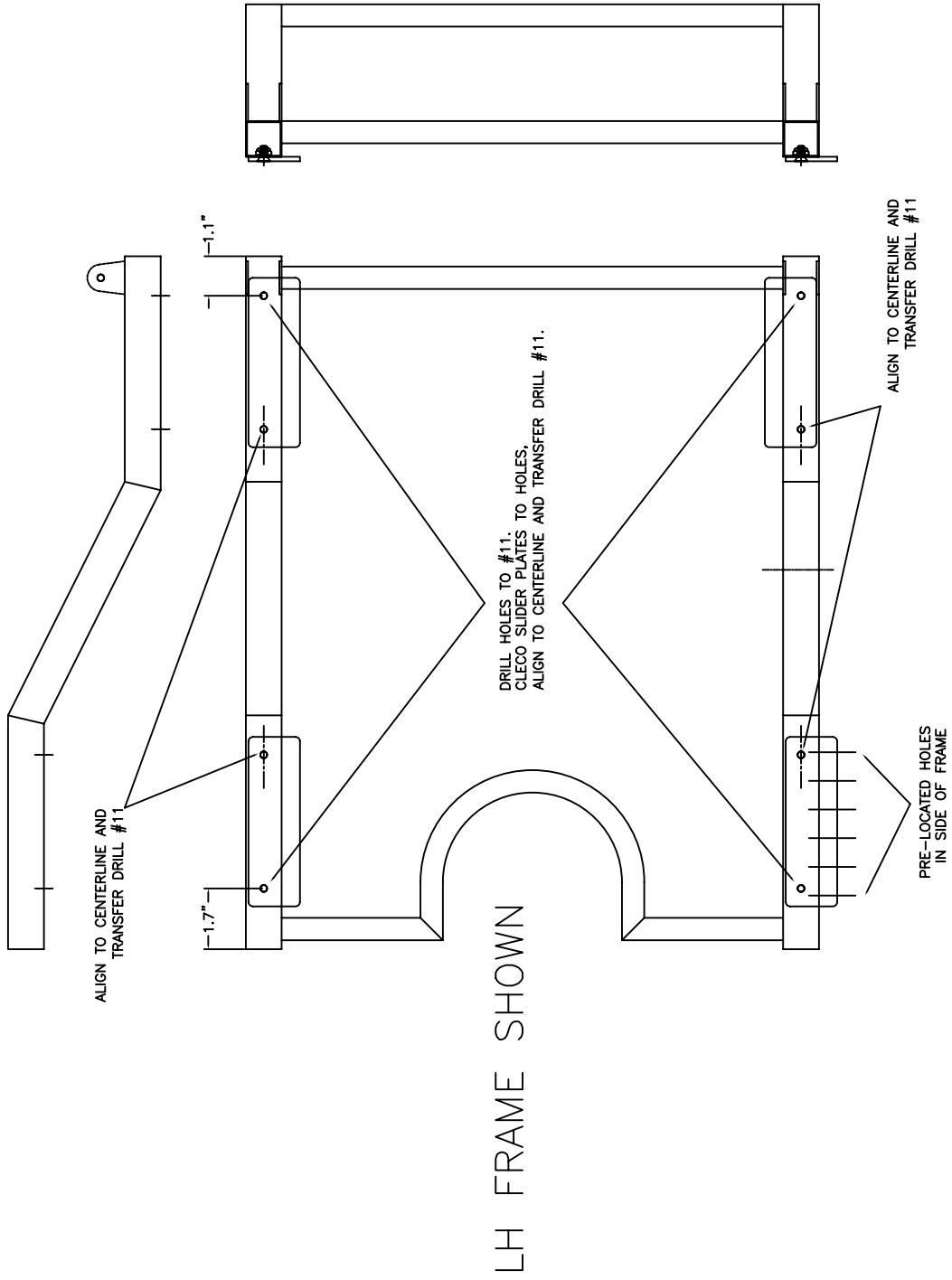


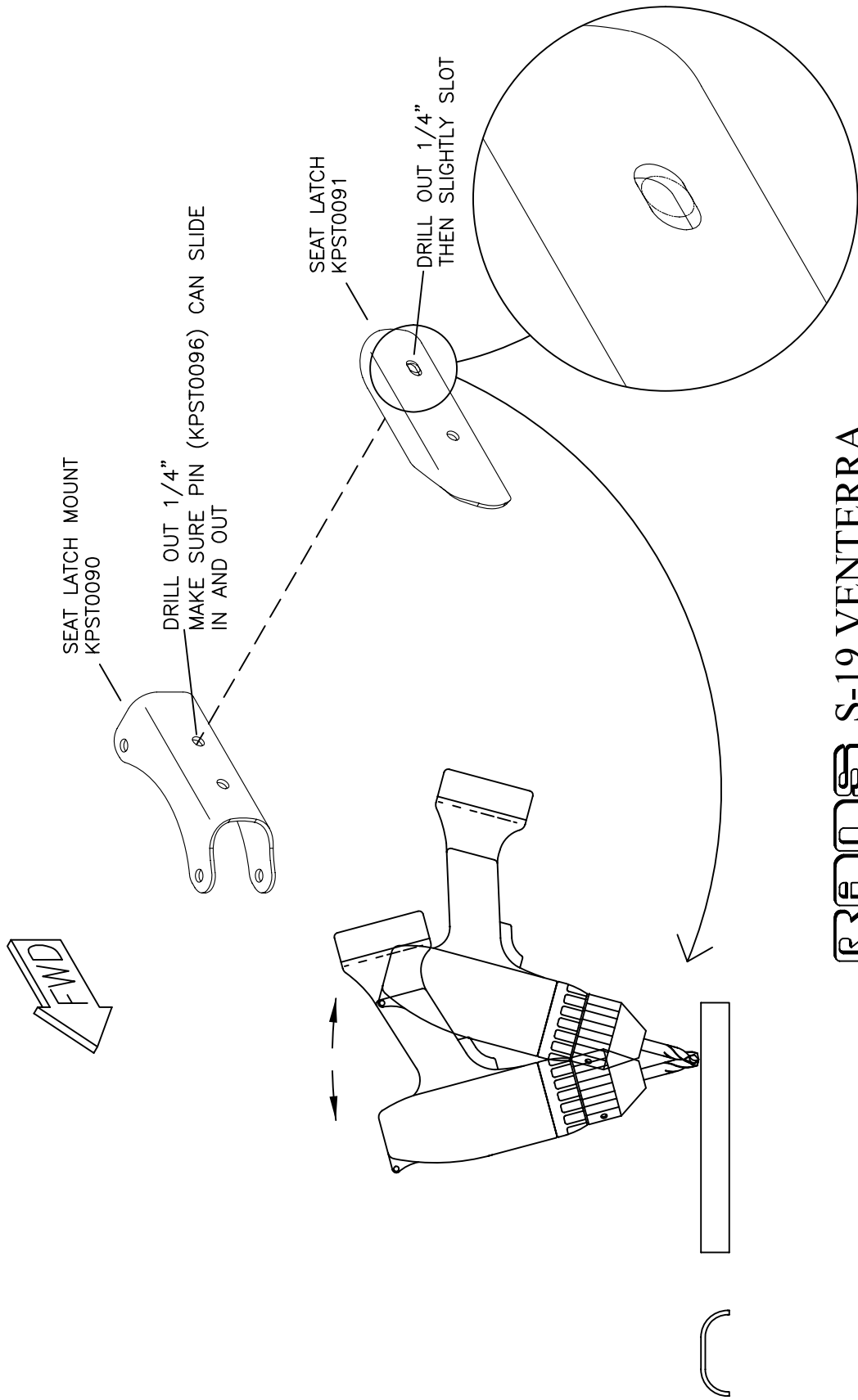
11 – SEAT ASSEMBLY AND INSTALLATION

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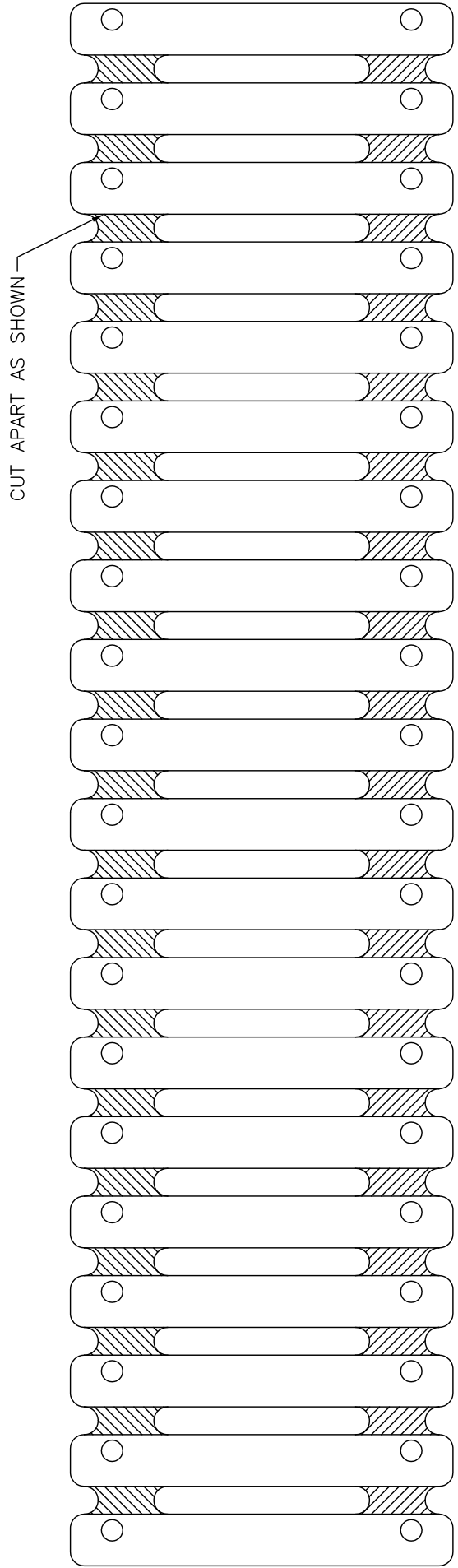
MD5225

RAMBO S-19 VENTERRA
SEAT BOTTOM FRAME DRILLING
FIGURE 11-02



RAMS S-19 VENTERRA
SEAT LATCH AND MOUNT MODIFICATION
FIGURE 11-04

MD5445

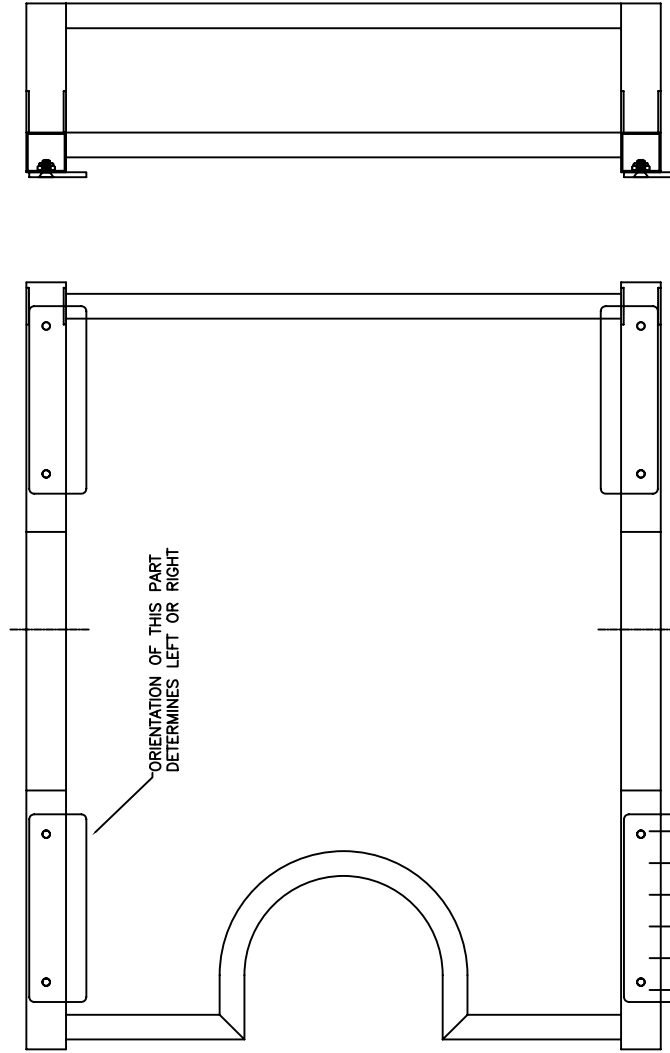
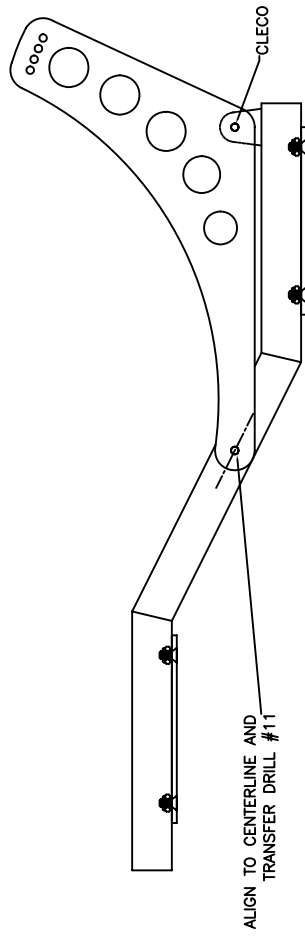


CUT APART AS SHOWN

MAKES 20 PARTS

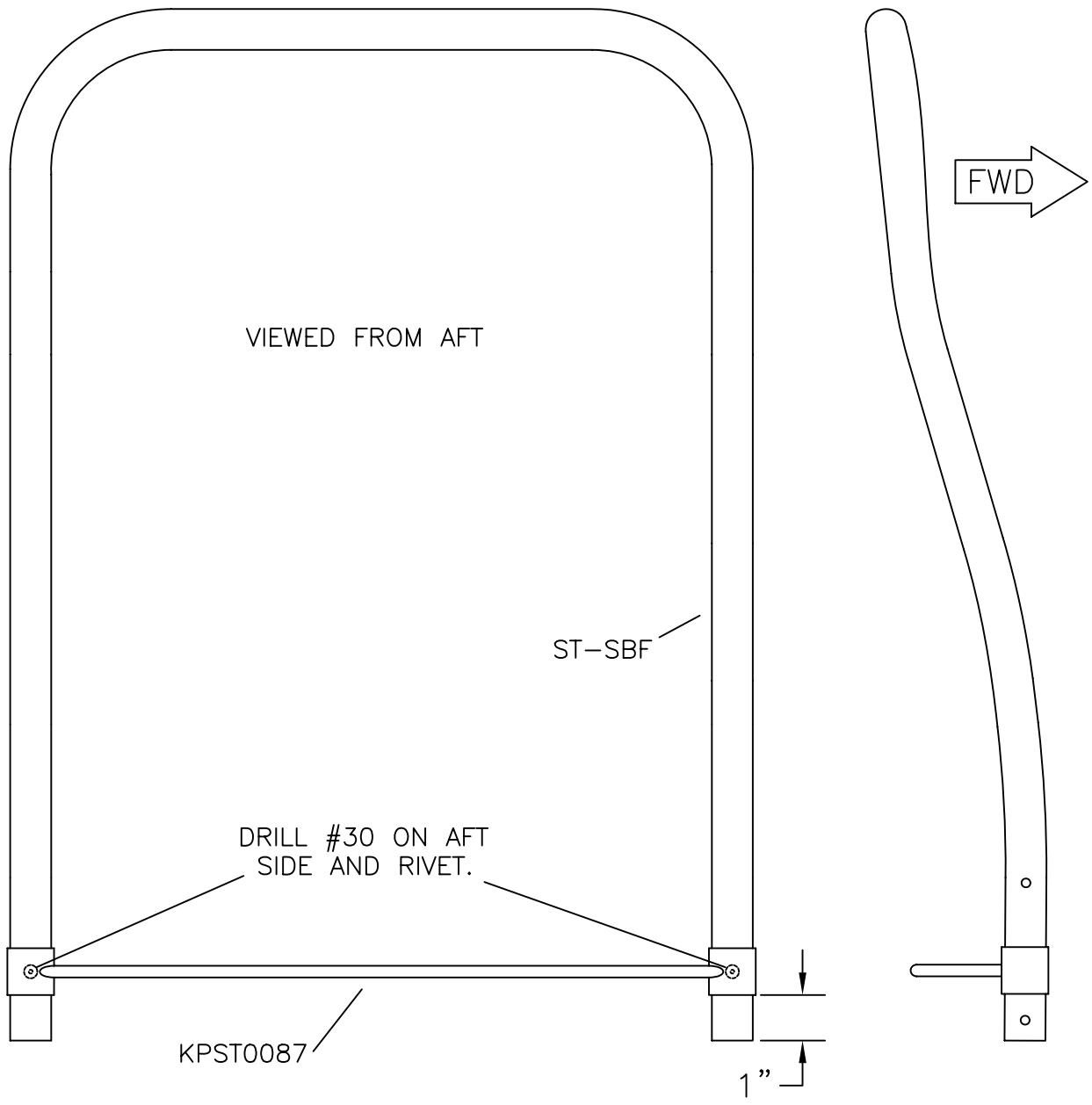
MD5465

**RAMPS S-19 VENTERRA
SEAT SHIM MODIFICATION
FIGURE 11-07**



MD5225

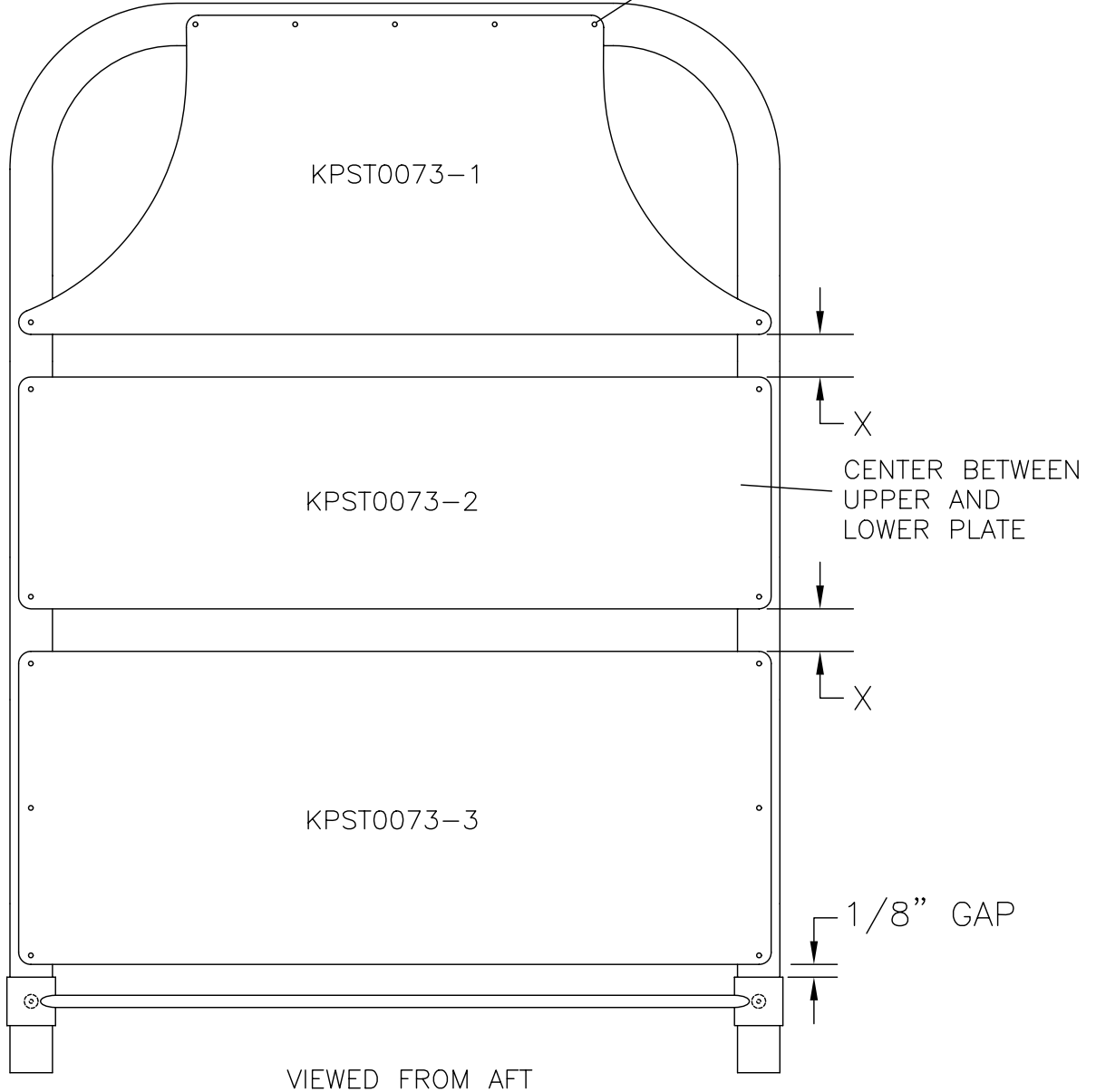
RRR S-19 VENTERRA
SEAT BACK ATTACH GUSSET DRILLING
FIGURE 11-09



MD5109

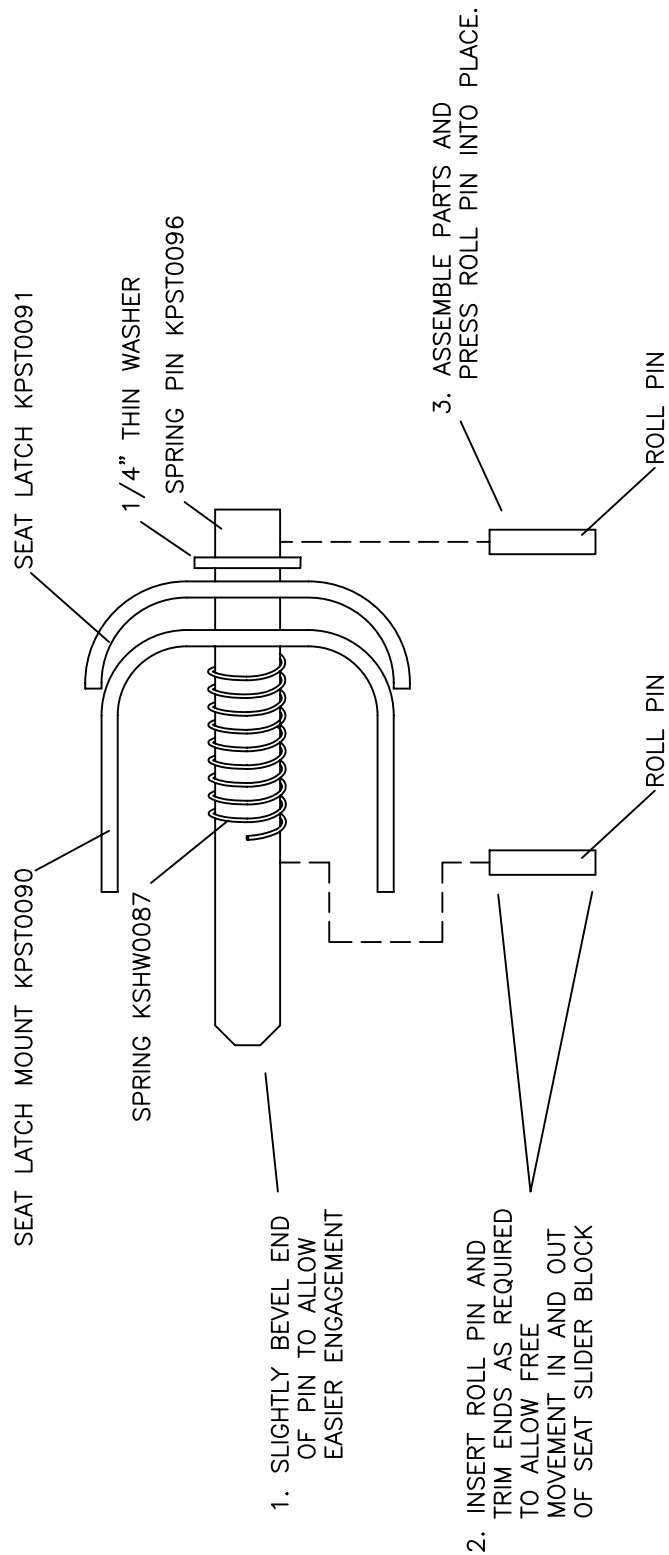
RANS S-19 VENTERRA
LOWER SEAT BACK BRACE POSITIONING
FIGURE 11-10

CENTER ALL HOLES
ON SEAT BACK
FRAME, DRILL #30
AND ATTACH WITH
AVEX RIVETS



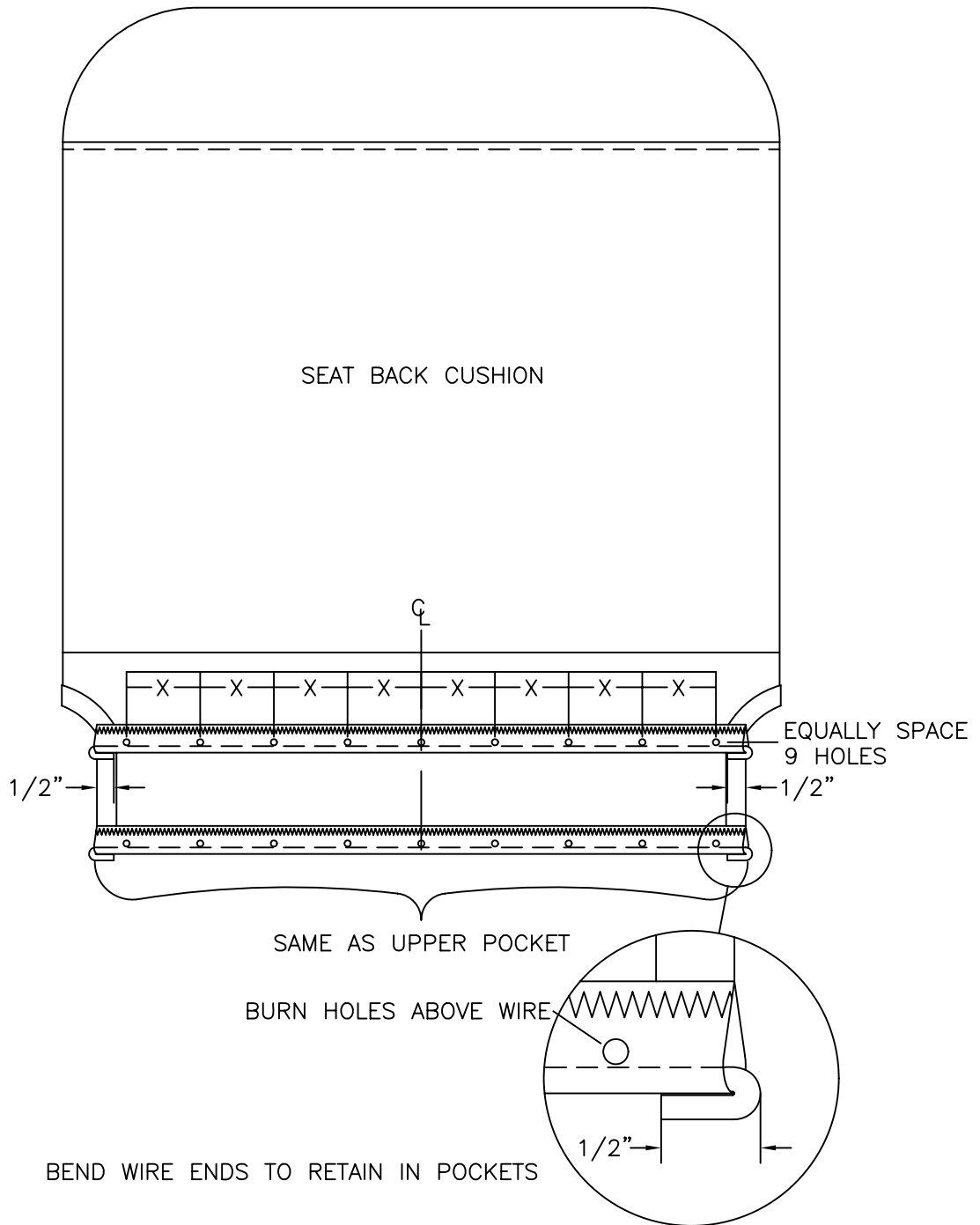
MD5534

RANS S-19 VENTERRA
SEAT BACK PLATE DRILLING
FIGURE 11-10A



RAMBO S-19 VENTERRA
SEAT LATCH ASSEMBLY
FIGURE 11-13

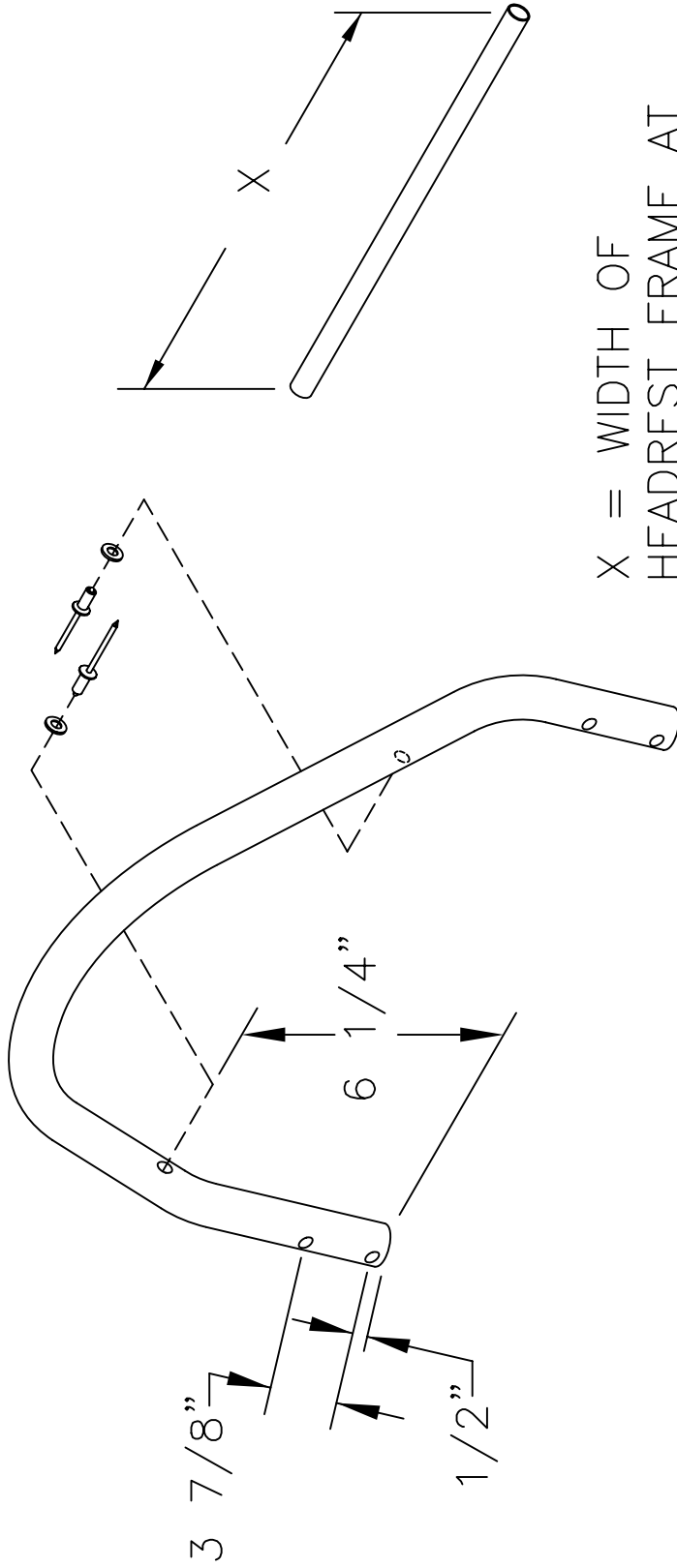
MD5446



RANS S-19 VENTERRA
SEAT BACK COVERING DETAIL
FIGURE 11-16

MD5091

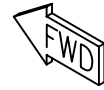
04/01/2011



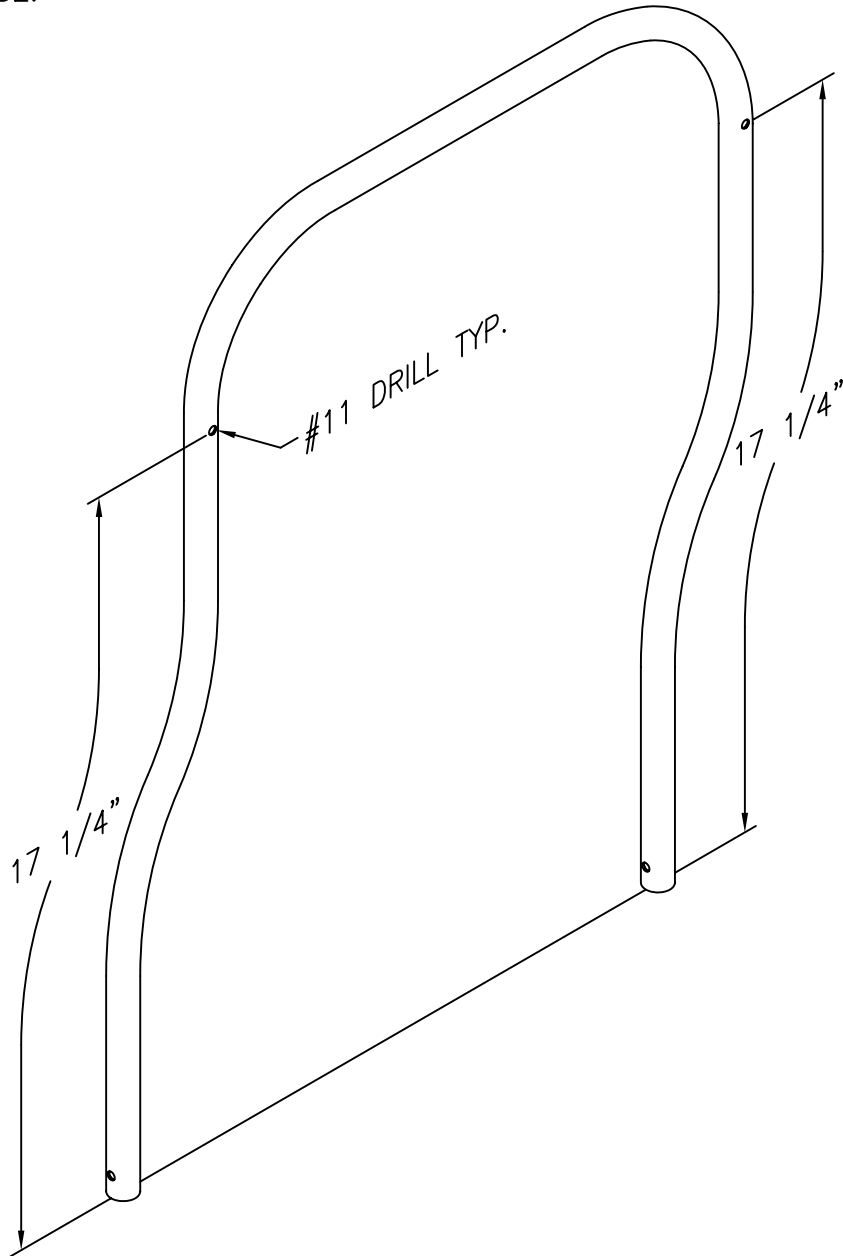
X = WIDTH OF
HEADREST FRAME AT
RIVET LOCATION.

MD5109

RAMS S-19 VENTERRA
OPTIONAL HEADREST - DRILLING
FIGURE 11B-02



DRILL HOLES ONLY
THROUGH AFT SIDE OF
TUBE.



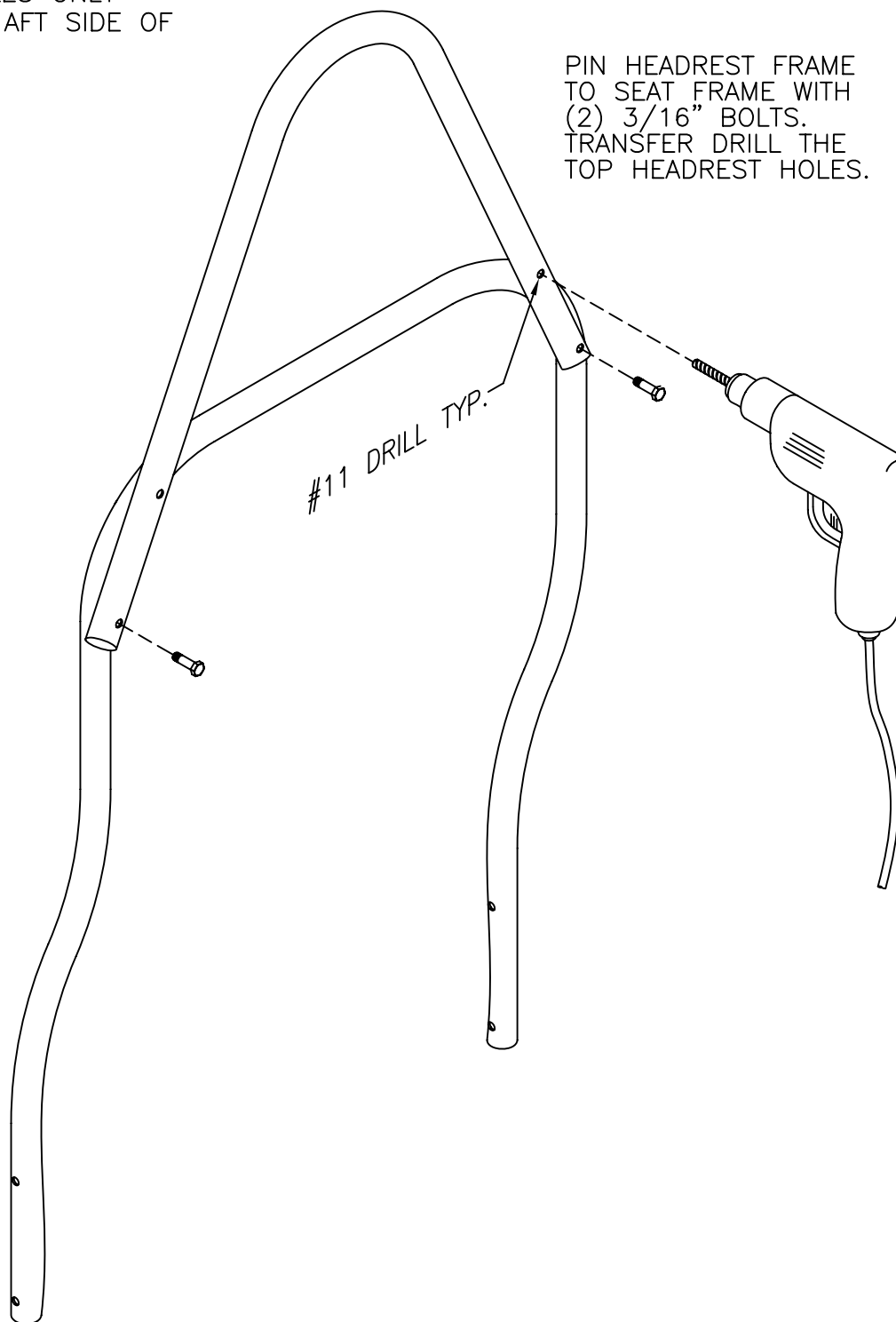
RANS S-19 VENTERRA
SEAT BACK FRAME DRILLING
FIGURE 11B-03

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04/01/2011

DRILL HOLES ONLY
THROUGH AFT SIDE OF
TUBE.

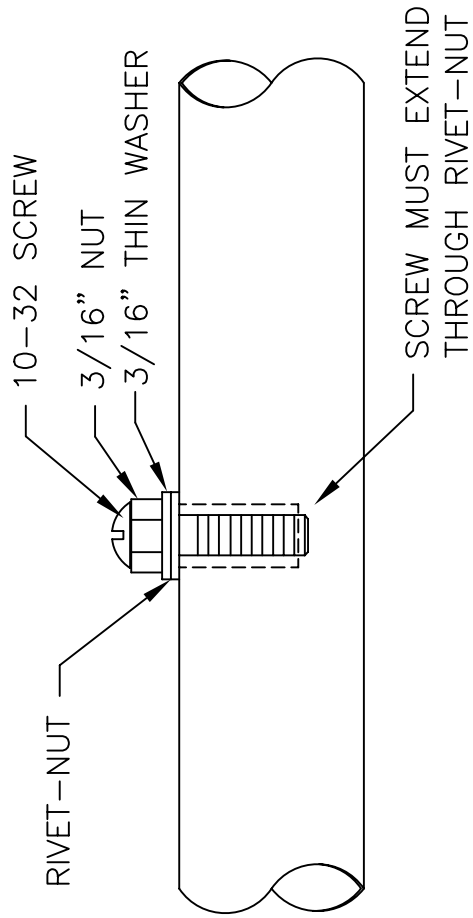
PIN HEADREST FRAME
TO SEAT FRAME WITH
(2) 3/16" BOLTS.
TRANSFER DRILL THE
TOP HEADREST HOLES.



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RANS S-19 VENTERRA
SEAT HEADREST TO SEAT BACK FRAME DRILLING
FIGURE 11B-04

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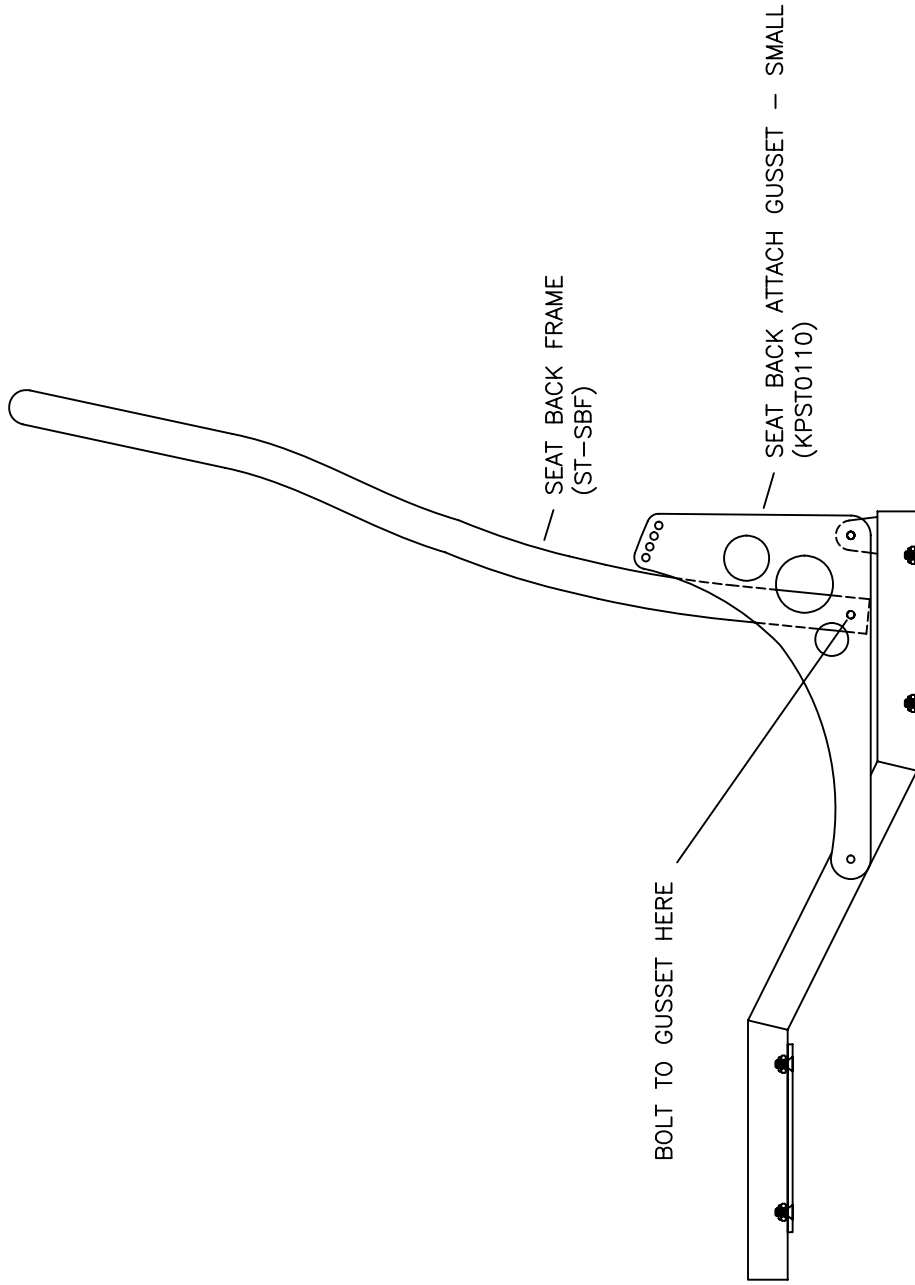


PROCEDURE BELOW MAY BE USED WHEN A RIVET-NUT PULLER IS NOT AVAILABLE.

1. FINGER TIGHTEN NUT AND RIVET-NUT ONTO SCREW.
2. INSERT RIVET-NUT INTO 1/4" HOLE.
3. TURN NUT 3 COMPLETE TURNS CLOCKWISE WHILE HOLDING SCREW STATIONARY.
4. BACK NUT OFF 1/2 TURN AND REMOVE SCREW.

RRR S-19 VENTERRA
RIVET-NUT INSTALLATION
FIGURE 11B-04A

MD343



MD5533

RAMS S-19 VENTERRA
OPTIONAL SHORTER PILOT SEAT ASSEMBLY
FIGURE 11C-02