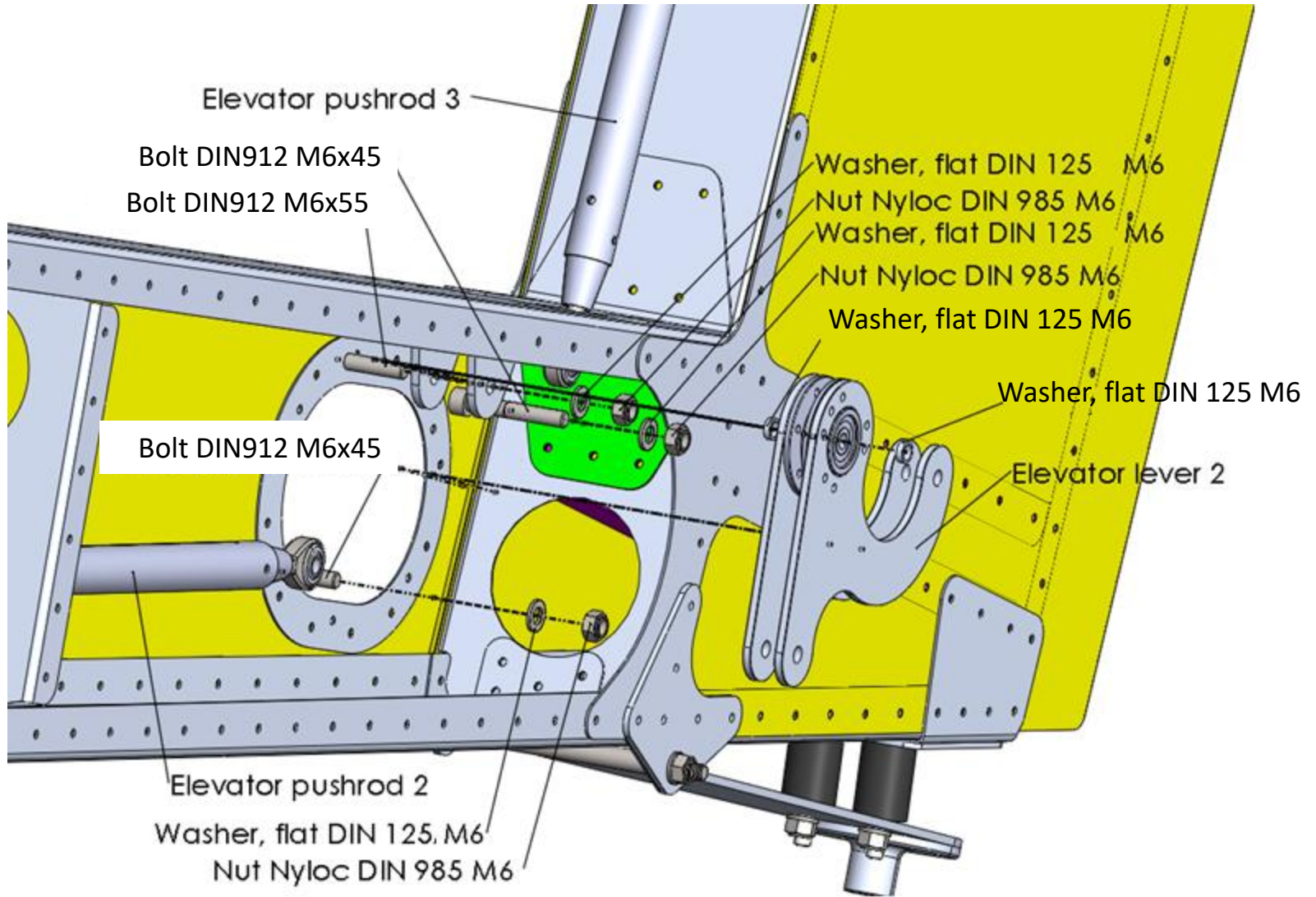
Washer, flat DIN 125 M6

Elevator lever 1

Elevator pushrod 2





Bolt DIN912 M6x45

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Control system assembly manual	D2_R0_00	Rev. 06	87	114

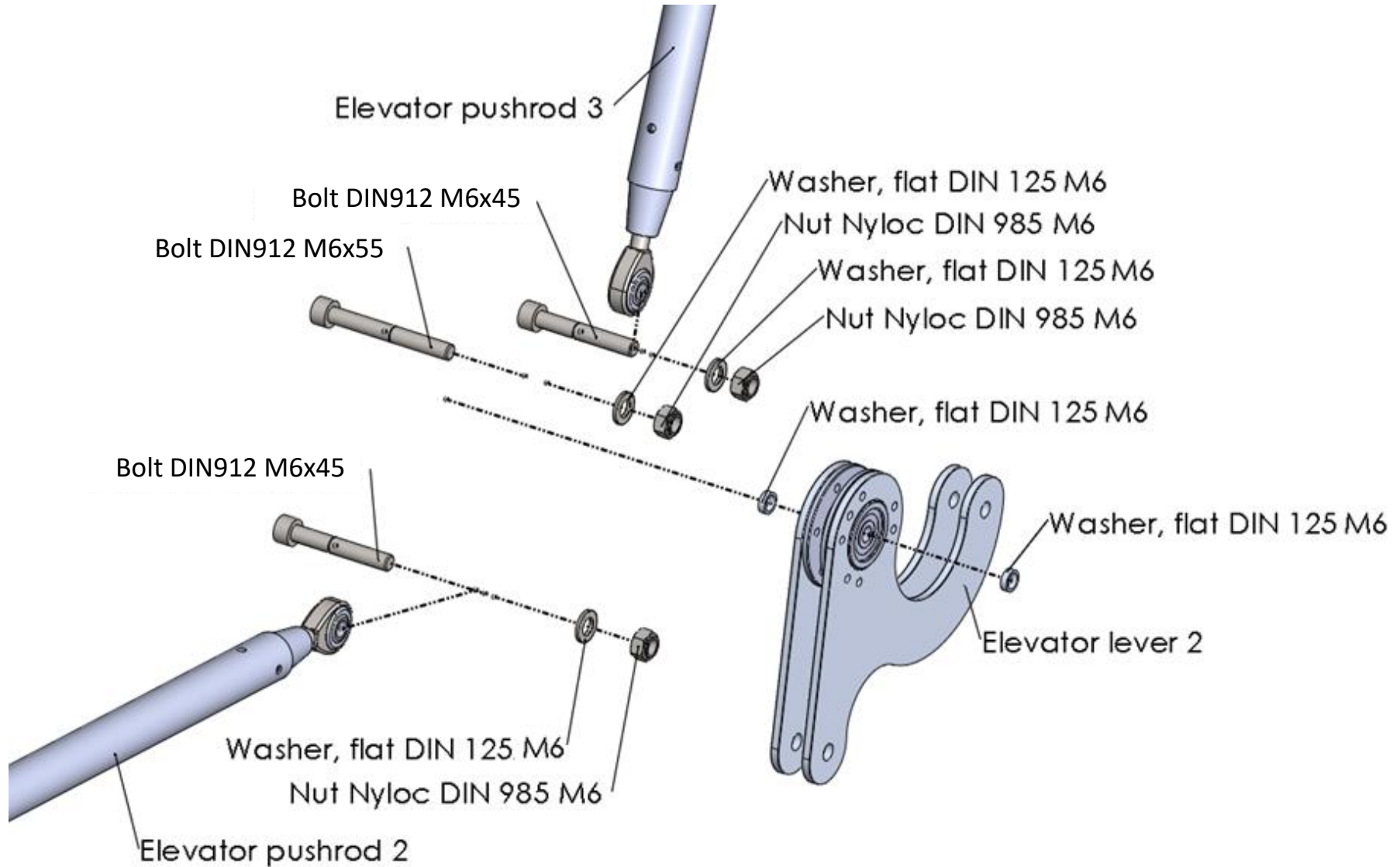


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Control system assembly manual	D2_R0_00	Rev. 06	88	114



Standard Parts		
Detail picture	Part	Quantity
	Bolt DIN 912 M6x55	1
	Bolt DIN 912 M6x45	2
	Nut Nyloc DIN 985 M6	3
	Washer, flat DIN 125 M6	5

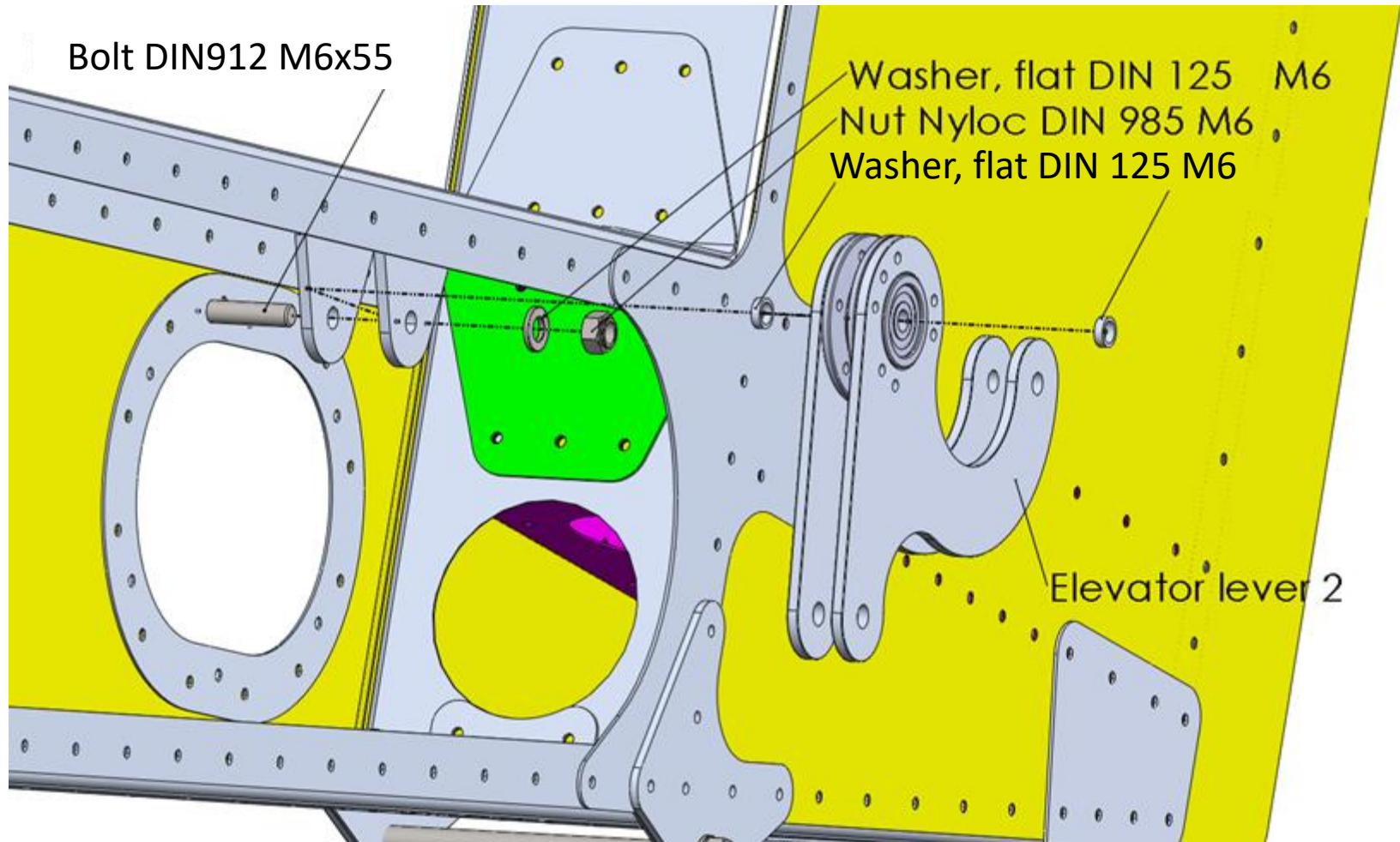
Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	89	114



Title	Document no.	Revision	Page	Pages
Control system assembly manual	D2_R0_00	Rev. 06	90	114



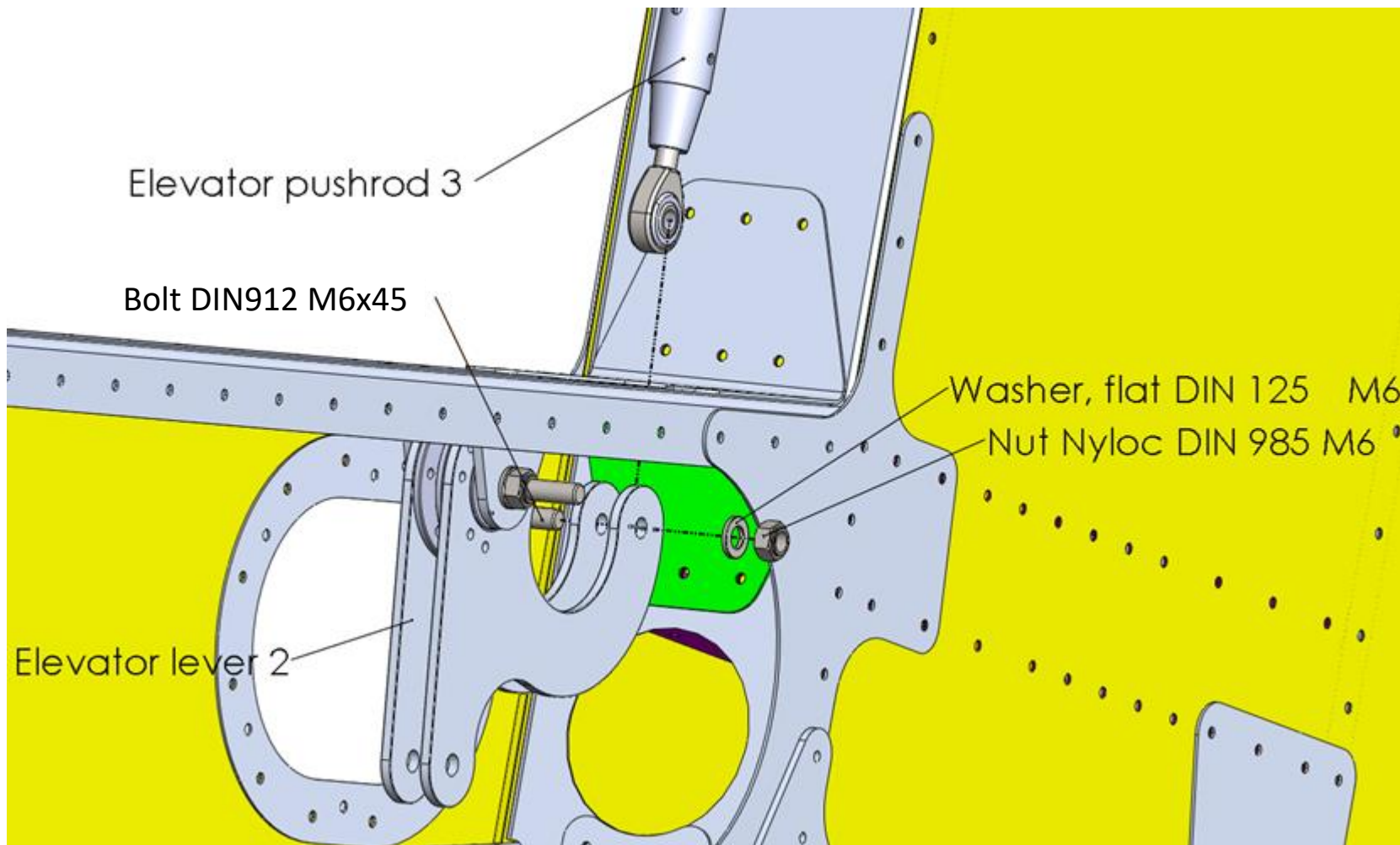
Step 1



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Control system assembly manual	D2_R0_00	Rev. 06	91	114



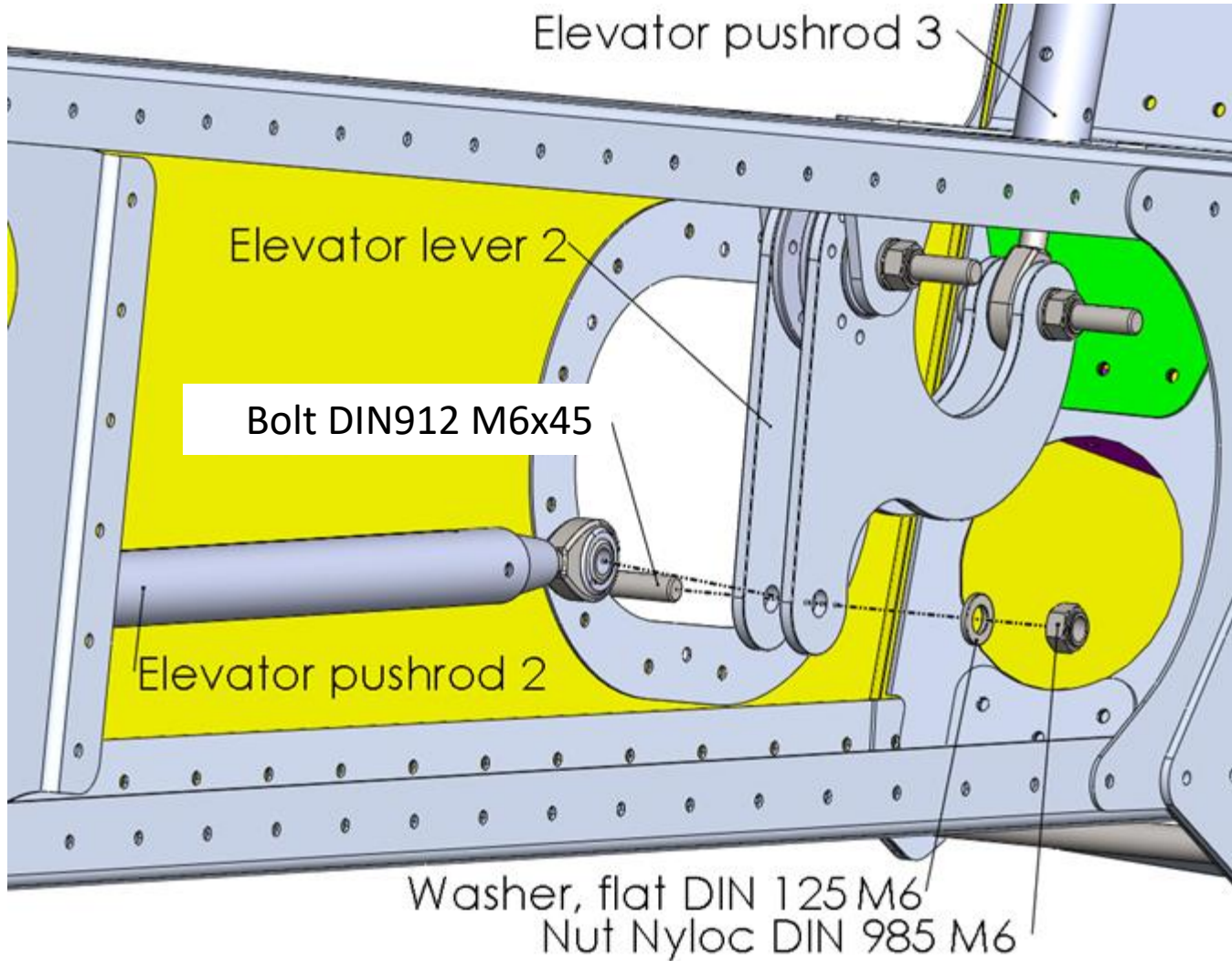
Step 2



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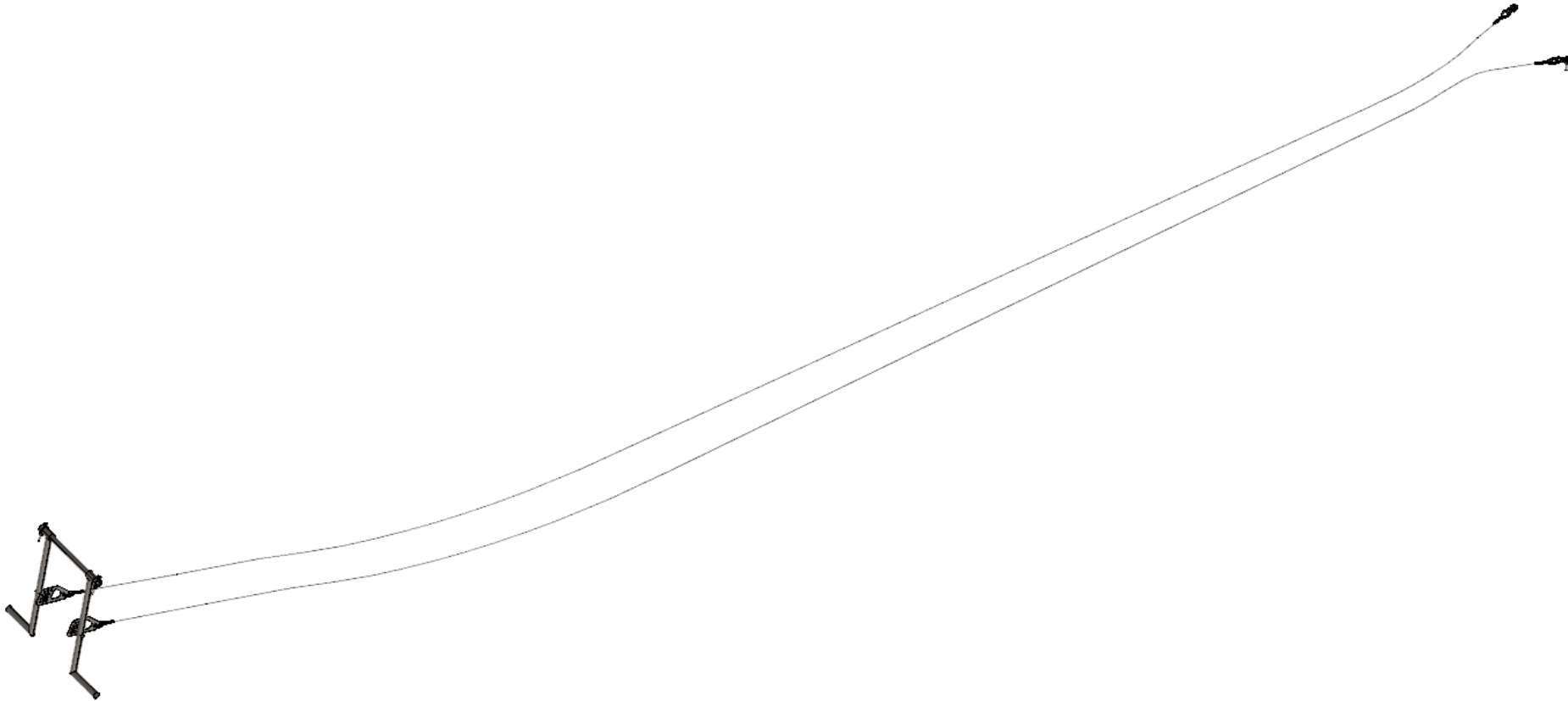
Step 3



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Rudder control system assembly



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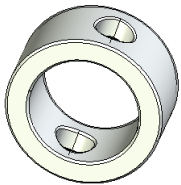
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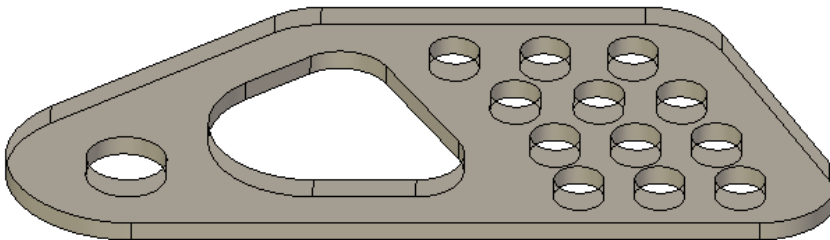
D2_R_21N

Quantity: 2



D2_R_30N

Quantity: 2



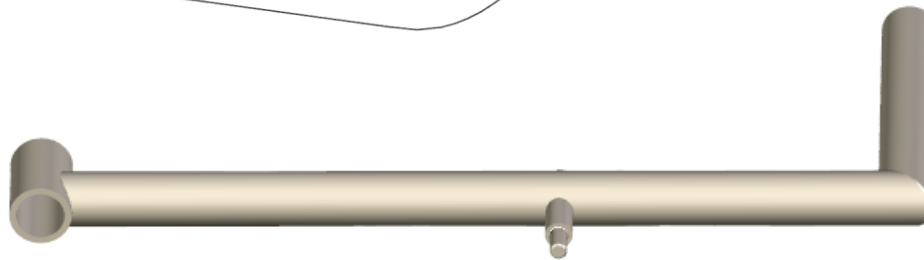
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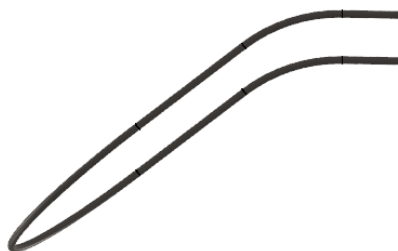
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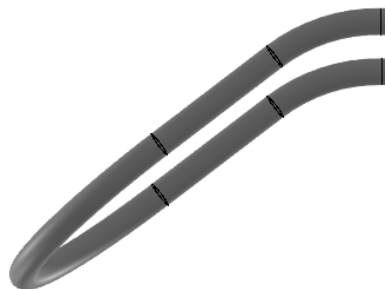
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D2_R_35N
Quantity: 2




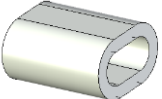
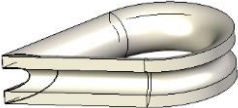




D2_R_36N
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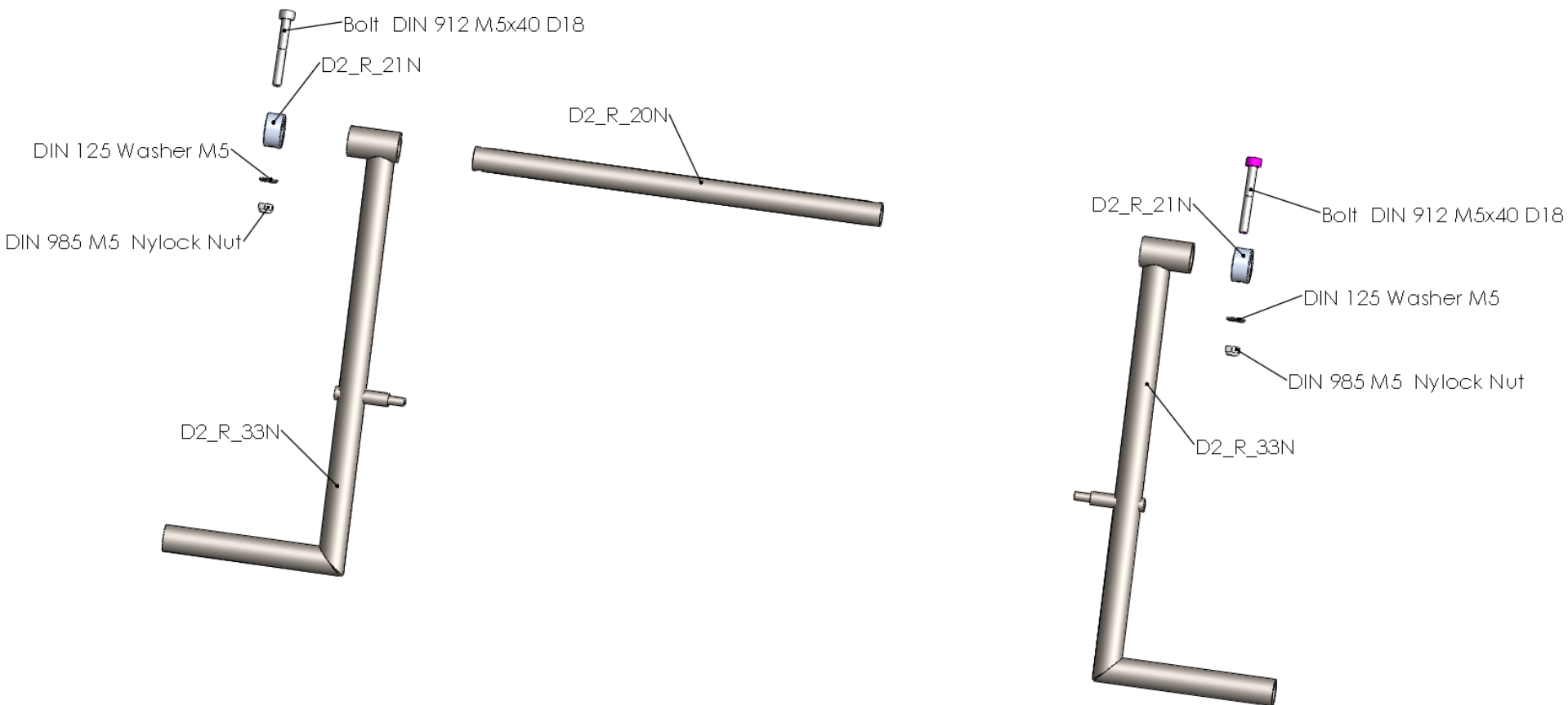


Standard Parts		
Detail picture	Part	Quantity
	Bolt DIN 912 M5x40	2
	Nut Nyloc DIN 985 M5	4
	Washer, flat DIN 125 M5	4
	Crimp sleeve	8
	Thimble	4
	Crimp sleeve	4
	Heat-shrinkable tube	4x10cm

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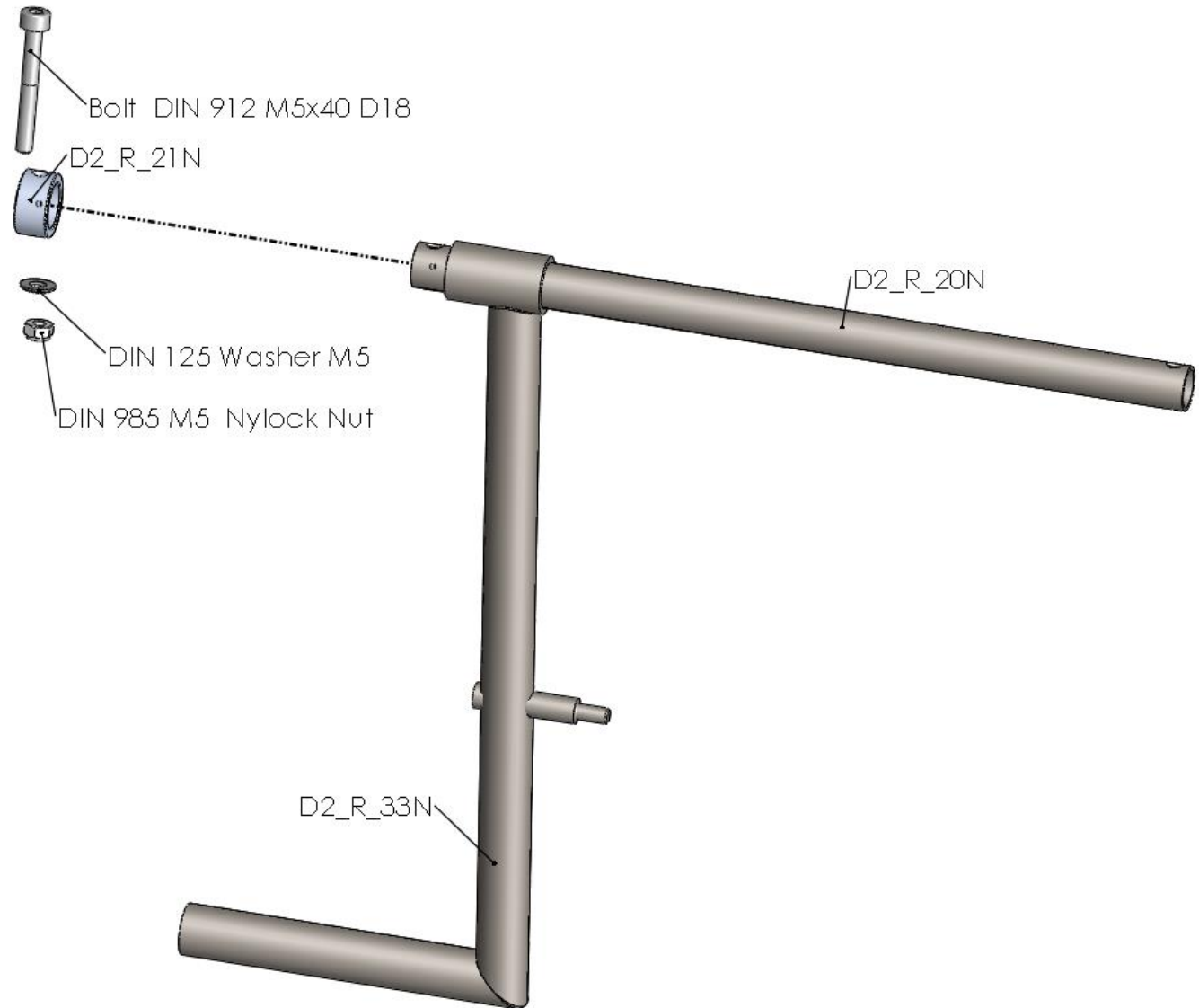
Step 1



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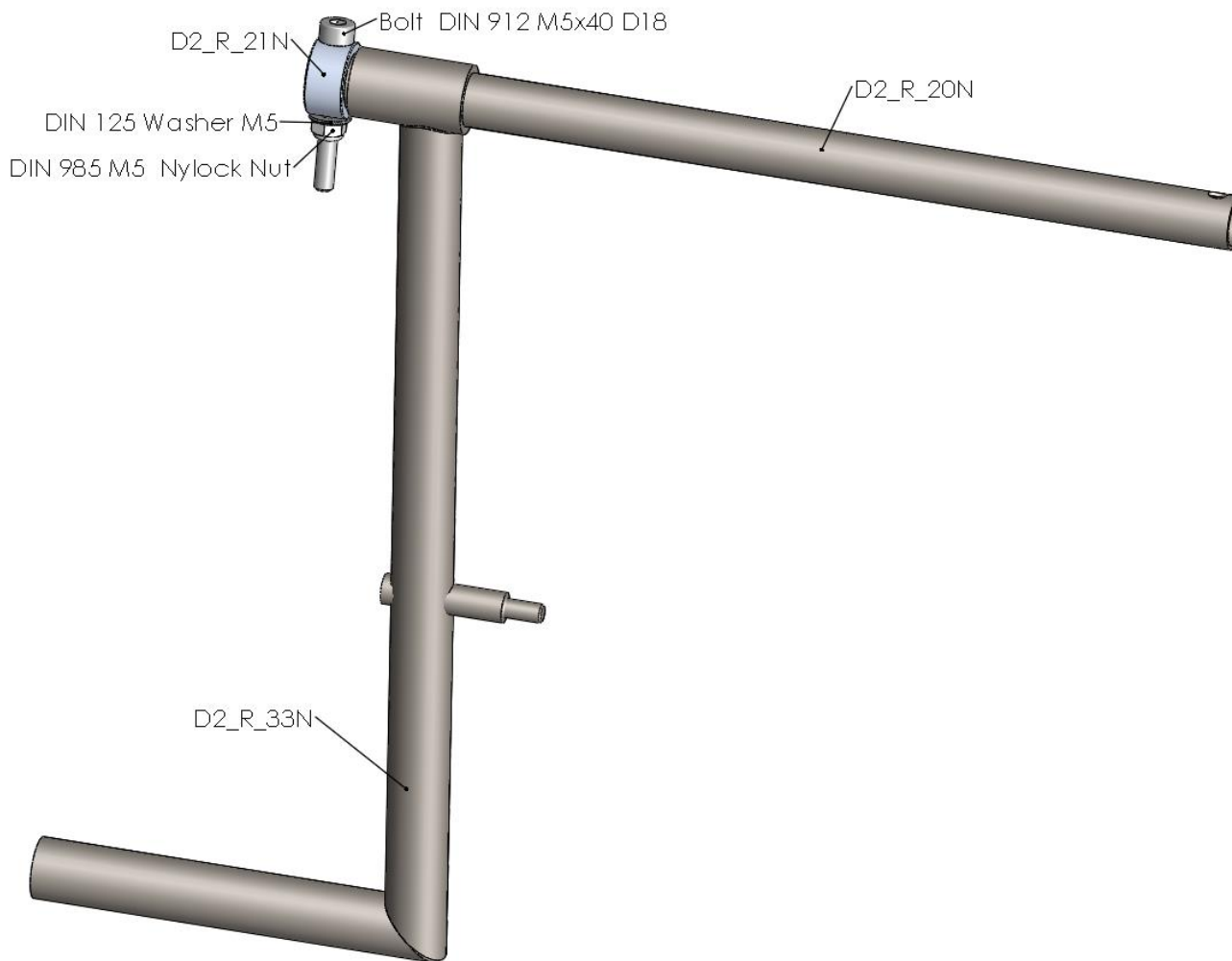
Step 2



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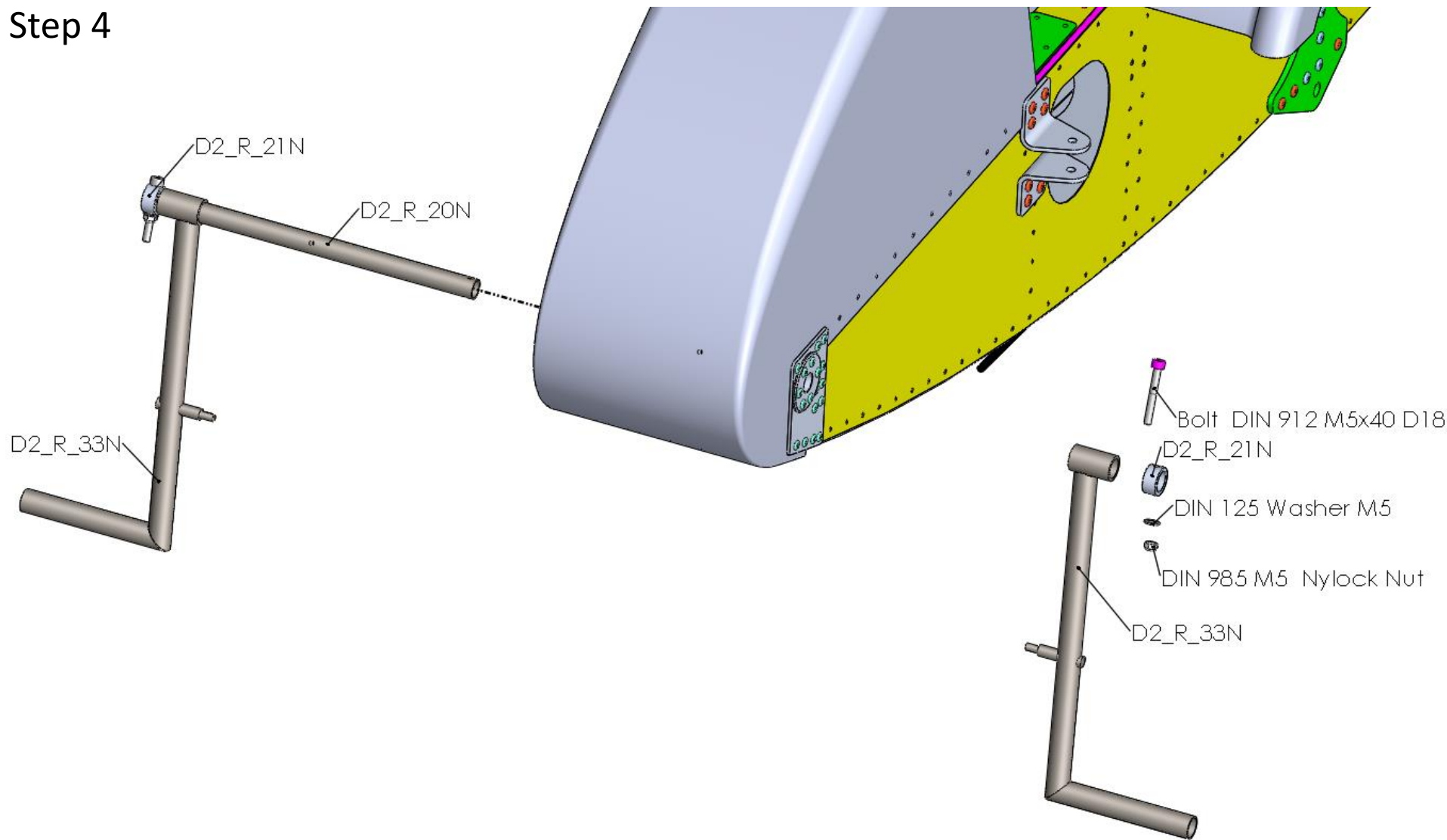
Step 3



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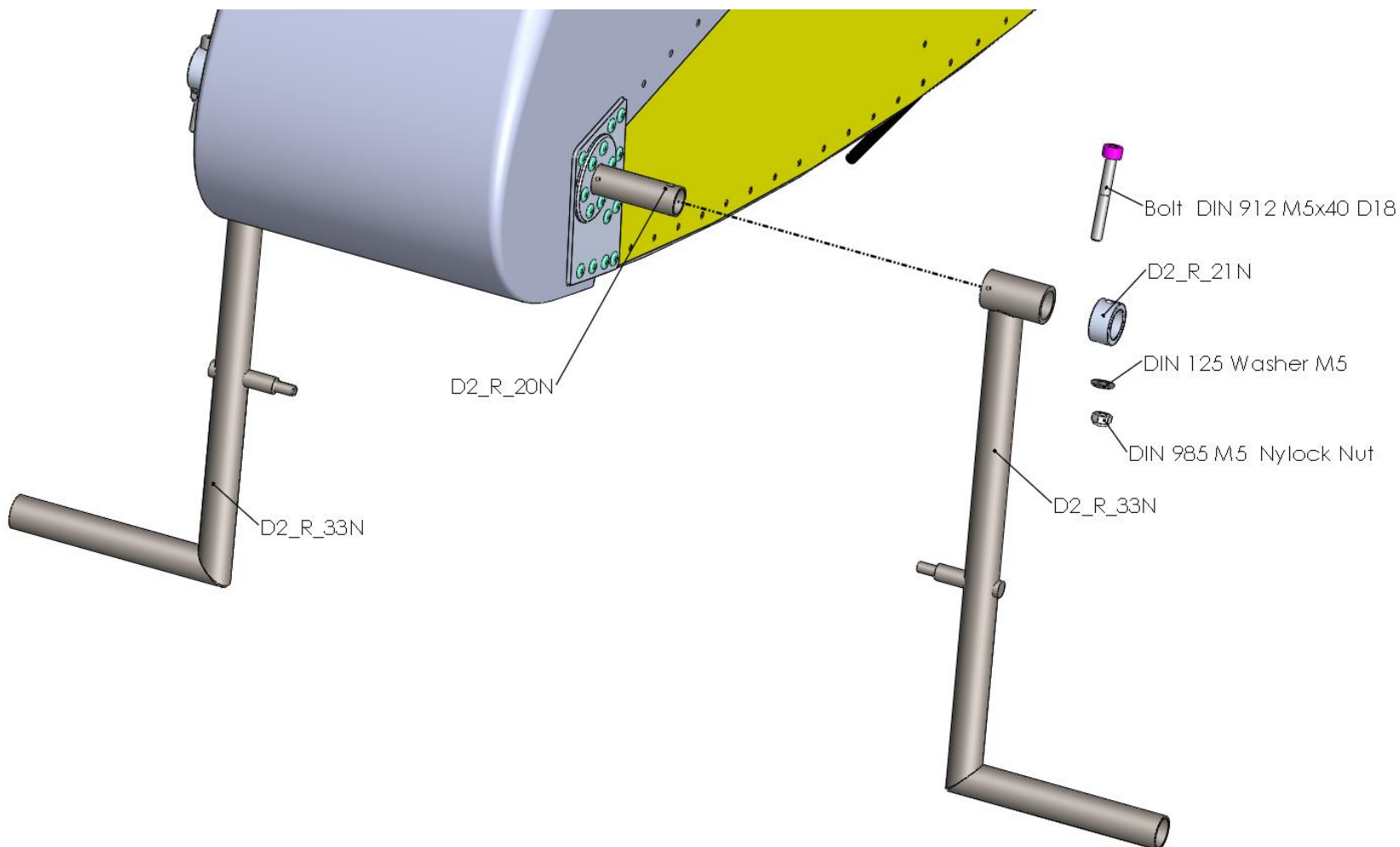
Step 4



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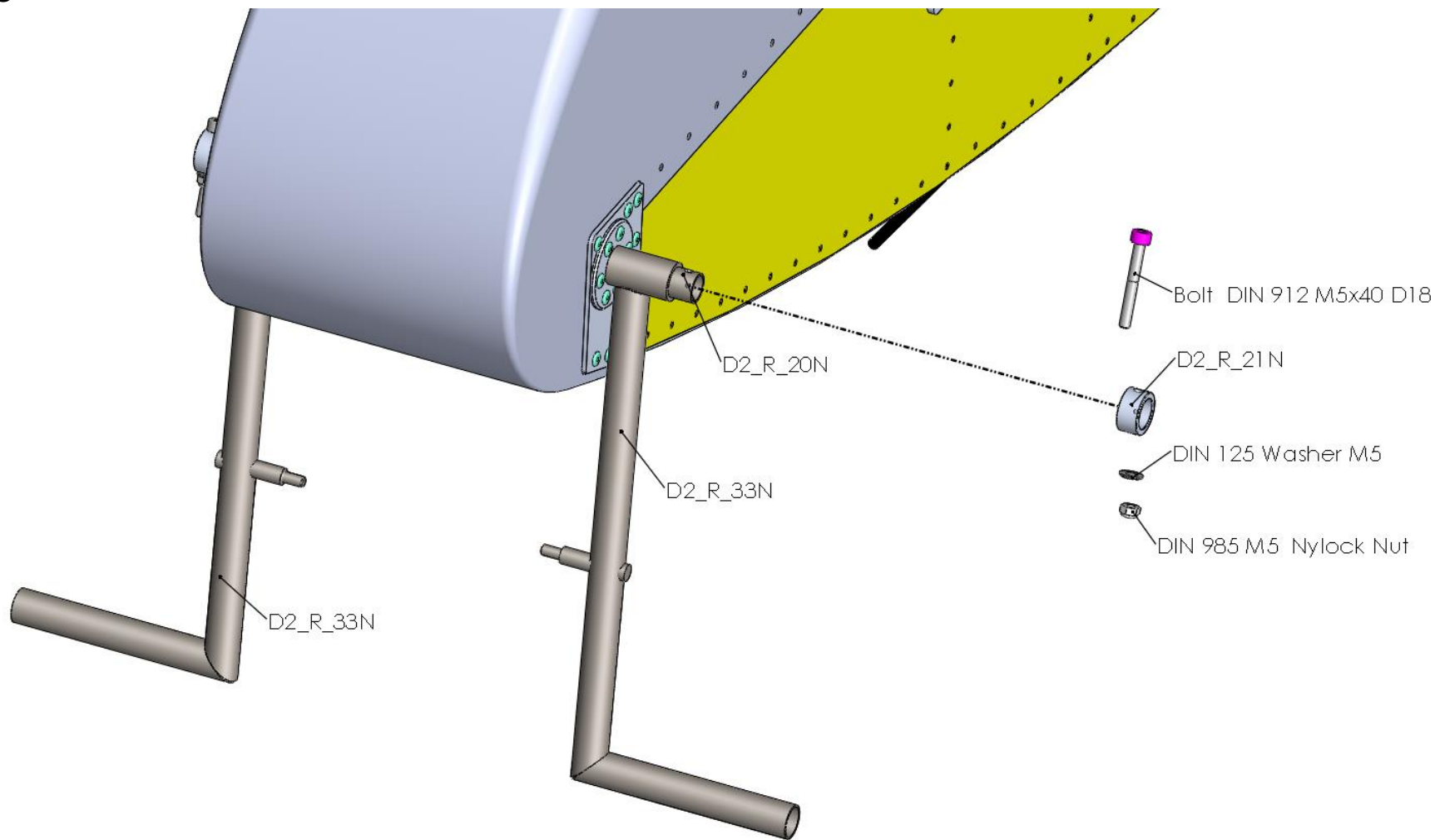
Step 5



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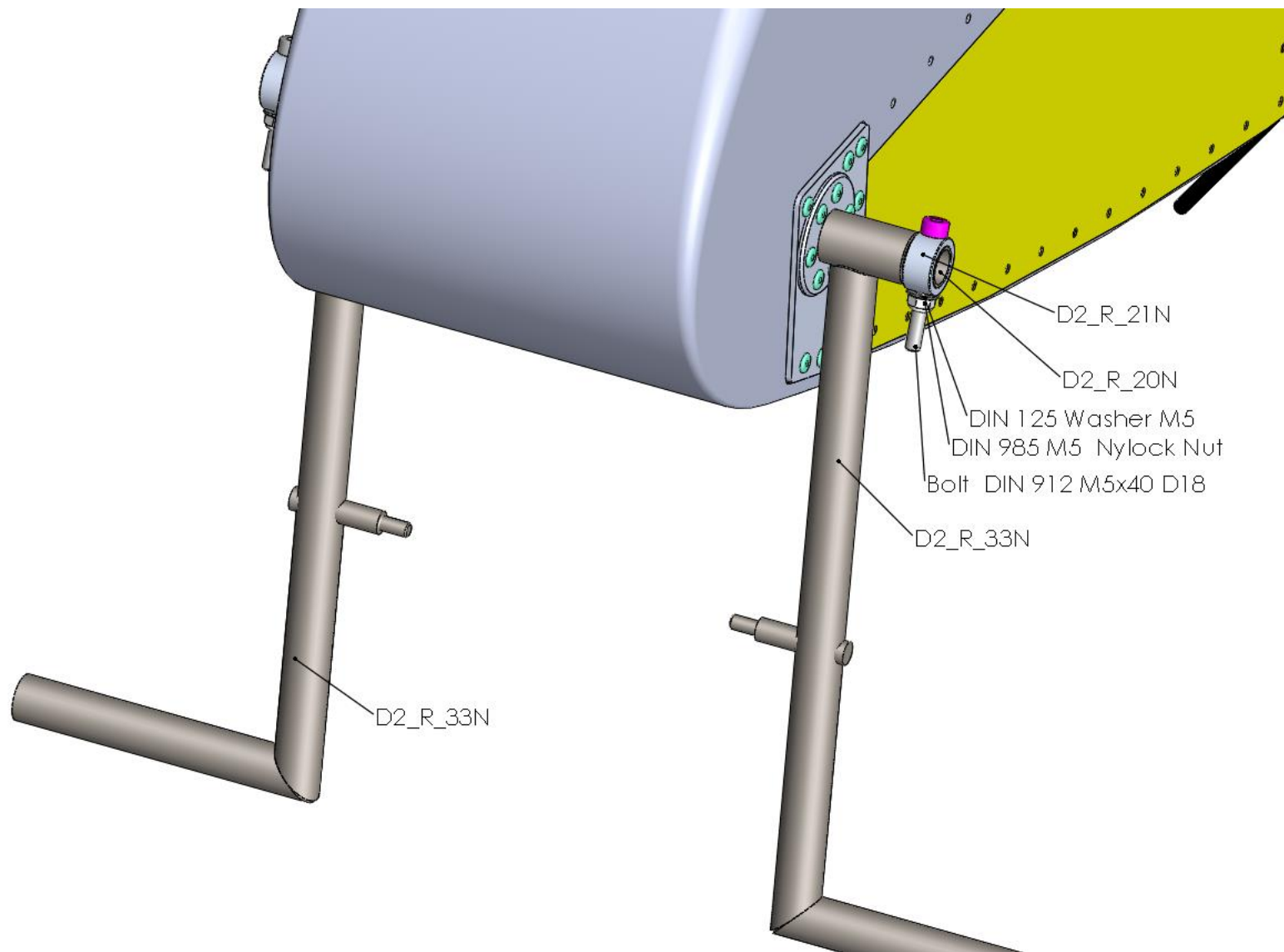
Step 6



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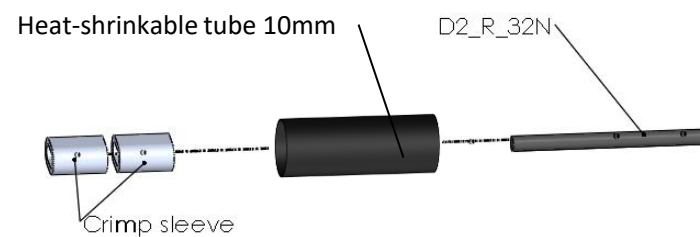
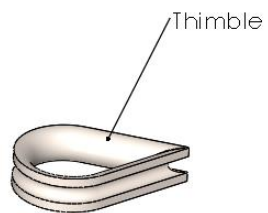
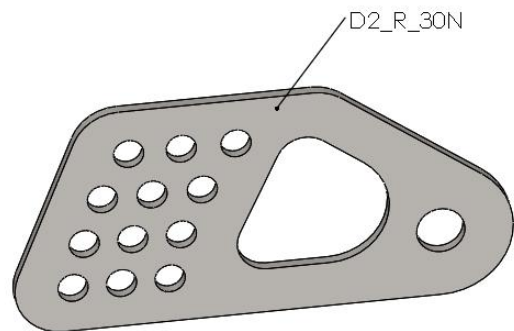
Step 7



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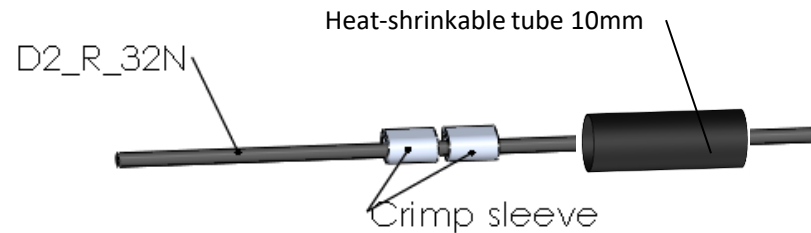
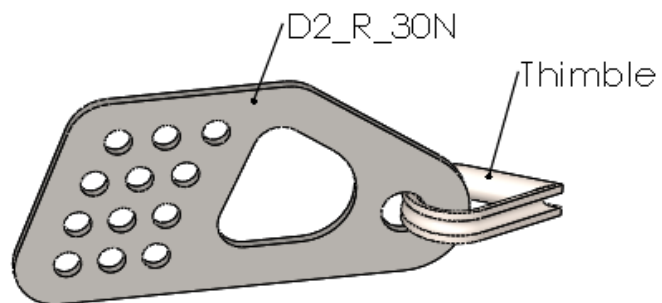
Step 8



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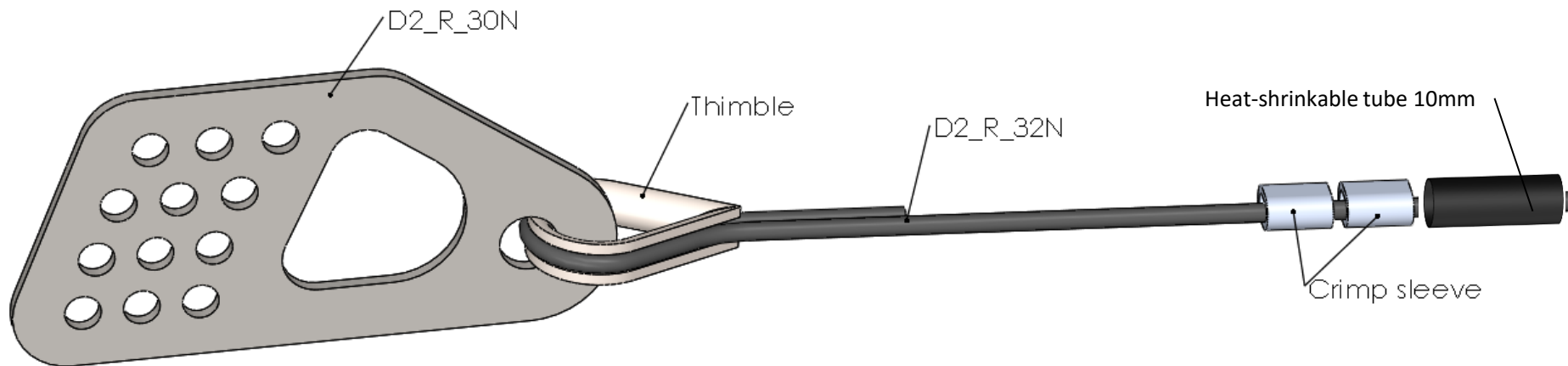
Step 10



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Step 11



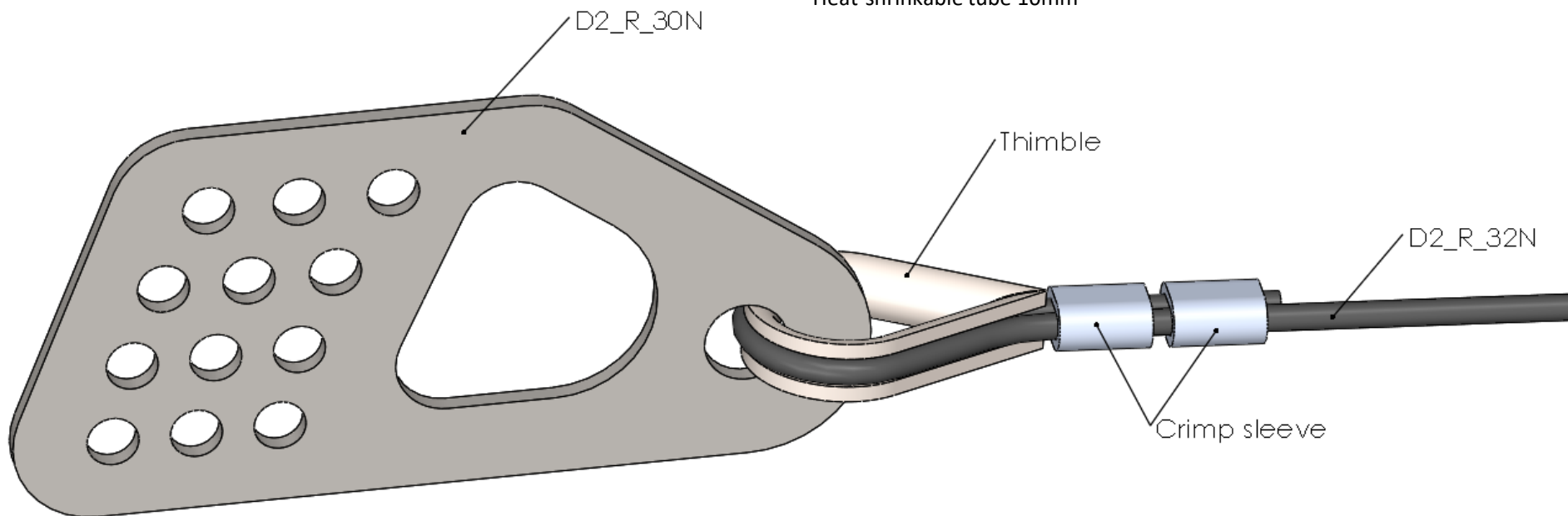
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Step 12



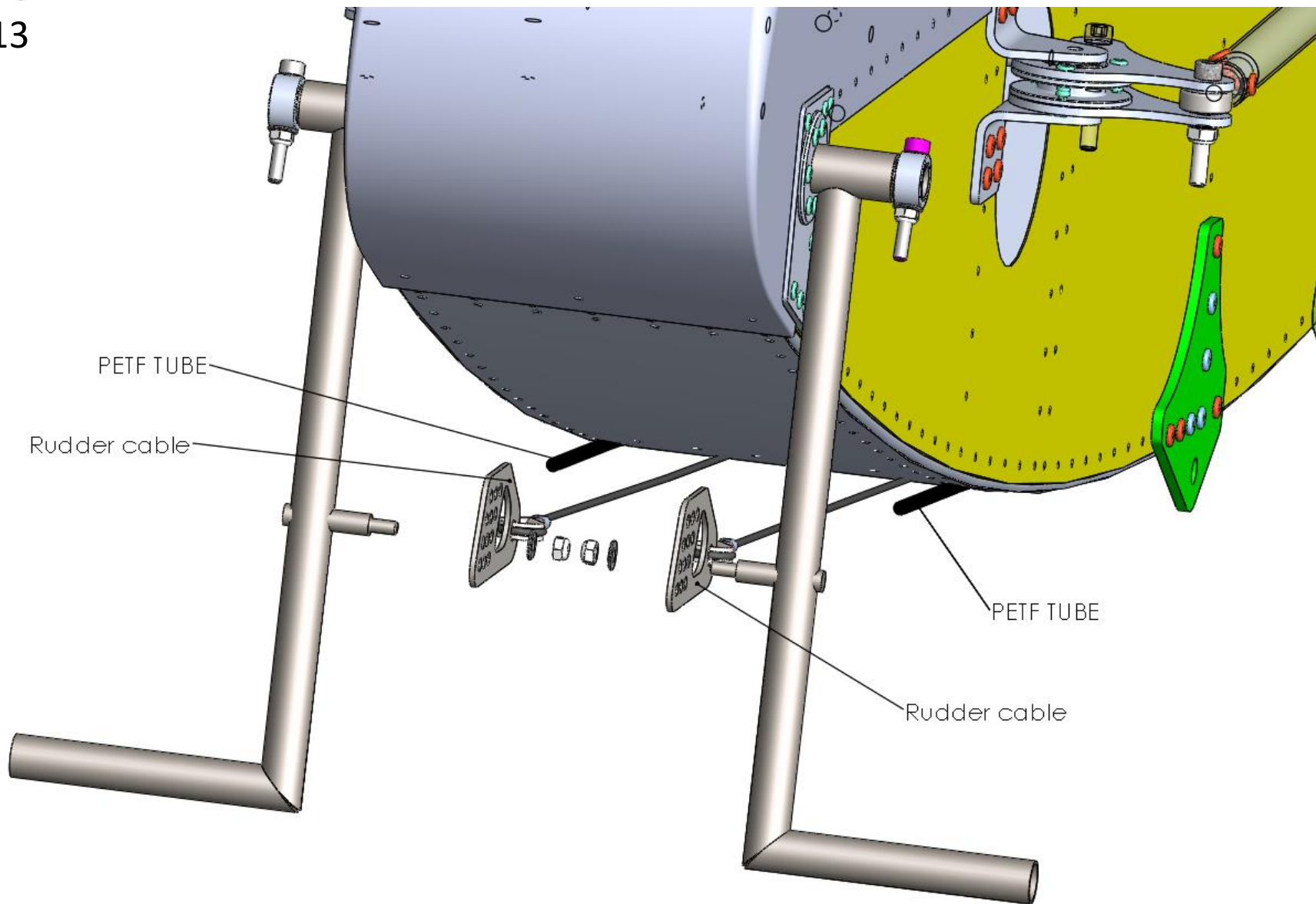
Heat-shrinkable tube 10mm



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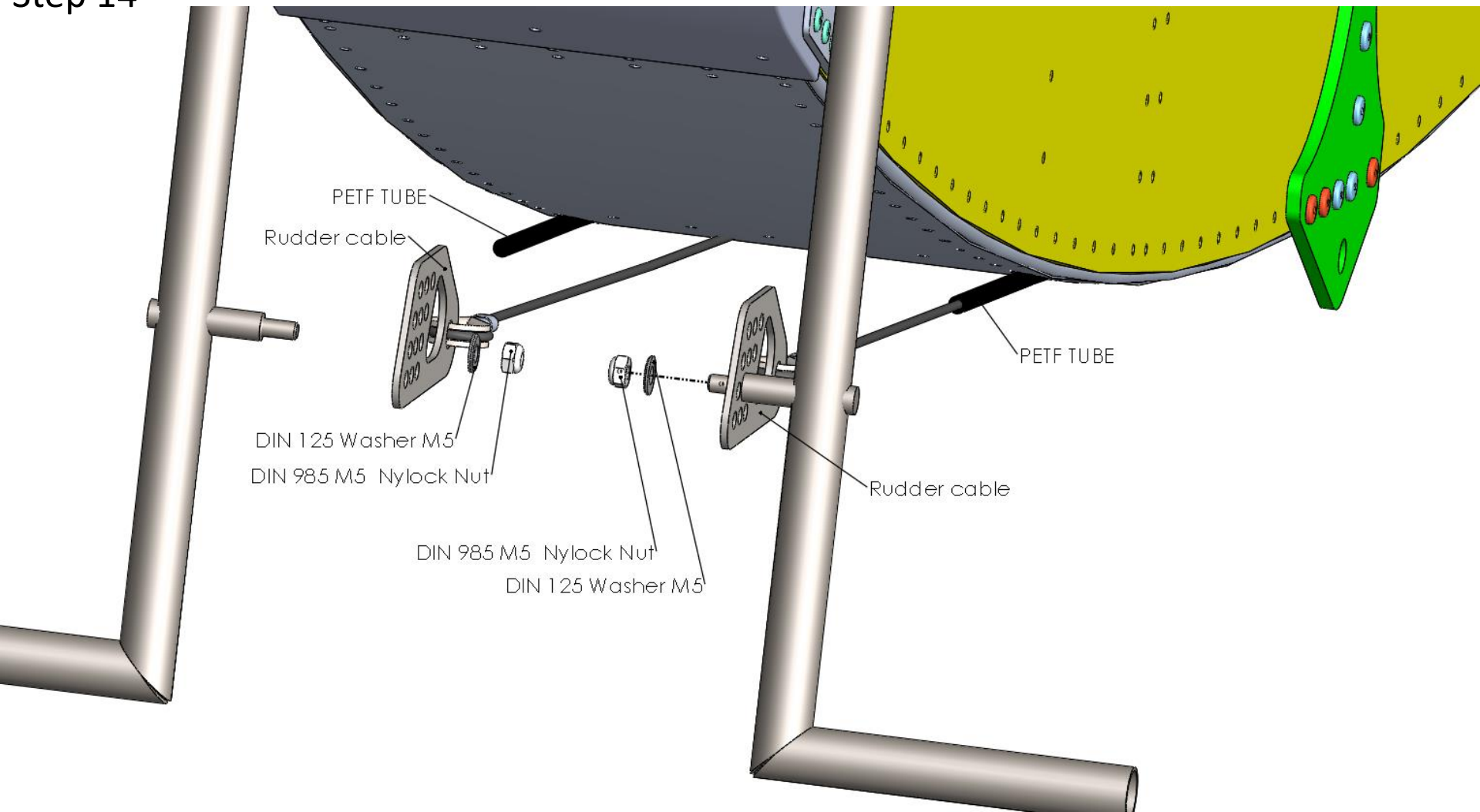
Step 13



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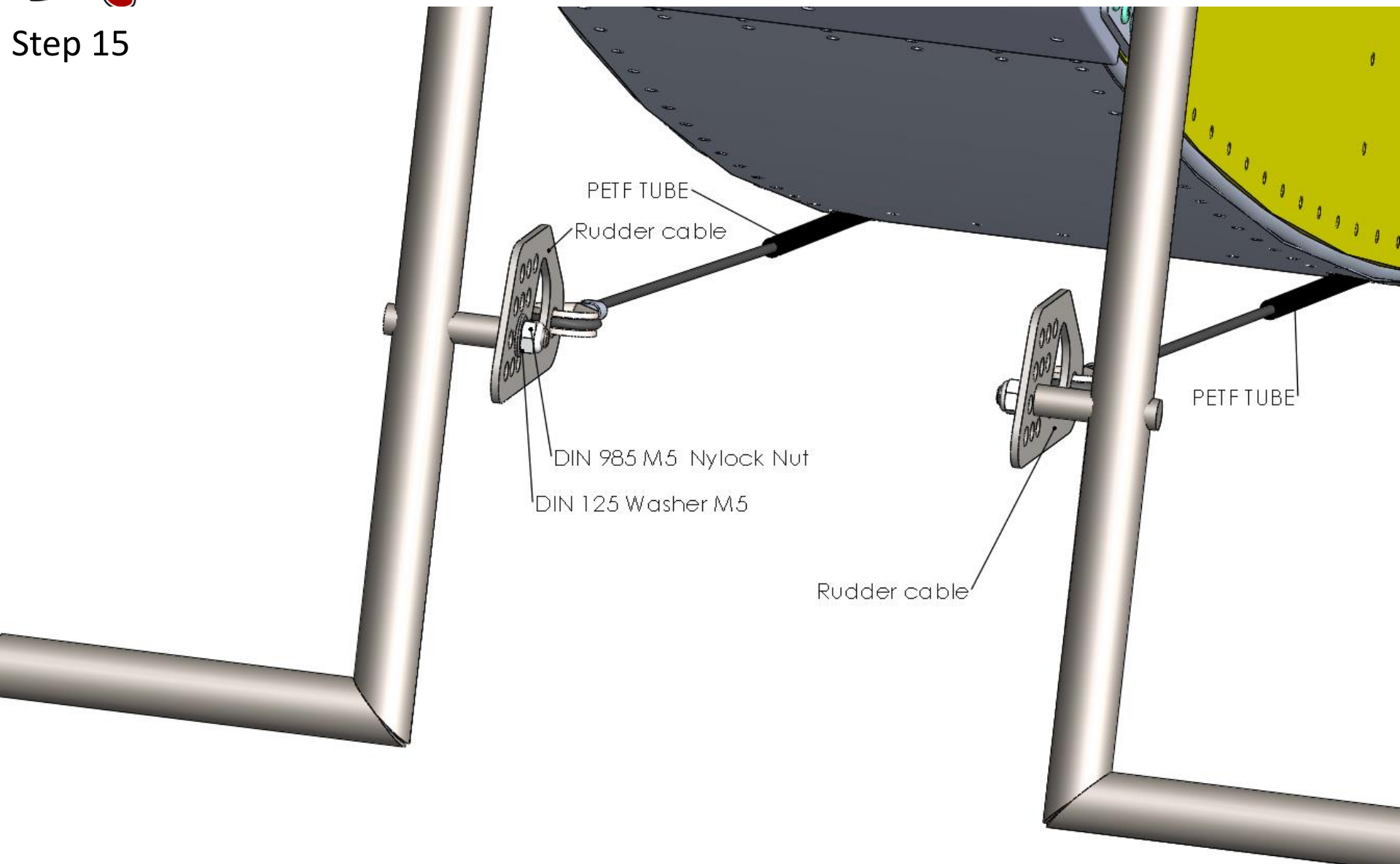
Step 14



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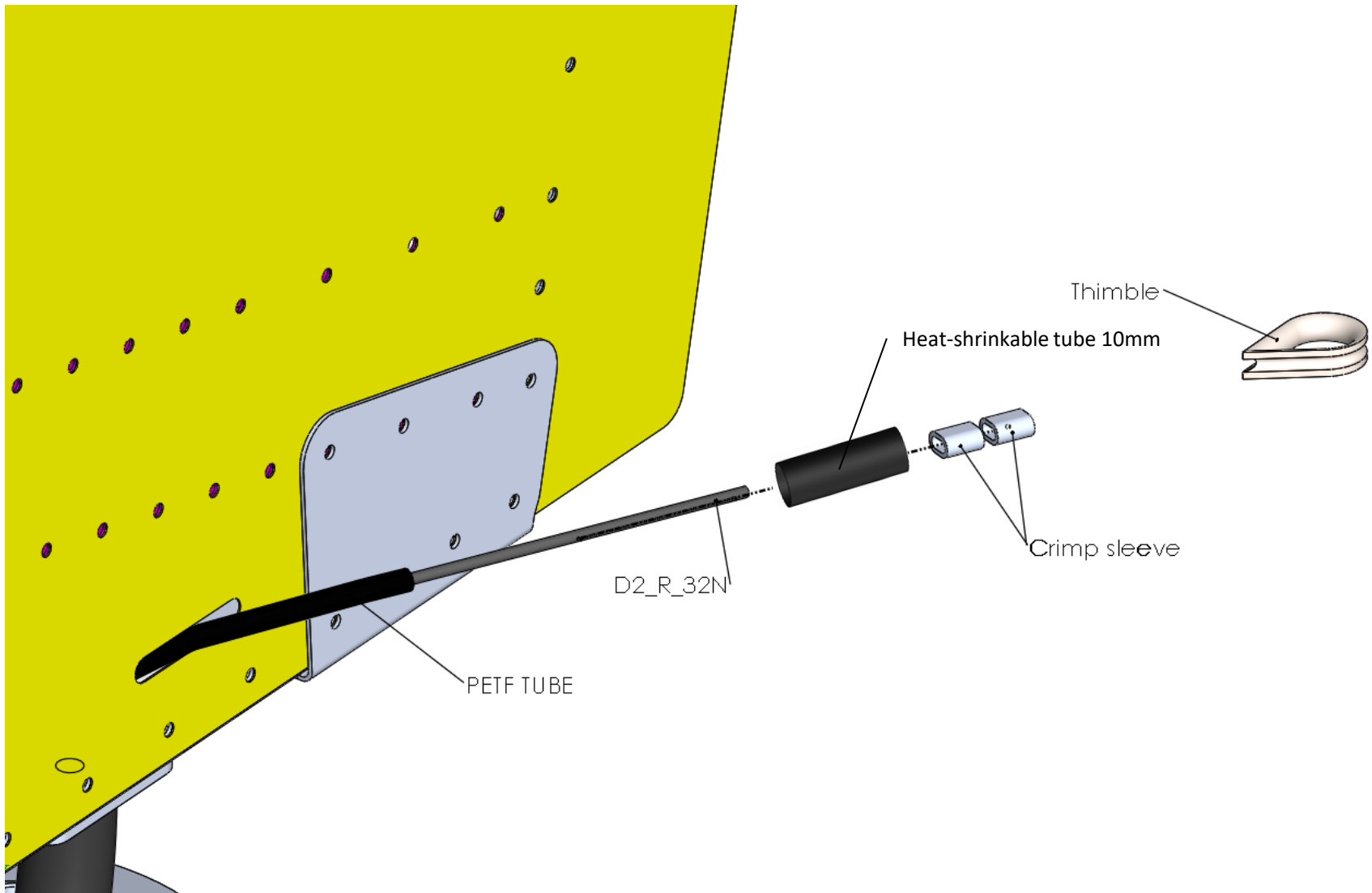
Step 15



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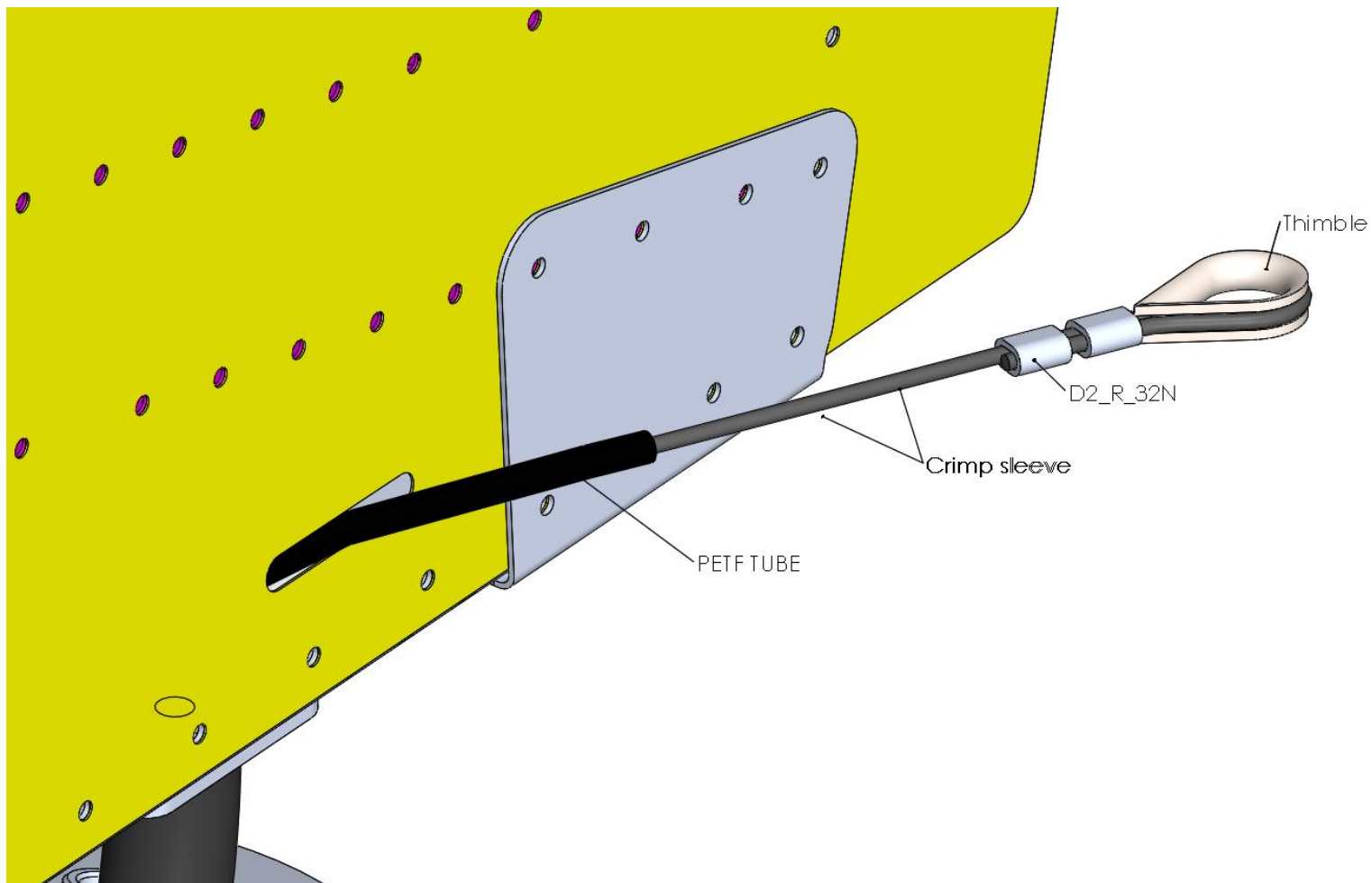
Step 16



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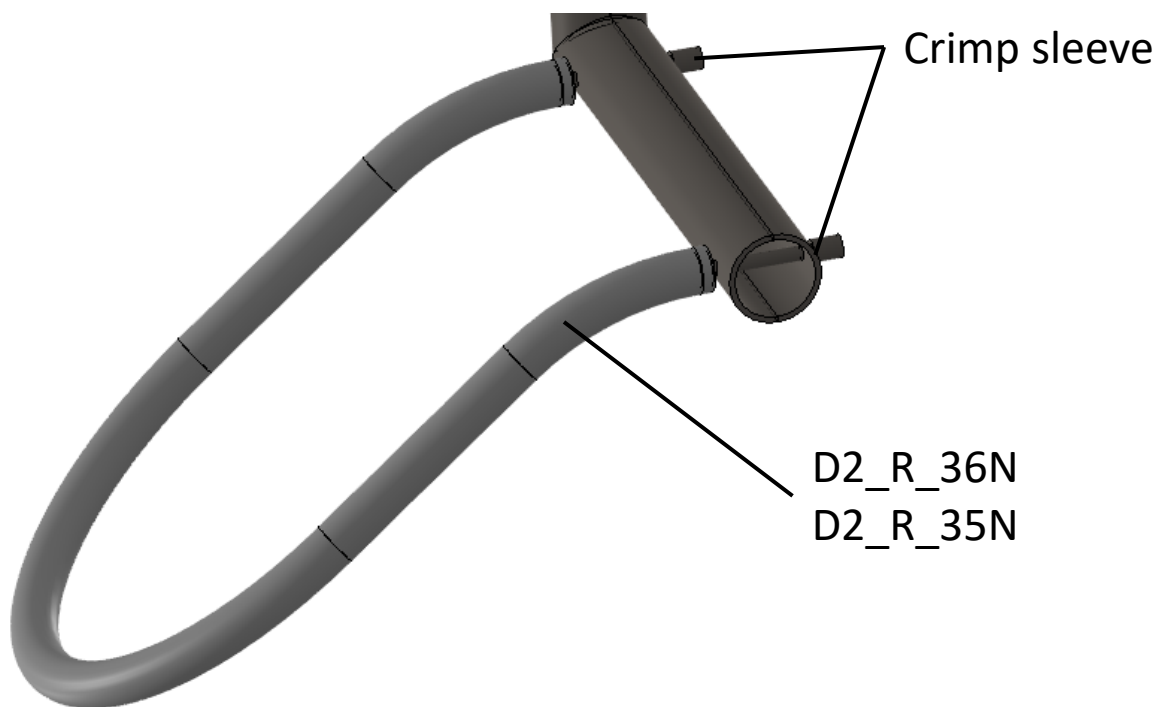
Step 18



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Step 19



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