

Title:

Rudder assembly manual

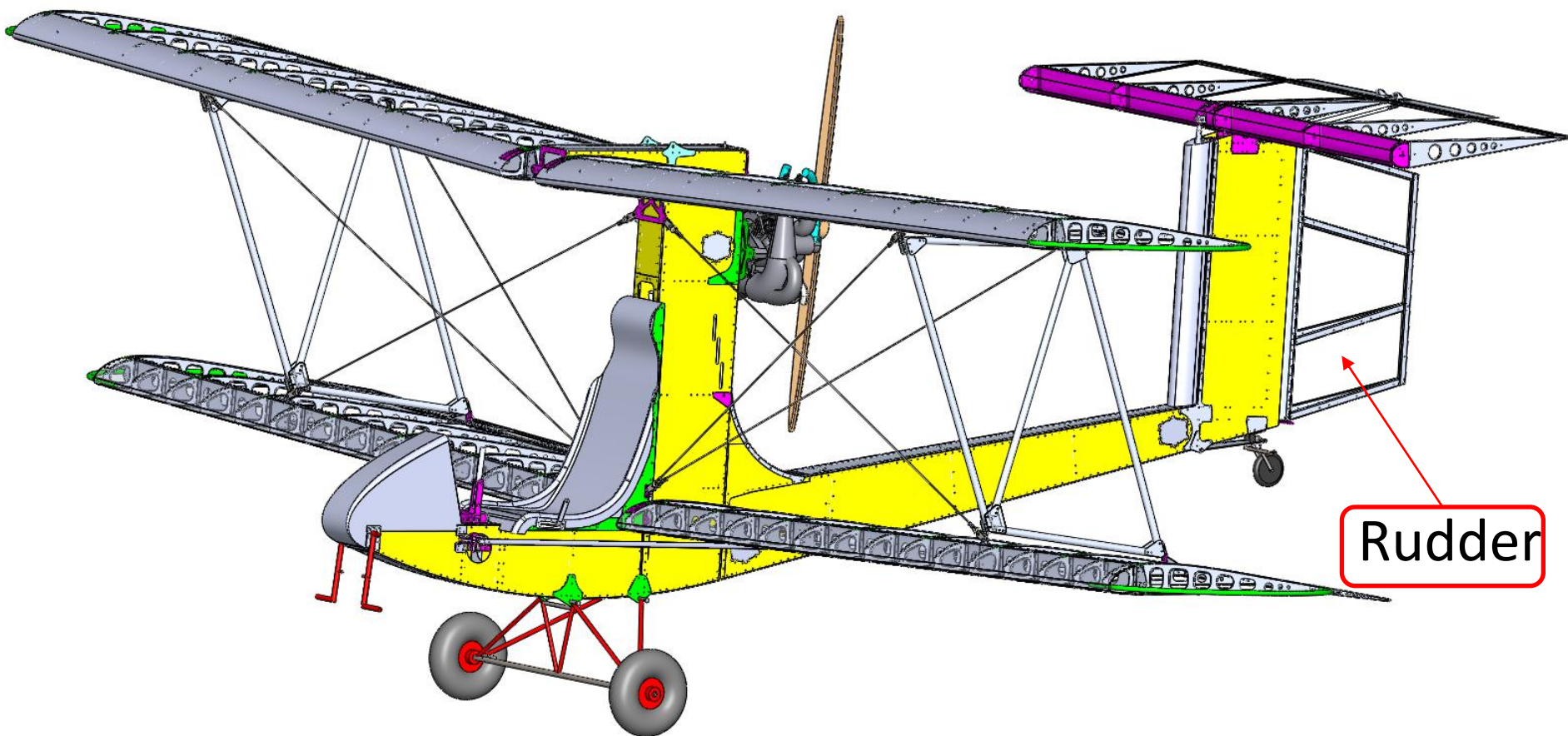
Document no.:

D2_T1_00

Revision:

R00

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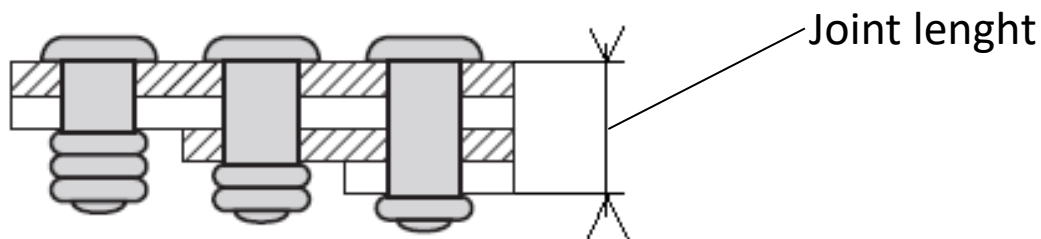
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General instructions:

- 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”:

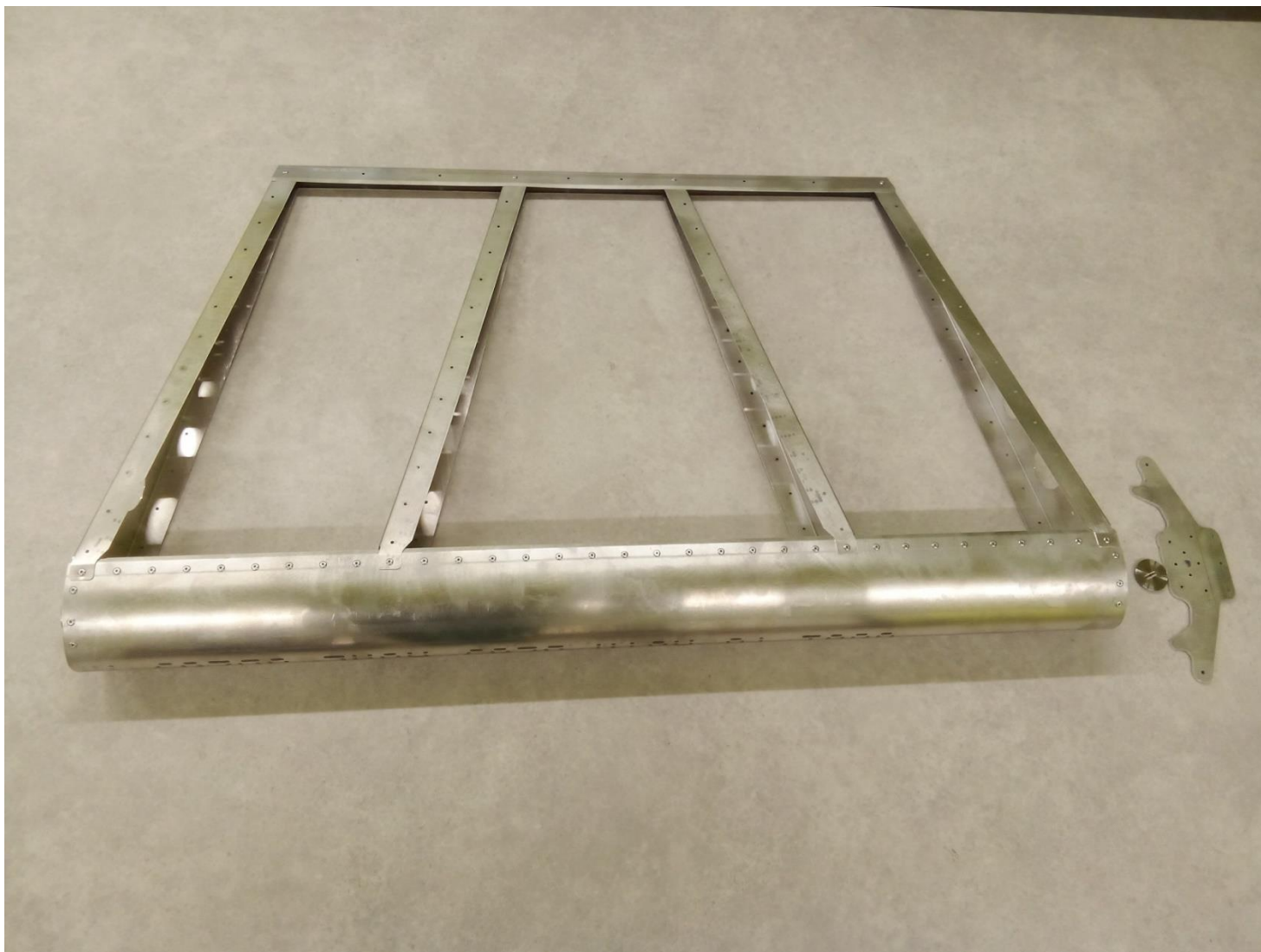


Blind rivet type:	Manufacturer part number:	Can be also marked as:		Min. length:	Max. length:
AVEX Φ 3,2x7,9 Al/St	16910410	Al 3,2x7,9	AVEX Φ 3,2x7,9 Al/Fe	0,8mm	4,8mm
AVEX Φ 3,2x11,2 Al/St	16910414	Al 3,2x11,2	AVEX Φ 3,2x11,2 Al/Fe	4,0mm	7,9mm
AVEX Φ 4x9,5 Al/St	16910512	Al 4x9,5	AVEX Φ 4x9,5 Al/Fe	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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Assembly tool

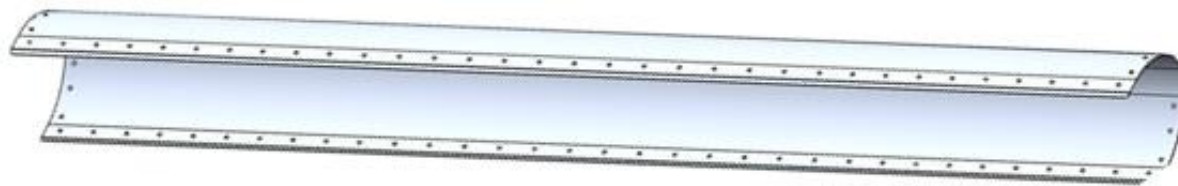


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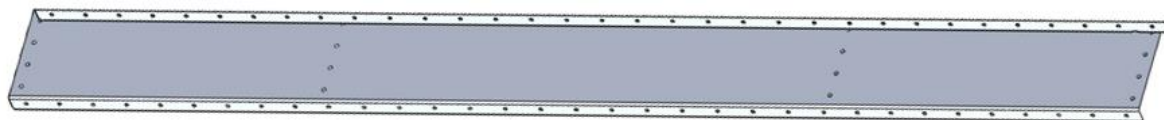
Part: D2_T3_01N

Quantity: 1 piece



Part: D2_T3_02N

Quantity: 1 piece



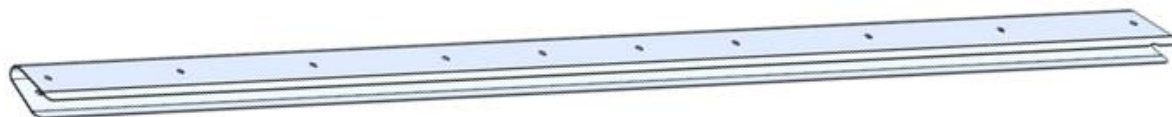
Part: D2_T2_03N

Quantity: 2 pieces



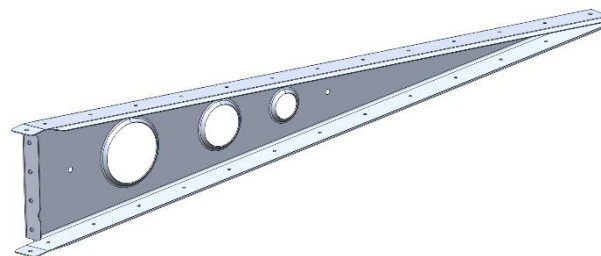
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Quantity: 1 piece



Part: D2_T3_05N

Quantity: 4 pieces

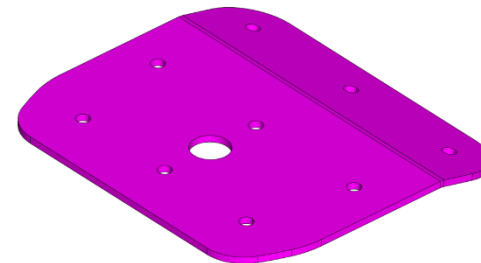


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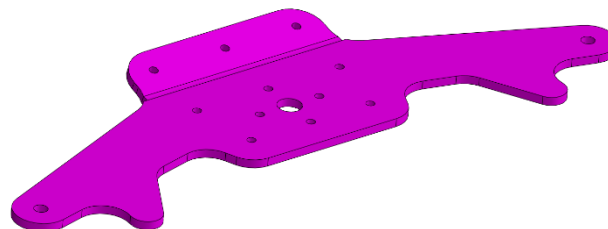
Part: D2_T3_06N

Quantity: 1 piece



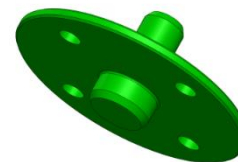
Part: D2_T3_07N

Quantity: 1 piece



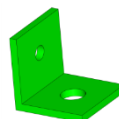
Part: D2_T3_08N

Quantity: 1 piece



Part: D2_T3_09N

Quantity: 1 piece

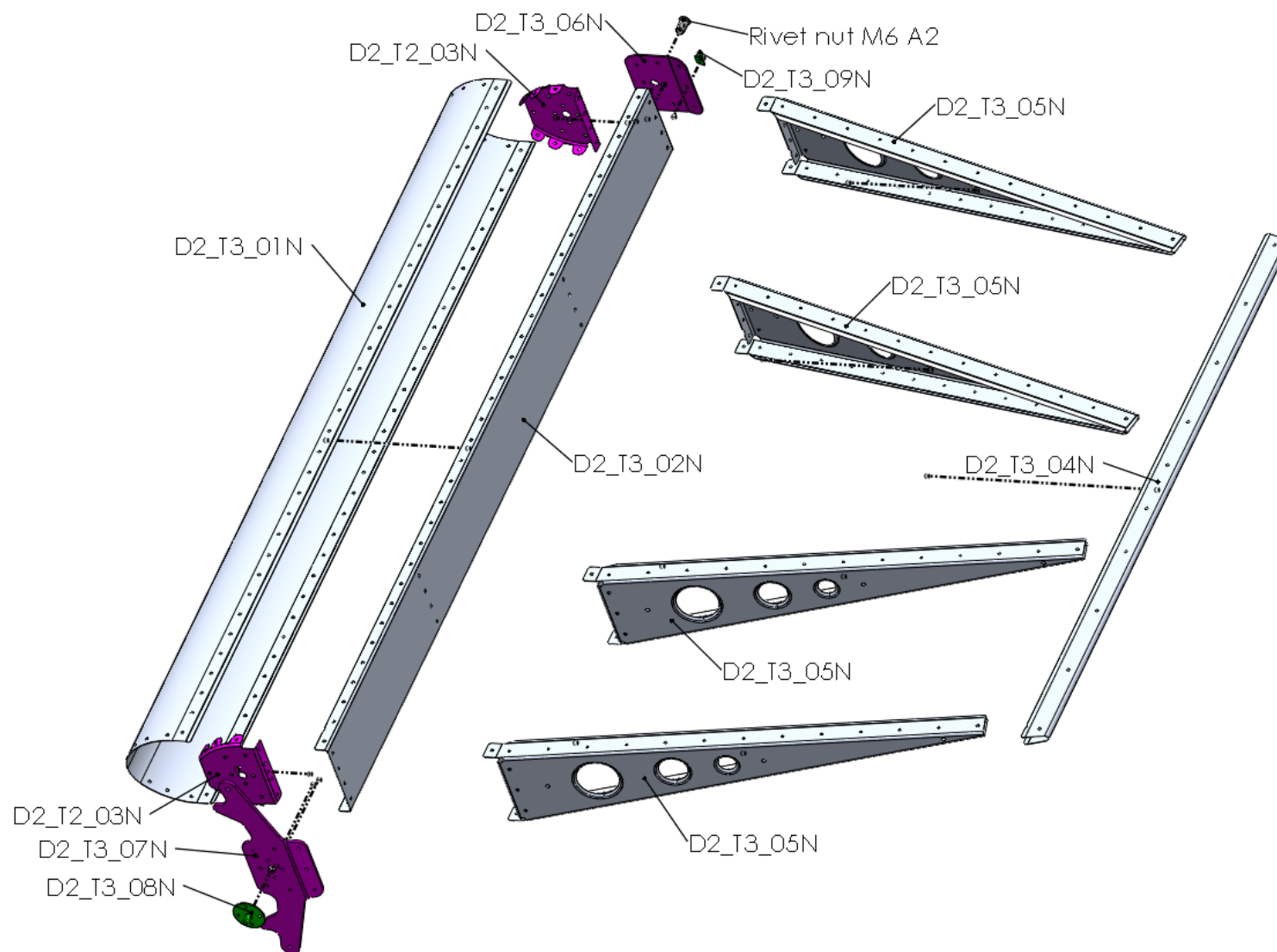


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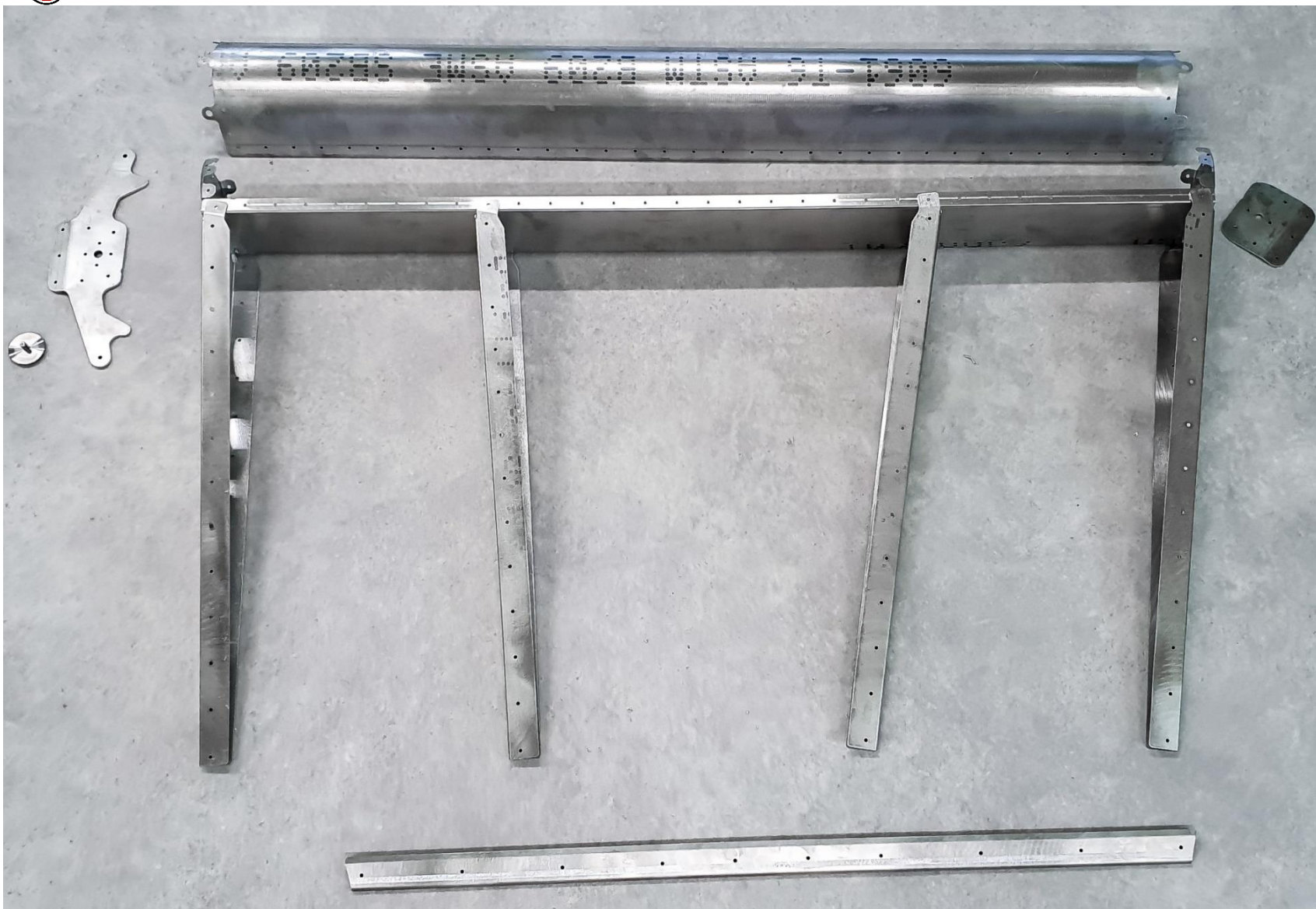


Standard Parts		
Detail picture	Part	Quantity
	Flat rivet nuts M6 x 16 mm	1
	Blind rivets AVEX Ø 3,2x7,9 AL/St	122

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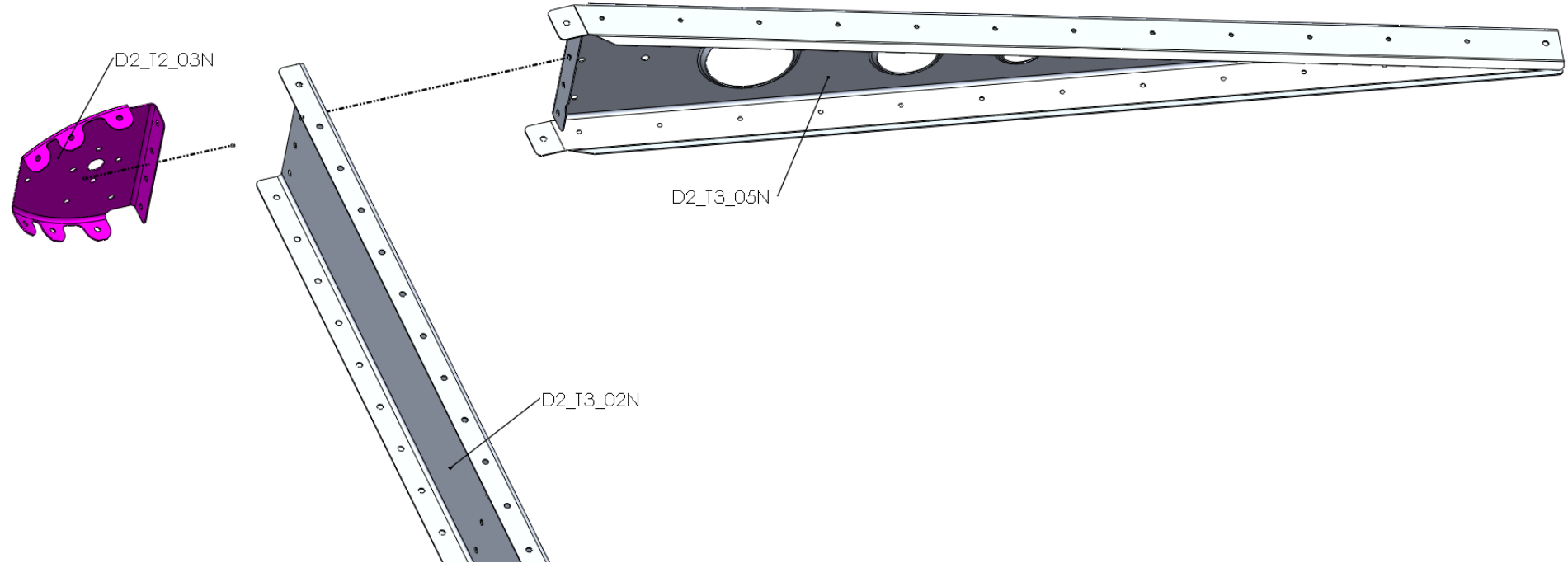
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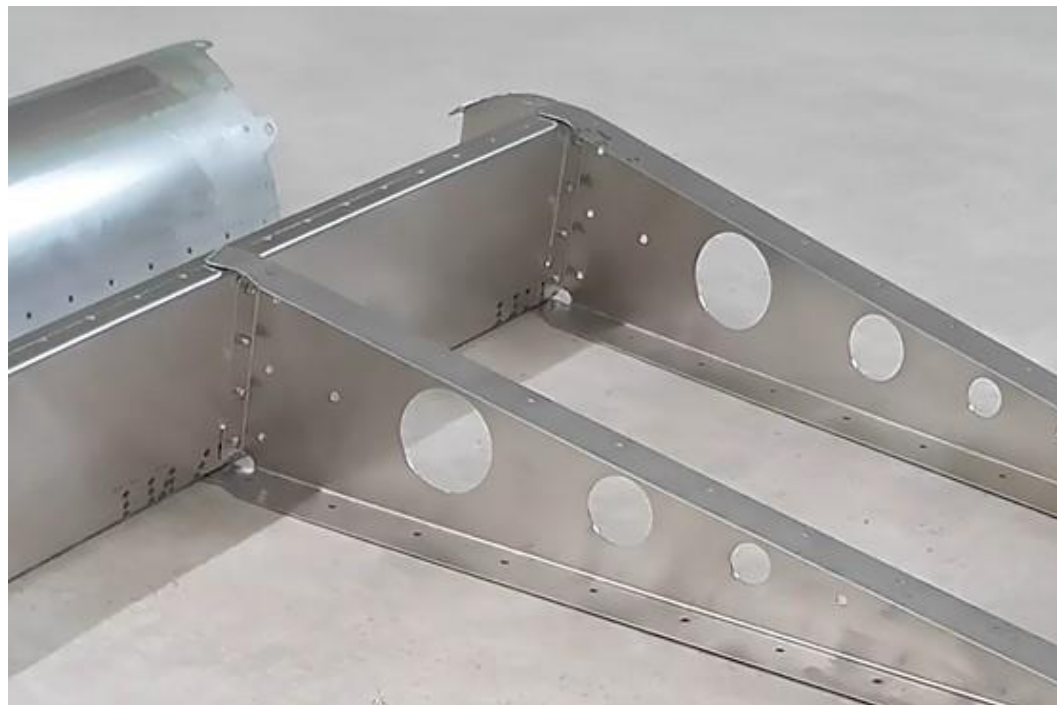
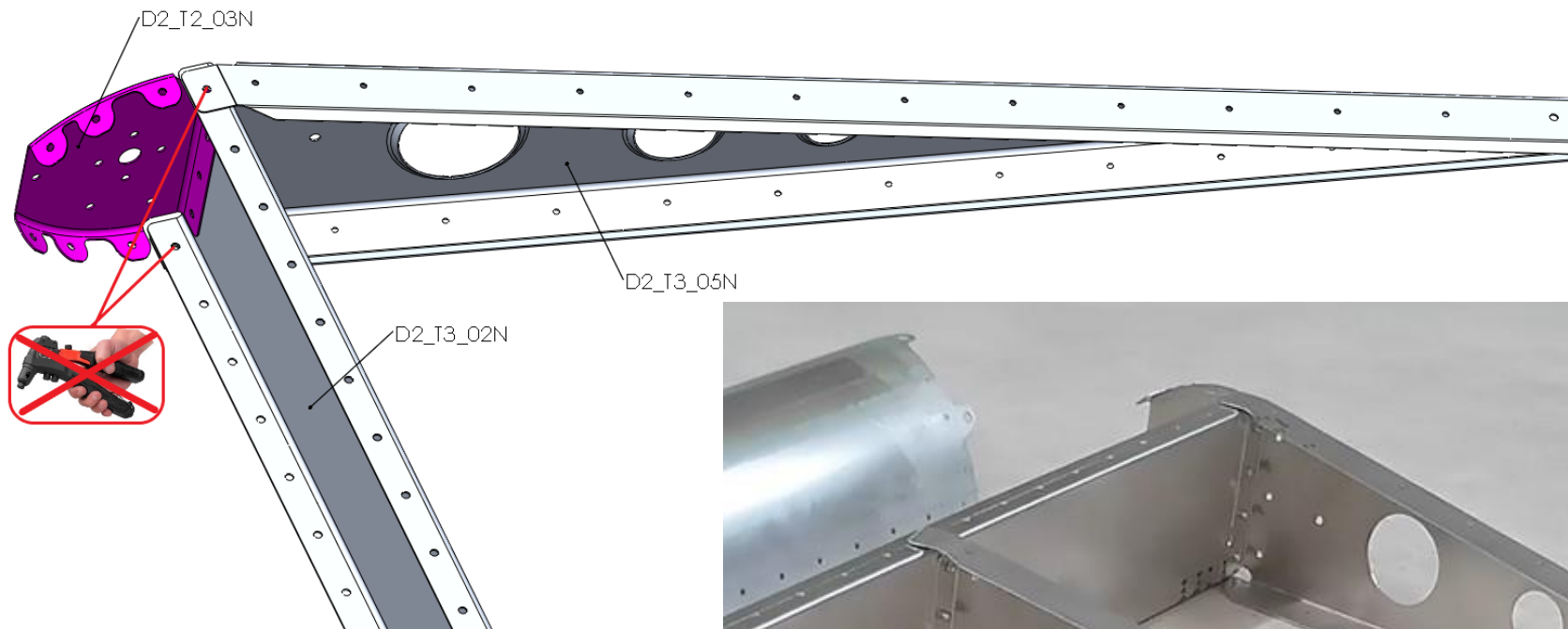
Step 1



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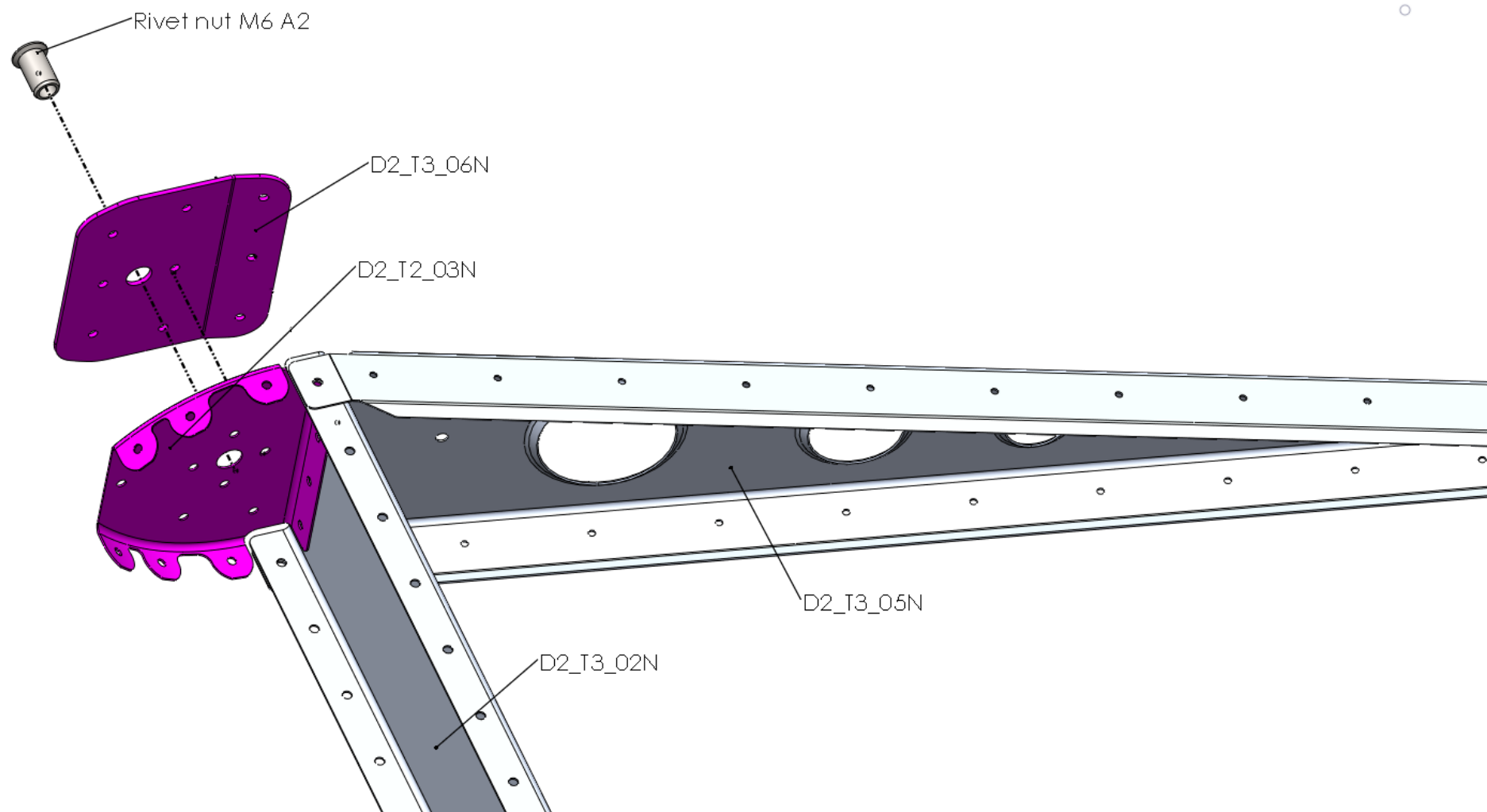
Step 2



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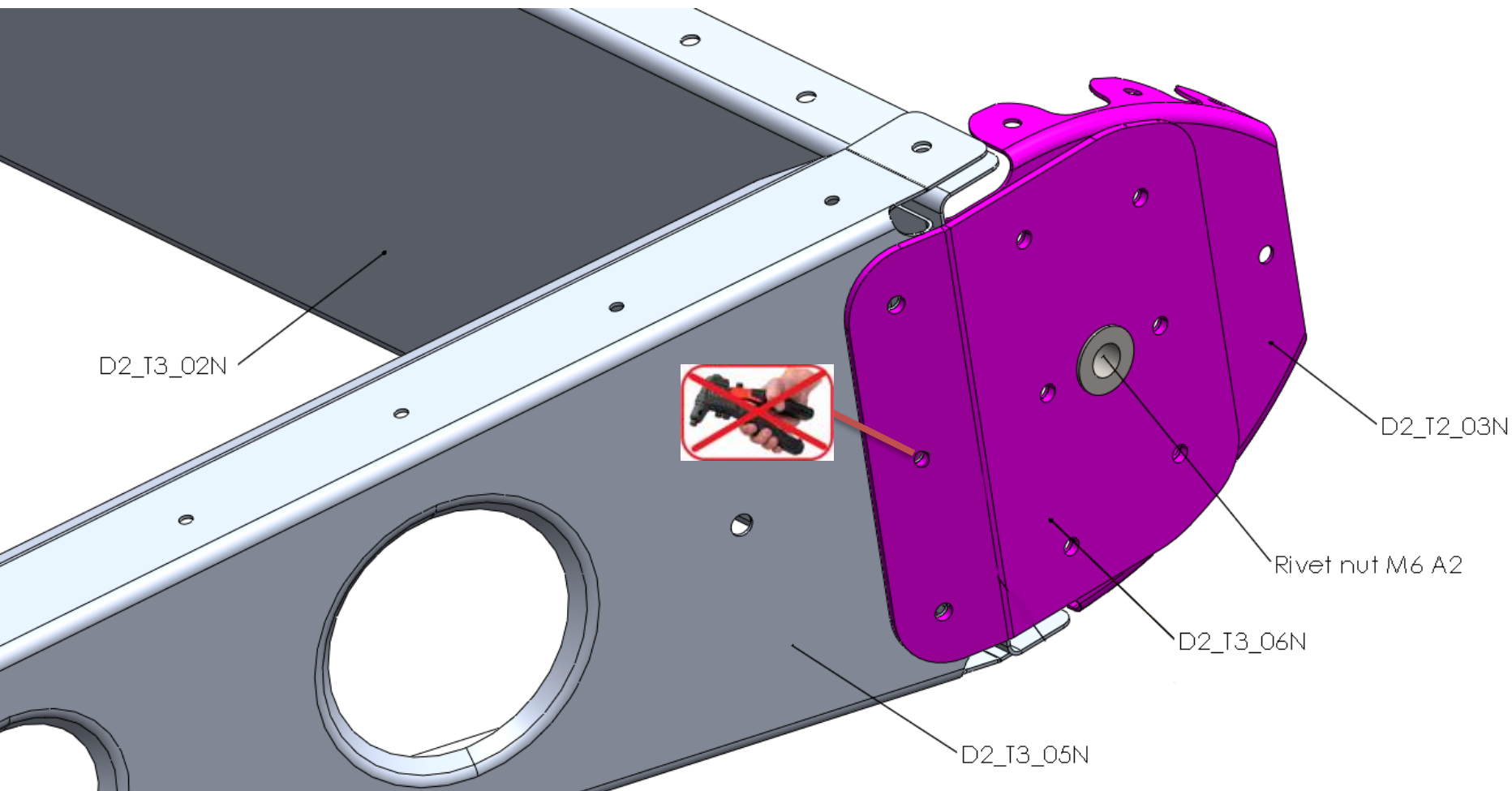
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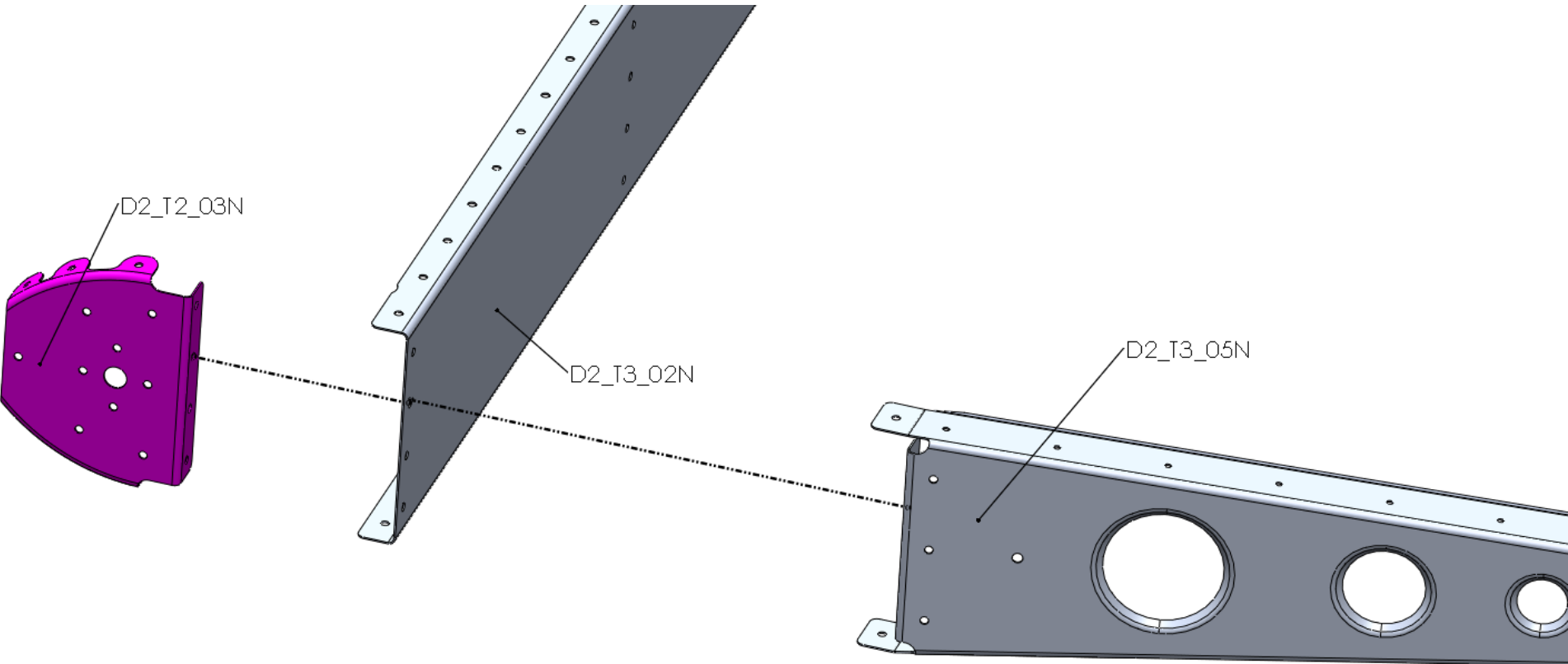
Step 4



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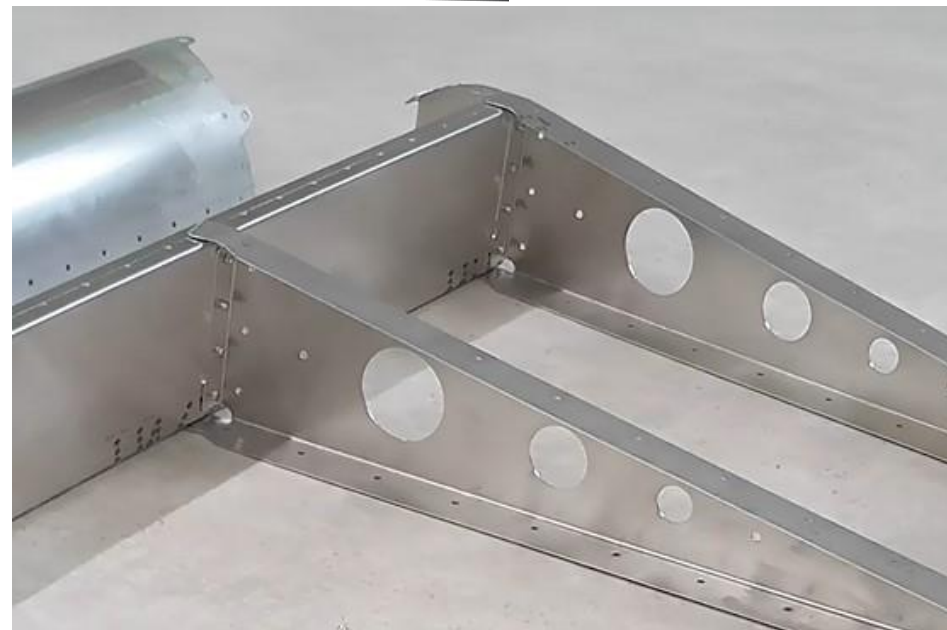
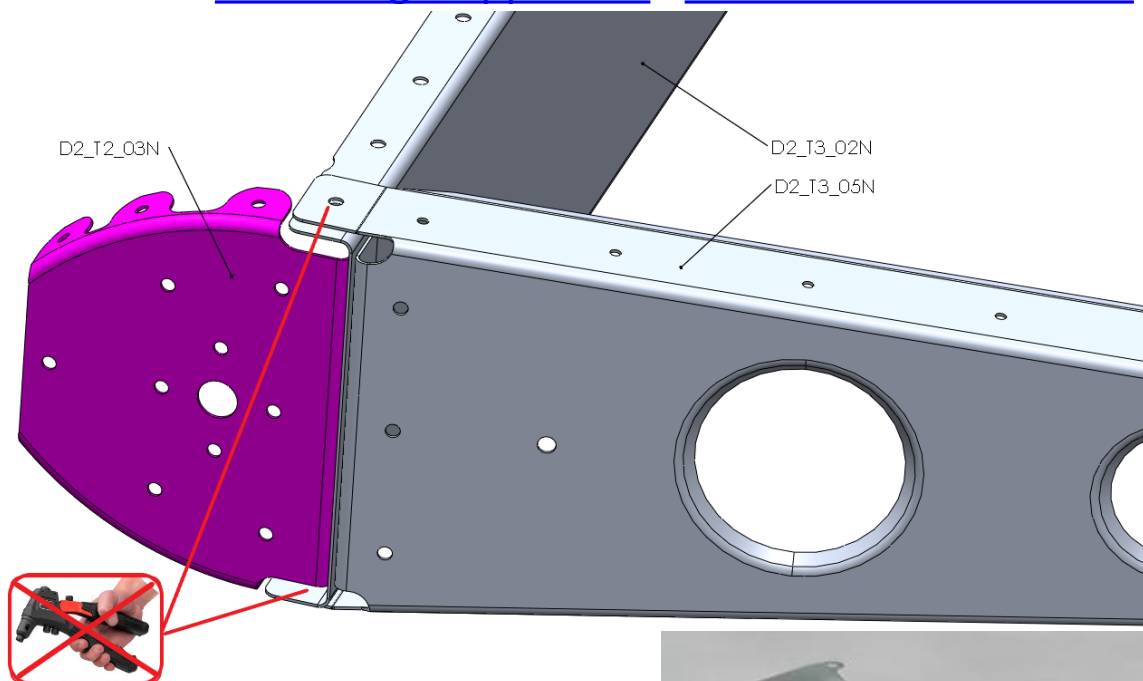
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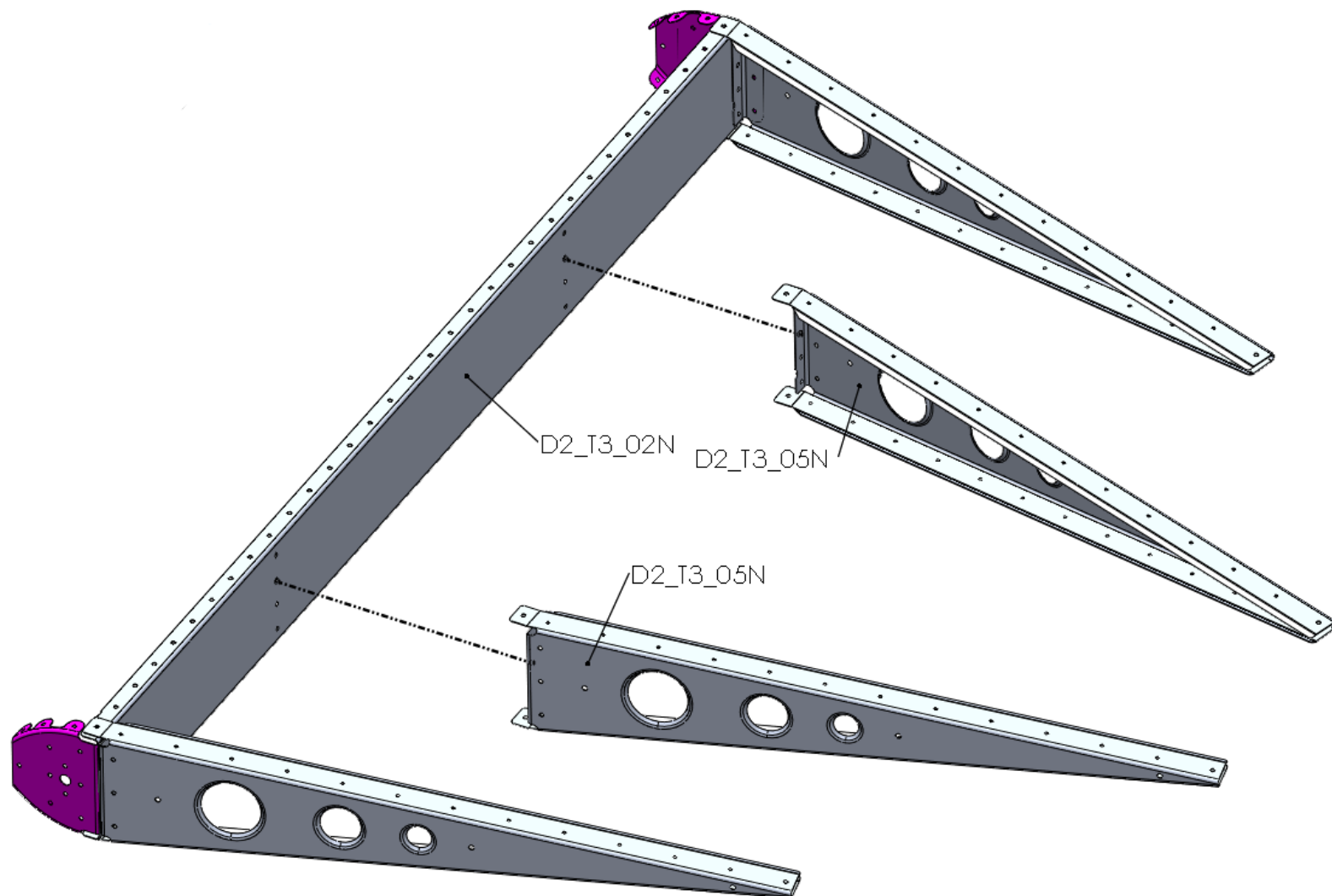
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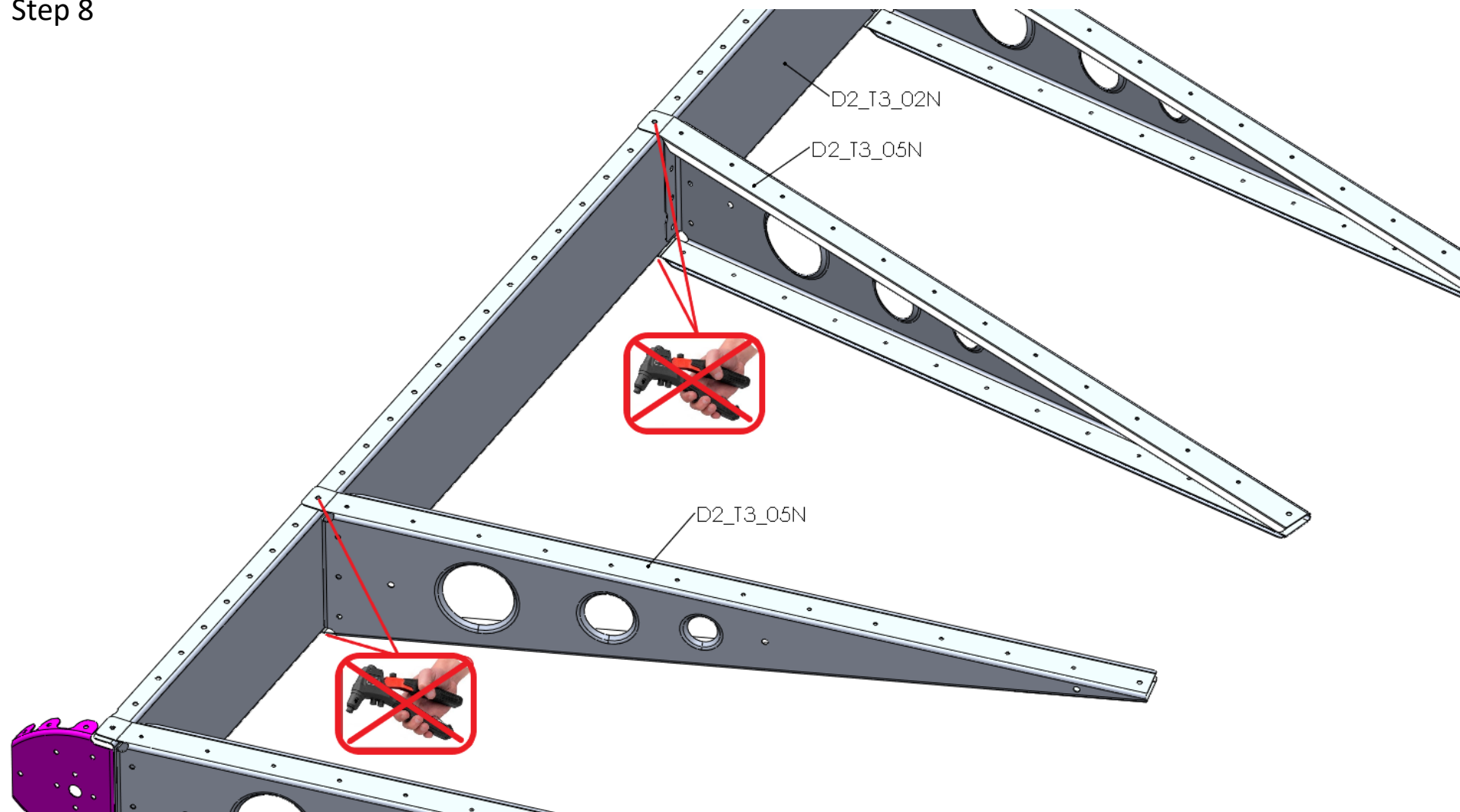
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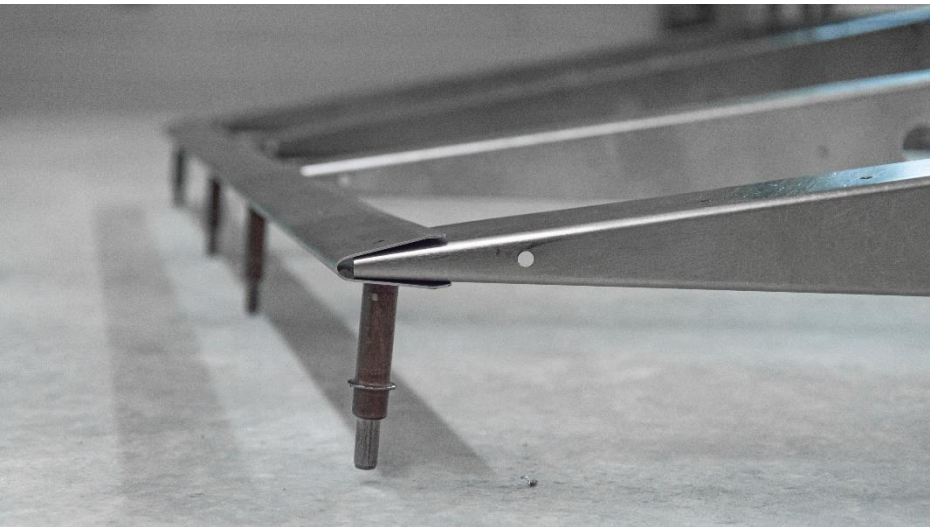
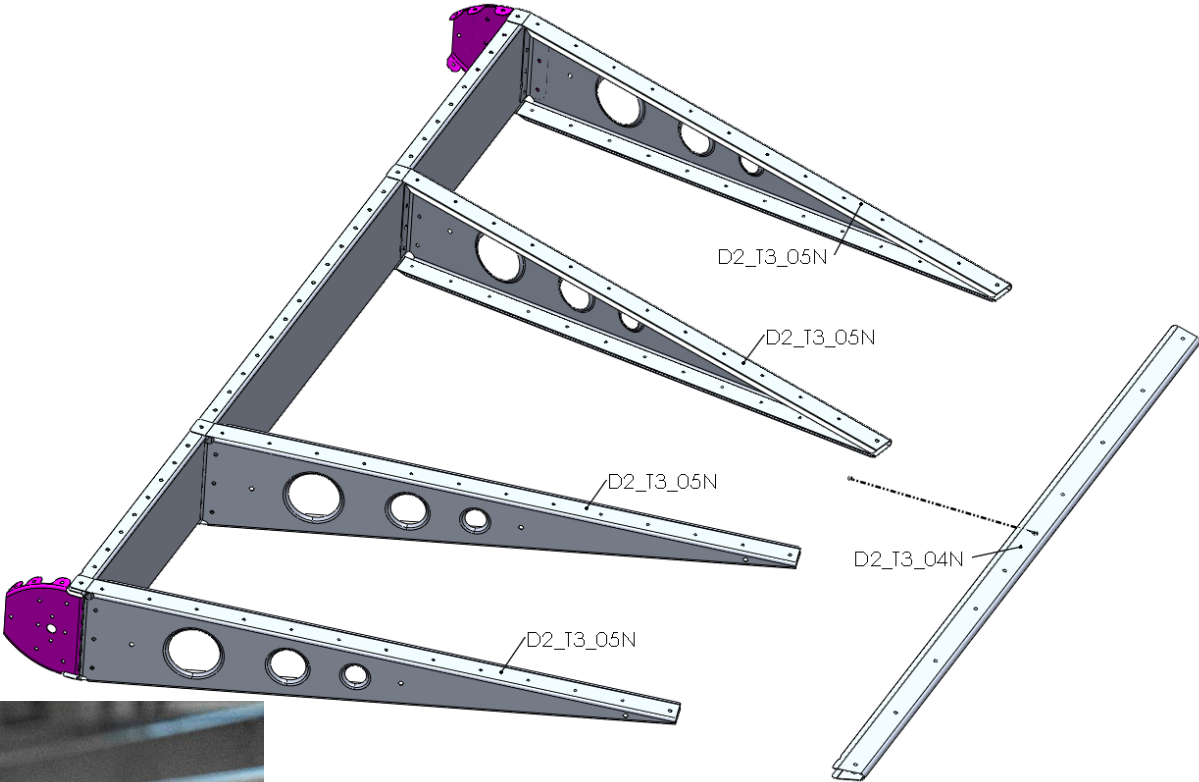
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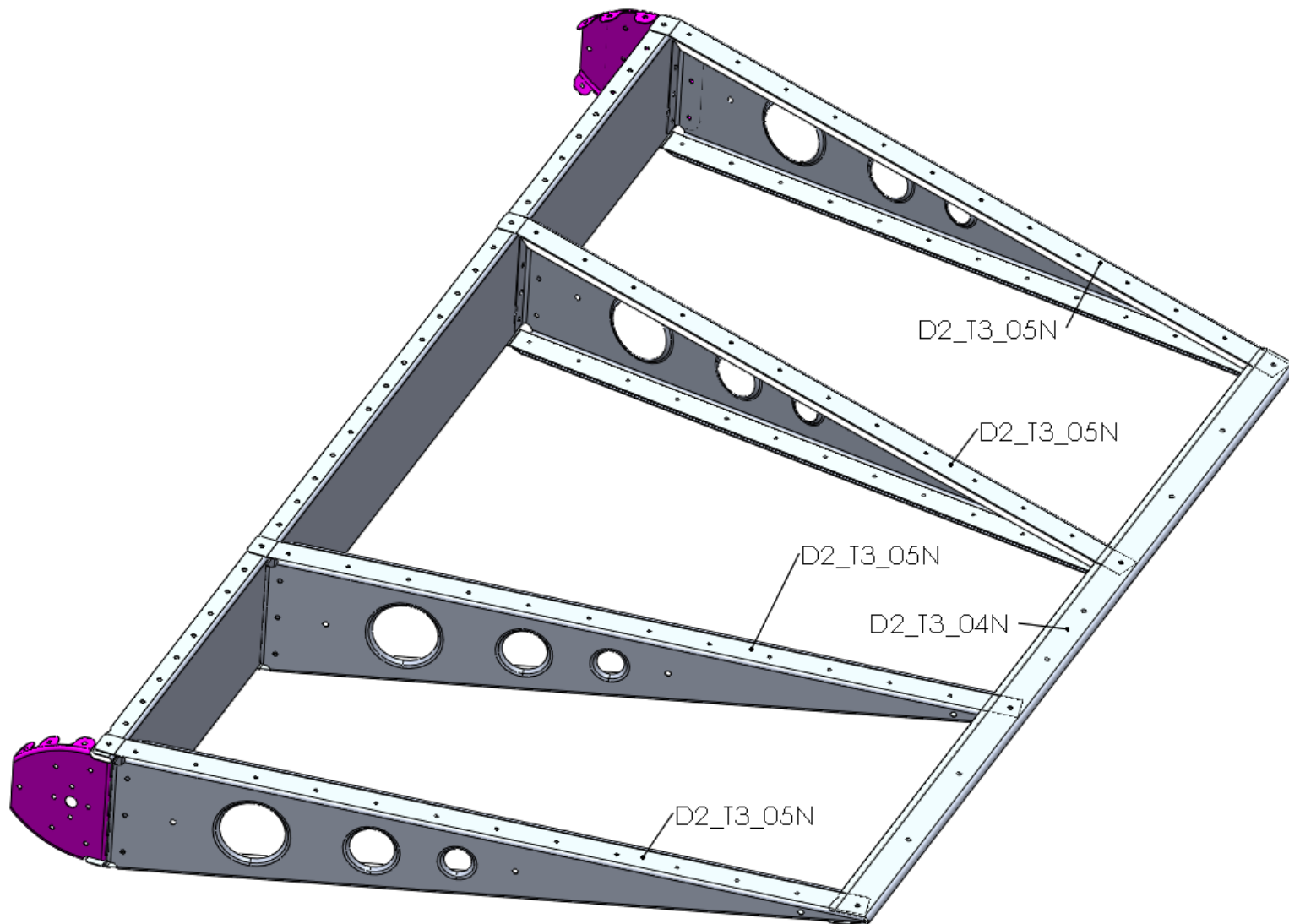
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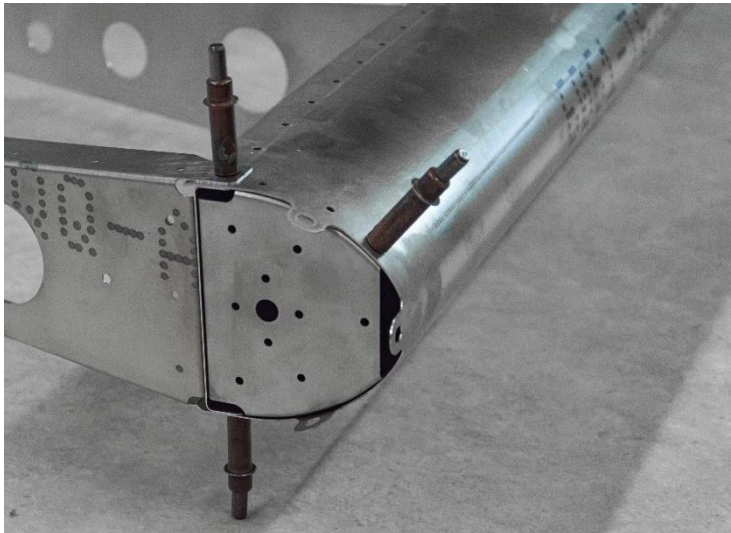
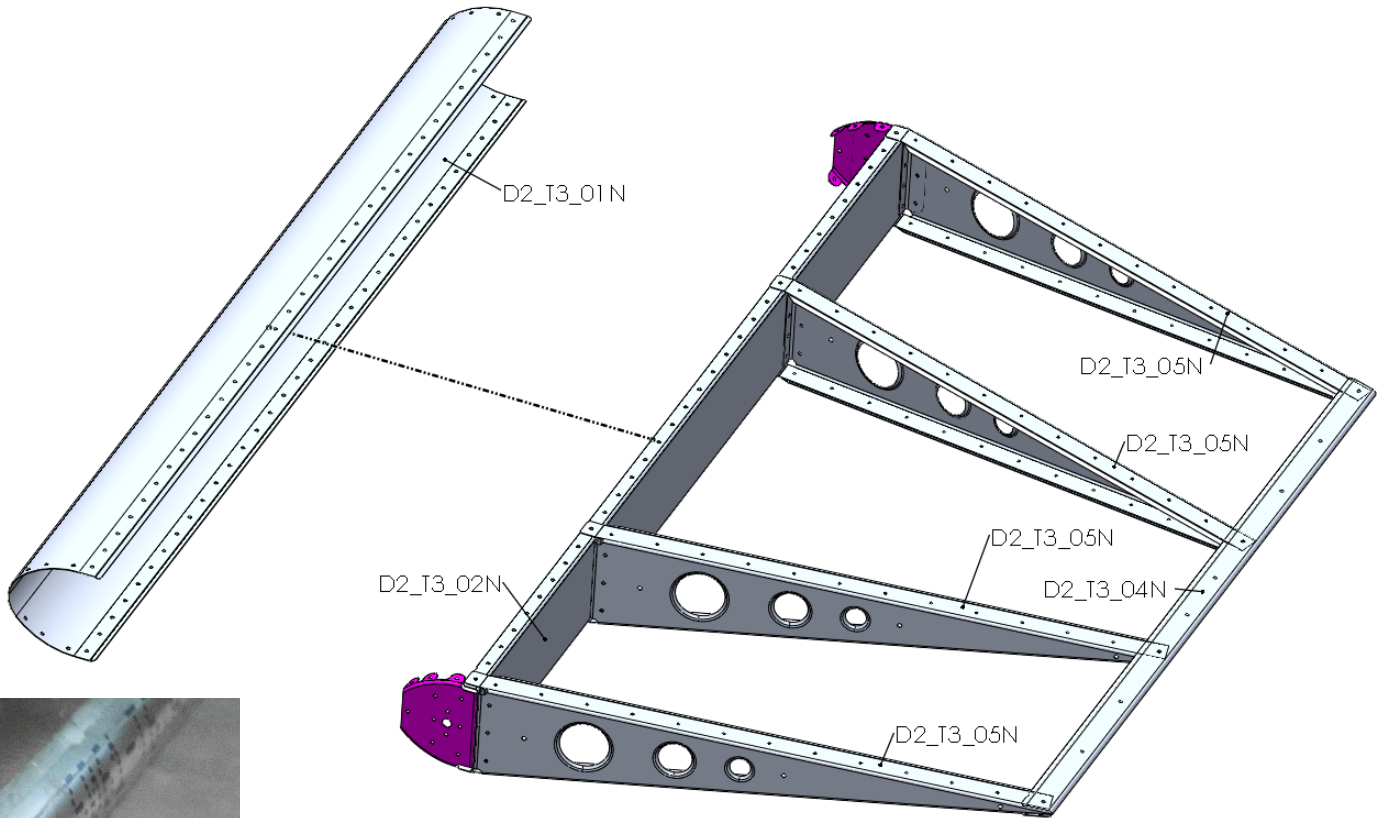
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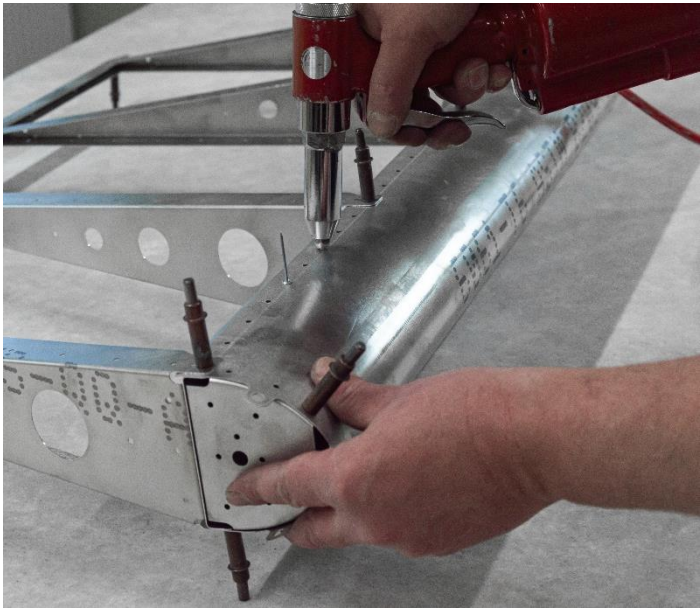
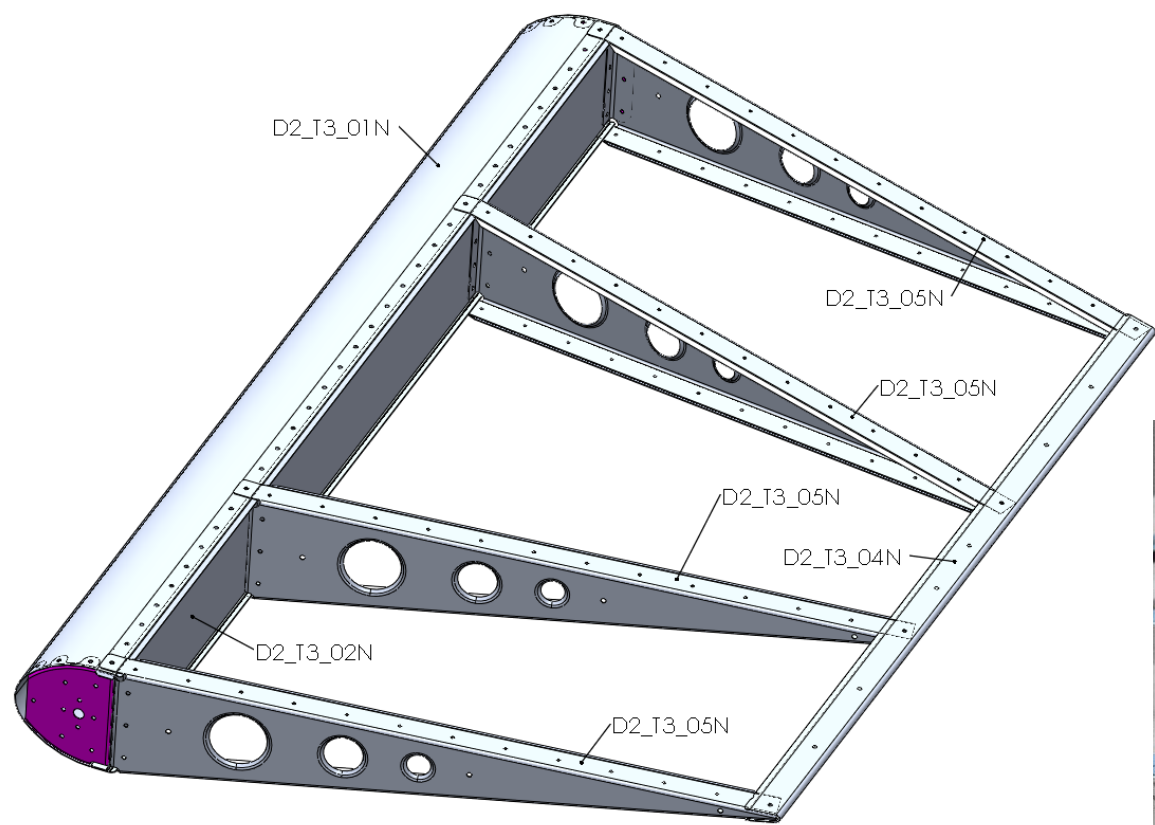
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Step 13

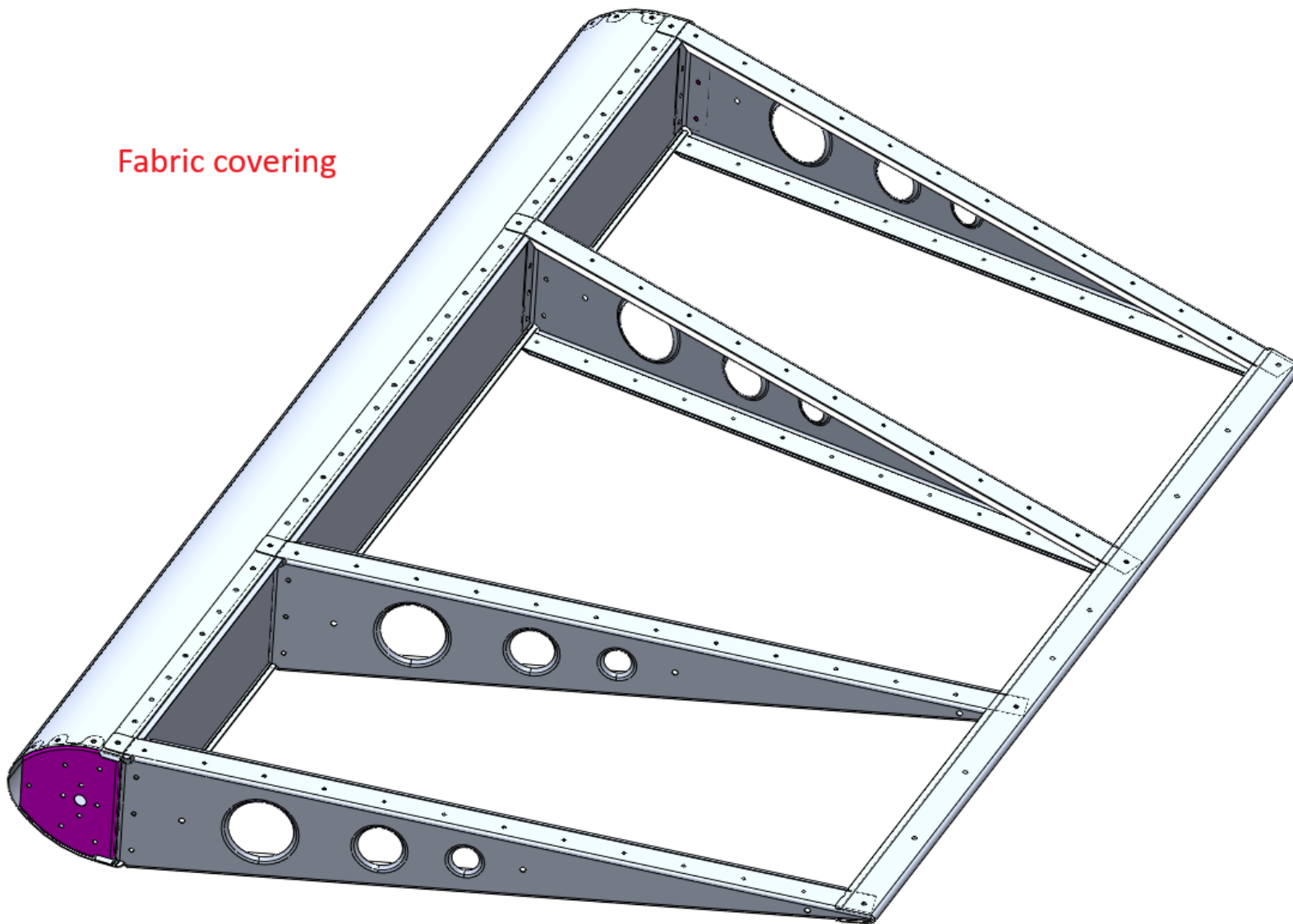


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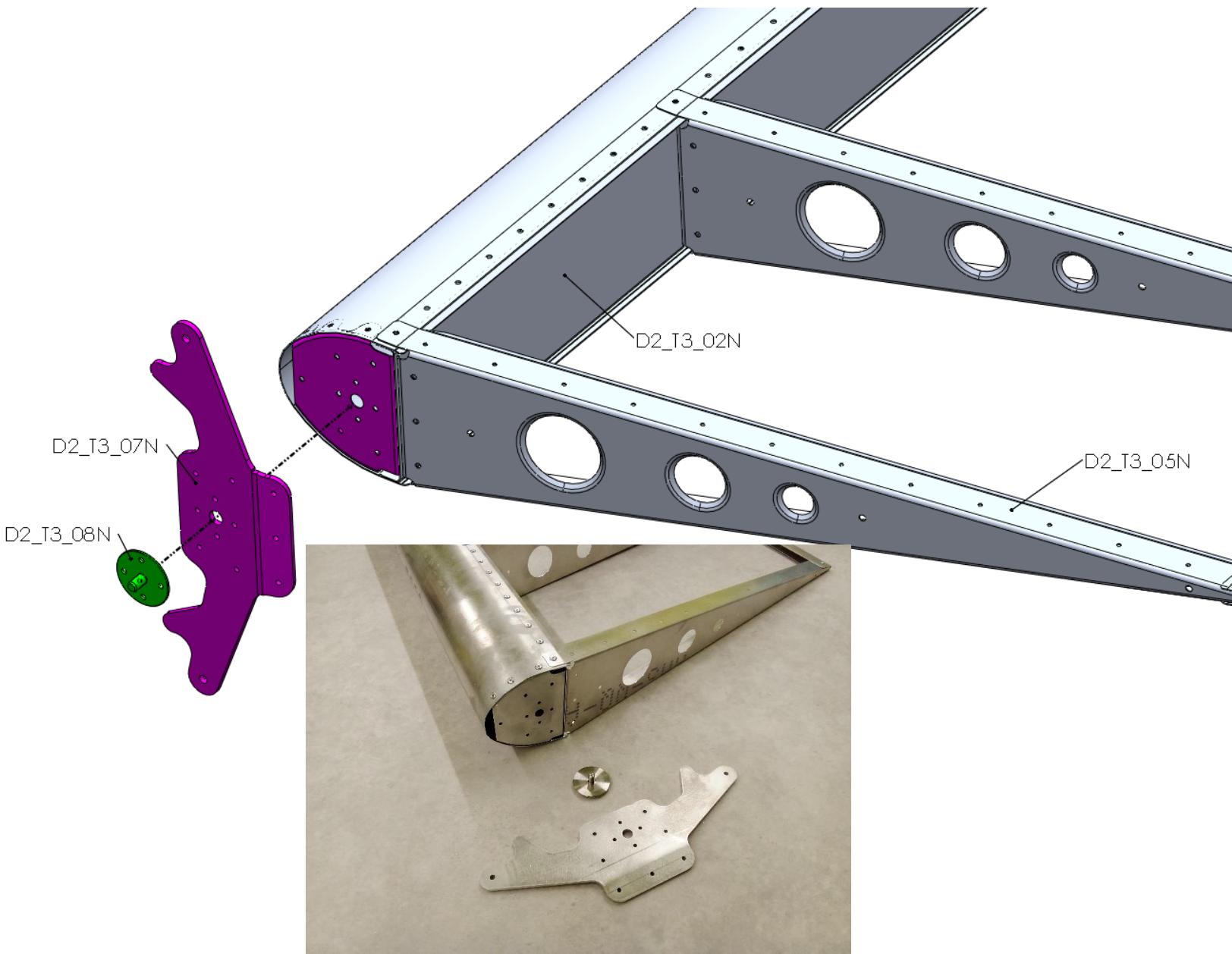
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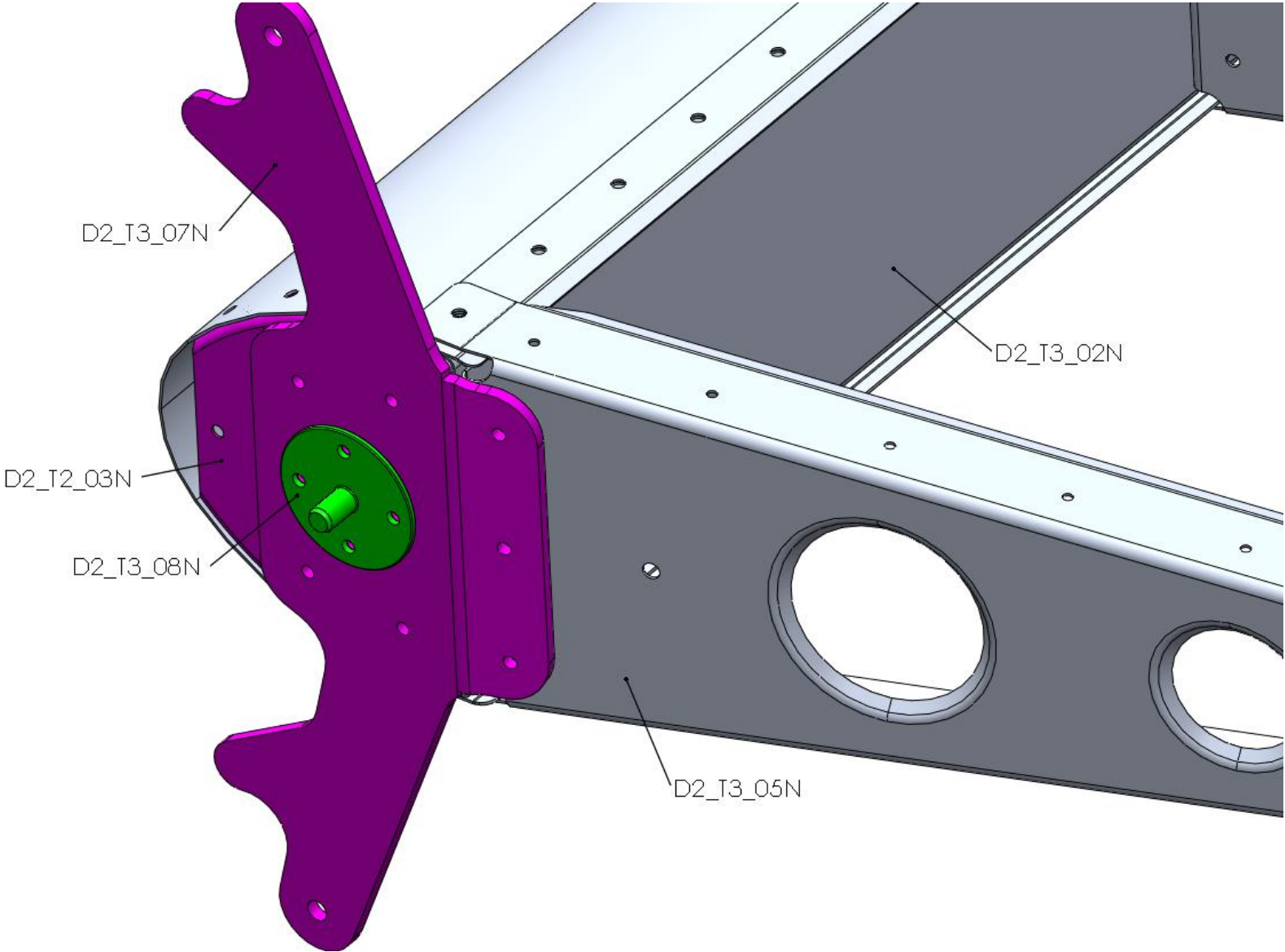
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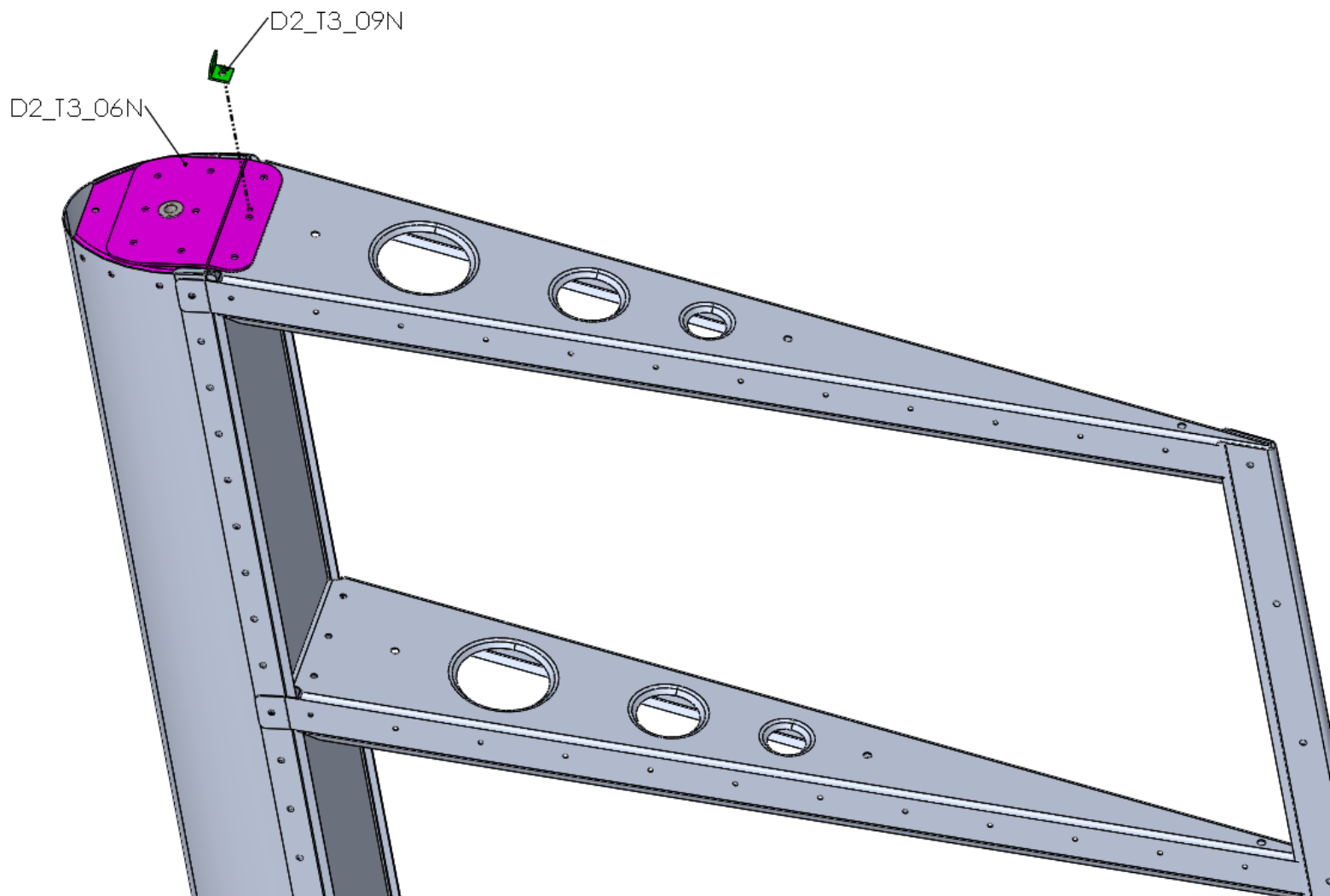
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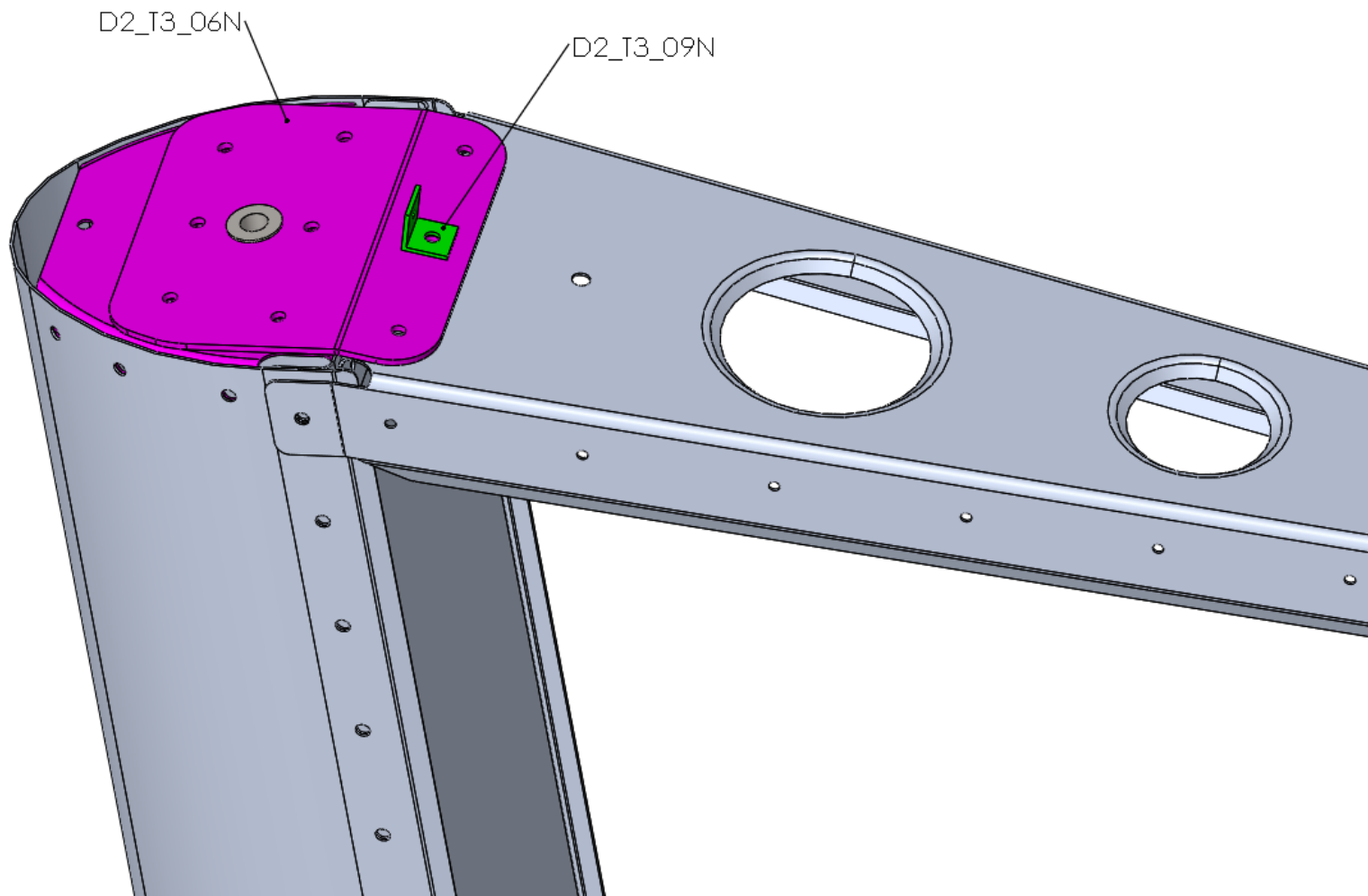
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