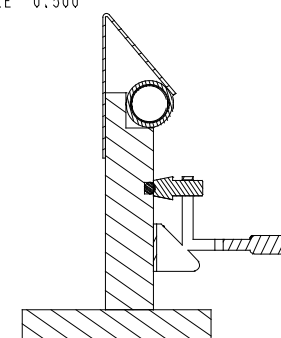


BONDING STEP: ALL COMPONENTS)

1. CLEAN AND MASK ALL COMPONENTS.
2. APPLY ADHESIVE AND CLAMP END ATTACHMENT (250176.PRT) TO RISER ONE AS SHOWN.)
3. APPLY ADHESIVE AND INSERT END PIECES (250180.PRT & 250181.PRT) INTO STRUT LONGERON (250179). CLAMP THIS COMPONENT GROUP (250180 INTO RISER THREE, 250181 INTO RISER FIVE) AS SHOWN.
4. APPLY ADHESIVE AND SCREW STRUT STABILIZER (250178.PRT) TO RISER FOUR AS SHOWN.)
5. APPLY ADHESIVE AND PLACE MID ATTACHMENTS (250142.PRT) ON RISERS TWO AND THREE AS SHOWN.
6. APPLY ADHESIVE AND CLAMP MID ATTACHMENT KEEPERS (250141.PRT) TO RISERS TWO AND THREE AS SHOWN.
7. APPLY ADHESIVE AND POSITION SLEEVE (250182.PRT) ON MAIN LONGERON (250175.PRT) IN APPROXIMATE POSITION, 86 MM FROM ONE END. INSERT THE OTHER END OF THIS COMPONENT GROUP INTO END ATTACHMENT (250176.PRT) ON RISER ONE AND LOCATE THE SLEEVE INTO POSITION ON RISER FIVE AS SHOWN. HOLD SLEEVE IN PLACE WITH SPRING CLAMP (250192.PRT) AND M6 SCREW AS SHOWN.
8. APPLY ADHESIVE AND CLAMP MID ATTACHMENT KEEPERS (250141.PRT) TO RISERS TWO AND THREE AS SHOWN.
9. CURE IN PLACE.
10. REMOVE FROM FIXTURE.

[illegible]