



Step 1: Read Section 5 and preview all assembly steps prior to construction.

NOTE: Step 2 through Step 4 refer to Figure 1. In these steps you will fabricate a wedge tool that will assist you when blind riveting in locations where you are unable to align the tool and the rivet. The wedge tool(s) will be placed between the rivet and the riveting tool enabling the riveting tool to pull the rivet from an angle, yet still achieve a properly seated manufactured head. For an example of how to use this tool refer to Section 5D.

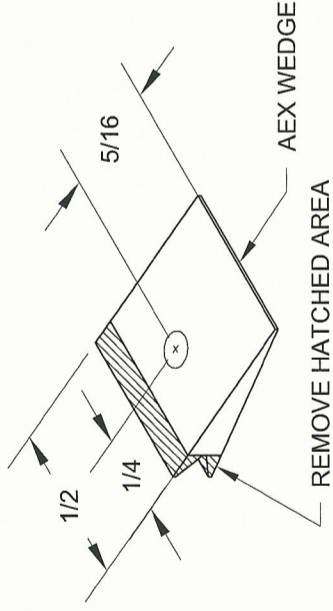


FIGURE 1:
WEDGE TOOL FABRICATION

Step 2: Trim both of the 'ears' off of the AEX Wedge.

Step 3: Beginning 1/4 inch from either end of the AEX Wedge, drill a hole every 1/2 inch using a #40 drill bit.

Step 4: Cut the AEX Wedge between each of the holes drilled in Step 3. You will now have multiple wedge tools to aid riveting, when applicable.

Step 5: Final-Drill #12 the 3/16 holes in the flange of the VS-1210 Hinge Brackets called out in Figure 2.

Step 6: Separate the VS-1210 Hinge Brackets by removing the material called out in Figure 2.

Separation is best done by cutting through the joining material and finishing the edge with a file.

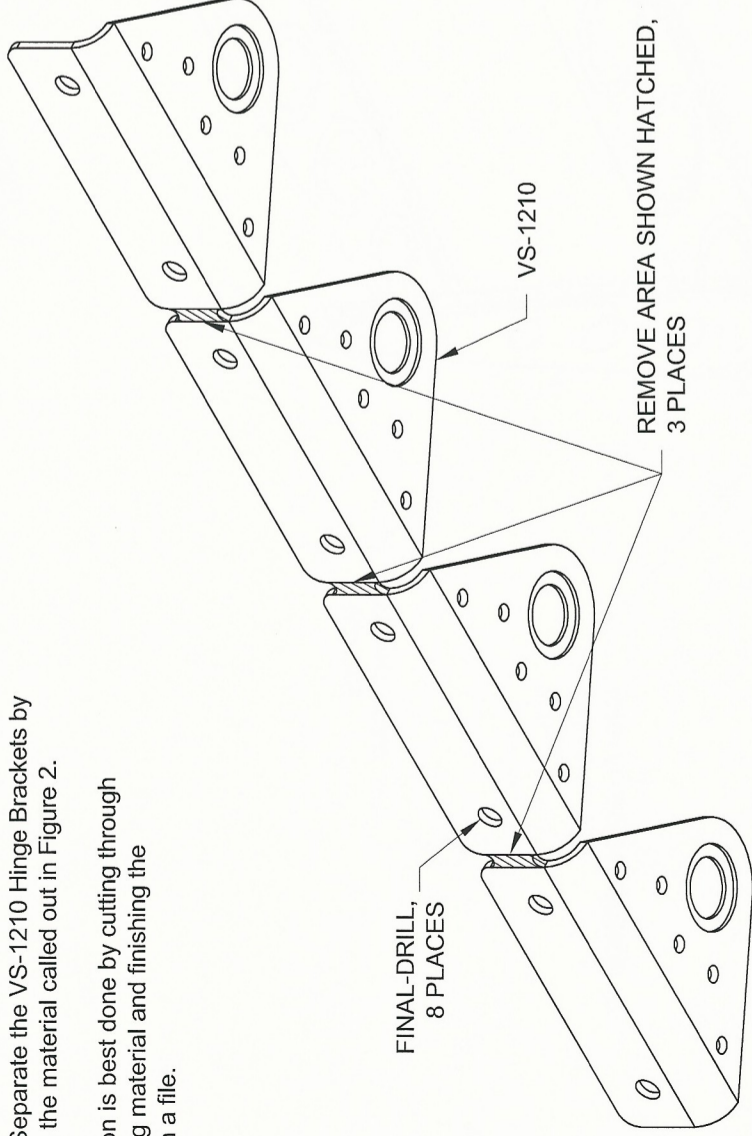


FIGURE 2:
HINGE BRACKET PREPARATION

Step 7: Mark the VS-1211 Hinge Spacers with the VS-1211A and VS-1211B part numbers as shown in Figure 3. Separate the VS-1211A and VS-1211B by removing the material called out in Figure 3.

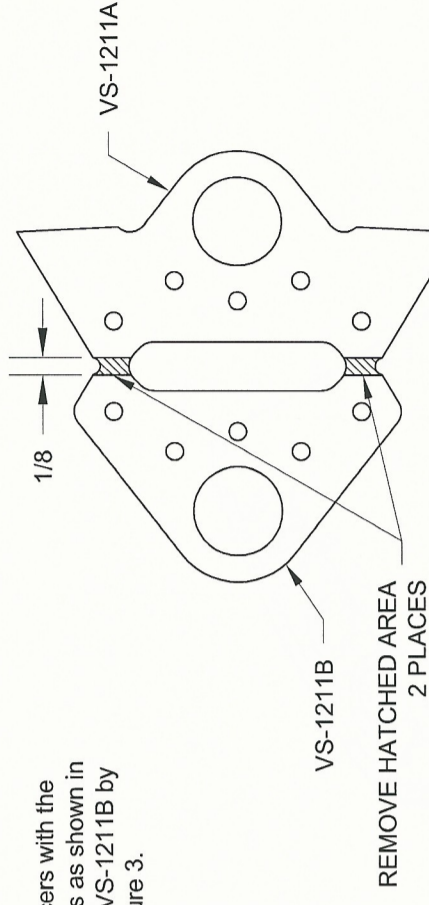


FIGURE 3:
HINGE SPACER SEPARATION

Step 8: Cleco the VS-1211A Hinge Spacer between two of the VS-1210 Hinge Brackets. Final-Drill #30 the 1/8 inch holes.

Repeat Step 8 with the VS-1211B Hinge Spacer and the remaining two hinge brackets.

Mark the parts (Section 5C), to return them to the same position as drilled. Then remove the clecoes and deburr (Section 5B) the edges and holes of all four hinge brackets and both hinge spacers.

Step 9: Insert the called out bearing into the largest hole in the VS-1211A Hinge Spacer. Re-cleco, then rivet the hinge spacer between the two VS-1210 Hinge Brackets in the same position as drilled per call-outs in Figure 4.

Refer to this assembly as the Lower Hinge Assembly.

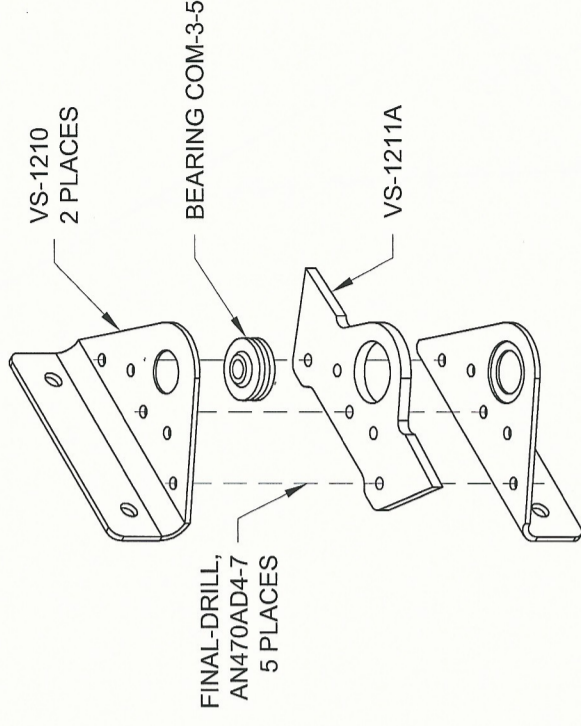


FIGURE 4:
LOWER HINGE ASSEMBLY

Step 10: Insert the called out bearing into the largest hole in the VS-1211B Hinge Spacer. Re-cleco, then rivet the hinge spacer between the two VS-1210 Hinge Brackets in the same position as drilled per call-outs in Figure 5.

Refer to this assembly as the Upper Hinge Assembly.

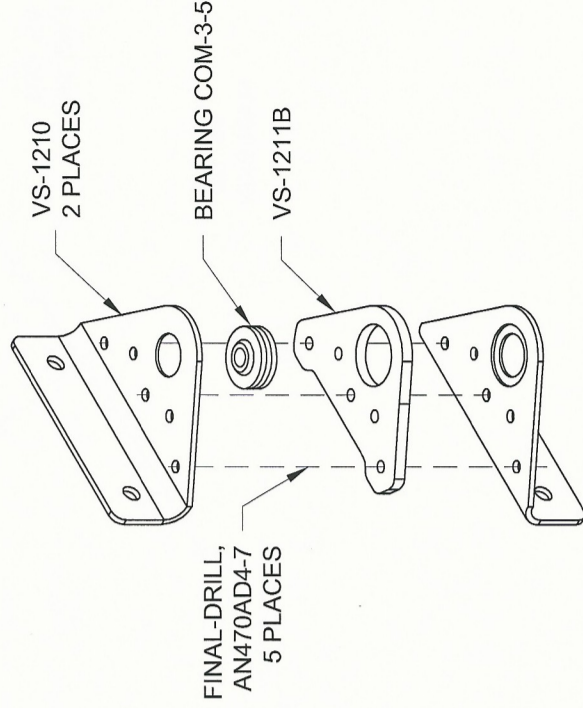


FIGURE 5:
UPPER HINGE ASSEMBLY