To: ALL BIDDERS 

CTBTO Ref. No.: 2024-0062/Thorvaldsdottir

(PLEASE QUOTE ON ALL COMMUNICATIONS)

Tel. No.: +43 (1) 26030-6350
E-mail: procurement@ctbto.org

Attn.: 
Phone:
Fax:
Email:

Date: 09 Apr 24

Title of Request: Provision of Air Transportation DBJ and Lower Deck Transport Containers

Deadline for Submission: 30 Apr 24 Vienna Local Time: 17:00

The Preparatory Commission for the Comprehensive Nuclear-Test-Ban Treaty Organization (hereinafter referred to as the ‘Commission’) hereby invites you to bid the following items as per conditions listed below.

<table>
<thead>
<tr>
<th>Item</th>
<th>Description and Requirements</th>
<th>Quantity</th>
<th>U/M</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Provision of Air Transportation DBJ and Lower Deck Transport Containers In accordance with attached Technical Specifications</td>
<td>1</td>
<td>Lot</td>
</tr>
</tbody>
</table>

When preparing your bid, please follow the attached instructions. You are kindly requested to complete and return the acknowledgement form by e-mail as soon as possible. If you have any questions you should contact the e-mail address indicated above. We look forward to receiving your bid.

Yours sincerely,

Sally Alvarez de Schreiner
Chief, Procurement Services Section
**ACKNOWLEDGEMENT FORM**

**Solicitation No:** 2024-0062
**Title:** Production and Delivery of GEN II IMRDS Pods, and ALP Containers

**Closing Date:** 30 Apr 24
**Vienna Local Time:** 17:00

**Procurement Staff:** Thorvaldsdottir

**CTBTO Req. No.:** 0010024042

Please complete 'A' or 'B' or 'C'
and Return

**WITHIN FIVE (5) DAYS**

THE PREPARATORY COMMISSION FOR THE
COMPREHENSIVE NUCLEAR-TEST-BAN TREATY ORGANIZATION (CTBTO)

*by email to*
procurement@ctbto.org

---

**A: We shall submit our bid**

<table>
<thead>
<tr>
<th>Company Name:</th>
<th>__________________________</th>
</tr>
</thead>
<tbody>
<tr>
<td>By:</td>
<td>__________________________</td>
</tr>
<tr>
<td></td>
<td>Contact Name:</td>
</tr>
<tr>
<td></td>
<td>__________________________</td>
</tr>
<tr>
<td></td>
<td>Email/Tel:</td>
</tr>
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<td></td>
<td>__________________________</td>
</tr>
</tbody>
</table>

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**B: We may submit and will advise**

<table>
<thead>
<tr>
<th>Company Name:</th>
<th>__________________________</th>
</tr>
</thead>
<tbody>
<tr>
<td>By:</td>
<td>__________________________</td>
</tr>
<tr>
<td></td>
<td>Contact Name:</td>
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<td>__________________________</td>
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<td></td>
<td>Email/Tel:</td>
</tr>
<tr>
<td></td>
<td>__________________________</td>
</tr>
</tbody>
</table>

---

**C: We will not submit a bid for the following reason(s)**

<table>
<thead>
<tr>
<th>Reason:</th>
<th>__________________________</th>
</tr>
</thead>
<tbody>
<tr>
<td>our current workload does not permit us to take on additional work at this time;</td>
<td></td>
</tr>
<tr>
<td>we do not have the required expertise for this specific project;</td>
<td></td>
</tr>
<tr>
<td>insufficient time to prepare a proper submission;</td>
<td></td>
</tr>
<tr>
<td>other (please specify)</td>
<td>__________________________</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Company Name:</th>
<th>__________________________</th>
</tr>
</thead>
<tbody>
<tr>
<td>By:</td>
<td>__________________________</td>
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<tr>
<td></td>
<td>Contact Name:</td>
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<td></td>
<td>Email/Tel:</td>
</tr>
<tr>
<td></td>
<td>__________________________</td>
</tr>
</tbody>
</table>
INSTRUCTIONS FOR PREPARATION AND SUBMISSION OF BIDS

1. General

The Preparatory Commission for the Comprehensive Nuclear-Test-Ban Treaty Organization (the Commission) with its headquarters in Vienna is the International Organization mandated to establish the global verification system foreseen under the Comprehensive Nuclear-Test-Ban Treaty (CTBT), which is the Treaty banning any nuclear weapon test explosion or any other nuclear explosions. The Treaty provides for a global verification regime, including a network of 321 stations worldwide, a communication system, an International Data Centre and on-site inspections to monitor compliance with the Treaty. More information can be found on the Commission's website: www.ctbto.org.

This Invitation to Bid (ITB) is for the provision of Air Transportation DBJ and Lower Deck Transport Containers (hereinafter referred to as the "Equipment" and/or the "Services") as described in the attached Technical Specifications.

The Bid shall meet all requirements stated in these Instructions and the Technical Specifications.

In case of an award, the following documents shall govern the Purchase Order and in case of discrepancies or inconsistencies, the documents to prevail shall be given precedence in the following order:
(a) The Commission's Purchase Order;
(b) The Commission’s General Conditions of Contract (Annex A);
(c) Technical Specifications (Annex B), including Attachments 1-4 "Design Documents";
(d) The Bidder’s Offer (Bid) (Annex C).

2. Documents included in this Invitation to Bid (ITB)

This ITB consists of the following documents:

(a) Letter of Invitation
(b) These Instructions for Preparation and Submission of Bids, including the Bidder’s Statement and:
   Attachment 1: Technical Compliance Matrix
   Attachment 2: Procedures for Submission of Electronic Offers in 2 Sealed Files
(c) Vendor Profile Form
(d) Statement of Confirmation
(e) The Commission’s General Conditions of Contract (Annex A ), incorporated herein by reference and available at this link: Microsoft Word - CTBTO General Conditions of Contract_08-10-2021_final clean.docx
(f) The Commission's Technical Specifications (Annex B)
NOTE: In the event of award, the Bid will be incorporated as Annex C to the Purchase Order.
3. **Amendment of the ITB Documents**

At any time prior to the closing date for submission of Bid, the Commission may, for any reason, modify the ITB documents by amendment. The Commission may consider extending the deadline in order to allow adequate time for considering the modifications in the preparation of the Bid.

4. **Language of the Bid**

The Bid and all correspondence and documents relating to it shall be in English.

5. **Format and Submission of the Bid**

The Bid shall be typed, dated and signed by an official legally authorized to enter into contracts on behalf of your organization. The Bid shall not contain any interlineation, erasures or overwriting except as necessary to correct errors, in which case such corrections shall be initialled by the authorized person(s) signing the Bid.

The Proposal shall be submitted electronically according to the attached “PROCEDURE FOR SUBMISSION OF ELECTRONIC OFFERS IN 2 SEALED FILES”.

Proposals sent by regular e-mail, unless clearly submitted as electronically sealed bids as indicated above and following the instructions outlined in Attachment 2 will not be considered and lead to the rejection of the bidder from the procurement process.

The Bid shall be received not later than the closing date and time indicated in the Letter of Invitation.

6. **Request for Clarifications and Contacting the Commission**

The Commission will issue clarifications, if required. Bidders are requested to e-mail any questions pertaining to this ITB as soon as possible after receipt of the solicitation documents, but in any case no later than 7 business days prior to the Closing Date. No requests for clarifications will be entertained after this time. Questions will only be accepted via e-mail and should be sent to:

```
E-mail: procurement@ctbto.org
Subject: ITB No. 2024-0062/THORVALDSDOTTIR - Request for Clarifications
```

The Commission will make all reasonable efforts to issue the clarifications not later than 5 business days prior to the Closing Date.

Except in the case of responding to an ITB clarification, no bidder shall contact the Commission on any matter relating to the Bid after its submission and until the award of the Purchase Order. Any attempt to influence the Commission in its evaluation of the Bid or the award decision may result in rejection of the Bid.
7. **Eligible Goods and Services**

The goods and services to be rendered under the Purchase Order shall have their origin in the States Signatories of the Comprehensive Nuclear-Test-Ban Treaty (CTBT) which is available in the CTBTO website at [www.ctbto.org](http://www.ctbto.org) under Status of Signatures and Ratifications | CTBTO. For purposes of this paragraph, "the origin" means the place from where the materials, goods and/or from which the services are supplied.

8. **Type of Contract and Payment**

The Commission intends to conclude a firm fixed price Purchase Order based on the Commission’s standard template. The terms and conditions of payment are as follows:

Within 30 days of receipt and acceptance of the Equipment and of the following documents:

1. Invoice(s) showing the firm fixed price of the Purchase Order. The Supplier shall submit the invoice electronically, from the Supplier’s official e-mail address in PDF format, duly signed and stamped by the Supplier and submitted to Payable_Invoices@ctbto.org. Each invoice shall contain the Purchase Order number (CTBTO and SAP numbers), detailed banking instructions, including the name and address of the Supplier’s bank, account number, account holder’s name and SWIFT, IBAN and/or ABA codes for payment by electronic transfer. and actual pre-paid transportation & insurance cost (as applicable);
2. Delivery Note acknowledged by the designated receiving staff in Seibersdorf, showing all the items delivered;
3. Certificate of Origin (original) or equivalent;
4. Certificate of transportation insurance (copy);
5. Acknowledgement Copy of the Purchase Order with the Supplier’s signature;
6. A copy of the documents reporting the result of Equipment Acceptance Testing, approved and counter-signed by the Commission and/or the end-user (if applicable);
7. The Supplier’s certificate, counter-signed by the Consignee/end-user, confirming the successful completion of the Services (as applicable); and
8. Any other relevant documents.

Applicable Taxes payable by the Supplier and/or its subcontractor(s) shall be invoiced separately or be separately identified on the invoice. Actual payment of the Taxes must primarily be supported by original documentation such as invoices, bank account statements, transfer orders, or receipts issued by the local tax or customs authorities. If submission of such original documentation is not possible for justifiable reasons, their copies could be accepted by the Commission, provided that they are duly signed and certified by local tax or customs authorities. In case the currency in which the taxes are levied is not the currency of the Purchase Order, bank statements (or equivalent) showing the exchange rate used for the conversion shall be submitted to the Commission, in addition to any other supporting documentation.

“Taxes” means all direct and indirect taxes (including value added tax, general sales tax or goods and services tax), assessments, fees, customs duties, liens and charges in as much as they are levied in conclusion or implementation of the Purchase Order, including customs restrictions and charges of similar nature in respect of articles imported or exported for the Commission’s official use.
9. **Content of the Bid**

The Bid shall contain, but not necessarily be limited to, the information described below.

The Bid shall be composed of the following separate parts:

I. Technical Bid; and  

II. Financial Bid;  

providing, but not limited to, the following information:

**PART I: TECHNICAL BID**

Please state the reference number and the date of this ITB in the Bid and any correspondence relating to it.

1. **Personnel**

The Bid shall state the contact details and address (name, telephone and fax numbers, and e-mail address) of the person/point of contact in your company dealing with this ITB.

**Use of former Preparatory Commission for the CTBTO (“Commission”) employees in the preparation of Quotations:**

A Bidder must not, in the absence of prior written approval from the Commission, permit a person to contribute to, or participate in, any process relating to the preparation of a Quotation or the procurement process if the person:

a. At any time during the 12 months immediately preceding the date of issue of the Solicitation was an official, agent, servant or employee of, or otherwise engaged by the Commission;  
b. At any time during the 24 months immediately preceding the date of issue of the Solicitation was an employee of the Commission personally engaged, directly or indirectly, in the definition of the requirements, project or activity to which the Solicitation relates.

2. **Technical Compliance Matrix, Bidder’s Statement, Statement of Confirmation and Vendor Profile Form**

The attached Technical Compliance Matrix, Bidder’s Statement, Statement of Confirmation and Vendor Profile Form shall be duly filled-in, signed and submitted together with the Bid.

3. **Specifications**

The Bid shall include a detailed description of the items proposed by providing a section-by-section response to the Technical Specifications and include relevant technical literature.
The Bid shall also provide any other relevant issue which the bidder would like to bring to the attention of the Commission whether or not having cost implications. This shall include details of warranties/manufacturer’s guaranties in respect to any Equipment item.

4. Manufacturer’s Part Number

The Bid shall include the Manufacturer’s Part Number for each good required by the Commission under this ITB.

5. Sub-Contractors

The Bid shall include names, legal status, address and qualifications of subcontractor(s), if any, involved in the Project and the scope of the subcontracted services. The bidder shall provide a statement that its organization shall be fully responsible for the performance of sub-contractors. All sub-contractors shall be legally established in one of the CTBT states signatories (the list is available on the CTBTO website at www.ctbto.org under Status of Signatures and Ratifications | CTBTO.)

6. Insurance

Insurance to be included in the Bid must be for All Risk, covering 110% of the cost of the equipment proposed, and from the date/place of the shipment to the date/place the delivery is completed. The insurance shall be in the name of the supplier and the Commission. You are requested to confirm that you will provide this insurance coverage.

7. Delivery Schedule

Delivery time shall be indicated in weeks after receipt of an order and shall be firm during the validity of the Bid.

8. Qualifications and References

1) Potential bidders shall include a minimum of 2 client references for similar projects with their Bid. If after reasonable efforts, the Commission is unable to contact the client references provided by the bidder, the Commission may take the decision not to further consider the offer provided by the bidder.

2) The Bid shall include documentary evidence demonstrating the qualification for the suppliers in compliance with the requirements of the Technical Specifications.

PART II: FINANCIAL BID

i. The Bid shall include the prices of the Equipment, including separately the costs for door-to-door DAP (Delivered At Place; Incoterms 2020) delivery to CTBTO's TeST Centre, 2444 Seibersdorf, Austria. The delivery terms shall be door-to-door CTBTO, Seibersdorf, Austria.

ii. The Bidder is required to prepare the Price Schedule using the Price Schedule Form attached to these Instructions for Preparation and Submission of Bids. In presenting the cost for each item, adequate justification and calculation must be included in the cost. All individual costs
shall be stated in EURO or US Dollars and be computed to constitute the total Purchase Order Price. Note that clear and detailed explanations would enable us to evaluate the Bid promptly and proceed with fewer requests for clarifications/justifications in a later stage. This is also a factor influencing the decision for Purchase Order award.

iii. In principle the Commission is exempt from taxes. Since the arrangement under which such exemption is respected varies from country-to-country, the selected bidder will be informed by the Commission whether tax exemption will occur at source or whether taxes paid by the selected bidder will be reimbursed by the Commission upon submission of the original supporting documentation.

(1) **For Austrian companies**
The price quoted shall be net of Taxes. All applicable Taxes payable by the selected bidder at the conclusion or implementation of the Purchase Order in respect of the goods/services shall be quoted separately or be separately identified on the Bid together with information on the nature of the tax and its method of calculation.

(2) **For European Union (EU) Companies**
The price quoted shall be net of Taxes. All applicable Taxes payable by the selected bidder at the conclusion or implementation of the Purchase Order in respect of the goods/services shall be quoted separately or separately identified on the Bid together with information on the nature of the Tax and its method of calculation. Due to the VAT exemption applicable to the Commission, no VAT will be charged to the Commission by the EEC Suppliers under the Contract (Ref. EU VAT Council Directive 2006/112/EC, Article 151).

(3) **For Non-EU Companies**
The price quoted shall be net of Taxes. All applicable Taxes payable by the selected bidder at the conclusion or implementation of the Purchase Order in respect of the goods/services shall be quoted separately or be separately identified on the Bid together with information on the nature of the tax and its method of calculation. For deliveries to Vienna, Austria, and due to the tax exemption at source, applicable to the Commission, no Taxes shall be charged to the Commission under the Contract.

9. **Completeness and Correctness of the Bid**

The Commission reserves the right to verify all information furnished in the Bid through a source of its choice. Any inaccurate information so given may lead to the rejection of the Bid.

10. **Evaluation of the Bid**

(a) The technical evaluation shall include the following evaluation criteria:

   (i) compliance with the technical specifications;
   (ii) supplier’s qualifications;
   (iii) delivery schedule.

(b) The Financial Bid of bidders passing the technical evaluation shall be evaluated as follows:
(i) contractual compliance;
(ii) commercial acceptability.

(a) The Commission, based on the evaluation method given above, will determine the Bid which is the “least costly technically acceptable Bid”. Bidders are expected to comply with all the provisions of the Commission’s General Conditions for Contract. Any deviation to these provisions may be a factor in the Commission’s award decision.

(b) To assist in the examination, evaluation and comparison of bids, the Commission may, at its discretion, request any Bidder to clarify its Bid. The Commission’s request for clarification and the Bidder’s response shall be in writing.

13. **Correction of Errors**

The Commission will check the Bid for any arithmetic errors. If there is a discrepancy between the unit price and the total price that is obtained by multiplying the unit price and quantity, the unit price shall prevail and the total price shall be corrected.

14. **Validity of the Bid**

The Bid shall be valid for 90 (ninety) days after the deadline for its submission to the Commission, unless an extension of validity has been requested by the Commission.

15. **Negotiations of the Bid and Award**

The Commission reserves the right to request clarifications on the Bid and to enter into negotiations regarding technical or commercial aspects of the Bid before awarding the Purchase Order under this ITB. If and when the Bid, including any amendment resulting from such negotiations, is fully agreed, the Commission will notify the bidder in writing.

16. **Modification and Withdrawal of the Bid**

Bidders may modify or withdraw their Bids after its submission, provided that written notice of the modification or withdrawal is received by the Commission by the closing date for the submission of the Bid. The Bid may not be modified subsequent to the closing date.

17. **The Commission’s Right to Reject the Bid**

The Commission reserves the right to accept or reject the Bid or to annul this procurement process at any time prior to award without having to inform the affected party of the grounds therefore, without thereby incurring any liability to the affected party.

18. **Costs of preparation and submission of the Bid**

Bidders shall bear all the costs associated with the preparation and submission of Bid and the Commission will not be responsible or liable for those costs, regardless of the outcome of this ITB.
19. **Proprietary Information**

All documentation and information contained in this ITB are proprietary to the Commission and shall not be duplicated, used or disclosed –in whole or in part- for any purpose other than to evaluate them and respond to the Commission’s ITB or otherwise without prior written agreement of the Commission.
| **BIDDER’S STATEMENT**  
**PLEASE FILL THIS FORM & SUBMIT WITH THE BID**  |
<table>
<thead>
<tr>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Delivery Time:</td>
</tr>
<tr>
<td>Shipping weight (kg) and Volume (m$^3$) – if applicable:</td>
</tr>
<tr>
<td>List of recommended consumables and spares including prices and details on local availability, if applicable (please tick):</td>
</tr>
<tr>
<td>☐ For one year period ☐ For a period of …………………………</td>
</tr>
<tr>
<td>Warranty period applicable (it shall be for a <strong>minimum of 60 months</strong>, starting from the acceptance of the Equipment by the Commission) – please tick below:</td>
</tr>
<tr>
<td>☐ For a two year period ☐ For a period of …………………………</td>
</tr>
<tr>
<td>Availability of local service in Vienna, Austria (if any/if applicable):</td>
</tr>
<tr>
<td>State country of origin or assembly of all items quoted:</td>
</tr>
<tr>
<td>Quantity discount and early payment discount (if any):</td>
</tr>
<tr>
<td>Include documentary evidence of qualifications to perform the order, which shall establish to the Commission’s satisfaction that the bidder has the financial, technical and production capability necessary to perform the order in its entirety and to provide spare parts and other necessary on-going services as required.</td>
</tr>
<tr>
<td>Included in this Bid: <strong>Yes</strong> ☐ <strong>No</strong> ☐</td>
</tr>
<tr>
<td>Confirmation that the bidder has reviewed the Commission’s General Conditions of Contract and agreed to all terms and conditions.</td>
</tr>
<tr>
<td>Yes ☐ No ☐</td>
</tr>
<tr>
<td>Remarks:</td>
</tr>
<tr>
<td>With regards to the software provided with the equipment, state and confirm whether the software licenses are transferable to third parties, i.e. the Commission or the Commission’s State Signatories (Member States).</td>
</tr>
<tr>
<td>Yes ☐ No ☐ Not applicable ☐</td>
</tr>
<tr>
<td>Remarks:</td>
</tr>
<tr>
<td><strong>Name:</strong></td>
</tr>
<tr>
<td><strong>Name &amp; Title of Contact Person:</strong></td>
</tr>
<tr>
<td><strong>Signature &amp; date:</strong></td>
</tr>
</tbody>
</table>
Attachment No. 1
Price Schedule Form

Bidders are required to prepare the Price Schedule using the form below.

The Price Schedule must provide a detailed cost breakdown of all goods and related services to be provided, from unit price to total prices.

Cost Breakdown per Item:

<table>
<thead>
<tr>
<th>Lot</th>
<th>Technical Specifications</th>
<th>Description</th>
<th>Quantity</th>
<th>Unit Price EUR/USD*</th>
<th>Total Price EUR/USD*</th>
</tr>
</thead>
<tbody>
<tr>
<td>Lot 1</td>
<td>Para. 3.1</td>
<td>DBJ Containers</td>
<td>4</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Lot 2</td>
<td>Para. 3.2</td>
<td>Lower Deck Transport Containers</td>
<td>2</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Lot 3</td>
<td>Para. 5</td>
<td>5 years’ Warranty</td>
<td>1</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>Delivery (DAP)</td>
<td></td>
<td>Lump sum fixed</td>
<td></td>
</tr>
</tbody>
</table>

Total Price in EUR or USD (DAP, door-to-door, excluding taxes**)

* Specify either EUR or USD
** Please see the Instructions for Preparation and Submission of Bids about any applicable taxes
## Technical Compliance Matrix

### Provision of Air Transportation DBJ and Lower Deck Transport Containers

<table>
<thead>
<tr>
<th>Criteria</th>
</tr>
</thead>
<tbody>
<tr>
<td>Technical Specifications Para 3.1 DBJ Containers</td>
</tr>
<tr>
<td>Bidder offers to produce 4 DBJ containers to full technical specifications from design documents.</td>
</tr>
<tr>
<td>Bidder can provide certification of air worthiness.</td>
</tr>
<tr>
<td>Technical Specifications Para 3.2 Lower Deck Containers</td>
</tr>
<tr>
<td>Hardshell with solid doors opening on hinges out to at least 180 degrees to allow for loading.</td>
</tr>
<tr>
<td>Doors can open to 180 degrees at least to allow for loading full capacity of the container</td>
</tr>
<tr>
<td>Solid doors, able to be secured by padlock or seal</td>
</tr>
<tr>
<td>Full compatibility with air cargo handling systems in use worldwide.</td>
</tr>
<tr>
<td>Interoperability with most cargo aircrafts in use worldwide (Airbus A300, Airbus A310, Airbus A330, Airbus A340, Airbus A350, Airbus A380, Boeing 737C, Boeing 747, Boeing 767, Boeing 777, IL-86, DC-10, MD-11)</td>
</tr>
<tr>
<td>Certified and accepted by main cargo operators worldwide</td>
</tr>
<tr>
<td>Forkliftable floor design (forklift pockets)</td>
</tr>
<tr>
<td>Airworthiness certificate</td>
</tr>
<tr>
<td>Dimensions of 3,175mm long x 2,235mm wide x 1,615 mm tall</td>
</tr>
<tr>
<td>Dimensions of 3,175mm long x 1,534mm wide x 1,615mm tall.</td>
</tr>
<tr>
<td>Units are stackable</td>
</tr>
<tr>
<td>-------------------------------------</td>
</tr>
<tr>
<td>Weather protection</td>
</tr>
<tr>
<td>Lightweight design with high weight bearing capability</td>
</tr>
<tr>
<td>Shelf option</td>
</tr>
<tr>
<td>Bergo floor option</td>
</tr>
</tbody>
</table>

**Technical Specifications Para 4 Supplier Requirements**

<table>
<thead>
<tr>
<th>Requirement</th>
<th>Y</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum of 10 years’ experience in global air transportation and material handling services,</td>
<td>Y</td>
</tr>
<tr>
<td>Experience and certification required for air cargo operations</td>
<td>Y</td>
</tr>
<tr>
<td>Specialized expertise on designing/evaluating and certifying Unit Load Devices (ULDs)</td>
<td>Y</td>
</tr>
<tr>
<td>Minimum of 8 years’ experience in the certified design and production of specialized /customized rapid deployment systems</td>
<td>Y</td>
</tr>
<tr>
<td>Supplier has experience in transporting cargo by air cost effectively.</td>
<td>Y</td>
</tr>
<tr>
<td>Supplier provides references of two similar projects</td>
<td>Y</td>
</tr>
</tbody>
</table>

**Technical Specifications Para 5**

| Warranty of five years is provided in offer.                               | Y |
The Commission invites you to submit your sealed offer (Bid, or Proposal) in response to the solicitation forming part of this request.

Please be sure to follow the instructions below very carefully, so that the documents you submit are encrypted, and cannot be opened without an encryption key (password). If the documents are not encrypted, they will not be accepted as part of this tender process.

**CRITICAL INFORMATION:**

Create separate zip files for the technical offer and the financial offer (labelling them clearly in the title) with different encryption keys. Instructions for how to do this are provided below.

**Step 1:** You provide the encryption key (password) for the **Technical Offer only** (in accordance with the below instructions)!

**Step 2:** After the Commission has performed the evaluation of the Technical Offer, if your Technical Offer is considered to be acceptable, the Commission will request the encryption key (password) for the Financial Offer you have already submitted by the tender Deadline.

Should you have any questions, please send an email to procurement@ctbto.org.

**We recommend that you leave yourself plenty of time to complete the below process (including getting any necessary assistance from the Commission), as late offer will not be accepted.**

**INSTRUCTIONS:**

1. In a **WINDOWS** environment, one way of meeting the requirements is as follows.

   We recommend using the open-source, free software **7-zip**, but if you are comfortable with other tools, the result should be the same, as long as you can apply encryption to the archive. In the below, we’ll use 7-zip as an example. (You can download the 7-zip code for Windows at: 7-zip.org)

2. In **LINUX** environment, you can use, for instance, “sha1sum” on the command line.
Creating the archives for submission

Regardless of whether the offer is a single file, or a collection of files, the files are easier to manage if delivered as a single, compressed file. Compressing the archive is a common way to meet size limitations in email systems.

As an example of how to submit your offer in the required format: assuming you are supplier “SOFTCOMP” and have the following files related to the offer for “RFP 2020-0010/EDWALD”. (You will need to replace these elements with the real information for your actual offer in line with the relevant Instructions for Preparation and Submission of Proposals/Bids.) Assuming further that you have installed the 7-zip software on the Windows system you are using.

We will only go through the creation of the Technical Offer (Proposal/Bid) component; the Financial Offer (Proposal/Bid) component is similar.

Select the four files and right-click; a Dialog box pops up, with one of the options being “7-ZIP    >”. Hover your cursor over the “ >” part and a few more options appear, select the “Add to archive” option.

Another dialog box pops up (see ‘Figure 2, Creating an Archive’, next page):

Using the standard Windows methods, select a suitable location for the archive (if you don’t change it, the archive gets created right where the selected files are), and give it a name in the form of: “SOFTCOMP-2020-0010-EDWALD-TECHNICAL-BID”, of course replacing all the elements with the true values for the offer in question: the actual company indicator, and the actual RFP/ITB identification string. Note that it is not possible to put a slash “/” in the file name, and therefore put a dash “-” instead. Leave the file extension “.zip’ as is.

Leave all the other settings as is, except: add a password to the encryption (see figure 2 below). This is done by typing the same password (of your choosing) twice in the two text fields in the lower right hand corner.

Make a note of this password. You must choose different passwords for the two zip archives, that is, the Technical and the Financial Proposal/Bid.
Figure 2 Creating an Archive

Now, we seek the “SHA1 Hash”, and electronic fingerprint of the archive you have just created. The hash is a string calculated from your file(s) and can be used to guarantee that the file has not been modified since you created it. Any change to the file will result in a different hash value.

There are many ways of calculating this; two common options are described below.

If the appropriate functionality is available in your Windows environment: Select the compressed archive in the Windows file manager, (e.g. SOFTCOMP-2020-0010-EDWALD-TECHNICAL-BID.zip) and right click. One of the options to select is “CRC SHA >”. Hovering over the “ >” brings a few more options to light, select the SHA-1 option. A smaller dialog pops up: (see Figure 3, SHA1 below).
If this CRC SHA function is not available by ‘right-click’ on your Windows version, you can also do this from ‘the command line’, a slightly more complicated way. Open a CMD window (see sidebar below), move to the folder where your archive is, and execute the command:

```
certutil –hashfile SOFTCOMP-2020-0010-EDWALD-TECHNICAL-BID.zip sha1
```

where you obviously replace the name of the file with your real file name. The output of this command is the SHA1 “hash”. You can copy-and-paste the string for use in the email (below).

Finally,

1. Create a new email, Subject: example- “SOFTCOMP-2020-0010-EDWALD”. Add the two compressed archives, that is, the Technical Offer and the Financial Offer archives as attachments. The text of the email should contain the SHA1 information for both archives. **SEND THIS TO:** sealed_bids@ctbto.org (note that there is an underscore “_” between “sealed” and “bids”). (Should the email become larger than your mail system allows, you can try sending the two archives in separate emails. Take care to include the right SHA1 information with each file.)

2. Create a new email, Subject: example- “SOFTCOMP-2020-2010-EDWALD-Technical Offer” the contents of which must contain the Encryption Key for the Technical Offer (the password
you used when creating the Technical Offer). (Again, note the underscore between ‘bid’ and ‘keys’.)
SEND THIS TO: bid_keys@ctbto.org

IMPORTANT NOTE: As stated above, only send the Encryption Key for the Technical Offer to the bid_keys@ctbto.org mailbox when sending your Technical and Financial Offer to the sealed_bids@ctbto.org mailbox. You shall only send the Encryption Key for the Financial Offer to the Commission if and when informed by the Commission that your Technical Offer had been evaluated as “technically acceptable”.

The Financial Offer Encryption Key will need to be provided by you to the same e-mail (bid_keys@ctbto.org) within 48 hours of the Commission’s request, clearly marked in Subject: Encryption Key for (example):“SOFTCOMP 2020-2010 EDWALD-Financial Offer”. If your Offer is not considered “technically acceptable”, the Commission will not request an Encryption Key for your Financial Offer, and it will remain unopened.

As mentioned above, should you have questions or difficulties, please send an e-mail to procurement@ctbto.org.

We recommend that you leave yourself plenty of time to complete the above process (including getting any necessary assistance from the Commission), as late offers will not be accepted.
ANNEX B

TECHNICAL SPECIFICATIONS

Provision of Air Transportation DBJ and Lower Deck Transport Containers

1. INTRODUCTION

The Preparatory Commission for the Comprehensive Nuclear-Test-Ban Treaty Organization (hereinafter referred to as the “Commission”) operates a global verification regime to monitor compliance with the Comprehensive Nuclear-Test-Ban Treaty (CTBT). It provides timely data, assessments and other products and services to Signatory States of the Treaty. More information can be found on the Commission's website: www.ctbto.org.

An On-Site Inspection (OSI) is the final verification measure to verify States’ compliance with the CTBT. An OSI requires that equipment and Inspectors are transported to the location to be inspected, which could potentially be anywhere in the world.

The OSI Division of the Commission holds technical equipment and mobile laboratories in a ‘ready state’ to be deployed. To achieve the requirements of an OSI, for storage and equipment preparation, and to deploy the majority of technical equipment, customized Air Transportation DBJ containers are used.

2. SCOPE OF WORK

These Technical Specifications define the requirements for the construction and delivery of four (4) DBJ containers in accordance with the design provided by CTBTO, and the provision of two (2) lower deck air transportation containers.

3. SPECIFICATIONS

3.1 The Supplier shall supply four (4) DBJ containers with the following specifications:

- Produced according to the design documents provided by CTBTO to full technical specifications. 
  Design documents are included with these Technical Specifications as Attachment 1-4.
- Provide certification for the containers' airworthiness.

3.2 The Supplier shall supply two (2) lower deck transport containers with the following specifications:
• Hardshell containers with solid doors opening on hinges out to at least 180 degrees to allow for loading.
• Doors with the following specifications:
  o Open to at least 180 degrees to allow for loading full capacity of the container
  o Solid doors able to be secured (padlocked, or sealed)
• Full compatibility with certified air cargo handling systems in use worldwide.
• Interoperability with most common cargo aircrafts in use worldwide (Airbus A300, Airbus A310, Airbus A330, Airbus A340, Airbus A350, Airbus A380, Boeing 737C, Boeing 747, Boeing 767, Boeing 777, IL-86, DC-10, MD-11).
• Certified and accepted by main cargo operators worldwide.
• Forkliftable floor design (forklift pockets) to enable ground handling outside of airports.
• Airworthiness certificate.
• Dimensions of 3,175mm long x 2,235mm wide x 1,615 mm tall and optional dimension of 3,175mm long x 1,534mm wide x 1,615mm tall.
• Units are stackable to enable multi-modal transportation (optional)
• Weather protection to protect internal cargo during airport outdoor storage, and also for use in the field environment.
• Lightweight design with high weight bearing capability to allow for maximum use of aircraft weight and space capacity.
• Optional shelf.
• Optional bergo floor.

4. QUALITY OF DELIVERABLES AND REQUIREMENTS FOR THE SUPPLIER

The Supplier shall ensure that services are performed in a highly professional and safe manner meeting with all the timelines and all requirements listed in these Technical Specifications.

The Supplier must provide adequate assurance such as references, certifications etc. on its overall ability to meet all the requirements and that it is properly capable and certified to perform the required activities of this Technical Specifications.

The Supplier shall have:

• Minimum of 10 years’ experience in global air transportation and material handling services, with emphasis on experience and certification required for air cargo operations and specialized expertise on designing/evaluating and certifying Unit Load Devices (ULDs).
• Minimum of 8 years’ experience in the certified design and production of specialized /customized rapid deployment systems.
• Demonstrated satisfactory references of at least 2 similar projects (designing and delivering complex and customized rapid deployment solutions for international organizations and/or for military purposes).

5. WARRANTY
The Supplier shall provide warranty for a period of five (5) years. The warranty shall include complete replacement of any equipment and systems provided by the Supplier, which at any time during the warranty period, due to manufacturing faults or poor workmanship, does not meet at least one requirement of these Technical Specifications.

6. DELIVERABLES
The Supplier shall supply:

• Four (4) DBJ containers in accordance with the design provided by CTBTO.
• Two (2) Lower deck containers in accordance with the specifications at paragraph 3.2 of this Annex.

7. TIMEFRAME REQUIREMENTS
The Supplier shall deliver the equipment within twenty-four (24) weeks from the Commission’s issuance of the Purchase Order.

8. ATTACHMENTS

ATTACHMENT 1: DESIGN DOCUMENT PART 1
ATTACHMENT 2: DESIGN DOCUMENT PART 2
ATTACHMENT 3: DESIGN DOCUMENT PART 3
ATTACHMENT 4: DESIGN DOCUMENT PART 4
Operation Manual 25-56-28 / RRM 628-OM
DBJ Container
1283-40-0000 and 1283-40-0001

Issue 2
15-09-2023
# RECORD OF REVISION

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1. Introduction

1.1. General
This operation manual (OM), of which VRR is the owner and maintainer of the document, is created to inform users and handlers of the best practices when working with the DBJ container.

Please refer to the DBJ container manual with number RRM-628 for more information about damage limitations, maintenance and spare part list check.

1.2. Layout of manual
This manual contains a general operation description, a step-by-step guidance of different operation procedures and cleaning instruction for the DBJ container.

1.3. Revision service
Revision of the product will result in an update of the manual.

1.4. Safety precautions
When handling the container we strongly advice to use the following safety precautions:
   » Always wear safety shoes while loading and unloading

![Safety Shoes Required](image)
2. Operation

2.1. General

The container shall be checked for damages prior to loading, as damaged containers may damage the aircraft loading and/or the restraint system invalidating the certified airworthiness. To ensure that a unit is in a serviceable condition, it must be inspected before each use.

Try to visualize the whole container load before commencing to pack, leave heavy and/or big items on the bottom. Spread load equally.

Cargo with density over 400 kg/m³ (25 lb/cu.ft) requires internal tie-down. This is not required in case of full load (min. 75%) with compressible material.

Before transporting the container on dollies, transporters or other vehicles, ensure that restraint stops, locks or other securing devices have been applied correctly.

⚠ CAUTION
» The doors must be properly closed when the container is moved.
» When the container is moved, the hose locks must be closed off by the gaskets, locked with the handles, and covered by zipping up the hose lock covers.
2.2. Transport

2.2.1. Transport by aircraft

The DBJ is a non-certified container without a pallet base. Therefore the DBJ must be placed on a certified aircraft pallet and fastened with a certified cargo net when transporting by air.

The DBJ will fit on a standard PMC pallet (civil, 3175 x 2438 mm / 125 x 96.0 inch) or a HCU/6E pallet (military).

When using a military HCU/6E pallet, chains can also be used to tie down the DBJ to the pallet. Use the tie down points on the corners of the container.

When using chains to tie down the container to a pallet a certified cargo net is still needed.

![Figure 1: DBJ on an HCU/6E pallet with net](image1.png)

![Figure 2: DBJ on a PMC pallet with net](image2.png)
2.2.2. **Transport by truck**

Use the tie-down points (Figure 3) on the base and corners of the container and/or the ISO corners, to tie down the container to a trailer.

Please note that the ISO corners positions do not match the ISO corner locks on a truck.

*Figure 3: Tie-down rings*
2.3. Hoisting

The DBJ can be hoisted by crane or as sling load by helicopter. Before hoisting, hooks should be attached to all four ISO-corners. A spreader must be used for stability and to prevent damages to the container. The chains must be connected to the tie-down rings as indicated in red in Figure 4 to prevent tipping over during hoisting.

⚠️ CAUTION

- The force from the ISO corners must be transferred to the spreader in a straight line. I.e. the connections to the tie-down rings must **not** be tightened to the point at which the chains from the ISO corners to the spreader are not straight anymore.
2.4. Loading cargo

When loading the container with cargo, all of the following items need to be adhered to:
▪ The Maximum Operational Gross Weight (MOGW)
▪ The maximum loads on the floor of the container
▪ The maximum loads on the shelf
▪ The location of the Centre of Gravity (CoG)

These items are discussed in the following sections.

2.4.1. Maximum Operational Gross Weight

<table>
<thead>
<tr>
<th>Description</th>
<th>Value 1</th>
<th>Value 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>Theoretical Manufacturer’s Empty Weight</td>
<td>827 kg</td>
<td>1823 lb</td>
</tr>
<tr>
<td>Maximum Operational Gross Weight</td>
<td>4536 kg</td>
<td>10000 lb</td>
</tr>
<tr>
<td>Maximum Net weight</td>
<td>3709 kg</td>
<td>8177 lb</td>
</tr>
</tbody>
</table>

2.4.2. Maximum allowable floor loads

The loads on the floor (base) of the container may not exceed any of the following values:
▪ 200 kg/cm$^2$
▪ 1000 kg/m$^2$
▪ 440 lb/inch$^2$
▪ 2200 lb/foot$^2$

2.4.3. Cargo on shelf

The maximum allowable load on the shelf is 1000 kg (2200 lb). The shelf must be supported by (at least) four panel brackets. The panel brackets all need to be at the same height. Place the panel brackets in the first and last seat track of both side walls of the ULD, see Figure 5 for a visualisation.

![Figure 5: Locations panel brackets for shelf (cross section, top view)](image_url)

Cargo on the shelf should be tied-down to the shelf’s integrated Seat/T-track.
2.4.4. Centre of Gravity (CoG)

The Maximum Operational Gross Weight (MOGW) of the container is limited to 4536 kg (10000 lb).

When loaded to this MOGW, the Centre of Gravity (CoG) of the loaded container has to be within the following limits:

- Height of CoG, measured from the bottom, must be below 1219 mm (48 inch).
- In the X-direction (parallel to the long side), the CoG must be in the centre of the container base (1321 mm / 52 inch from the side edge) with a tolerance of ± 10% (264 mm / 10,4 in).
- In the Y direction (parallel to the short side), the CoG must be in the centre of the container base (1067 mm / 42 inch from the front edge) with a tolerance of ± 10% (213 mm / 8,4 in).

The above is visualised in Figure 6.

![Figure 6: Allowed area for the CoG](image-url)
Document “SAE AS36101 – Load distribution model” states that when the gross weight is lower than the MOGW, linear trade-off may be used for increased CoG eccentricity limits in proportion of the lower gross weight. See Figure 7 for this trade-off.

![Allowable CoG offset](image)

**Figure 7: Allowable CoG offset**

Figure 7 illustrates, as an example, that the ULD is loaded to only 50% of the MOGW, the lateral and longitudinal CoG offset can vary up to +/- 30% instead of +/- 10% at MOGW.

Whether at maximum gross weight or the lower gross weight trade-off limitation of Figure 7, the reference load distribution model shall not be used as a method for actually distributing cargo on a container base at ULD build-up. If a piece of cargo will occupy only part of the base surface, it shall be centred on the base and not in a corner. If only a partial load is planned, stacking shall start in the base centre area rather than at the edge.

During ULD build-up, all steps should be taken to provide a loaded ULD CoG location as closely as possible to its geometric centre. When the nature or shape of cargo makes this impossible in practice, the objective should be to limit CoG offset to one direction only, either longitudinal or lateral, not exceeding the maximum allowable offset in that direction. Only as a last resort should both longitudinal and lateral maximum CoG offset be simultaneously used.
2.4.4.1. Example calculation CoG

The file ‘CoG_calculation_CTBTO.xlsx’ can be used for calculating the centre of gravity.

The origin of this calculation is chosen at the left corner at the back of the container, positive x-direction is to the right, positive y-direction is to the front of the container, positive z-direction is upwards. See Figure 8 for the location of the origin.

![Figure 8: Location of origin for CoG calculation.](image)

For this example the following loads were used:

- M1 = weight of empty container = 827 [kg]
- M2 = weight of shelf = 128 [kg]
- M3 = bulk on shelf = 500 [kg]
- M4 = bulk on base = 3000 [kg]

The example locations of the loads are shown in the table below and in Figure 9.

<table>
<thead>
<tr>
<th>M</th>
<th>Mass [kg]</th>
<th>X [mm]</th>
<th>Y [mm]</th>
<th>Z [mm]</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>827</td>
<td>1250</td>
<td>1000</td>
<td>690</td>
</tr>
<tr>
<td>2</td>
<td>128</td>
<td>1250</td>
<td>1000</td>
<td>1440</td>
</tr>
<tr>
<td>3</td>
<td>500</td>
<td>2250</td>
<td>1300</td>
<td>1540</td>
</tr>
<tr>
<td>4</td>
<td>3000</td>
<td>650</td>
<td>1800</td>
<td>40</td>
</tr>
</tbody>
</table>

Total mass = 4455 [kg]
Total mass < MOGW*

*The total mass must be smaller than the MOGW of the container (= 4536 [kg])
Figure 9: Loading example of container

With a moment calculation around the origin the location of the CoG can be obtained in x-, y- and z-direction.

<table>
<thead>
<tr>
<th>Mass * X</th>
<th>Mass * Y</th>
<th>Mass * Z</th>
</tr>
</thead>
<tbody>
<tr>
<td>1033750</td>
<td>827000</td>
<td>570630</td>
</tr>
<tr>
<td>160000</td>
<td>128000</td>
<td>184320</td>
</tr>
<tr>
<td>1125000</td>
<td>650000</td>
<td>770000</td>
</tr>
<tr>
<td>1950000</td>
<td>5400000</td>
<td>120000</td>
</tr>
<tr>
<td><strong>SUM</strong></td>
<td><strong>7005000</strong></td>
<td><strong>1644950</strong></td>
</tr>
</tbody>
</table>
The CoG shift is obtained by dividing the sum of the moments by the total mass. See Figure 10 for allowed CoG limits.

<table>
<thead>
<tr>
<th>CoG shift</th>
<th>X shift</th>
<th>Y shift</th>
<th>Z shift</th>
</tr>
</thead>
<tbody>
<tr>
<td>Limits</td>
<td>986 - 1514</td>
<td>787 - 1213</td>
<td>0 - 1040</td>
</tr>
</tbody>
</table>

![Figure 10: CoG limits (origin in left rear corner)](image)

The way of loading the container in this example is insufficient. The CoG shift in x- and y-direction is outside the limits.

One solution is to shift the bulk on the base to a location where the container will be more in equilibrium.

Current location M4 \([x; y] = [650; 1800]\).
New location M4 can be \([850; 1200]\).

The CoG shift will now be within the limits, see table below.

<table>
<thead>
<tr>
<th>CoG shift</th>
<th>X shift</th>
<th>Y shift</th>
<th>Z shift</th>
</tr>
</thead>
<tbody>
<tr>
<td>Limits</td>
<td>986 - 1514</td>
<td>787 - 1213</td>
<td>0 - 1040</td>
</tr>
</tbody>
</table>

A second solution is to lower the weight of the bulk. When minimizing the load, the limits of the CoG shifts are expanded according to Figure 7.
### 2.5. Seat/t-track load

The interior of the container is lined with Seat/T-track extrusions. The maximum force that may be applied on the Seat/T-track can be seen in below. These values for the maximum loads apply to any direction.

<table>
<thead>
<tr>
<th>Location of Seat/T-track</th>
<th>Maximum load (N)</th>
<th>Maximum load (kg)</th>
<th>Minimum distance between loads (mm)*</th>
<th>Figure</th>
</tr>
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<td>Walls</td>
<td>2484</td>
<td>250</td>
<td>1000</td>
<td>Figure 11</td>
</tr>
<tr>
<td>Track bar</td>
<td>2484 (max. total load)</td>
<td>250 (max. total load)</td>
<td>Not applicable</td>
<td>-</td>
</tr>
<tr>
<td>Ceiling</td>
<td>1530</td>
<td>150</td>
<td>1000</td>
<td>Figure 12</td>
</tr>
<tr>
<td>Floor</td>
<td>3545</td>
<td>360</td>
<td>100</td>
<td>Figure 13</td>
</tr>
</tbody>
</table>

*As the load decreases, the required minimum distance between these loads decreases linearly.

When loading the container, spread the load evenly though the container. The CoG must stay within its described limits.

![Diagram of Seat/T-track load](image)

*Figure 11: Walls*
Product   DBJ Container / 1283-40-0000 and 1283-40-0001
CMM        25-56-28 / RRM 628
Chapter    Description and operation
Issue      2 / 15 September 2023

Figure 12: Ceiling

Figure 13: Floor
2.5.1. Track bar

Besides the integrated Seat/T-track, the container is equipped with two separate track bars, see Figure 14. These can be placed in various locations in the seat track on the walls of the container and provide a horizontal section of Seat/T-track. Two track bars fit next to each other on the side walls of the container. A maximum total load of 2484 N (250 kg) is allowed on the track bar in any direction.

Figure 14: Track bar

2.5.1.1. Placing the track bar

1. Align the studs of the track bar with the seat track on the wall.
2. Push the studs in the seat track which causes the pin on the track bar to be pushed outward.
3. Slide the track bar up or down causing the pin to snap into the seat track.
2.6. Stacking

The container may NOT be stacked on top of another container during transport or deployment. However, the containers could be stacked during storage:

- If the stack does not go beyond two containers in height;
- If wooden beams are placed in between the containers;
- If kept protected from any external influences e.g. forklift collision or weather circumstances such as wind;
- If the containers are not loaded with any equipment.
- If the wooden beams do not damage the zipper and/or roof of the bottom container.

*CTBTO is fully responsible for stacking the containers. VRR will not take any responsibility for failure or accidents related to stacking the containers.*

![Figure 15: Stacked containers](image-url)
2.7. Opening/closing main doors

The main doors are located at the front of the container. Please find a short description on how to open and close the doors below:

2.7.1. Opening the main doors

1. Open left door first by opening the lock of the left door

2. Pull at lock and pull door open

3. Open right door same way as left door
2.7.2. **Closing the main doors**

Close right door first

Place pin (A) in slot, then place keeper (B) in slot.

Close door handle and lock it

Close left door same way as right door
2.8. **Extendibility pack of DBJ 1283-40-0000**

Using the extendibility pack, a setup of two or four containers can be made to provide a workplace which can be cooled or heated using an air-conditioning unit. The expandability pack which need to be used for DBJ P/N 1283-40-0000 is P/N: 2000-05-0044.

The extendibility pack consists of the following items (Figure 16):

- 1x Shelf/pallet
- 4x Ramp
- 2x Modular roof
- 1x Cover

![Figure 16: Extendibility pack components](image-url)
2.8.1. Stowing extendibility pack components

The modular roof and shelf can be stored in the container in a specific way.

2.8.1.1. Stowing the modular roof

Please find below a short description on how to stow the modular roof in the container:

⚠️ CAUTION

- Keep two panel brackets within reach.
- Stowing the modular roof is a two person job.

1. Open both main doors
2. Hang the modular roof on the three hooks located in the roof
3. Use roof handles for easy handling modular roof
4. Swing modular roof upwards
5. Place a panel bracket to the side wall underneath the modular roof as high as possible
6. Put the roof handles back in the clamps
2.8.1.2. **Stowing the shelf**

Please find below a short description on how to stow the shelf in the container:

⚠️ **CAUTION**
- The panel brackets must be placed on the first and last track of the side walls.
- A forklift truck is needed for this job.

1. Open both main doors
2. Place the panel brackets on the first and last track of the side walls. Place all the brackets at the same height.
3. Using a forklift, carefully manoeuvre the shelf inside the container and set it down on the panel brackets.
4. Tie down the shelf by fastening all four straps to the seat track of the container.

The shelf can now be loaded, taking into account the maximum loading conditions in sections 2.4.3 and 2.4.4.
2.8.2. Two container configuration

Please find below a short description on how to setup the two-container configuration in Figure 17.

![Figure 17: Two-container configuration](image)

- Choose a flat surface of 8,5 x 3 m.
- Put the first container (containing the shelf) in place.

1. Open both main doors
2. Loosen the straps of the shelf by taking the double studs out of the seat track.
3. With a forklift carefully take the shelf outside the container and set it down on the ground.
4. Leave 290 to 330 mm between the container and the shelf.
Place two ramps between container and shelf.

The pins will lock the ramp into the base of the container.

Take out the roof handles for easy handling.

Remove all panel brackets and swing modular roof outside.

Position doors such that they are in line with the sides of the shelf and the container.

Lower the modular roof, making sure the pins slide into the tubes atop the doors.
Repeat steps 1 and 7-10 for the second container.

Align the second container with the first container.

Place the containers 2550 to 2600 mm apart.

Place the last two ramps between the second container and shelf.

The pins will lock the ramp into the base of the container.

Place cover over container and zip the cover to the containers.
To install the HVAC system, open one of the hose lock covers on the slanted side of the container.

Open the two rubber handles on the hose lock.

Remove the gasket.

If not already, connect the hose to the HVAC system. The containers are now ready for use.

Open the cover with the two zippers on the side.

Slide the hose lock up.

Place the hose, close the hose lock and lock the rubber handles.
2.8.3. **Four container configuration**

Please find below a short description on how to setup the four-container configuration.

Choose a flat surface of 8,5 x 7 m

<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>1</strong></td>
<td><strong>2</strong></td>
</tr>
<tr>
<td><img src="image1.png" alt="Diagram" /></td>
<td><img src="image2.png" alt="Diagram" /></td>
</tr>
<tr>
<td>Perform steps 1-16 of section 2.8.2 twice.</td>
<td>Place both pairs of containers 1,3 m to 1,5 apart.</td>
</tr>
<tr>
<td><strong>3</strong></td>
<td><strong>4</strong></td>
</tr>
<tr>
<td><img src="image3.png" alt="Diagram" /></td>
<td><img src="image4.png" alt="Diagram" /></td>
</tr>
<tr>
<td>Attach the tunnel to the cover using the zippers.</td>
<td>Perform steps 17-23 of section 2.8.2 to connect the HVAC unit to the containers.</td>
</tr>
</tbody>
</table>
2.9. Extendibility pack of DBJ 1283-40-0001

Using the extendibility pack, a setup of two or four containers can be made to provide a workplace which can be cooled or heated using an air-conditioning unit. The expandability pack which needs to be used for DBJ P/N 1283-40-0001 is P/N: 2000-07-2624.

The extendibility pack consists of the following items (Figure 16):

- 1x Shelf/pallet (balloon 3 in Figure 18)
- 4x Ramp (balloon 1 in Figure 18)
- 2x Sliding modular roof (balloon 2 in Figure 18)
- 1x Cover (balloon 4 in Figure 18)
- 1x Contour guidance pieces (balloon 5 in Figure 18). This is a "map on the floor" to indicate the container and shelf positions with respect to each other, thereby helping the forklift driver. Note that this is only an optional article that can be ordered separately. Since it is only optional, and since its usage speaks for itself, it has not been included in the rest of this operating manual.

![Figure 18: Extendibility pack components](image-url)
2.9.1. Stowing extendibility pack components

The modular roof and shelf can be stored in the container in a specific way.

The improved modular roof (2000-07-2626) is a sliding roof that is installed in the container once, as described in section 2.9.1.1. After that it can be deployed easily by sliding the roof out of the container, and stored easily by sliding it back into the container, as described in section 2.9.2.

2.9.1.1. Installing the modular roof into the container

Please find below a description on how to install the modular roof in the container:

⚠️ CAUTION
» Keep two panel brackets within reach.
» Installing the modular roof is a two person job.

Step 1: Open both main doors

Step 2: Remove the end stop blocks from both roller tracks, by loosening the nuts on the back of the stop blocks (use a torx T9 bit and 7mm wrench).

Step 3: Carry the roof into the container with two people.

Step 4: Lift the modular roof with two people and Please use the orientation of the bracket shown in the image above, otherwise the roof will be installed upside down.
Step 5: place back the end stops in both roller tracks by fastening the bolts.

Step 6: one person tilts the roof horizontal and positions the wheels against the end stop. Another person then supports the roof with two roof support brackets (2000-07-2774), one per side of the container.

Step 7: Secure (fasten) the roof in place with two straps (2000-07-3403), one per side of the container.

Step 8: put the roof handles back in the clamps.
2.9.1.2. **Stowing the shelf**

Please find below a short description on how to stow the shelf in the container:

⚠ **CAUTION**
- The panel brackets must be placed on the first and last track of the side walls.
- A forklift truck is needed for this job.

Open both main doors

Place the panel brackets on the first and last track of the side walls. Place all the brackets at the same height.

Using a forklift, carefully manoeuvre the shelf inside the container and set it down on the panel brackets.

Tie down the shelf by fastening all four straps to the seat track of the container.

The shelf can now be loaded, taking into account the maximum loading conditions in sections 2.4.3 and 2.4.4.
2.9.2. **Two container configuration**

Please find below a short description on how to setup the two-container configuration in Figure 17.

![Figure 19: Two-container configuration](image)

- Choose a flat surface of 8,5 x 3 m.
- Put the first container (containing the shelf) in place.

1. Open both main doors
2. Loosen the straps of the shelf by taking the double studs out of the seat track.
3. With a forklift carefully take the shelf outside the container and set it down on the ground.
4. Leave 290 to 330 mm between the container and the shelf.
Place two ramps between container and shelf.

The pins will lock the ramp into the base of the container.

Take out the roof handles for easy handling.

Loosen the straps and roof support brackets and slide the modular roof outside.

Position doors such that they are in line with the sides of the shelf and the container.

Lower the modular roof, making sure the pins slide into the tubes atop the doors.
Repeat steps 1 and 7-10 for the second container.

Align the second container with the first container.

Place the containers 2550 to 2600 mm apart.

Place the last two ramps between the second container and shelf.

The pins will lock the ramp into the base of the container.

Place cover over container and zip the cover to the containers.
To install the HVAC system, open one of the hose lock covers on the slanted side of the container.

Open the cover with the two zippers on the side.

Open the two rubber handles on the hose lock.

Slide the hose lock up.

Remove the gasket.

Place the hose, close the hose lock and lock the rubber handles.

If not already, connect the hose to the HVAC system. The containers are now ready for use.
### 2.9.3. Four container configuration

Please find below a short description on how to setup the four-container configuration.

Choose a flat surface of 8,5 x 7 m

<table>
<thead>
<tr>
<th></th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Perform steps 1-16 of section 2.8.2 twice.</td>
</tr>
<tr>
<td>2</td>
<td>Place both pairs of containers 1,3 m to 1,5 apart.</td>
</tr>
<tr>
<td>3</td>
<td>Attach the tunnel to the cover using the zippers.</td>
</tr>
<tr>
<td>4</td>
<td>Perform steps 17-23 of section 2.8.2 to connect the HVAC unit to the containers.</td>
</tr>
</tbody>
</table>
2.10. Connections

2.10.1. Roxtec

Two Roxtec Systems are installed in the rear panel of the container.

Two frames are installed in both bottom corners at the back of the container. The two 120x60 mm frames accept different modules. These modules can be mixed up as long the total height is no more than 60 mm and a row always has the same height.

In two 120x60 mm frames will fit the following number of modules:
- 64x RM 15; or
- 36x RM 20; or
- 6x RM 40 + 12x RM 20; or
- 4x RM 60

<table>
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<th>Module</th>
<th>For cable diameter (mm)</th>
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<td>3 - 11</td>
</tr>
<tr>
<td><img src="RM_20.png" alt="Image" /></td>
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<tr>
<td><img src="RM_60.png" alt="Image" /></td>
<td>RM 60</td>
<td>24 - 54</td>
</tr>
</tbody>
</table>
2.10.2. HVAC

The container has two Dantherm duct connectors on the slanted side. The duct connectors are spaced 1,2 m apart and fit a hose with a diameter of Ø400 mm. Because the duct connector is not 100% watertight, the duct is covered with a cover. The cover has zippers on two sides for opening and closing. For insulation purposes a gasket is placed in the duct connector when not used.

Figure 20: Duct cover

Figure 21: Detail – duct connector without cover
3. Cleaning

The interior and exterior faces of the container may be cleaned with any good grade industrial detergent, cleaner and/or water. The interior has to be wiped dry with a clean cloth.

There are no objections to blowing out the container with compressed air or using a vacuum cleaner.

In extremely contaminated condition, steam cleaning is permissible but only with a maximum temperature of 70 degrees Celsius.

If sealing is damaged or missing it shall be restored immediately.

It's permitted to clean the interior and exterior of the container with high pressure cleaner but with a maximum pressure of 2,5 bar.

⚠️ CAUTION

» Never use aggressive agents or chemicals;
» The use of household like chemicals is preferred
### Item Description

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<th>Part Number</th>
<th>Material</th>
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</table>

**Dimensions in mm**

- 400 1000 2000
- 1000 2000 > 1.0
- 1.4
- 2
- 7 30 120
- < 400 0.2 0.3 0.5 0.8

- Mass: 820.38 kg
- Title: DBJ container
- Drawn: MBNH 23-05-2023
- Checked: PV7 08-08-2023
- Approved: HS 08-08-2023
- Drawn: MBNH 23-05-2023
- Checked: PV7 08-08-2023
- Approved: HS 08-08-2023
- Issue: 1283-40-0001
- Sheet: 3 of 4
- Dimensions in mm
- This drawing is property of VRR which reserved all rights
- Rivets according to VRR-SP2201
Extendability pack (2000-07-2624)
for DBJ containers

Contents:
1 x Cover (2000-05-1771)
1 x Shelf (2000-05-0438)
2 x Modular roof (2000-07-2626)
4 x Ramp (2000-04-9116)

Optionally:
1 x contour guidance pieces (2000-07-2664)
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<th>Item No.</th>
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<th>Height/Thickn.</th>
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Dimensions in mm (u.n.o.)

Mass: 322.35 kg

Finish:

Raw extrusion in accordance with OEM drawing and EN755-9

Prepared: A2

This drawing is property of VRR which reserved all rights.
### STEP 1

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**Dimensions in mm (u.n.o.)**
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- Height: 1000 2000
- Thickness: < 1.0 1.4 2
- Side: 7 30 120
- Mass: 322.35 kg

**Issue Drawing no.**
- A2 08-06-2023
- A2 31-07-2023
- A2 08-08-2023

**Dimensions in mm (A2)**
- Stolwijkstraat 57
- 3079 DN Rotterdam
- The Netherlands
- vrr.aero
- info@vrr.aero
- +31 (0)10 479 8100

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### STEP 2

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**Title:** DBJ base level 1  
**Dimensions:** in mm (A2)  
**Mass:** 322.35 kg  
**Issue:** 2000-07-2725  
**Finish:**  

---

**VRR**  
Stolwijkstraat 57, 3079 DN Rotterdam, The Netherlands  
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info@vrr.aero  
+31 (0)10 479 8100  

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## DETAIL F

### SCALE 1 : 3

## Torque load M6: 8.1 Nm

### STEP 4

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**Title:** DBJ base level 1

**Dimensions in mm**  
**Mass:** 322.35 kg

---

**VRR**  
Stolwijkstraat 57  
3079 DN Rotterdam  
The Netherlands  
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info@vrr.aero  
+31 (0)10 479 8100

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**Title:** DBJ base Level 2

**Dimensions in mm (u.n.o.)**

- 0.2
- 0.3
- 0.5
- 0.8
- 0.5
- 1.0
- 1.4
- 2

**Mass:** 195.51 kg

**Preparation:**

- A2

**This drawing is property of VRR which reserved all rights.**
### Torque load M6: 6.3 Nm

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<tr>
<th>Item No.</th>
<th>Description</th>
<th>QTY</th>
<th>Length</th>
<th>Width/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tr>
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<td>BO-14579T-06025-A2</td>
<td>AISI 304</td>
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<td>Nord-Lock Washer M6</td>
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<td>Bk-St. Monobolt 6,4</td>
<td>36</td>
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<td>2,0-15,9</td>
<td>BK-02771-00824</td>
<td>Steel (MGLP-R8-10)</td>
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<td>Tie-Down Ring</td>
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<td>4</td>
<td>2000-05-0526</td>
<td>Ven. 5754-H22</td>
<td>Bond with V30</td>
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</table>

**Dimensions in mm (u.n.o.):**
- 1000: 1.4
- 2000: 2.0

**Mass:** 9.01 kg

---

**Title:** Base edge rear

---

**Drawn:** MBNH 08-06-2023

**Checked:** Prvd 31-07-2023

**Approved:** HS 08-08-2023

**Drawing no.:** 2000-07-2727

**Issue:** A

**Dimensions in mm:**
- A

---

**Rivets according to VRR-SP2201**
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<th>Height/Thickn.</th>
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<th>Material</th>
<th>Remarks</th>
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<td>2000-05-0226</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
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**Dimensions in mm (u.n.o.)**
- 400 1000 2000
- 7 30 120 400 1000 2000
- 0.2 0.3 0.5 0.8

**Tolerances (u.n.o.)**
- 0.5 0.7 1.0 1.4

**Mass:** 5.80 kg

**Issue: 2000-05-0226**  Sheet: 1 of 1

**Title:** Base edge sheet

---

**Scale:** 1:7  **Date:** 14-03-2019  **Drawing no.:** 2000-05-0226  **Issue:** A

**Drawn:** JWR  **Checked:** HS  **Approved:** JWR

**Finish:** Dimensions in mm (u.n.o.)

---

**Dimensions:**
- 247.5
- 2617
- 109.5 109.5
- 15
- 5.2
- 6.8
- 8.5
- 40,2

**Engraving:**
- DOWN 90° R 5

---

**Fax:** +31 10 479 5478  **Tel:** +31 10 479 8100

**Location:** 3079 DN Rotterdam The Netherlands  **Email:** info@vrr-aviation.com  **Fax:** +31 10 479 5478

---

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<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<td>Csk.St. Monobolt 6</td>
<td>6,4</td>
<td>3,1-12,1</td>
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<td>Steel (MGL100-R8-8)</td>
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<td>2</td>
<td>2</td>
<td>Thread block Tie-down points</td>
<td>160</td>
<td>48</td>
<td>8</td>
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<td>Alu. 6082-T6</td>
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<td>Base edge flange</td>
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<td>124,8</td>
<td>3</td>
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<td>Alu. 5754-H22</td>
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This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
A = 6.8
B = 12.0 - D = 0.0
B = 10.5 - D = 0.6
C = 2.2
H = 100°

(For Monobolt Ø6.4 Rivet)

Base edge flange

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Scale: 1:4
Drawing no.: 2000-05-0241
Issue: A

Date: 14-03-2019
Checked: HS
Approved: JWR

Mass: 0.81 kg
Dimensions in mm (u.n.o.)

Finish: 40

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**Dimensions in mm (u.n.o.)**

| Mass:        | 0.16 kg |

**Tolerances (u.n.o.)**

< 7 | 30 | 120 | 400 | 1000 | 2000 |
< 0.2 | 0.3 | 0.5 | 0.8 |

Raw extrusion in accordance with OEM drawing and EN755-9

**Issue:**

2000-05-0259

**Drawing no.:**

A

**Date:**

14-03-2019

**Checked:**

HS

12-04-2019

**Approved:**

JWR

09-05-2019

**Sheets:**

1 of 1

**Dimensions in mm (u.n.o.)**

< 7 | 30 | 120 | 400 | 1000 | 2000 |
< 0.2 | 0.3 | 0.5 | 0.8 |

**Finish:**

Alu. 6082-T6

**Title:**

Thread block Tie-down points

This drawing is property of Van Riemslijk Rotterdam b.v. which reserved all rights
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<td>Csk.St. Monobolt 6,4</td>
<td>16,4</td>
<td>3,1-12,1 Ø6,4</td>
<td>BK-02761-00821</td>
<td>Steel (MGL100-R8-8)</td>
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<td>Base edge flange</td>
<td>441,3</td>
<td>124,8</td>
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**Section Details**

- **Date**: 14-03-2019
- **Checked**: HS
- **Approved**: JWR
- **Mass**: 0.59 kg

**Dimensions in mm**

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Base edge flange

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<th>Length</th>
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<td>Alu. 5754-H22</td>
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Mass: 0.42 kg

Dimensions in mm (u.n.o.)

Tolerances (u.n.o.)

Finish: 

Drawing no.: 2000-05-0248
Issue: A
Sheet: 1 of 1

Title: Base edge flange

Scale: 1:3
Date: 14-03-2019

Drawn: JWR
Checked: HS
Approved: JWR

Dimensions in mm (u.n.o.)

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Tel: +31 10 479 8100
3079 DN Rotterdam
The Netherlands
Fax:+31 10 479 5478

info@vrr-aviation.com
<table>
<thead>
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<th>Item No.</th>
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<th>Length</th>
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**Title:** Corner flange long

**Dimensions:**

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**Mass:** 0.59 kg

**Drawing Information:**

- Drawn: JWR
- Checked: HS
- Approved: JWR
- Date: 14-03-2019, 12-04-2019, 09-05-2019

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
A = 6.8
B = 12.0 - D = 0.0
B = 10.5 - D = 0.6
C = 2.2
H = 100°

(For Monobolt Ø6.4 Rivet)
(Revision C)

Base edge flange

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<th>QTY.</th>
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<td>124.8</td>
<td>3</td>
<td>2000-05-0252</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

Mass: 0.42 kg

Dimensions in mm (u.n.o.)

- Tolerances (u.n.o.)
- Raw extrusion in accordance with OEM drawing and EN755-9

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
Min. load capacity in all directions = 7500lbs (3336daN)

Caution: the D-ring must be able to rotate freely without pinching

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Tie-Down Ring</td>
<td></td>
<td></td>
<td></td>
<td>ZN_VRR-DFSTN</td>
<td>S355J2H</td>
<td>Zinc plated</td>
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Scale: 1:10
Date: 07-03-2022
Drawing no.: ZN_VRR-DFSTN
Issue: A

Dimensions in mm (un.o.)

Mass: 0.13 kg

Title: Tie-Down Ring

Sheet: 1 of 1

Dimensions in mm (un.o.)

Mass: 0.13 kg

Finish:

Dimensions in mm (un.o.)

Mass: 0.13 kg

Finish:

Dimensions in mm (un.o.)

Mass: 0.13 kg

Finish:

Dimensions in mm (un.o.)

Mass: 0.13 kg

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Dimensions in mm (un.o.)

Mass: 0.13 kg

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Dimensions in mm (un.o.)

Mass: 0.13 kg

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Dimensions in mm (un.o.)

Mass: 0.13 kg

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Dimensions in mm (un.o.)

Mass: 0.13 kg

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Dimensions in mm (un.o.)

Mass: 0.13 kg

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Dimensions in mm (un.o.)

Mass: 0.13 kg

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Dimensions in mm (un.o.)

Mass: 0.13 kg

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Dimensions in mm (un.o.)

Mass: 0.13 kg

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Dimensions in mm (un.o.)

Mass: 0.13 kg

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Dimensions in mm (un.o.)

Mass: 0.13 kg

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Dimensions in mm (un.o.)

Mass: 0.13 kg

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Dimensions in mm (un.o.)

Mass: 0.13 kg

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Mass: 0.13 kg

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Dimensions in mm (un.o.)

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Dimensions in mm (un.o.)

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Dimensions in mm (un.o.)

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Mass: 0.13 kg

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Dimensions in mm (un.o.)

Mass: 0.13 kg

Finish:

Dimensions in mm (un.o.)

Mass: 0.13 kg

Finish:

Dimensions in mm (un.o.)

Mass: 0.13 kg

Finish:

Dimensions in mm (un.o.)

Mass: 0.13 kg

Finish:
### Torque load M6: 6.3 Nm

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<th>QTY.</th>
<th>Description</th>
<th>Length</th>
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<th>Height/Thickn.</th>
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<th>Remarks</th>
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<tbody>
<tr>
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<td>Bk.St. Monobolt 6,4</td>
<td>6,4</td>
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<td>Ø6,4</td>
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<td>Steel (MGLP-R8-10)</td>
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</tr>
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<td>7</td>
<td>12</td>
<td>Torx Socket Cap Screw</td>
<td>25</td>
<td>M6</td>
<td>2,2</td>
<td>BO-14579T-06025-A2</td>
<td>AISI 304</td>
<td>ISO 14579 torx</td>
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<tr>
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**Dimensions in mm (u.n.o.)**

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<tr>
<th>Name</th>
<th>Date</th>
<th>Changes Date</th>
<th>Name</th>
<th>Date</th>
<th>Changes Date</th>
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<td>Pvid</td>
<td>31-07-2023</td>
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**Drawing info:**

- **Issue:** 2000-07-2728
- **Drawing number:** A
- **Sheet:** 1 of 1
- **Dimensions:** 2000 x 2700
- **Finish:** Bend with V30
- **Material:** 5754-H22
- **Mass:** 7.13 kg
- **Scale:** 1:1
- **Title:** Base edge side

---

**Remark:** Rivets according to VRR-SP2201
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<tr>
<th>No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
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<th>Remarks</th>
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<tbody>
<tr>
<td>3</td>
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<td>Csk.St. Monobolt</td>
<td>6,4</td>
<td>3,1-12,1</td>
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<td>Steel (MGL100-R8-8)</td>
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<tr>
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<td>1</td>
<td>Thread block Tie-down</td>
<td>160</td>
<td>48</td>
<td>8</td>
<td>2000-05-0259</td>
<td>Alu. 6082-T6</td>
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<td>3</td>
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<td>Alu. 5754-H22</td>
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**Title:** Corner flange short
**Base edge flange**

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<th>Length</th>
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<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tr>
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<td>Base edge flange</td>
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<td>124.8</td>
<td></td>
<td>2000-05-0253</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

**Dimensions in mm**

- A = 6.8
- B = 12.0 - D = 0.0
- B = 10.5 - D = 0.6
- C = 2.2
- H = 100°

**Engraving**

- 2x 27.8 Ø0.8
- 36.9
- 15

**Scale:** 1:2

- **Issue:**
  - Drawing no.: 2000-05-0253
  - Sheet: 1 of 1

- **Mass:** 0.18 kg

- **Finish:**

- **Dimensions in mm (u.n.o.)**

- **Tolerances (u.n.o.)**
  - ±0.2 ±0.3 ±0.5 ±0.8 ±1.0 ±1.4 ±2 ±4
  - Raw extrusion in accordance with OEM drawing and EN755-9

- **Mass:** 0.18 kg

**This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights**
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia.</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
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<th>Remarks</th>
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</thead>
<tbody>
<tr>
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<td>6,4</td>
<td>3,1-12,1</td>
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<td>Steel (MGL100-R8-8)</td>
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<td>1</td>
<td>Thread block Tie-down points</td>
<td>160</td>
<td>48</td>
<td>8</td>
<td>2000-05-0259</td>
<td>Alu. 6082-T6</td>
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<tr>
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<td>207,3</td>
<td>124,8</td>
<td>3</td>
<td>2000-05-0250</td>
<td>Alu. 5754-H22 Bend with Y/C</td>
<td></td>
</tr>
</tbody>
</table>

Finish:

Fax: +31 10 479 5478
Tel: +31 10 479 8100
3079 DN Rotterdam
The Netherlands

Projection

Name: JWR
Date: 14-03-2019
Checked: HS
Date: 12-04-2019
Approved: JWR
Date: 09-05-2019

Mass: 0.36 kg

Title: Corner flange short

This drawing is property of Van Riemsdijk Rotterdam b.v., which reserved all rights.
Base edge flange

Item No. | QTY. | Description | Length | Width/Dia | Height/Thickn. | Part Number | Material | Remarks
--- | --- | --- | --- | --- | --- | --- | --- | ---
1 | 1 | Base edge flange | 207.3 | 124.8 | 3 | 2000-05-0250 | Alu. 5754-H22 | Bend with V30

Dimensions in mm (u.n.o.)

- Mass: 0.18 kg

Finish: 2000-05-0250

Base edge flange

A = 6.8
B = 12.0 - D = 0.0
B = 10.5 - D = 0.6
C = 2.2
H = 100°

(For Monobolt Ø6,4 Rivet)

Revision C

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
Torque load M6: 6.3 Nm

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<tr>
<th>Item No.</th>
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<th>Remarks</th>
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<tr>
<td>8</td>
<td>12</td>
<td>Torx Socket Cap Screw</td>
<td>25</td>
<td>M6</td>
<td>BO-14579T-06025-A2</td>
<td>AISI 304</td>
<td>ISO 14579 torx</td>
</tr>
<tr>
<td>7</td>
<td>12</td>
<td>Nord-Lock Washer M6</td>
<td>ø10,8</td>
<td>M6</td>
<td>BO-NORDLCK-06-SMO</td>
<td>SMO</td>
<td>SMO</td>
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<tr>
<td>6</td>
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<td>Bk.St. Monobolt 6,4</td>
<td>2,0-15,9</td>
<td>Ø6,4</td>
<td>BK-02771-00824</td>
<td>Steel</td>
<td>(MGLP-R8-10)</td>
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<tr>
<td>5</td>
<td>4</td>
<td>Tie-Down Ring</td>
<td>ZN_VRR-DFSTN</td>
<td>S355J2H</td>
<td>Zinc plated</td>
<td></td>
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<tr>
<td>4</td>
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<td>Corner flange long</td>
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<td>Alu.</td>
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Finish:
- Projection

Dimensions in mm (u.n.o.)

Tolerances (u.n.o.)
- ±
- 0.2
- 0.3
- 0.5
- 0.8

Mass: 7.01 kg

This drawing is property of VRR which reserved all rights.
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<tr>
<th>Item No.</th>
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<th>Part Number</th>
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<th>Remarks</th>
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<tr>
<td>1</td>
<td>1</td>
<td>Base edge sheet</td>
<td>2617</td>
<td>247.5</td>
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<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
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</tbody>
</table>

**Dimensions in mm (u.n.o.)**
- Mass: 3.80 kg

**Tolerances (u.n.o.)**
- 400 \( \times \) 1200
- 400 \( \times \) 2000
- 7 \( \times \) 30 \( \times \) 120
- 400 \( \times \) 1000
- 2000 \( \times \) 2000
- \( T \geq 0.2 \) mm

**Issue**
- Drawn: JWR 14-03-2019
- Checked: HS 12-04-2019
- Approved: JWR 09-05-2019

**Sheet 1 of 1**

---

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
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<th>Part Number</th>
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<td>Tube 100x40x3</td>
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<td>100/40</td>
<td>2000-05-0245</td>
<td>Alu. 6060-T66</td>
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**Issue:** A

**Drawing no.:** 2000-05-0245

**Sheet:** 1 of 1

**Dimensions in mm (±0.05):**

- Mass: 1.07 kg
- Finish: 
- Tolerances (±0.05):
  - ±0.2
  - ±0.3
  - ±0.5
  - ±0.8

**Title:** Tube 100x40x3

**Drawn:** JWR (14-03-2019)
**Checked:** HS (12-04-2019)
**Approved:** JWR (09-05-2019)

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
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<th>Width/Dia</th>
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Finish: A

Dimensions in mm (u.n.o.)

- 400 > 1.0
- 1000 > 1.4
- 2000 > 2

Tolerances (u.n.o.)

- +0.2
- +0.3
- +0.5
- +0.8

Mass: 0.71 kg

2000-05-0247 Sheet : 1 of 1

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
<table>
<thead>
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<th>Item No.</th>
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Scale: 1:4

Drawn: JWR 14-03-2019
Checked: HS 12-04-2019
Approved: JWR 09-05-2019

Mass: 0.56 kg

Finish: Dimensions in mm (u.n.o.)

Issue: 2000-05-0242 A

Tolerances (u.n.o.):
- ± 0.2 0.3 0.5 0.8

Raw extrusion in accordance with OEM drawing and EN755-9

Title: Tube 100x40x3
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
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<th>Length</th>
<th>Width/Dia</th>
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**Dimensions in mm (u.n.o.)**

- Mass: 1.42 kg

**Tolerances (u.n.o.)**

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**Raw extrusion in accordance with OEM drawing and EN755-9**

**Issue**

- 2000-05-0618

**Sheet:** 1 of 1

**Drawn:** JWR

**Checked:** HS

**Approved:** JWR

**Mass:** 1.42 kg

**Finish:**

- Dimensions in mm (u.n.o.)

**Title:** Tube 100x40x3

**Fax:** +31 10 479 5478

**Tel:** +31 10 479 8100

**3079 DN Rotterdam**

**The Netherlands**

**info@vrr-aviation.com**

**This drawing is property of Van Rijmsdijk Rotterdam b.v. which reserved all rights**
**Title:** Tube 100x40x3

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>719</td>
<td>1</td>
<td>Tube 100x40x3</td>
<td>8 x 80 = 640</td>
<td></td>
<td></td>
<td>2000-05-0619</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.):**
- Mass: 1.42 kg
- Finished dimensions: 25 x 45°, 2x
- 2000-05-0619

**Tolerances (u.n.o.):**
- ± 0.2
- ± 0.3
- ± 0.5
- ± 0.8

**Issue:** A

**Drawing no.:** 2000-05-0619

**Finish:**
- Dimensions in mm (u.n.o.)
- Raw extrusion in accordance with OEM drawing and EN755-9

---

**Fax:** +31 10 479 5478
**Tel:** +31 10 479 8100
**Stolwijkstraat 57**
**3079 DN Rotterdam**
**The Netherlands**
**info@vrr-aviation.com**

---

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Tube 100x40x3</td>
<td>282</td>
<td>100.40</td>
<td>3</td>
<td>2000-05-0622</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

- Mass: 0.54 kg

Finish:

- 2000-05-0622

Issue:

- A

Tolerances (u.n.o.):

- ±0.2 ±0.3 ±0.5 ±0.8

- Raw extrusion in accordance with OEM drawing and EN755-9

Title: Tube 100x40x3
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Tube 100x40x3</td>
<td>282</td>
<td>100/40</td>
<td>3</td>
<td>2000-05-0642</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

| Scale: 1:5 | Date: 14-03-2019 | Drawing no.: 2000-05-0642 | Issue: A |
| Drawn: JWR | Checked: HS | Approved: JWR | Sheet: 1 of 1 | |

**Mass:** 0.54 kg

**Dimensions in mm (u.n.o.)**
- <7 30 120 400 1000 2000 3000 4000 5000 6000 7000>
- ±0.2 ±0.3 ±0.5 ±0.8 ±1.0 ±1.4 ±2.5 ±5.0 ±10.0 ±20.0 ±50.0 

**Tolerances (u.n.o.)**
- Raw extrusion in accordance with OEM drawing and EN755-9

---

**Title:** Tube 100x40x3
**Title:** Corner Right

**Item No.** | Description | Length | Width | Height | Thickn. | Part Number | Material | Remarks
---|---|---|---|---|---|---|---|---
1 | Corner Right | 210 | 190 | 124 | 2000-04-8211 | Alu. 6082-T6 | Milled Part | 

**Scale:** 1:3

**Drawing no.:** 2000-04-8211

**Issue:** B

**Dimensions in mm (u.n.o.)**

| Mass: | 3.39 kg |

---

**Tolerances (u.n.o.)**

- Raw extrusion in accordance with OEM drawing and EN755-9

---

**Issue Drawing no.:**

**Title:** Corner Right

**Dimensions:**

- 101,5 x 101,5 x 24
- 124 x 116 x 124
- 190 x 124 x 116
- 210 x 124 x 124

---

**Finish:**

- HS

---

**Projection:**

- +Fillets

---

**Tag:** A3

---

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---

**Stolwijkstraat 57**

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**The Netherlands**

**vrr.aero**

**info@vrr.aero**

**+31 (0)10 479 8100**
<table>
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<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Corner Right</td>
<td>210</td>
<td>190</td>
<td>124</td>
<td>2000-04-8211</td>
<td>Alu. 6082-T6</td>
<td>Milled Part</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- 400 1000 2000
- 7 30 120 400 1000 2000
- ±0.2, ±0.3, ±0.5, ±0.8
- ±0.1, ±0.2
- Raw extrusion in accordance with OEM drawing and EN755-9

**Tolerances (u.n.o.)**

- ±0.2, ±0.3, ±0.5, ±0.8
- ±0.1, ±0.2
- Raw extrusion in accordance with OEM drawing and EN755-9

**Mass:** 3.39 kg

**Finish:** B

**Drawn:** JWR 14-03-2019

**Checked:** VvM 09-10-2019

**Approved:** JWR 10-10-2019

**Issue:** 2000-04-8211

**Sheet:** 2 of 2

**Title:** Corner Right

---

This drawing is property of VRR which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
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<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Isocorner top plate</td>
<td>169</td>
<td>143</td>
<td>8</td>
<td>2000-04-8214</td>
<td>Alu. 6082-T6</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.):**

- A: 9.0
- B: 18.0
- C: 4.5
- H: 90°

**Mass:** 0.49 kg

**Finish:**

- Engraving: 8
- R10
- 6.8

**Dimensions:**

- A: 169
- B: 163
- H: 90°

**Tolerances (u.n.o.):**

- ±0.2
- ±0.3
- ±0.5
- ±0.8

**Issue:**

- 2000-04-8214

**Drawing Details:**

- Scale: 1:1
- Date: 15-03-2019
- Drawing no.: 2000-04-8214
- Sheet: 1 of 1
- Issue: A
- Checked: HS
- Approved: JWR
- Dimensions in accordance with OEM drawing and EN755-9

**Remarks:**

- Raw extrusion in accordance with OEM drawing and EN755-9

**Title:** Isocorner top plate

**Contact Information:**

- Fax: +31 10 479 5478
- Tel: +31 10 479 8100
- 3079 DN Rotterdam
- The Netherlands
- info@vrr-aviation.com

**Projection:**

- A

---

**Disclaimer:** This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
(For Monobolt Ø6,4 Rivet) (Revision C)

SECTION A-A
SCALE 1 : 2

A = 6,8
B = 12,0 - D = 0,0
B = 10,5 - D = 0,6
C = 2,2
H = 100°

Flatpattern on sheet 2

<table>
<thead>
<tr>
<th>Item</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Fork pocket sheet</td>
<td>946,3</td>
<td>107,7</td>
<td></td>
<td>2000-05-0229</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

Scale: 1:4
Date: 15-03-2019
Drawing no.: 2000-05-0229
Issue: A

Checked: HS
12-04-2019
Approved: JWR
09-05-2019

Mass: 1.23 kg
Finish: Dimensions in mm (u.n.o.)

Title: Fork pocket sheet

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A = 6.8
B = 12.0 - D = 0.0
B = 10.5 - D = 0.6
C = 2.2
H = 100°

(For Monobolt Ø6.4 Rivet)

Dimensions in mm (u.n.o.)

Tolerances (u.n.o.)

Mass:         1.23 kg

2000-05-0229

Sheet : 1 of 2

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
### Flatpattern on sheet 2

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Fork pocket sheet</td>
<td>983,3</td>
<td>167,7</td>
<td></td>
<td>2000-05-0231</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

**Scale:** 1:4  
**Date:** 15-03-2019  
**Drawing no.:** 2000-05-0231  
**Issue:** A  
**Tolerances (u.n.o.)**<br>± 0.3  
**Mass:** 1.30 kg  
**Finish:**  
**Title:** Fork pocket sheet

---

**Engraving**

**SECTION A-A**  
**SCALE 1 : 2**
A = 6.8
B = 12.0 - D = 0.0
B = 10.5 - D = 0.6
C = 2.2
H = 100°

(For Monobolt Ø6.4 Rivet)

Title: Fork pocket sheet

Dimensions in mm (u.n.o.)

Mass: 1.29 kg

Finish: Raw extrusion in accordance with OEM drawing and EN755-9

Tolerances (u.n.o.)

Issue: 2000-05-0231 Sheet: 1 of 2

Scale: 1:3

Drawn: JWR 15-03-2019
Checked: HS 12-04-2019
Approved: JWR 09-05-2019
Engraving

SECTION A-A
SCALE 1 : 2

A = 6.8
B = 12.0 - D = 0.0
B = 10.5 - D = 0.6
C = 2.2
H = 100°

(Fork pocket sheet)

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia.</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Fork pocket sheet</td>
<td>729.3</td>
<td>167.7</td>
<td>2000-05-0233</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
<td></td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

- Mass: 0.95 kg

Flatpattern on sheet 2

Issue:

- Drawn: JWR 15-03-2019
- Checked: HS 12-04-2019
- Approved: JWR 09-05-2019

Finish:

- Dimensions in mm (u.n.o.)
- Mass: 0.95 kg

Projection

This drawing is property of Van Riemdsijk Rotterdam b.v. which reserved all rights
A = 6,8
B = 12,0 - D = 0,0
B = 10,5 - D = 0,6
C = 2,2
H = 100°

(For Monobolt Ø6,4 Rivet)

Dimensions in mm (u.n.o.)

Mass: 0.95 kg

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Fork pocket sheet</td>
<td>729,3</td>
<td>167,7</td>
<td>3</td>
<td>2000-05-0233</td>
<td>Al 5754-H22</td>
<td>Bend with V80</td>
</tr>
</tbody>
</table>

Scale: 1:3

Issue: 2000-05-0233

Title: Fork pocket sheet

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### Fork pocket sheet

<table>
<thead>
<tr>
<th>Item No.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Fork pocket sheet</td>
<td>766.3</td>
<td>167.7</td>
<td>3</td>
<td>2000-05-0234</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

*Dimensions in mm (u.n.o.)*

- 400  1000  2000  400  1000  2000 > 7 30 120 400 1000 2000 > 0.2 0.3 0.5 0.8 0.2 0.3 0.5 0.8

*Mass:* 1.01 kg

**Flatpattern on sheet 2**

**Title:** Fork pocket sheet

**Issue:** 2000-05-0234

**Drawn:** JWR 15-03-2019

**Checked:** HS 12-04-2019

**Approved:** JWR 09-05-2019

**Scale:** 1:4

**Sheet:** 1 of 2

**Dimensions in mm (u.n.o.)**

- 15-03-2019
- 12-04-2019
- 09-05-2019

**Tolerances (u.n.o.)**

- ±0.2
- ±0.3
- ±0.5
- ±0.8

**Finish:**

**Dimensions in mm (u.n.o.)**
### Flatpattern on sheet 2

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Fork pocket sheet</td>
<td>946.3</td>
<td>167.7</td>
<td>2000-05-0633</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

| Mass:         | 1.23 kg |

**Tolerances (u.n.o.)**

- \( A \approx 6.8 \)
  - \( B = 12.0 - D = 0.0 \)
  - \( B = 10.5 - D = 0.6 \)
  - \( C = 2.2 \)
  - \( H = 100° \)

**Issue:**

- Drawing no.: [2000-05-0633](#) Sheet : 2 of 2
- Drawn: JWR 15-03-2019
- Checked: HS 12-04-2019
- Approved: JWR 09-05-2019

**Finish:**

- Dimensions in mm (u.n.o.)

**Projection:**

- Section A-A
- Scale 1 : 2

**Engraving**

- 616.5
- 362.5
- 40

**Note:**

- This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
A =  6.8
B = 12.0 - D = 0.0
B = 10.5 - D = 0.6
C =   2.2
H = 100°
(For Monobolt Ø6.4 Rivet)
A = 6.8
B = 12.0 - D = 0.0
B = 10.5 - D = 0.6
C = 2.2
H = 100°
(For Monobolt Ø6,4 Rivet)

Dimensions in mm (u.n.o.)

Tolerances (u.n.o.)

Mass: 0.95 kg

2000-05-0636
### Flat Pattern on Sheet 2

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Fork pocket sheet</td>
<td>983.3</td>
<td>167.7</td>
<td>3</td>
<td>2000-05-0638</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

**Scale:** 1:4  
**Issue:** Sheet: 1 of 2  
**Drawing no.:** 2000-05-0638  
**Issue:** A  
**Tolerances (u.n.o.):**  
- < 7 30 120 400 1000 2000  
- ≥ 7 30 120 400 1000 2000  
- 9 61 122 305  
- 9 10 20 30  

**Mass:** 1.30 kg  
**Finish:**  

---

**Engraving**  
**SECTION A-A**  
**SCALE 1 : 2**

---

### Dimensions in mm (u.n.o.)

- Raw extrusion in accordance with OEM drawing and EN755-9

---

**This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights**
(For Monobolt Ø6,4 Rivet)
1 | 1 | Connection plate | 150 | 84 | 3 | 2000-05-0260 | Alu. 6082-T6 |
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
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<th></th>
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<tbody>
<tr>
<td>Item No.</td>
<td>QTY.</td>
<td>Description</td>
<td>Length</td>
<td>Width/Dia</td>
<td>Height/Thickn.</td>
<td>Part Number</td>
<td>Remarks</td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>Connection plate</td>
<td>2000-05-0260</td>
<td>0.10 kg</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Scale:</td>
<td>1:1</td>
<td>Date:</td>
<td>Drawing no.:</td>
<td>Issue</td>
<td>Tolerances (u.n.o.)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Checked:</td>
<td>HS</td>
<td>12-04-2019</td>
<td></td>
<td></td>
<td>&gt; ±0.2 ±0.3 ±0.5 ±0.8</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Approved:</td>
<td>JWR</td>
<td>09-05-2019</td>
<td></td>
<td></td>
<td>Raw extrusion in accordance with OEM drawing and EN755-9</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

- 7
- 30
- 120
- 400
- 1000
- 2000

> ±0.2
±0.3
±0.5
±0.8

Tolerances (u.n.o.)

- Mass: 0.10 kg

Title: Connection plate

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
Dia holes
Countersunk holes: Ø6.85
holes: Ø6.8

A = 6.8
B = 12.0 - D = 0.0
B = 10.5 - D = 0.6
C = 2.2
H = 100°

Item

No. QTY. Description Length Width Dia. Height Thickn. Part Number Material Remarks

1 1 Mid Sheet base 2832 2124 2.5 2000-05-1112 Alu. 7021-T6

Mass: 38.37 kg

Finish: B

Scale: 1:12

Drawing no.: 2000-05-1112

Issue: B

Tolerances (u.n.o.):

Dimensions in mm (u.n.o.)

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3079 DN Rotterdam
The Netherlands

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+31 (0)10 479 8100
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Pallet rubber</td>
<td>2116</td>
<td>623</td>
<td>3</td>
<td>2000-05-1099</td>
<td>EPDM-Plaatrubber</td>
<td>art. nr. 422.000003</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Width: 400, 1000, 2000
- Height: 7, 30, 120
- Thickness: 1.0, 1.4

**Tolerances (u.n.o.)**

- Width: ±0.2, ±0.3, ±0.5, ±0.8
- Height: ±7, ±30, ±120

**Dimensions in mm**

- Width: 400, 1000, 2000
- Height: 7, 30, 120

**Mass:** 3.95 kg

**Finish:**

- Drawing no.: 2000-05-1099
- Sheet: 1 of 1

**Issue:** B

- Drawn: JWR 18-03-2019
- Checked: HS 13-02-2020
- Approved: JWR 06-03-2020

- Original drawing and RAW projection in accordance with OEM drawing and EN755-9

- Projection

- Size: A3

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>5</td>
<td>2</td>
<td>Bk.St. Monobolt 6,4</td>
<td>6,4</td>
<td>2,0-15,9</td>
<td>Ø6,4</td>
<td>BK-02771-00824</td>
<td>Steel (MGLP-R8-10)</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>4</td>
<td>Csk.St. Monobolt 4,8</td>
<td>4,8</td>
<td>3,2-12,2</td>
<td>Ø4,8</td>
<td>BK-02761-00619</td>
<td>Steel (MGL100-R6-9)</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>Tube 50x40x13</td>
<td>50</td>
<td>40</td>
<td>13</td>
<td>2000-04-8266</td>
<td>Alu. 6061-T6</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>Seat/T-track profile</td>
<td>50</td>
<td>15</td>
<td>2000-05-8266</td>
<td>2000-05-1081</td>
<td>Alu. 6061-T6</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>Leg bracket 1993 142,7</td>
<td>1993 142,7</td>
<td>142,7</td>
<td>2000-05-1081</td>
<td>2000-05-1081</td>
<td>Alu. 6061-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
### Leg bracket

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Leg bracket</td>
<td>1993</td>
<td>142.7</td>
<td>3</td>
<td>2000-05-1081</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**
- Raw extrusion in accordance with OEM drawing and EN755-9
- Mass: 2.29 kg

**Tolerances (u.n.o.)**
- ± 0.2 ± 0.3 ± 0.5 ± 0.8

**Issue**
- Drawing no.: 2000-05-1081
- Sheet: 1 of 1

**Extra Information**
- Scale: 1:6
- Date: 19-03-2019
- Drawn: JWR
- Checked: HS
- Approved: JWR
- Mass: 2.29 kg
- Dimensions in mm (u.n.o.)

**Engraving**
- UP 90° R 5

**Dimensions**
- Length: 142.7 mm
- Width: 3 mm
- Height: 1993 mm

**Notes**
- This drawing is property of Van Riemsdijk Rotterdam b.v., which reserved all rights.
### Seat-T track profile

**Dimensions in mm (U.N.O.)**

<table>
<thead>
<tr>
<th>Amax</th>
<th>Bmax</th>
<th>Cmin</th>
<th>Dmin</th>
</tr>
</thead>
<tbody>
<tr>
<td>30</td>
<td>120</td>
<td>400</td>
<td>2000</td>
</tr>
</tbody>
</table>

**Tolerances (U.N.O.)**

- ±0.12
- ±0.08
- ±0.05
- ±0.03

**Mass:** 2.51 kg

**Finish:** U001 - Aludon

**Material:** Alu. 6061-T6

**Remarks:**
- Projection
- Dimensions in mm (U.N.O.)
- Raw extrusion in accordance with OEM drawing and EN755-9

### Table

<table>
<thead>
<tr>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Seat-T track profile</td>
<td>1993</td>
<td>50</td>
<td>15</td>
<td>2000-04-8266</td>
<td>Alu. 6061-T6</td>
<td></td>
</tr>
</tbody>
</table>

**Drawn:** JWR 21-03-2019

**Checked:** HS 12-04-2019

**Approved:** JWR 09-05-2019

**Issue:** A

**Drawing no.:** 2000-04-8266

**Sheet:** 1 of 1

---

(For Monobolt Ø4.8 Rivet)

- A = 5.0
- B = 9.9 - D = 0.0
- B = 8.8 - D = 0.5
- C = 2.1
- H = 100°
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Tube 50x40x3</td>
<td>8 x 101.6 = 812.8</td>
<td>8 x 101.6 = 812.8</td>
<td>2000-05-0261</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.):  
- Mass: 2.68 kg  

Issue: Tolerances (u.n.o.):  
- 7.00 12.00 40.00 100.00 200.00
- $\pm 2.00$ $\pm 0.50$ $\pm 0.10$ $\pm 0.04$ $\pm 0.02$

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length Width/ Dia</th>
<th>Height/ Thickness</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>5</td>
<td>44</td>
<td>Csk.St. Monobolt 4,8</td>
<td>Ø4,8</td>
<td>3,2-12,2</td>
<td>BK-02761-00619</td>
<td>Steel (MGL100-R6-9)</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>23</td>
<td>Bk.St. Monobolt 6,4</td>
<td>Ø6,4</td>
<td>2,0-15,9</td>
<td>BK-02771-00824</td>
<td>Steel (MGLP-R8-10)</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>Tube 50x40x3</td>
<td>1993</td>
<td>50/40</td>
<td>2000-05-0261</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>Seat-T track profile</td>
<td>1993</td>
<td>50</td>
<td>2000-05-8266</td>
<td>Alu. 6061-T6</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>Leg bracket</td>
<td>1993</td>
<td>142,7</td>
<td>2000-05-1081</td>
<td>Alu. 5754-H22 Bend with V30</td>
<td></td>
</tr>
</tbody>
</table>

**Title:** Seat/T-track beam

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
<table>
<thead>
<tr>
<th>No.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Diameter</th>
<th>Height/Thickness</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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</thead>
<tbody>
<tr>
<td>1</td>
<td>Tube</td>
<td>50x40</td>
<td>3</td>
<td>2000-05-0261</td>
<td>Alu. 6060-T6</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>Seat-T track profile</td>
<td>1993</td>
<td>15</td>
<td>2000-05-8266</td>
<td>Alu. 6061-T6</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>Leg bracket</td>
<td>1993</td>
<td>142.7</td>
<td>2000-05-1081</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>Csk. St. Monobolt 4,8</td>
<td>99.5</td>
<td>3.2-12.2</td>
<td>BK-02761-00619</td>
<td>Steel (MGL100-R6-9)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5</td>
<td>Bk. St. Monobolt 6,4</td>
<td>99.5</td>
<td>2.0-15.9</td>
<td>BK-02771-00824</td>
<td>Steel (MGLP-R8-10)</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
### Dimensions (in mm)

- **Length**: 2075.2
- **Width**: 203
- **Height**: 101.8
- **Mass**: 2.26 kg

### Tolerances

- **A**: ±0.5
- **B**: ±0.3
- **C**: ±0.1
- **H**: ±0.3

### Notes

- **Engraving**

### Draft Details

- **Issue**: A
- **Drawing no.**: 2000-05-0272

### Material

- **Alu. 5754-H22**

### Remarks

- **Bend with V16**

### Title

- **top base sheet**
A
H
C
D  B 
A =   5,0
B =   9,9 - D = 0,0
B =   8,8 - D = 0,5
C =   2,1
H = 100°
(For Monobolt Ø4,8 Rivet) 

### Table

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>top base sheet</td>
<td>2075.2</td>
<td>274.2</td>
<td></td>
<td>2000-05-0273</td>
<td>Alu. 5754-H22</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Raw extrusion in accordance with OEM drawing and EN755-9
- Tolerances (u.n.o.):
  - Mass: 2.91 kg

**Projected**

- UP 90° R 2.5

**Drawing Details**

- Scale: 1:6
- Date: 21-03-2019
- Drawing no.: 2000-05-0273
- Issue: A
- Checked: HS (12-04-2019)
- Approved: JWR (09-05-2019)
- Finish: Dimensions in mm (u.n.o.)

**Title**

- top base sheet

**Dimensions**

- 2014
- 213
- 274.2
- 65
- 101.7
- 63.1
- 30
- 120
- 1.0
- 0.2
- 7
- 0.3
- 0.5
- 400
- 5
- 0.8
- 30
- 0.0
- 0.4
- 63.1
- 274.2
- 65
- 101.7
- 63.1
- UP 90° R 2.5

**Notes**

- This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
(For Monobolt Ø4,8 Rivet)
The diagram illustrates a top base sheet with dimensions and tolerances. The sheet is intended for use with Monobolt Ø4.8 rivets, as indicated by the notation (For Monobolt Ø4.8 Rivet).

The sheet's dimensions are as follows:
- Width: 2075.2 mm
- Height: 457 mm
- Diameter: 65 mm
- Radius: 2.5 mm
- Engraving: 63.1 mm

The material is Alu. 5754-H22, and the part number is 2000-05-1098. The mass of the sheet is 5.08 kg.

The drawing is an Engraving R2.5 and has a scale of 1:7. It is revised to Revision C as indicated by the notation (Revision C).

The title of the sheet is "top base sheet."
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>outside doorpost</td>
<td>2502</td>
<td>86.5</td>
<td>2</td>
<td>2000-04-8710</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

- Mass: 3.33 kg
- Tolerances (u.n.o.)
  - ±0.5

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
Item | No. | QTY. | Description | Length | Width/Dia | Height/Thickn. | Part Number | Material | Remarks
--- | --- | --- | --- | --- | --- | --- | --- | --- | ---
1 | 1 | Door rubber Extrusion | 2486 | 2000-04-8336 | Rubber | Almet (AN625) | Finish: | Mass: 0.25 kg | 2000-04-8336

Dimensions in mm (u.n.o.):
- Length: 400, 1000, 2000
- Width: 1000, 2000
- Diameter: > 1.0, 1.4, 2
- Height/Thickness: 7, 30, 120
- Tolerances: ±0.2, ±0.3, ±0.5, ±0.8

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Doorkeeper base</td>
<td>217</td>
<td>40</td>
<td>38.5</td>
<td>2000-05-1764</td>
<td>Alu. 6082-T6</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Mass: 0.80 kg
- Drawn: JWR 21-03-2019
- Checked: HS 12-04-2019
- Approved: JWR 09-05-2019

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
The image contains a mechanical drawing with dimensions and tolerances. It includes a table with details such as item number, quantity, description, length, width, and part number. The drawing is associated with the upper floor and is made of aluminum 5754-H22. The drawing number is 2000-05-0265, and the date is 21-03-2019. The dimensions are given in millimeters and include tolerances. The drawing is part of a project involving upper floor Engraving.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Topfloor Aft Edge</td>
<td>2501</td>
<td>122.7</td>
<td>26.9</td>
<td>29.9</td>
<td>29.9</td>
<td>2501</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Mass: 2.30 kg

**Tolerances (u.n.o.)**

- < 7, 30, 120, 400, 1000, 2000
- > 30, 120, 400, 1000, 2000
- ±4 ±4 ±4

**Raw extrusion in accordance with OEM drawing and EN755-9**

**Issue Drawing no.:** 2000-05-0268

- Sheet: 1 of 1

**Finish:** A

**Dimensions in mm (u.n.o.)**
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Top floor edge</td>
<td>2507</td>
<td>141.7</td>
<td>3</td>
<td>2000-05-0916</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

- **Scale:** 1:1
- **Dimensions in mm (u.n.o.):**
  - Raw extrusion in accordance with OEM drawing and EN755-9
  - Mass: 2.58 kg

---

**Title:** Top floor edge Front

**Issue:** 2000-05-0916

**Dimensions in mm (u.n.o.)**

| Tolerances (u.n.o.) | < 7 30 120 400 1000 2000 | g0.2 g0.3 g0.4 g0.5 g0.6 g0.7 | ±0.2 ±0.3 ±0.4 ±0.5 ±0.6 ±0.7 |

---

**Drawing Information**

- **Issue Drawing no.:** 2000-05-0916
- **Drawing no.:** Sheet : 1 of 1

**Dimensions in mm (u.n.o.)**

- **Mass:** 2.58 kg
- **Finish:**
- **Date:** 21-03-2019
- **Checked:** HS 12-04-2019
- **Approved:** JWR 09-05-2019
Engraving

Title: Leg bracket

Item No. | QTY. | Description | Length | Width/Dia | Height/Thickn. | Part Number | Material | Remarks
--- | --- | --- | --- | --- | --- | --- | --- | ---
1 | 1 | Leg bracket | 558.7 | 119.7 | 3 | 2000-05-1097 | Alu. 5754-H22 | Bend with V30

Scale: 1:3

Drawn: JWR 22-03-2019
Checked: HS 12-04-2019
Approved: JWR 09-05-2019

Issue no.: 2000-05-1097 Sheet: 1 of 1

Dimensions in mm (u.n.o.)

Raw extrusion in accordance with OEM drawing and EN755-9

Finish: A

Mass: 0.45 kg

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
**Leg bracket**

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Leg bracket</td>
<td>1993</td>
<td>142.7</td>
<td>3</td>
<td>2000-05-1116</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Mass: 2.29 kg

**Tolerances (u.n.o.)**

- ±2
- ±1.5
- ±1.0
- ±0.5
- ±0.3
- ±0.2

**Raw extrusion in accordance with OEM drawing and EN755-9**

- Dimensions in mm (u.n.o.)

**Issue**

- A

**Drawn:** JWR 22-03-2019

**Checked:** HS 12-04-2019

**Approved:** JWR 09-05-2019

**Finish:**

**Dimensions in mm (u.n.o.)**

- 7
- 30
- 120
- 400
- 1000
- 2000

**Raw extrusion in accordance with OEM drawing and EN755-9**

**Title:**

Leg bracket

**Revision:**

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>Description</th>
<th>Length (mm)</th>
<th>Width/ Dia (mm)</th>
<th>Height/ Thickn. (mm)</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Cel rubber</td>
<td>1809</td>
<td>25</td>
<td>25</td>
<td>2000-05-1625</td>
<td>EPDM</td>
<td></td>
</tr>
</tbody>
</table>

**Scale:** 1:1

**Drawn:** JWR  
**Checked:** HS  
**Approved:** JWR

**Date:** 22-03-2019  
**Checked Date:** 12-04-2019  
**Approved Date:** 09-05-2019

**Issue:** Sheet : 1 of 1

**Issue Drawing no.:** 2000-05-1625

**Tolerances (u.n.o.):**
- > 400 mm
- 7 30 120 400 1000 2000
- ±0.2 ±0.3 ±0.5 ±0.8 ±1.0 ±1.4 ±2

**Dimensions in mm (u.n.o.):**
- Mass: 1.33 kg
- Raw extrusion in accordance with OEM drawing and EN755-9

**This drawing is property of Van Rijmsdijk Rotterdam b.v. which reserved all rights**
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Cel rubber</td>
<td>2278</td>
<td>25</td>
<td>25</td>
<td>2000-05-1626</td>
<td>EPDM</td>
<td></td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.):

- Length: 2278
- Width: 25
- Height: 25
- Diameter: 2000-05-1626

Mass: 1.68 kg

Tolerances (u.n.o.):

- Length: ±7
- Width: ±10
- Height: ±14
- Diameter: ±2

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
STEP 1

Place INNO SEAL between panels when assembling

Remove excess sealant

Note that the sealant has a dry time of 2 hours
STEP 2

Place INNO SEAL between panels when assembling

Remove excess sealant

Note that the sealant has a dry time of 2 hours

<table>
<thead>
<tr>
<th>Item</th>
<th>No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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</thead>
<tbody>
<tr>
<td>28</td>
<td>1</td>
<td>1</td>
<td>Bk.Rivet Klamp-Tite 4,8</td>
<td>156,2</td>
<td>112</td>
<td>2</td>
<td>BK-BAPKTR-06W-04</td>
<td>Alu. w. Rub. washer</td>
<td></td>
</tr>
<tr>
<td>27</td>
<td>1</td>
<td>1</td>
<td>Bk.Rivet Klamp-Tite 4,8</td>
<td>156,2</td>
<td>112</td>
<td>2</td>
<td>BK-BAPKTR-06W-04</td>
<td>Alu. w. Rub. washer</td>
<td></td>
</tr>
<tr>
<td>23</td>
<td>1</td>
<td>1</td>
<td>Fill plate corner gusset</td>
<td>155,2</td>
<td>112</td>
<td>2</td>
<td>2000-05-1417</td>
<td>Alu. 5754-H22</td>
<td></td>
</tr>
<tr>
<td>22</td>
<td>1</td>
<td>1</td>
<td>Fill plate corner gusset</td>
<td>155,2</td>
<td>112</td>
<td>2</td>
<td>2000-05-1416</td>
<td>Alu. 5754-H22</td>
<td></td>
</tr>
<tr>
<td>14</td>
<td>1</td>
<td>1</td>
<td>Gusset</td>
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Finish:

Projection

This drawing is property of VRR which reserved all rights

Rivets according to VRR-SP2201

Title: Hull DBJ

Dimensions in mm (u.n.o.)

Mass: 380.02 kg
**STEP 2**

Place INNO SEAL between panels when assembling.

Remove excess sealant.

Note that the sealant has a dry time of 2 hours.

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**Finish:**

Projection

**Tolerances:**

Dimensions in mm (u.n.o.)

**Mass:** 380.02 kg

**Title:** Hull DBJ

**Drawn:** MBB/H

**Date:** 25-05-2023

**Drawing no.**: 2000-07-2646

**Issue:** A

**Drawing no.**: 2000-07-2647

**Approval:** HS

**Date:** 08-08-2023

**Sheet:** 5 of 15

**Dimensions in mm (u.n.o.)**

**Rivets according to VRR-SP2201**

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Rivets according to VRR-SP2201
STEP 3

Place INNO SEAL between panels when assembling
Remove excess sealant
Note that the sealant has a dry time of 2 hours
Fasten bolts with torque load M8: 18.0 Nm

No rivets here

Note placement of L-extrusion when placing top panel

Place INNO SEAL between panels when assembling

Remove excess sealant

Note that the sealant has a dry time of 2 hours

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<th>Description</th>
<th>Length</th>
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<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tr>
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<td>M8</td>
<td>2/3</td>
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<td>AISI 304</td>
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Finish: Projection

Name Date Changes Iss.

Rating: 25-05-2023 31-07-2023 08-08-2023

Dimensions in mm

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Rivets according to VRR-SP2201

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The Netherlands
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info@vrr.aero
+31 (0)10 479 8100

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Rivets according to VRR-SP2201
### Table

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### Notes

- **Tolerances (u.n.o.)**
  - Dimensions in mm (u.n.o.)
  - 400 1000 2000
  - 0.2 0.3 0.5 0.8
  - 7 30 120

- **Mass:** 380.02 kg
- **Finish:** Hull DBJ
- **Dimensions in mm:**
  - Sheet : 8 of 15
- **Drawing no.:** 2000-07-2646
- **Iss.:** A
- **Scale:** 1:12
- **Date:** 25-05-2023
- **Project:** Structural 17
  - 30/36 kW Euro
  - 30/36 kW Chino
  - +31 (0)20 484588

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- **Rivets according to VRR-SP2201**
### STEP 5

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### Tolerances (u.n.o.)

- Dimensions in mm (u.n.o.)

- Mass: 380.02 kg

- Rivets according to VRR-SP2201

---

**Mass:** 380.02 kg

**Title:** Hull DBJ

**Dimensions in mm (u.n.o.)**

**Finish:**

**Issue:** A

**Drawing no.:** 2000-07-2646

**Sheet:** 9 of 15
Kit instructions

Corner detail
rear side

Rear side

Hull DBJ

Scale: 1:8
Date: 25-05-2023
Drawing no. 2000-07-2646
Issue A

Dimensions in mm

Mass: 380.02 kg

Rivets according to VRR-SP2201
This drawing is property of VRR which reserved all rights.
Rivets according to VRR-SP2201
Kit instructions

Hoselock cover is hidden

Finish: Projection

Title: Hull DBJ

Scale: 1:8
Drawing no.: 2000-07-2646
Issue: A

Checked: PvT
Approved: HS
Mass: 380.02 kg

Dimensions in mm

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3079 DN Rotterdam
The Netherlands
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+31 (0)10 479 8100
Place INNO SEAL on (5)/(6) before placing on
Remove excess sealant
Not that the sealant has a dry time of 2 hours.

Note:
See sheet 2 for details.
Use malplates to drill missing holes in panel, see sheet 3.
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<thead>
<tr>
<th>No.</th>
<th>Item</th>
<th>Description</th>
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Outside

Inside

Use malplates 21 + 22 to drill missing holes

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Dimensions in mm (u.n.o.)

Rivets according to VRR-SP2201

- Mass: 78.85 kg
- Scale: 1:10
- Date: 25-05-2023
- Drawing no.: 2000-07-2647
- Issue: A
- Tolerances: ±0.2 ±0.3 ±0.5 ±0.8
- Finish: DBJ panel left
- Size: A2

This drawing is property of VRR which reserved all rights.
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**Tolerances:**

- Dimensions in mm (U.N.O.)
- Mass: 78.85 kg

**Drawing Information:**

- Drawing no.: 2000-07-2647
- Issue: A
- Scale: 1:7
- Date: 25-05-2023
- Prepared by: MBMH
- Checked by: PvT
- Approved by: HS
- Sheet: 4 of 4

**Dimensions in mm (U.N.O.)**

- 750 mm ≤ L ≤ 3000 mm
- 100 mm ≤ W ≤ 2200 mm
- 100 mm ≤ Diameter ≤ 2200 mm
- 20 mm ≤ Thickness ≤ 70 mm

**Mass:** 78.85 kg

**Exit:**

- Stolwijkstraat 57
- 3079 DN Rotterdam
- The Netherlands
- VRR.Aero
- info@vrr.aero
- +31 (0)10 479 8100

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Rivets according to VRR-SP2201
Typ. tolerances for insulation/sandwich panels

Dimensions in mm (u.n.o.)

Stolwijkstraat 57
3079 DN Rotterdam
The Netherlands

This drawing is property of VRR which reserved all rights.
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Typ. tolerances for insulation/sandwich panels

- Dimensions in mm (u.n.o.)
- Outside dimensions of panel:
- Thickness of panel:
- Position of cutouts / inserts:
- Dimensions of cutouts:
- Tolerance on CNC features:

No gaps in core allowed -> Fill with glue
All core parts MUST be glued together

Mass: 43.13 kg

DBJ panel left

Glue foam and inserts using Adekit A 290 / H 6290 POLYOL / H6280 ISOCYANATE
Glue face sheets to foam using SikaForce-712 L80 Part A and SikaForce-7010 Part B

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Welding according to procedure VRR-W3-090 except when indicated otherwise

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<td>Alu. 6060-T66</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>Tube 60x30x2</td>
<td>1563.7</td>
<td>60/30</td>
<td>2</td>
<td>2000-05-0294</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>1</td>
<td>Tube 60x30x2</td>
<td>615.8</td>
<td>60/30</td>
<td>2</td>
<td>2000-05-0295</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
<tr>
<td>5</td>
<td>1</td>
<td>Tube 60x30x2</td>
<td>1556.8</td>
<td>60/30</td>
<td>2</td>
<td>2000-05-0292</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
<tr>
<td>6</td>
<td>6</td>
<td>Tube 40x30x2</td>
<td>1918.5</td>
<td>40/30</td>
<td>2</td>
<td>2000-05-0296</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
<tr>
<td>7</td>
<td>1</td>
<td>Tube 40x30x2</td>
<td>1715.3</td>
<td>40/30</td>
<td>2</td>
<td>2000-05-0297</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

Finish:

Fax: +31 10 479 5478
Tel: +31 10 479 8100
info@vrr-aviation.com

The Netherlands
Stolwijkstraat 57
DN  Rotterdam
400 1000 2000
1000 2000
> 1.0
1.4
2
< 7 30 120
7 30 120 400
0.2
0.3
0.5
0.8

Mass: 21.45 kg

Internal panel frame

This drawing is property of Van Riemsdijk Rotterdam b.v., which reserved all rights.
Title: Tube 60x30x2

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Tube 60x30x2</td>
<td>1563,7</td>
<td>60/30</td>
<td>2</td>
<td>2000-05-0294</td>
<td>Alu.</td>
<td>6060-T66</td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

Raw extrusion in accordance with OEM drawing and EN755-9

Finish:

Tolerances (u.n.o.):

- 7 30 120 400 1000 2000
- ±0,02 ±0,03 ±0,05 ±0,1 ±0,14 ±0,2

Mass: 1.44 kg

Issue: Sheet: 1 of 1

Dimensions in mm (u.n.o.)

Date: 22-03-2019

Checked: HS 12-04-2019

Approved: JWR 09-05-2019

Drawn: JWR

Scale: 1:5

Drawing no.: 2000-05-0294

This drawing is property of Van Riemtsdijk Rotterdam b.v. which reserved all rights.
<table>
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<th>Item No.</th>
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<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Tube 60x30x2</td>
<td>615.8</td>
<td>60/30</td>
<td>2</td>
<td>2000-05-0295</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- 400  1000  2000
- 1.0  1.4  2
- < 7  30  120 400 1000 2000
- > 0.2 0.3 0.5 0.8

**Tolerances (u.n.o.)**

- Raw extrusion in accordance with OEM drawing and EN755-9

**Mass:** 0.55 kg

**Drawn:** JWR 22-03-2019

**Checked:** HS 12-04-2019

**Approved:** JWR 09-05-2019

**Issue:** Sheet: 1 of 1

**Dimensions in mm (u.n.o.)**

- 400  1000  2000
- 1.0  1.4  2
- < 7  30  120 400 1000 2000
- > 0.2 0.3 0.5 0.8

**Tolerances (u.n.o.)**

- Raw extrusion in accordance with OEM drawing and EN755-9

**Mass:** 0.55 kg

**2000-05-0295**

**Issue:** A

**Dimensions in mm (u.n.o.)**

- 400  1000  2000
- 1.0  1.4  2
- < 7  30  120 400 1000 2000
- > 0.2 0.3 0.5 0.8

**Tolerances (u.n.o.)**

- Raw extrusion in accordance with OEM drawing and EN755-9

**Mass:** 0.55 kg
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length/ Dia</th>
<th>Height/ Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Tube 60x30x2</td>
<td>1556.8</td>
<td>60/30</td>
<td>2</td>
<td>2000-05-0292</td>
<td>Alu. 6060-T66</td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.):
- Mass: 1.41 kg

Tolerances (u.n.o.):
- 2000-05-0292

Finish: A

Dimensions in mm (u.n.o.):
- 45° 70° 1556.8 30 60 2

Projection

Size:

Issue A

Dimensions in mm (u.n.o.):
- Raw extrusion in accordance with OEM drawing and EM755-9

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Tube 40x30x2</td>
<td>1918.5</td>
<td>40/30</td>
<td>2</td>
<td>2000-05-0296</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

**PROJECTION**

- Detail A
- Scale 1:2
- Applies on both sides

**Dimensions in mm (u.n.o.)**

- Raw extrusion in accordance with OEM drawing and EN755-9
- Tolerances (u.n.o.)
  - ± 0.2
  - ± 0.3
  - ± 0.5
  - ± 0.8

**Mass:** 1.36 kg

**Finish:**

- Dimensions in mm (u.n.o.)

**Issue Drawing no.:**

- 2000-05-0296
- Sheet: 1 of 1

**Issue:** A

**Date:**

- Drawn: JWR 22-03-2019
- Checked: HS 12-04-2019
- Approved: JWR 09-05-2019

**Dimensions:**

- 400 1000 2000
- 1000 2000 400

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
Item No. | QTY. | Description | Length | Width/Dia | Height/Thick. | Part Number | Material | Remarks
--- | --- | --- | --- | --- | --- | --- | --- | ---
1 | 1 | Tube 40x30x2 | 1715.3 | 40/30 | 2 | 2000-05-0297 | Alu. 6060-T66 | 

Finish:

Dimensions in mm (u.n.o.)

- Mass: 1.20 kg
- Tolerances (u.n.o.)
- Raw extrusion in accordance with OEM drawing and EN755-9

Title: Tube 40x30x2

Drawn: JWR | Checked: HS | Approved: JWR
22-03-2019 | 12-04-2019 | 09-05-2019

Issue Drawing no.: 2000-05-0297 Sheet: 1 of 1

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Insulation panel</td>
<td>2135.5</td>
<td>30.4</td>
<td>2017.5</td>
<td>60,4</td>
<td>2000-05-0328</td>
<td>RTM-Plus</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

1. Scale: 1:14

2. Drawing no.: 2000-05-0328

3. Issue: A

4. Sheet: 1 of 1

**Tolerances (u.n.o.)**

- ± 7 30 120 400 1000 2000
- ± 0.2 ±0.3 ±0.5 ±0.8

**Raw extrusion in accordance with OEM drawing and EN755-9**

**Mass:** 10.61 kg

**Finish:**

**Dimensions in mm (u.n.o.)**
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width Dia</th>
<th>Height</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>1</td>
<td>Outer sheet</td>
<td>2135.5</td>
<td>2117.5</td>
<td>0.8</td>
<td>PE-GEGW 0.8 NF</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Length: 2135.5
- Width: 2117.5
- Thickness: 0.8

**Tolerances (u.n.o.)**

- Mass: 5.54 kg

**Drawing Information**

- **Issue**: A
- **Drawing no.**: 2000-05-0329
- **Date**: 22-03-2019
- **Checked**: HS
- **Approved**: JWR
- **Dimensions in mm (u.n.o.)**
- **Finish:**
- **Scale:** 1:12
- **Issue Drawing no.:** A3
- **Title:** Outer sheet
- **Dimensions in mm (u.n.o.)**
- **Mass:** 5.54 kg
- **Part Number**: 2000-05-0329
- **Material:** PE-GEGW 0.8 NF

**Raw Extrusion in accordance with OEM drawing and EN755-9**

**This drawing is property of Van Riemdijk Rotterdam b.v. which reserved all rights**
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Insert</td>
<td>200</td>
<td>100</td>
<td>8</td>
<td>2000-05-1202</td>
<td>Alu. 6082-T6</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

Raw extrusion in accordance with OEM drawing and EN755-9

<table>
<thead>
<tr>
<th>Size</th>
<th>Scale: 1:1</th>
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</thead>
<tbody>
<tr>
<td>A3</td>
<td></td>
</tr>
</tbody>
</table>

**Mass:** 0.43 kg

**Finished:**

- Dimensions in mm (u.n.o.)
- Tolerances (u.n.o.):
  - + 0.2 0.3 0.5 0.8
  - -
  - 7 30 120 400 1000 2000
  - 7 30 120 400 1000 2000
  - 7 30 120 400 1000 2000

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A = 5.0
B = 9.9 - D = 0.0
B = 8.8 - D = 0.5
C = 2.1
H = 100°

(For Monobolt Ø4.8 Rivet)

13 x 127 = 1651
75 x 25.4 = 1905
Seat-T track profile RR 205

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Seat-T track profile RR 205</td>
<td>1803.5</td>
<td>50</td>
<td>15</td>
<td>2000-05-1457</td>
<td>Alu. 6061-T6</td>
<td></td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

- Mass: 2.25 kg

Tolerances (u.n.o.)

- Raw extrusion in accordance with OEM drawing and EN755-9

Additional details:

- A = 5.0
- B = 9.9 - D = 0.0
- B = 8.8 - D = 0.5
- C = 2.1
- H = 100°

Seat-T track profile RR 205

Scale: 1:5

Drawing no.: 2000-05-1457

Sheet: 1 of 1

Dimensions: 1803.5 x 19.9 ±0.12, 5 Csk., 66 x 25.4 = 1676.4, 12 x 127 = 1524.

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Tube 40x15x2</td>
<td>166</td>
<td>15/40</td>
<td>2</td>
<td>2000-07-2645</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm**

- **Length**: 166
- **Width/Dia**: 40x15
- **Height/Thick.**: 2

**Tolerances**

- **Length**: ±0.05
- **Width/Dia**: ±0.03
- **Height/Thick.**: ±0.05

**Mass**: 0.06 kg

**Issue**: 2000-07-2645

**Drawn**: MBMH 25-05-2023

**Checked**: PvP 31-07-2023

**Approved**: HS 08-08-2023

**Finish**: A

**Remarks**: Raw extrusion in accordance with OEM drawing and EN755-9
<table>
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<th>Item No.</th>
<th>QTY</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Door post</td>
<td>2033.8</td>
<td>119.5</td>
<td>48.2 11.2</td>
<td>2000-05-0492</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Scale:** 1:6
**Date:** 25-03-2019
**Drawing no.:** 2000-05-0492
**Sheet:** 1 of 1
**Mass:** 3.77 kg

**Issue:** A
**Tolerances (u.n.o.):**
- ±0.2
- ±0.3
- ±0.5
- ±0.8

**Raw extrusion in accordance with OEM drawing and EN755-9**

---

**Dimensions in mm:**
- 2033.8
- 119.5
- 48.2
- 11.2

**Title:** Door post

---

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Tel: +31 10 479 8100
Stolwijkstraat 57
3079 DN Rotterdam
The Netherlands
info@vrr-aviation.com

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
<td></td>
<td>1</td>
<td>Internal frame sheet</td>
<td>1553</td>
<td>116.2</td>
<td>2</td>
<td>2000-05-0373</td>
<td>Alu. 5754-H22</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

Scale: 1:5  
Issue: 2000-05-0373  
Sheet: 1 of 1  
Dimensions in mm (u.n.o.)

Mass: 0.92 kg  
Finish: 

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Title: Internal frame sheet

Item No. | QTY. | Description | Length | Width/Dia | Height/Thickn. | Part Number | Material | Remarks
--- | --- | --- | --- | --- | --- | --- | --- | ---
1 | 1 | Internal frame sheet | 610.3 | 116.2 | | 2000-05-0369 | Alu. 5754-H22 | Bend with V16

Scale: 1:3

Issue Drawing no.: 2000-05-0369

Drawing no.: Sheet : 1 of 1

Dimensions in mm (u.n.o.)

Mass: 0.36 kg

Finish: A

Tolerances (u.n.o.)

Raw extrusion in accordance with OEM drawing and EN755-9

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Internal frame sheet</td>
<td>1495.3</td>
<td>116.2</td>
<td>2</td>
<td>2000-05-0368</td>
<td>Alu. 5754-H22</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**
- Width 7, 30, 120, 400
- Height 1000, 2000
- Thickness 0.2, 0.3, 0.5, 0.8

**Tolerances (u.n.o.)**
- Width ±0.3
- Height ±0.5
- Thickness ±0.1

**Mass:** 0.93 kg

**Issue:** 2000-05-0368

**Projection:**
- Scale: 1:5
- Date: 25-03-2019
- Drawing no.: 2000-05-0368
- Sheet: 1 of 1

**Finish:**
- Bend with V16

**Dimensions in mm (u.n.o.)**
- Width <7, 30, 120, 400
- Height >1000, 2000
- Thickness ±0.2

**Raw extrusion in accordance with OEM drawing and EN755-9**
**Left slanted corner gusset**

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Left slanted corner gusset</td>
<td>294.3</td>
<td>267.3</td>
<td>58</td>
<td>2000-05-0508</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- < 7, 30, 120, 400, 1000, 2000
- 7, 10, 15, 18, 21, 24
- Raw extrusion in accordance with OEM drawing and EN755-9

**Tolerances (u.n.o.)**

- 0.2, 0.3, 0.5, 0.8

**Mass:** 0.34 kg

**Issue:** 2000-05-0508

**Finish:** Sheet: 1 of 1

**Dimensions in mm (u.n.o.)**
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/ Dia</th>
<th>Height/ Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Left inner corner gusset</td>
<td>266.9</td>
<td>248.6</td>
<td>3</td>
<td>2000-05-1459</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Width: 266.9
- Length: 248.6
- Height: 3
- Thickness: 15
- Diameter: 6.8

**Tolerances (u.n.o.)**

- Width: ±0.2
- Length: ±0.3
- Height: ±0.5
- Thickness: ±0.8

**Mass:** 0.27 kg

**Drawing Details:**

- Scale: 1:3
- Date: 09-05-2019
- Drawing no.: 2000-05-1459
- Issue: A
- Sheet: 1 of 1

**Issue History:**

- Drawn: JWR 25-03-2019
- Checked: HS 12-04-2019
- Approved: JWR 09-05-2019

**Dimensions in mm (u.n.o.)**

- 400
- 1000
- 2000
- 7
- 30
- 120
- 400
- 1000
- 2000
- 0.2
- 0.3
- 0.5
- 0.8

**Raw Extrusion in accordance with OEM drawing and EN755-9**

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A = 5.0
B = 9.9 - D = 0.0
B = 8.8 - D = 0.5
C = 2.1
H = 100°

(For Monobolt Ø4.8 Rivet)
**Thread block doors**

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Thread block doors</td>
<td>1710</td>
<td>48</td>
<td>8</td>
<td>2000-05-1627</td>
<td>Alu, 6082-T6</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Mass: 1.76 kg
- Drawn: JWR 25-03-2019
- Checked: HS 12-04-2019
- Approved: JWR 09-05-2019
- Issue: 2000-05-1627 A

Projection

Size A3

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Tel: +31 10 479 8100
3079 DN Rotterdam
The Netherlands
Fax:+31 10 479 5478

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Malplate DBJ side panel LEFT inside</td>
<td>1712.8</td>
<td>148.5</td>
<td>6.8</td>
<td>100</td>
<td>21</td>
<td>121.4</td>
</tr>
</tbody>
</table>

Finish: 

Issue: A

Drawing no.: 2000-05-4188

Sheet: 1 of 1

Dimensions in mm (u.n.o.)

Mass: 2.01 kg

Title: Malplate DBJ side panel LEFT inside

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+31 (0)10 479 8100
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Malplate side panel outside</td>
<td>1756.6</td>
<td>229.6</td>
<td>209.5</td>
<td>2000-05-4178</td>
<td>Alu. 5754-H22</td>
<td>One per order</td>
</tr>
</tbody>
</table>

**Finish:**

**Issue:**

**Tolerances (u.n.o.):**

- < 7 30 120 400 1000 2000
- > 7 30 120 400 1000 2000

**Dimensions in mm (u.n.o.):**

- Thickness: 30
- Diameter: 120
- Length: 400

**Mass:** 2.91 kg

**Drawing no.:** 2000-05-4178

**Issue:** A

**Sheet:** 1 of 1

**Drawn:** JWR 07-10-2019

**Checked:** HS 07-10-2019

**Approved:** JWR 08-10-2019

**Title:** Malplate side panel outside

**Dimensions in mm:**

- Engraving: 3
- Thickness: 100.9
- Diameter: 1756.6
- Width: 26.5
- Height: 229.6
- Length: 5.2
- Width: 6.8
- Thickness: 80

This drawing is property of VRR which reserved all rights.
Place INNO SEAL on 5 / 6 before placing on. Not that the sealant has a dry time of 2 hours.

Remove excess sealant.

Use Malplates to drill missing holes in panel, see sheet 3.

Note: See sheet 2 for details.
Instal these parts first

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
<td>22</td>
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<td>Malplate DBJ side panel Right inside</td>
<td>Alu. 5754-H22</td>
<td>One per order</td>
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<tr>
<td>21</td>
<td>1</td>
<td>Malplate side panel outside</td>
<td>Alu. 5754-H22</td>
<td>One per order</td>
</tr>
<tr>
<td>20</td>
<td>18</td>
<td>TVD Rivet 2,0-4,5 ø4,8 12,3</td>
<td>BK-TVD603GT AISI 304</td>
<td></td>
</tr>
<tr>
<td>19</td>
<td>22</td>
<td>Bk.Rivet Klamp-Tite 4,8 4,8-9,5 Ø4,8</td>
<td>BK-BAPKTR-06W-06 Alu. w. Rub. washer</td>
<td></td>
</tr>
<tr>
<td>18</td>
<td>252</td>
<td>Csk.St. Monobolt 4,8 3,2-12,2 Ø4,8</td>
<td>BK-02761-00619 Steel (MGL100-R6-9)</td>
<td></td>
</tr>
<tr>
<td>17</td>
<td>92</td>
<td>Bk.St. Monobolt 6,4 2,0-15,9 Ø6,4</td>
<td>BK-02771-00824 Steel (MGLP-R8-10)</td>
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<td>16</td>
<td>1</td>
<td>Door rubber Extrusion</td>
<td>Rubber Almet (AN625)</td>
<td></td>
</tr>
<tr>
<td>15</td>
<td>1</td>
<td>Thread block doors</td>
<td>Alu. 6060-T6</td>
<td></td>
</tr>
<tr>
<td>14</td>
<td>1</td>
<td>Thread block Tie-down points</td>
<td>Alu. 6060-T6</td>
<td></td>
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<tr>
<td>13</td>
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<td>Fill plate base gusset</td>
<td>Alu. 5754-H22</td>
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<tr>
<td>12</td>
<td>1</td>
<td>Right inner corner gusset 2077 57 3</td>
<td>Alu. 5754-H22</td>
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<tr>
<td>11</td>
<td>1</td>
<td>Right Slanted corner gusset 294,3 267,3 3</td>
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<tr>
<td>10</td>
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<td>Right Slanted corner gusset 289,7 276,2 3</td>
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<td>9</td>
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<td>Internal Frame Sheet 1494,6 116,2 2</td>
<td>Alu. 5754-H22 Bend with V16</td>
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<tr>
<td>8</td>
<td>1</td>
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<td>Alu. 5754-H22 Bend with V16</td>
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<tr>
<td>7</td>
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<td>Internal Frame Sheet</td>
<td>Alu. 5754-H22 Bend with V16</td>
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<tr>
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<td>1</td>
<td>DBJ corner sheets</td>
<td>Alu. 5754-H22 Bend with V16</td>
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<tr>
<td>5</td>
<td>1</td>
<td>Door post 2033,8 119,5 2</td>
<td>AISI 304 Bend with V16</td>
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<tr>
<td>4</td>
<td>3</td>
<td>Tube 40x15x2</td>
<td>Alu. 6060-T6</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>Seat-T track profile RR 205 1811,2 50 15</td>
<td>Alu. 6061-T6</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>6</td>
<td>Seat-T track profile RR 205 1989 50 15</td>
<td>Alu. 6061-T6</td>
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</tr>
<tr>
<td>1</td>
<td>1</td>
<td>DBJ panel right</td>
<td>Assembly</td>
<td></td>
</tr>
</tbody>
</table>

The drawing is property of VRR which reserved all rights.
Use Malplates 21 and 22 to drill missing holes.
Inside

Outside

SECTION B-B SCALE 1:2

DETAIL A SCALE 1:2

<table>
<thead>
<tr>
<th>Item</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Remarks</th>
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<tbody>
<tr>
<td>5</td>
<td>1</td>
<td>Insert</td>
<td>200</td>
<td>100</td>
<td>8</td>
<td>2000-05-1202</td>
<td>Alu. 6062-T6</td>
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<tr>
<td>4</td>
<td>1</td>
<td>Outer sheet</td>
<td>2135.5</td>
<td>2117.5</td>
<td>0.8</td>
<td>2000-05-0295</td>
<td>PE-GEGW</td>
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<tr>
<td>3</td>
<td>1</td>
<td>Insulated panel</td>
<td>2135.5</td>
<td>2117.5</td>
<td>0.8</td>
<td>2000-05-0295</td>
<td>PE-GEGW</td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>Inner sheet</td>
<td>2077.5</td>
<td>2059.5</td>
<td>0.8</td>
<td>2000-07-2974</td>
<td>PE-GEGW</td>
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<tr>
<td>1</td>
<td>1</td>
<td>Internal panel frame</td>
<td></td>
<td></td>
<td></td>
<td>2000-05-1865</td>
<td>Assembly</td>
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</table>

Dimensions in mm (u.n.o.)

Tolerance (u.n.o.)

Typ. tolerances for insulation/sandwich panels

- 0/-1
- 0.5

Mass: 43.13 kg

DBJ panel right

Outside dimensions of panel:

Thickness of panel:

Position of cutouts / inserts:

Dimensions of cutouts:

Tolerance on CNC features:

No gaps in core allowed -> Fill with glue

All core parts MUST be glued together

Glue foam and inserts using Adekit A 290 / H 6290 POLYOL / H6280 ISOCYANATE

Glue face sheets to foam using SikaForce-712 L80 Part A and SikaForce-7010 Part B

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length 1</th>
<th>Width/ Dia 2</th>
<th>Height/ Thickn. 3</th>
<th>Part Number 4</th>
<th>Material</th>
<th>Remarks</th>
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<td>Insert</td>
<td>205</td>
<td>100</td>
<td>8</td>
<td>2000-05-1202</td>
<td>Alu. 6082-T6</td>
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<tr>
<td>4</td>
<td>1</td>
<td>Outer sheet</td>
<td>218,5</td>
<td>217,5</td>
<td>0,8</td>
<td>2000-06-0298</td>
<td>PE-GEGW 0,8 NF</td>
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<tr>
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<td>1</td>
<td>Insulation panel</td>
<td>218,5</td>
<td>2017,5</td>
<td>60,4</td>
<td>2000-05-0299</td>
<td>RTM-Plus</td>
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<tr>
<td>2</td>
<td>1</td>
<td>Inner sheet</td>
<td>2077,5</td>
<td>2059,5</td>
<td>0,8</td>
<td>2000-07-2974</td>
<td>PE-GEGW 0,8 NF</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>Internal panel frame</td>
<td></td>
<td></td>
<td></td>
<td>2000-06-1866</td>
<td>Assembly</td>
<td></td>
</tr>
</tbody>
</table>

**Typ. tolerances for insulation/sandwich panels**

- Dimensions in mm (u.n.o.)
- Drawn: MBMH
- Checked: PvT
- Approved: HS
- Date: 31-07-2023
- Scale: 1:10

**Outside dimensions of panel:**
- Thickness of panel:
- Position of cutouts / inserts:
- Dimensions of cutouts:
- Tolerance on CNC features:
Welding according to procedure VRR-W3-090 except when indicated otherwise

<table>
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<tr>
<th>No.</th>
<th>QTY.</th>
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<th>Length</th>
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<th>Height/ Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
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<td>1</td>
<td>Tube 40x30x2</td>
<td>1715,3</td>
<td>40/30</td>
<td>2</td>
<td>2000-05-0297</td>
<td>Alu. 6060-T66</td>
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<td>6</td>
<td>Tube 40x30x2</td>
<td>1918,5</td>
<td>40/30</td>
<td>2</td>
<td>2000-05-0296</td>
<td>Alu. 6060-T66</td>
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<td>5</td>
<td>1</td>
<td>Tube 60x30x2</td>
<td>1959,5</td>
<td>60/30</td>
<td>2</td>
<td>2000-05-0293</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>1</td>
<td>Tube 60x30x2</td>
<td>1556,8</td>
<td>60/30</td>
<td>2</td>
<td>2000-05-0292</td>
<td>Alu. 6060-T66</td>
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<td>1</td>
<td>Tube 60x30x2</td>
<td>615,8</td>
<td>60/30</td>
<td>2</td>
<td>2000-05-0295</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>Tube 60x30x2</td>
<td>1563,7</td>
<td>60/30</td>
<td>2</td>
<td>2000-05-0294</td>
<td>Alu. 6060-T66</td>
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<td>1</td>
<td>1</td>
<td>Tube 100x60x4</td>
<td>2135,5</td>
<td>100/60</td>
<td>4</td>
<td>2000-05-0311</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

Mass: 19.80 kg

Projection
Fax:+31 10 479 5478
Tel: +31 10 479 81003079 DN Rotterdam The Netherlands
info@vrr-aviation.com

 SECTION A-A
 SCALE 1:3

Weld detail

Internal panel frame

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**SCALE 1:10**

---

**Title:** Tube 100x60x4

**Dimensions in mm (u.n.o.)**

- Raw extrusion in accordance with OEM drawing and EN755-9

**Tolerances (u.n.o.)**

- ±0.2 mm
- ±0.3 mm
- ±0.5 mm
- ±0.8 mm

---

**Item No.** | **QTY.** | **Description** | **Length** | **Width/Dia** | **Height/Thick.** | **Part Number** | **Material** | **Remarks**
--- | --- | --- | --- | --- | --- | --- | --- | ---
1 | 1 | Tube 100x60x4 | 2135.5 | 100x60 | 4 | 2000-05-0311 | Alu. 6060-T66 | 

**Issue**

- B

**Sheet:** 1 of 1

**Dimensions in mm (u.n.o.)**

- ±0.2 mm
- ±0.3 mm
- ±0.5 mm
- ±0.8 mm

---

**Drawing Details**

- Scale: 1:7
- Date: 25-03-2019
- Drawing no.: 2000-05-0311
- Sheet: 1 of 1

**Finish:**

- B

---

**Technical Information**

- Mass: 6.77 kg
- Dimensions: 100x60x4

---

**Contact Information**

- Stolwijkstraat 57
  - 3079 DN Rotterdam
  - The Netherlands

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---

**Notes:**

- This drawing is property of VRR which reserved all rights
Visible side (smooth side)

Dimensions in mm (u.n.o.)

Tolerances (u.n.o.)

Outside dimensions of panel:

±1

Thickness of panel:

±1

Position of outside / inserts:

±1

Dimensions of cutouts:

±0.5

Tolerance on CNC features:

No gaps in core allowed -> Fill with glue

All core parts MUST be glued together

Item No. QTY. Description Length Width/Thickn. Part Number Material Remarks

1 1 Inner sheet 2077.5 2059.5 0.8 2000-07-2974 PE-GEGW 0.8 NF

Typ. tolerances for insulation/sandwich panels

Dimensions in mm (u.n.o.)

Mass: 5.23 kg

2000-07-2974 Sheet : 1 of 2

Drawing no.: 2000-07-2974

Issue A

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2059,5
2077,5
5
127
40°
10
R10
5
1663,7
0
288,2
310,8
542,2
564,8
796,2
818,8
1050,2
1072,8
1304,2
1326,8
1558,2
1580,8
1812,2
1834,8

969
1169
0
2007,9
1987,9
0,8

Visible side
(smooth side)

Ø5 holes

See also sheet 2
**Item No.** | **QTY.** | **Description** | **Length** | **Width/Dia.** | **Height/Thickn.** | **Part Number** | **Material** | **Remarks**
--- | --- | --- | --- | --- | --- | --- | --- | ---
1 | 1 | Inner sheet | 2077.5 | 2059.5 | 0.8 | 2000-07-29 | PE-GE0W U.3 | NF |

**Dimensions in mm (u.n.o.)**

- **Outside dimensions of panel:**
- **Thickness of panel:**
- **Position of cutouts / inserts:**
- **Dimensions of cutouts:**
- **Tolerance on CNC features:**
- **No gaps in core allowed -> Fill with glue**
- **All core parts MUST be glued together**

**Typ. tolerances for insulation/sandwich panels**

**Scale:** 1:12

**Drawing no.:** 2000-07-2974

**Issue:** A

**Drawn:** MBMH 19-06-2023

**Checked:** PvT 31-07-2023

**Approved:** HS 08-08-2023

**Mass:** 5.23 kg

**Dimensions in mm (u.n.o.)**

- **Vis. side (smooth side):**
- **Ø6.8 holes:**

---

**Inner sheet**

---

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width</th>
<th>Height</th>
<th>Thicken.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tr>
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<td>Outer sheet</td>
<td>2135.5</td>
<td>2117.5</td>
<td>0.8</td>
<td>2000-05-0298</td>
<td>PE-GEWG 0.8 NF</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Date: 26-03-2019  
Checked: HS  
Approved: JWR  
Mass: 5.54 kg

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A = 5.0
B = 9.9 - D = 0.0
B = 8.8 - D = 0.5
C = 2.1
H = 100°

(For Monobolt Ø4.8 Rivet)

12 × 127 = 1524
67 × 25.4 = 1701.8

1 Item
QTY. Description
1 Seat-T track profile RR 205 1811.2
50
15 2000-04-8265 Alu. 6061-T6

Mass: 2.25 kg

Dimensions in mm (u.n.o.)
Raw extrusion in accordance with OEM drawing and EN755-9

Tolerances (u.n.o.)

Issue
2000-04-8265 A

Sheet: 1 of 1

Drawn: JWR 26-03-2019
Checked: HS 12-04-2019
Approved: JWR 09-05-2019

Revision C

Title: Seat-T track profile RR 205

Projection
Size 
A3

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Scale: 1:5

Dimensions in mm (u.n.o.)

< 7 30 120 400 1000 2000
7 30 120 400 1000 2000

< 0.2 0.3 0.5 0.8

Mass: 2.25 kg

Finish:
### DBJ corner sheets

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
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<td>1</td>
<td>DBJ corner sheets</td>
<td>2120.8</td>
<td>201.5</td>
<td>6.8</td>
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<td>AISI 304</td>
<td>Bend with V16</td>
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</table>

#### Dimensions in mm (u.n.o.)

- 400: 400 1000 2000
- 1000: 7 30 120 400 1000 2000
- 1000: ø0.2 ø0.5 ø0.8 ø1.0 ø1.4 ø2

#### Tolerances (u.n.o.)

- Raw extrusion in accordance with OEM drawing and EN755-9

#### Mass

6.56 kg

---

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tr>
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<td>1</td>
<td>Internal frame sheet</td>
<td>1553</td>
<td>116.2</td>
<td>2</td>
<td>2000-05-0381</td>
<td>Alu. 5754-H22</td>
<td>Bend with V1/6</td>
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</table>

Dimensions in mm (u.n.o.)

Tolerances (u.n.o.)

Mass: 0.92 kg

2000-05-0381 Sheet: 1 of 1

Dimensions in mm (u.n.o.)

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Tel: +31 10 479 8100

The Netherlands

info@vrr-aviation.com
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/ Dia</th>
<th>Height/ Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
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<td>1</td>
<td>Internal Frame Sheet</td>
<td>610.3</td>
<td>116.2</td>
<td>58.1</td>
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<td>Bend with V16</td>
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**Scale:** 1:5  
**Issue:** 2000-05-0380  
**Dimensions in mm (u.n.o.)**  
- Raw extrusion in accordance with OEM drawing and EN755-9  

**Tolerances (u.n.o.)**  
- ± 7 30 120 400 1000 2000  
- ± 0.1 0.15 0.18 0.2 0.24 0.3 0.5 0.8

**Mass:** 0.36 kg  
**Finish:**  
**Dimensions in mm (u.n.o.)**  

**Title:** Internal Frame Sheet
**Internal Frame Sheet**

**Item No.** | **QTY.** | **Description** | **Length** | **Width/Dia** | **Height/Thickn.** | **Part Number** | **Material** | **Remarks**  
--- | --- | --- | --- | --- | --- | --- | --- | ---  
1 | 1 | Internal Frame Sheet | 1494.6 | 116.2 | 2 | 2000-05-0374 | Alu. 5754-H22 | Bend with V16  

**Dimensions in mm (u.n.o.)**

- Width: 100
- Thickness: 58.1
- Height: 8.5
- Length: 1494.6

**Tolerances (u.n.o.)**

- Width: ±0.2
- Thickness: ±0.3
- Height: ±0.5
- Length: ±0.8

**Mass:** 0.93 kg

**Issue**: 2000-05-0374

**Drawn**: JWR 26-03-2019

**Checked**: HS 12-04-2019

**Approved**: JWR 09-05-2019

**Sheet**: 1 of 1

**Drawing no.**: A

**Dimensions in mm (u.n.o.)**

- Width: 100
- Thickness: 58.1
- Height: 8.5
- Length: 1494.6

**Tolerances (u.n.o.)**

- Width: ±0.2
- Thickness: ±0.3
- Height: ±0.5
- Length: ±0.8

**Mass:** 0.93 kg

**Issue**: 2000-05-0374

**Drawn**: JWR 26-03-2019

**Checked**: HS 12-04-2019

**Approved**: JWR 09-05-2019

**Sheet**: 1 of 1

**Drawing no.**: A

**Dimensions in mm (u.n.o.)**

- Width: 100
- Thickness: 58.1
- Height: 8.5
- Length: 1494.6

**Tolerances (u.n.o.)**

- Width: ±0.2
- Thickness: ±0.3
- Height: ±0.5
- Length: ±0.8

**Mass:** 0.93 kg

**Issue**: 2000-05-0374

**Drawn**: JWR 26-03-2019

**Checked**: HS 12-04-2019

**Approved**: JWR 09-05-2019

**Sheet**: 1 of 1

**Drawing no.**: A

**Dimensions in mm (u.n.o.)**

- Width: 100
- Thickness: 58.1
- Height: 8.5
- Length: 1494.6

**Tolerances (u.n.o.)**

- Width: ±0.2
- Thickness: ±0.3
- Height: ±0.5
- Length: ±0.8

**Mass:** 0.93 kg

**Issue**: 2000-05-0374

**Drawn**: JWR 26-03-2019

**Checked**: HS 12-04-2019

**Approved**: JWR 09-05-2019

**Sheet**: 1 of 1

**Drawing no.**: A

**Dimensions in mm (u.n.o.)**

- Width: 100
- Thickness: 58.1
- Height: 8.5
- Length: 1494.6

**Tolerances (u.n.o.)**

- Width: ±0.2
- Thickness: ±0.3
- Height: ±0.5
- Length: ±0.8

**Mass:** 0.93 kg

**Issue**: 2000-05-0374

**Drawn**: JWR 26-03-2019

**Checked**: HS 12-04-2019

**Approved**: JWR 09-05-2019

**Sheet**: 1 of 1

**Drawing no.**: A

**Dimensions in mm (u.n.o.)**

- Width: 100
- Thickness: 58.1
- Height: 8.5
- Length: 1494.6

**Tolerances (u.n.o.)**

- Width: ±0.2
- Thickness: ±0.3
- Height: ±0.5
- Length: ±0.8

**Mass:** 0.93 kg

**Issue**: 2000-05-0374

**Drawn**: JWR 26-03-2019

**Checked**: HS 12-04-2019

**Approved**: JWR 09-05-2019

**Sheet**: 1 of 1

**Drawing no.**: A

**Specifications**: 

- Material: Alu. 5754-H22
- Bend with V16

**Dimensions**: 

- Width: 100
- Thickness: 58.1
- Height: 8.5
- Length: 1494.6

**Tolerances**: 

- Width: ±0.2
- Thickness: ±0.3
- Height: ±0.5
- Length: ±0.8

**Mass**: 0.93 kg

**Issue Details**: 

- Issue: 2000-05-0374
- Sheet: 1 of 1

**Contact Information**: 

- Fax: +31 10 479 5478
- Tel: +31 10 479 8100
- 3079 DN Rotterdam
- The Netherlands
- info@vrr-aviation.com

**Drawing Scale**: 1:5

**Drawn by**: JWR

**Checked by**: HS

**Approved by**: JWR

**Date**: 09-05-2019

**Finish**: Dimensions in mm (u.n.o.)

**Remarks**: Raw extrusion in accordance with OEM drawing and EN755-9

**This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights**
Title: Right Slanted corner gusset

<table>
<thead>
<tr>
<th>Item No.</th>
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<th>Height/ Thickn.</th>
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<th>Material</th>
<th>Remarks</th>
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<td>Right Slanted corner gusset</td>
<td>289.7</td>
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Scale: 1:3

Drawing no.: 2000-05-1254

Issue: A

Finish: Mass: 0.33 kg

Dimensions in mm (u.n.o.)

Tolerances (u.n.o.)

- < 7 30 120 400 1000 2000
- ≥ 7 30 120 400 1000 2000

Raw extrusion in accordance with OEM drawing and EN755-9

Title: Right Slanted corner gusset

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
Title: Right Slanted corner gusset

<table>
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<th>Item No.</th>
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<td>Right Slanted corner gusset</td>
<td>294.3</td>
<td>267.3</td>
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<td>Bend with V30</td>
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Dimensions in mm (u.n.o.): 1.0 1.4 2 < 7 30 120 400 1000 2000 7 30 120 400 1000 2000 7 30 120 400 1000 2000 

Tolerances (u.n.o.): ±0.2 ±0.3 ±0.5 ±0.8

Mass: 0.35 kg

Finish: 2000-05-1255

Sheets: 1 of 1

Issue Drawing no.: 2000-05-1255

Sheet : 1 of 1

26-03-2019

2000-05-1255

Drawn: JWR

Checked: HS

Approved: JWR

Dimensions in mm (u.n.o.): 7 30 120 400 1000 2000 ±0.2 ±0.3 ±0.5 ±0.8

Raw extrusion in accordance with OEM drawing and EN755-9

This drawing is property of Van Riemsljijk Rotterdam b.v. which reserved all rights
<table>
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<td>1</td>
<td>Fill plate base gusset</td>
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<td>57</td>
<td>3</td>
<td>2000-05-1282</td>
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<td></td>
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**Scale:** 1:6

**Date:**
- Drawn: 26-03-2019
- Checked: 12-04-2019
- Approved: 09-05-2019

**Drawing no.:** 2000-05-1282

**Issue:** A

**Sheet:** 1 of 1

**Finish:**

**Dimensions in mm (u.n.o.)**

- Mass: 0.94 kg

**Tolerances (u.n.o.)**

- + 7 10 12 400 1000 2000 4000 10000 20000
- ± 0.3 0.5 0.8

Raw extrusion in accordance with OEM drawing and EN755-9
## Item Details

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<td>Malplate DBJ side panel</td>
<td>1712.8</td>
<td>148.5</td>
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<td>2000-05-4182</td>
<td>Alu. 5754-H22</td>
<td>One per order</td>
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### Technical Specifications

- **Dimensions in mm (u.n.o.):**
  - Width: 1712.8
  - Height: 148.5
  - Diameter: 21
  - Thickness: 6.8
  - Engraving: 162.3
  - Projection: 3

- **Finish:**
  - Type: A

- **Issue:**
  - Drawing no.: 2000-05-4182
  - Sheet: 1 of 1

- **Dimensions:**
  - Mass: 2.01 kg

- **Tolerances (u.n.o.):**
  - Width: ±0.2 to ±1.0
  - Height: ±0.3 to ±1.4

- **Scale:** 1:5

- **Date:**
  - Drawn: 07-10-2019
  - Checked: 07-10-2019
  - Approved: 08-10-2019

- **Stolwijkstraat 57**
  - 3079 DN Rotterdam
  - The Netherlands
  - vrr.aero
  - info@vrr.aero
  - +31 (0)10 479 8100

This drawing is property of VRR which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
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<td>Nord-Lock Large Washer M5 ø10.8 M5</td>
<td>BO-NORDLCK-05SP-SMO</td>
<td>SMO SMO</td>
<td>BO-NORDLCK-05SP-SMO</td>
<td>BK-BAPKTR-06W-04</td>
<td>SMO SMO</td>
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<td>17</td>
<td>16</td>
<td>Nord-Lock Large Washer M10 ø21.0 M10</td>
<td>BO-NORDLCK-10SP-SMO</td>
<td>SMO SMO</td>
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<td>16</td>
<td>66</td>
<td>Bk.Rivet Klamp-Tite 4,8 1,3-6,3 Ø4,8</td>
<td>BK-BAPKTR-06W-04</td>
<td>Alum. w. Rub. washer</td>
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<td>Steel (MGLP-R6-7)</td>
<td>BK-02771-00617</td>
<td>Steel (MGLP-R6-7)</td>
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<tr>
<td>14</td>
<td>252</td>
<td>Csk.St. Monobolt 4,8 3,2-12,2 Ø4,8</td>
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<td>Mennekes</td>
<td>WO-821</td>
<td>Mennekes</td>
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**Drawings:**

- **Finish:** Projection
- **Issue:** A
- **Drawing no.:** 2000-07-2685
- **Title:** DBJ panel rear
- **Dimensions in mm (u.n.o.):**
  - **Tolerances:** (u.n.o.)
  - **Scale:** 1:6
  - **Dimensions in mm:**
    - **Size:** (u.n.o.)
  - **Drawn:** MBMH
  - **Checked:** PvT
  - **Approved:** HS
  - **Date:** 08-08-2023
  - **Issue:** 05-07-2023
  - **Changes:** 03-07-2023
  - **Date Name:**
  - **Mass:** 78.33 kg

**Notes:**

- **Raw extrusion in accordance with OEM drawing and EN755-9**
- **Projection:**
  - **Name:** Stolwijkstraat 57
  - **Date:** 06-06-2023
  - **Check:** PvT
  - **Date:** 31-07-2023
  - **Approved:** HS
  - **Date:** 08-08-2023

**Contact:**

- **VRR**
  - **Address:** Stolwijkstraat 57
  - **City:** 3079 DN Rotterdam
  - **Country:** The Netherlands
  - **Email:** info@vrr.aero
  - **Phone:** +31 (0)10 479 8100

**Disclaimer:**

This drawing is property of VRR which reserved all rights.
**Torque load: 26 Nm**

Place INNO SEAL on 3/4/9 before placing on

Remove excess sealant

Not that the sealant has a dry time of 2 hours.

---

### Item Details

<table>
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<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
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<td>9</td>
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<td></td>
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<td>2000-05-0354 Alu. 6061-T6</td>
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<td>2000-05-0355 Assembly</td>
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**Dimensions in mm (u.n.o.)**

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<th>Description</th>
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**DBJ panel rear**
3,0 Steps
1 - 3 Steps
Acceptable finish of slanted sides insulation panels
Slanted side milled
Slanted side sawn

Keep steps within contour

Inside

Outside

SECTION B-B
SCALE 1 : 2

Details of insulation/sandwich panels:

- Projection
- Name
- Date
- Changes
- Iss.

Dimensions in mm (u.n.o.)

Mass: 40.21 kg

Typ. tolerances for insulation/sandwich panels:

- Tolerance on CNC features:
- No gaps in core allowed -> Fill with glue
- All core parts MUST be glued together

Glue foam and inserts using Adekit A 290 / H 6290 POLYOOL / H6280 ISOCYANATE
Glue face sheets to foam using SikaForce-712 L80 Part A and SikaForce-7010 Part B

DBJ panel rear
Welding according to procedure VRR-W3-090 except when indicated otherwise

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<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<td>1546</td>
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<td>2000-05-0350</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

Finish:

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Tel: +31 10 479 8100
3079 DN Rotterdam
The Netherlands
info@vrr-aviation.com

Projection

Size

A2

Sheet : 1 of 1

Dimensions in mm (u.n.o.)

Weld detail

Mass: 16.47 kg

Internal panel frame rear

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<table>
<thead>
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<th>Item No.</th>
<th>QTY.</th>
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<th>Part Number</th>
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<td>2</td>
<td>2000-05-0349</td>
<td>Alu. 6060-T66</td>
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</table>

**Dimensions in mm (u.n.o.)**

- Mass: 2.27 kg
- Raw extrusion in accordance with OEM drawing and EN755-9

**Tolerances (u.n.o.)**

- ±0.2
- ±0.3
- ±0.5
- ±0.8

**Issue**

- 2000-05-0349

**Sheet**: 1 of 1

**Dimensions in mm (u.n.o.)**

- ±0.2
- ±0.3
- ±0.5
- ±0.8

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
**Title:** Tube 40x30x2

<table>
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<tr>
<th>Item No.</th>
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<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
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**Dimensions in mm (u.n.o.):**

<table>
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**Tolerances (u.n.o.):**

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<th>1000</th>
<th>2000</th>
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<th>2000</th>
<th>7</th>
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<td></td>
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<td>0.3</td>
<td>0.5</td>
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**Issue:**

<table>
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<th>Sheet : 1 of 1</th>
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<tbody>
<tr>
<td>2000-05-0350</td>
<td>A</td>
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</tbody>
</table>

**Dimensions:**

- 1436 mm
- 40 mm
- 30 mm
- 2 mm

**Remarks:**

- DÉTAIL A
- SCALE 1 : 1
- applies on both sides

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<table>
<thead>
<tr>
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<th>Length</th>
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<th>Height/Thickn.</th>
<th>Part Number</th>
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<td></td>
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<td>1546</td>
<td>Alu. 6060-T66</td>
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Dimensions in mm (u.n.o.)

- Width: 30
- Height: 60
- Thickness: 2

Mass: 1.38 kg

Finish: 2000-05-0348

Sheet: 1 of 1
### Item No. | QTY. | Description | Length | Width Dia | Height/Thickn. | Part Number | Material | Remarks
--- | --- | --- | --- | --- | --- | --- | --- | ---
1 | 1 | Inner sheet | 2566 | 1605.5 | 0.8 | 2000-07-2715 | PE-GEGW 0.8 NF | |

**Dimensions in mm (u.n.o.)**

- Mass: 5.06 kg

**Typ. tolerances for insulation/sandwich panels**

- Dimensions of cutouts:
- Tolerance on CNC features:
- No gaps in core allowed -> Fill with glue
- All core parts MUST be glued together

**Visible side (smooth side)**

**Scale:** 1:10

**Drawing no.:** 2000-07-2715

**Issue:** A

**Drawn:** MBMH 06-06-2023
**Checked:** PV T 31-07-2023
**Approved:** HS 08-08-2023

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**+31 (0)10 479 8100**

---

**No gaps in core allowed -> Fill with glue**

**All core parts MUST be glued together**
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
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<th>Width Dia</th>
<th>Height Thk/n.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<td>0.8</td>
<td>2000-07-2715</td>
<td>PE-GEDW 0.3</td>
<td>NF</td>
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</tbody>
</table>

**Holes Ø6.8 mm**

Visible side (smooth side)

**Typ. tolerances for insulation/sandwich panels**

- Outside dimensions of panel: ±1
- Thickness of panel: ±0.5
- Position of cutsouts / inserts: ±1
- Dimensions of cutouts: ±0.5
- Tolerance on CNC features: ±0.5
- No gaps in core allowed -> Fill with glue
- All core parts MUST be glued together

**Dimensions in mm (u.n.o.)**

**Mass:** 5.06 kg

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3 Steps
1 - 3 Steps
Acceptable finish of slanted sides insulation panels
Slanted side milled
Slanted side sawn
Keep steps within contour

Dimensions in mm (u.n.o.)
Mass: 10.32 kg
Typ. tolerances for insulation/sandwich panels
Dimensions in mm (u.n.o.)

Scale: 1:10
Date: 06-06-2023
Drawing no.: 2000-07-2713
Issue A

Title: Insulation panel

This drawing is property of VRR which reserved all rights
### Insulation panel

**Item No.** | **QTY.** | **Description** | **Length** | **Width Dia.** | **Height/Thickn.** | **Part Number** | **Material** | **Remarks**
---|---|---|---|---|---|---|---|---
1 | 1 | Insulation panel | 2566 | 1627.5 | 80.4 | 2000-07-2713 | RTM-Plus | |

**Dimensions in mm (u.n.o.)**

- **Outside dimensions of panel:**
  - \(+0.2\)
  - \(-0.1\)
- **Thickness of panel:**
  - \(+0.2\)
  - \(-0.1\)
- **Position of cutouts / inserts:**
  - \(+0.2\)
  - \(-0.1\)
- **Dimensions of cutouts:**
  - \(+0.2\)
  - \(-0.1\)
- **Tolerance on CNC features:**
  - \(+0.5\)

**Typ. tolerances for insulation/sandwich panels**

- **No gaps in core allowed:** Fill with glue
- **All core parts MUST be glued together**

**Scale:** 1:10

**Drawing no.:** 2000-07-2713

**Issue:** A

**Drawing:**

- Scale: 1:3
- Projection

**Title:** Insulation panel

**Dimensions:**

- **SECTION B-B**
  - Scale 1:3
  - 241
  - 260
  - 215
  - 295
  - 200
  - R10
  - 0
  - 264
  - 2042
  - 2064.5
  - 100
  - 2466
  - 0
  - 228.5
  - 969
  - 556.5

- **SECTION A-A**
  - Scale 1:3
  - 264
  - 2215
  - 270
  - 2466

**Mass:** 10.32 kg

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<table>
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<th>Item No.</th>
<th>QTY.</th>
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<th>Width</th>
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<th>Part Number</th>
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**Typ. tolerances for insulation/sandwich panels**

- Outside dimensions of panel: ±1
- Thickness of panel: +0.1
- Position of cutouts / inserts: ±1
- Dimensions of cutouts: ±0.1
- Tolerance on CNC features: ±0.5

No gaps in core allowed -> Fill with glue
All core parts MUST be glued together.

Dimensions in mm (u.n.o.)

Mass: 5.14 kg

**Dimensions**

- Outside dimensions of panel: 2566 x 2528 x 2482 mm
- Thickness of panel: 164 mm
- Position of cutouts / inserts: 84 x 38 mm
- Dimensions of cutouts: 27.9 x 67.9 x 100.9 x 180.9 mm
- Tolerance on CNC features: ±0.5

No gaps in core allowed -> Fill with glue
All core parts MUST be glued together.
Visible side (smooth side)

Item No. QTY. Description Length Width/ Dia Height/ Thckn. Part Number Material Remarks
1 1 Outer sheet 2566 1627.5 0.8 2000-07-2708 PE-GEGW 0.8

Typ. tolerances for insulation/sandwich panels
Dimensions in mm (u.n.o.)

Mass: 5.14 kg

Outside dimensions of panel:
Thickness of panel:
Position of cutouts / inserts:
Dimensions of cutouts:
Tolerance on CNC features:
No gaps in core allowed -> Fill with glue
All core parts MUST be glued together

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<table>
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<th>Item No.</th>
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<th>Height/Thick.</th>
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**Dimensions in mm (u.n.o.)**

- Length: 260
- Width/Dia: 241
- Height/Thick.: 8

**Tolerances (u.n.o.)**

- ±0.2
- ±0.3
- ±0.5
- ±0.8

**Mass:** 0.93 kg

**Issue:** 2000-05-1350

**Sheet:** 1 of 1

**Finish:** Dimensions in mm (u.n.o.)

**Title:** Insert

---

Engraving

Engraving

Projection

Size

A3

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<th>Part Number</th>
<th>Material</th>
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**Dimensions in mm (u.n.o.)**

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**Tolerances (u.n.o.)**

- 7
- 30
- 120
- 400
- 1000
- 2000
- > 2000

- g6.3
- g6.15
- g6.18
- g7.10
- g7.14

Raw extrusion in accordance with OEM drawing and EN755-9

**Issue**

- 2000-07-2714

**Drawing no.:** 2000-07-2714

**Sheet:** 1 of 1

**Issue:** A

**Finish:**

**Dimensions in mm (u.n.o.)**

**Title:** Insert

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**The Netherlands**

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---

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A = 5.0  
B = 9.9 - D = 0.0  
B = 8.8 - D = 0.5  
C = 2.1  
H = 100°

(For Monobolt Ø4.8 Rivet)  
(Revision C)
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<th>Date:</th>
<th>Drawing no.:</th>
<th>Issue</th>
<th>Tolerances (u.n.o.)</th>
<th>Dimensions in mm (u.n.o.)</th>
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<td>JWR</td>
<td>09-05-2019</td>
<td></td>
<td></td>
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<td></td>
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</tbody>
</table>

Title: Outer frame sheet

Dimensions in mm:
- Length: 1543
- Width: 86.9
- Height: 15
- Thickness: 15

Mass: 2.15 kg
Engraving

**Outer frame sheet**

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<td>1541.9</td>
<td>173.8</td>
<td>86.9</td>
<td>2000-05-0395</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
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</table>

**Dimensions in mm (u.n.o.)**

- Mass: 2.15 kg

**Tolerances (u.n.o.)**

- 2000-05-0395

**Issue**

- Sheet: 1 of 1

**Drawing Details**

- Scale: 1:5
- Drawn: JWR (28-03-2019)
- Checked: HS (12-04-2019)
- Approved: JWR (09-05-2019)
- Issue: A

**Additional Notes**

- This drawing is property of Van Riemsdijk Rotterdam b.v., which reserved all rights.
<table>
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<tr>
<td>1</td>
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<td>Internal Frame Sheet</td>
<td>2389</td>
<td>119,1</td>
<td>59,5</td>
<td>9,5 9,5</td>
<td>12,6</td>
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**Drawing Information**

- **Scale:** 1:7
- **Date:**
  - Drawn: JWR - 28-03-2019
  - Checked: HS - 12-04-2019
  - Approved: JWR - 09-05-2019
- **Drawing no.:** 2000-05-0384
- **Issue:** A
- **Finish:**
- **Dimensions in mm (u.n.o.)**
- **Mass:** 1.49 kg
- **Tolerances (u.n.o.):**
  - < 7 ± 0.3 ± 0.5 ± 0.8
  - 7 ± 0.2 ± 0.4 ± 0.6 ± 0.8 ± 1.0 ± 1.4 ± 2
  - Raw extrusion in accordance with OEM drawing and EN755-9

**Dimensions**

- 2389
- 119,1
- 59,5
- 9,5 9,5
- 12,6
- UP 40° R 2.5
- 2
- R2,5
- 40°
- 106
- 40,1
- 30
- 120
- 7
- 30
- 120
- 400
- 1000
- 2000
- 400
- 1000
- 2000
- 0.2
- 0.3
- 0.5
- 0.8

**Projection**

- Engraving

**Title**

Internal Frame Sheet
### Table

<table>
<thead>
<tr>
<th>No.</th>
<th>Item</th>
<th>QTY.</th>
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<th>Length</th>
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<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
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<tr>
<td>4</td>
<td>Wedge</td>
<td>1</td>
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<td>120</td>
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<td>AISI 316</td>
<td>Roxtec art. no ARW0001201021</td>
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<tr>
<td>3</td>
<td>Stayplate</td>
<td>3</td>
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<td>ROXTEC ASP0001200021</td>
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<td>RM</td>
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<td>20</td>
<td>RUB-RM0010020100</td>
<td>Rubber</td>
<td>Roxtec RM00100201000</td>
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<tr>
<td>1</td>
<td>SFHM</td>
<td>1</td>
<td>JVI ALL</td>
<td>2x1</td>
<td>Alu.</td>
<td>6060-T66</td>
<td>5SFHM00012248</td>
<td>Alu.</td>
<td>6060-T66 Roxtec 5SFHM00012248</td>
</tr>
</tbody>
</table>

**Finish:**
- Material: AISI 316
- Color: Silver
- Surface: Matte

**Dimensions in mm (u.n.o.)**

- 400 1000 2000
- 0.2 0.3 0.5 0.8

**Tolerances (u.n.o.)**
- ±0.5

**Mass:** 3.90 kg

**Drawing no.:** 2000-05-1205

**Issue:** A

**Sheet:** 2 of 2

**This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.**
Roxtec installation instructions

Modules

To seal the frame against the structure, apply TSL 1556 sealing strip or a pre-punched gasket.

When using TSL 1556, attach the end of the sealing strip to the frame.

Apply two rounds of sealing strip.

Cut the sealing strip so that it overlaps as shown in the picture. Make sure that the sealing strip parts are mounted tightly against each other in the overlap section.

Attach the frame to the structure.

Frame

This drawing is property of Van Riemsdijk Rotterdam b.v., which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
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<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Connector plate</td>
<td>468</td>
<td>388</td>
<td>2</td>
<td>2000-07-2684</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Length: 468
- Width: 388
- Height: 2

**Tolerances (u.n.o.)**

- Mass: 1.99 kg

**Issue**

- Drawing no.: 2000-07-2684
- Sheet: 1 of 2
- Issue: A

**Finish:**

- Raw extrusion in accordance with OEM drawing and EN755-9

**Title:**

Connector plate

---

This drawing is property of VRR which reserved all rights
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
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<th>Height/Thickn.</th>
<th>Part Number</th>
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<th>Remarks</th>
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<tr>
<td>1</td>
<td>1</td>
<td>Connector plate</td>
<td>468</td>
<td>388</td>
<td>2</td>
<td>2000-07-2684</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**
- Mass: 1.99 kg
- Finish: 2000-07-2684

**Drawing Information**
- Title: Connector plate
- Issue: A
- Drawing no.: 2000-07-2684
- Sheet: 2 of 2
- Scale: 1:2
- Drawn: MBMH 06-06-2023
- Checked: PvT 31-07-2023
- Approved: HS 08-08-2023
- Dimensions in accordance with OEM drawing and EN755-9
- This drawing is property of VRR which reserved all rights

**Notes**
- The diagram shows a connector plate with dimensions and tolerances indicated.
- The EN 755-9 standard is referenced for the drawing.
<table>
<thead>
<tr>
<th>Item No.</th>
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<tbody>
<tr>
<td>2</td>
<td>2</td>
<td>Flange connector</td>
<td>277.8</td>
<td>46.2</td>
<td>2</td>
<td>2000-07-2720</td>
<td>Alu. 5754-H22</td>
<td>Bend with V16</td>
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</table>

Dimensions in mm (u.n.o.)

- 2000  1000  2000
- 1000  2000  > 1.0
- 7       30    120   400 1000 2000
- \( \pm 0.1 \), \( \pm 0.1 \), \( \pm 0.1 \), \( \pm 0.1 \), \( \pm 0.1 \), \( \pm 0.1 \)
- Raw extrusion in accordance with OEM drawing and EN755-9

Mass: 0.06 kg

Finish:

Dimensions in mm (u.n.o.)

Title: Flange connector

Drawn: MBMH
Checked: PvT
Approved: HS

Issue: 2000-07-2720
Sheet: 1 of 1

Stolwijkstraat 57
3079 DN Rotterdam
The Netherlands
vrr.aero
info@vrr.aero
+31 (0)10 479 8100

This drawing is property of VRR which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
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<th>Length</th>
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<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Flange connector</td>
<td>197,8</td>
<td>46,2</td>
<td>18,9</td>
<td>2000-05-1343</td>
<td>Alu. 5754-H22</td>
<td>Bend with V16</td>
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</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Mass: 0.04 kg

**Tolerances (u.n.o.)**

- Raw extrusion in accordance with OEM drawing and EN755-9

**Issue**

- Drawn: JWR 29-03-2019
- Checked: HS 12-04-2019
- Approved: JWR 09-05-2019

**Sheet : 1 of 1**

**Dimensions in mm (u.n.o.)**

- This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
### Table

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
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<th>Part Number</th>
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<th>Remarks</th>
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<tbody>
<tr>
<td>26</td>
<td>8</td>
<td>Torx Socket Button Screw</td>
<td>20</td>
<td>M6</td>
<td>BO-7380T-06020-A2</td>
<td>AISI 304</td>
<td>ISO7380 torx</td>
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<tr>
<td>25</td>
<td>4</td>
<td>Torx Socket Csk. Screw</td>
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<td>M8</td>
<td>BO-14581T-08016-A2</td>
<td>AISI 304</td>
<td>ISO 14581 torx</td>
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<tr>
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<td>12</td>
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<td>12</td>
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<td>ø16,6</td>
<td>M6</td>
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<td>SMO SMO</td>
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<td>22</td>
<td>8</td>
<td>Nord-Lock Large Washer M6</td>
<td>ø13,5</td>
<td>M6</td>
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<td>245</td>
<td>SMO SMO</td>
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<tr>
<td>21</td>
<td>28</td>
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<td>4,8</td>
<td>4,8-9,5</td>
<td>BK-BAPKTR-06W-06</td>
<td>Alu.</td>
<td>w. Rub. washer</td>
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<tr>
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<td>58</td>
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<td>4,8</td>
<td>1,3-6,3</td>
<td>BK-BAPKTR-06W-04</td>
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<td>w. Rub. washer</td>
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<td>270</td>
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<td>4,8</td>
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<td>(MGL100-R6-9)</td>
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<td>ø6</td>
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### Torque Load M6: 8.1 Nm

#### Description

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<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia.</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
<td>26</td>
<td>8</td>
<td>Torx Socket Button Screw</td>
<td>20</td>
<td>M6</td>
<td>BO-7380T-06020-A2</td>
<td>AISI 304</td>
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<td>Nord-Lock Large Washer M8</td>
<td>16</td>
<td>M8</td>
<td>BO-NORDLCK-08SP-M8</td>
<td>245 SMO</td>
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<tr>
<td>22</td>
<td>8</td>
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<td>13,5</td>
<td>M6</td>
<td>BO-NORDLCK-06SP-M6</td>
<td>245 SMO</td>
<td>SMO</td>
<td></td>
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</tbody>
</table>

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**SECTION E-E**

**SCALE 1 : 2**

**SECTION F-F**

**SCALE 1 : 2**

**SECTION G-G**

**SCALE 1 : 2**

---

**Loctite!**

**Torque load!**

---

**DBJ panel top**
Place INNO SEAL on 3 / 5 / 4 / 10 / 11 before placing on 1

Remove excess sealant
Not that the sealant has a dry time of 2 hours.

---

STEP 2

---

**Table:**

<table>
<thead>
<tr>
<th>Item No.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tr>
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<td>2009</td>
<td>2000-04-6138</td>
<td>Rubber</td>
<td>41</td>
<td></td>
<td></td>
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</tbody>
</table>
**SECTION H-H**

**SCALE 1 : 2**

---

**STEPL 3**

Do not tighten bolts before assembling top panel on side panels

See also "Hull DBJ" drawing: 2000-07-2646

---

<table>
<thead>
<tr>
<th>No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
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<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>21</td>
<td>28</td>
<td>Bk.Rivet Klamp-Tite</td>
<td>4,8</td>
<td>4,8-9,5</td>
<td>Ø4,8</td>
<td>BK-BAPKTR-06W-06</td>
<td>Alu. w. Rub. washer</td>
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</tr>
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<td>22</td>
<td>58</td>
<td>Bk.Rivet Klamp-Tite</td>
<td>4,8</td>
<td>1,3-6,3</td>
<td>Ø4,8</td>
<td>BK-BAPKTR-06W-04</td>
<td>Alu. w. Rub. washer</td>
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<tr>
<td>23</td>
<td>2</td>
<td>Locking block</td>
<td>120</td>
<td>33</td>
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**Drawn: MBMH**

**Checked: PvT**

**Approved: HS**

**Issue: Drawing no:**

**Title:** DBJ panel top

**Dimensions in mm (u.n.o.)**

**Mass:** 90.22 kg

**Finish:** Assembly

**Rivets according to VRR-SP2201**

---

**STORAGE IN ACCORDANCE WITH DBJ drawing and EN755-9**
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
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<td>4,8</td>
<td>Ø4,8</td>
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<td>BK-BAPKT06W06</td>
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<td>1,3-6,3</td>
<td>Ø4,8</td>
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<td>3,2-12,2</td>
<td>Ø4,8</td>
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<td>BK-02761-00619</td>
<td>Steel (MGL100-R6-9)</td>
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<td>2,0-15,9</td>
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<td>Ø4,8</td>
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<td>373,5</td>
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<td>205</td>
<td>1536</td>
<td>50</td>
<td>2000-05-0343</td>
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<td>2000-05-0338</td>
<td>Assembly</td>
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</tbody>
</table>

DBJ panel top

VRR panel top

Dimensions in mm (u.n.o.)

Scale: 1:8

Mass: 90.22 kg

Finish:

DBJ panel top

Rivets according to VRR-SP2201

This drawing is property of VRR which reserved all rights.

Rivets according to VRR-SP2201
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<th>Description</th>
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<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
<td>4</td>
<td>1</td>
<td>Outer sheet</td>
<td>2566</td>
<td>1692</td>
<td>0,8</td>
<td>PE-GEGW</td>
<td>0,8 NF</td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>Insulation panel</td>
<td>2566</td>
<td>1592</td>
<td>60,4</td>
<td>RTM-Plus</td>
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<tr>
<td>2</td>
<td>1</td>
<td>Inner sheet</td>
<td>2566</td>
<td>1663,9</td>
<td>0,8</td>
<td>PE-GEGW</td>
<td>0,8 NF</td>
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<td>1</td>
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**Title:** DBJ panel top

**Dimensions in mm:**

- Height: 2000
- Width: 1000
- Depth: 70

**Mass:** 44.13 kg

**Issue Drawing no.:** 2000-05-0336

**Issue:** B

**Drawn:** JWR

**Checked:** HS

**Approved:** JWR

**Date:** 13-02-2020

**Date:** 10-03-2020

**Sheet:** 2 of 2

**Title:** DBJ panel top

**Issue:** B

**Drawing no.:** 2000-05-0336

**Drawing is property of VRR which reserved all rights.**
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<th>Material</th>
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<td>30/60</td>
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<td>Alu. 6060-T66</td>
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<td>Tube 90x30d2</td>
<td>1552</td>
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<td>9</td>
<td>Tube 40x30d2</td>
<td>1502</td>
<td>40/30</td>
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<td>100/60</td>
<td>4</td>
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Welding according to procedure VRR-W3-090 except when indicated otherwise.

**Weld detail**

**Dimensions in mm**

- Width: 1152.0
- Height: 28.0
- Depth: 199.0

**Mass:** 22.87 kg

This drawing is property of VRR which reserved all rights.
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<tr>
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<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<td>Tube 100x60x4</td>
<td>2566</td>
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<td>4</td>
<td>2000-05-0345</td>
<td>Alu. 6060-T66</td>
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</table>

**Title:** Tube 100x60x4

**Mass:** 8.19 kg

**Issue:** B

**Issue Drawing no.:** 2000-05-0345

**Sheet:** 1 of 1

**Dimensions in mm (U.N.O.):**

- Length: 100
- Width: 60
- Thickness: 4

**Tolerances (U.N.O.):**

- ±0.2
- ±0.3
- ±0.5
- ±0.8

**Raw extrusion in accordance with OEM drawing and EN755-9**

This drawing is property of VRR which reserved all rights.
<table>
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<tr>
<th>Item No.</th>
<th>QTY.</th>
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<td>2</td>
<td>2000-05-0342</td>
<td>Alu. 6060-T66</td>
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**Projection**

**Title:** Tube 40x30x2

**Dimensions in mm (u.n.o.)**

- 400 1000 2000
- 7 30 120 400 1000 2000
- 0.02 0.03 0.05 0.08

**Tolerances (u.n.o.)**

- < 7 30 120 400 1000 2000
- 0.02 0.03 0.05 0.08

- Raw extrusion in accordance with OEM drawing and EN755-9

**Mass:** 1.07 kg

**Issue:** 2000-05-0342

**Finish:** Sheet : 1 of 1

**Dimensions in mm (u.n.o.)**

- 7       30    120   400  
- 0.02 0.03 0.05 0.08

**Tolerances (u.n.o.)**

- < 7 30 120 400 1000 2000
- 0.02 0.03 0.05 0.08

**Mass:** 1.07 kg

**Issue:** 2000-05-0342

**Finish:** Sheet : 1 of 1

**Dimensions in mm (u.n.o.)**

- 7       30    120   400  
- 0.02 0.03 0.05 0.08

**Tolerances (u.n.o.)**

- < 7 30 120 400 1000 2000
- 0.02 0.03 0.05 0.08

**Mass:** 1.07 kg

**Issue:** 2000-05-0342

**Finish:** Sheet : 1 of 1

**Dimensions in mm (u.n.o.)**

- 7       30    120   400  
- 0.02 0.03 0.05 0.08

**Tolerances (u.n.o.)**

- < 7 30 120 400 1000 2000
- 0.02 0.03 0.05 0.08
<table>
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<th>Item No.</th>
<th>QTY.</th>
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<th>Width Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
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<tbody>
<tr>
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<td>1</td>
<td>Insulation panel</td>
<td>2566</td>
<td>1592</td>
<td>60,4</td>
<td>2000-05-0340</td>
<td>RTM-Plus</td>
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</table>

**Dimensions in mm (u.n.o.):**
- Length: 2566
- Width: 1592
- Height/Thickn.: 60,4

**Tolerances (u.n.o.):**
- ±0.4
- ±0.8
- ±1.2
- ±1.6
- ±2.0

**Mass:** 10.49 kg

**Drawing information:**
- Scale: 1:10
- Date: 29-03-2019
- Drawing no.: 2000-05-0340
- Issue: B
- Finish:
- Dimensions in mm (u.n.o.)
- Raw extrusion in accordance with OEM drawing and EN755-9
- This drawing is property of VRR which reserved all rights.

**Contact:**
- Stolwijkstraat 57
- 3079 DN Rotterdam
- The Netherlands
- info@vrr.aero
- +31 (0)10 479 8100
<table>
<thead>
<tr>
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<th>Length</th>
<th>Width</th>
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<th>Thicken.</th>
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Visible side (smooth side)

Scale: 1:12

Drawn: JWR 29-03-2019
Checked: HS 12-04-2019
Approved: JWR 09-05-2019

Mass: 5.45 kg

Dimensions in mm (u.n.o.)

Raw extrusion in accordance with OEM drawing and EN755-9

Tolerances (u.n.o.)

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
A = 5.0
B = 9.9 - D = 0.0
B = 8.8 - D = 0.5
C = 2.1
H = 100°

58 x 25.4 = 1473.2

SECTION A-A
SCALE 1 : 1

1536

For Monobolt Ø4,8 Rivet (Revision C)

Item
No.
1
QTY.
1
Description
Seat-T track profile RR 205
1536
15
50
15
2000-05-0343
Alu. 6061-T6

Mass: 1.94 kg
Finish: U001 - Aludon

Dimensions in mm (u.n.o.)
Raw extrusion in accordance with OEM drawing and EN755-9

Tolerances (u.n.o.)

Issue
2000-05-0343

Title: Seat-T track profile RR 205

Drawing no.:
Sheet 1 of 1

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
**Outer frame sheet**

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
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<th>Length</th>
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<th>Part Number</th>
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<td>1604.6</td>
<td>173.8</td>
<td>3</td>
<td>2000-05-0397</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
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**Dimensions in mm (u.n.o.)**

- Width: 1604.6
- Height: 173.8
- Thickness: 3

**Mass:** 2.23 kg

**Drawing Details:**
- **Scale:** 1:5
- **Date:** 29-03-2019
- **Drawing no.:** 2000-05-0397
- **Issue:** A
- **Finish:**
- **Dimensions in mm (u.n.o.)**

**Tolerances (u.n.o.):**

- Width: +0.2 -0.3
- Height: +0.5 -0.8

**This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.**
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
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<th>Remarks</th>
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<td>173.8</td>
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Finish: 
2000-05-0392  Sheet: 1 of 1

Dimensions in mm (u.n.o.)
- Mass: 2.23 kg

Tolerances (u.n.o.)
- 2000-05-0392

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<table>
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<th>Item No.</th>
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<td>AISI 304</td>
<td>Bend with V16</td>
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**Dimensions in mm (u.n.o.)**

| Mass:   | 8.70 kg |

**Issue**

- **Drawing no.:** 2000-05-0437
- **Issue:** A
- **Sheet:** 1 of 2
- **Dimensions in mm (u.n.o.)**

**Title:** Frame sheet door
**Gusset**

**Item No.** | **QTY.** | **Description** | **Length** | **Width/ Dia.** | **Height/ Thickn.** | **Part Number** | **Material** | **Remarks**
---|---|---|---|---|---|---|---|---
1 | 1 | Gusset | 390,2 | 347,4 | 3 | 2000-05-0494 | Alu. 5754-H22 | Bend with V30

**Dimensions in mm (u.n.o.)**
- 400  1000  2000
- 7 30 120 400 1000 2000
- 0,2 0,3 0,5 0,8

**Tolerances (u.n.o.)**
- Raw extrusion in accordance with OEM drawing and EN755-9

**Issue**
- A

**Drawing no.:** 2000-05-0494

**Sheet:** 1 of 1

**Finish:**
- Dimensions in mm (u.n.o.)
- Mass: 0.62 kg

**Date:**
- Drawn: 29-03-2019
- Checked: 12-04-2019
- Approved: 09-05-2019

**Scale:** 1:4

**Fax:** +31 10 479 5478
**Tel:** +31 10 479 8100
**Stolwijkstraat 57**
**3079 DN Rotterdam**
**The Netherlands**

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### Gusset

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Gusset</td>
<td>390.3</td>
<td>347.3</td>
<td>200.1</td>
<td>2000-05-0479</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Mass: 0.62 kg
- **2000-05-0479**

**Tolerances (u.n.o.)**

- ± 7 ± 30 ± 120 ± 400 ± 1000 ± 2000
- ± 0.2 ± 0.3 ± 0.5 ± 0.8

**Issue**

- Drawing no.: 2000-05-0479
- Sheet: 1 of 1

**Dimensions**

- **347.4**
- **390.2**
- **209.9**

**Engraving**
### Slanted corner gusset

**Item No.** | **QTY.** | **Description** | **Length** | **Width/Dia** | **Height/Thickn.** | **Part Number** | **Material** | **Remarks**
---|---|---|---|---|---|---|---|---
1 | 1 | Slanted corner gusset | 393.9 | 373.5 | 3 | 2000-05-0497 | Alu. 5754-H22 | Bend with V30

**Scale:** 1:4  
**Date:** 29-03-2019  
**Drawing no.:** 2000-05-0497  
**Issue:** A  
**Tolerances (u.n.o.)**
- \( < 7 \text{ mm} \)  
- \( 120 \text{ mm} \)  
- \( 1000 \text{ mm} \)  
- \( 2000 \text{ mm} \)  

- \( 1.0 \text{ mm} \)  
- \( 1.4 \text{ mm} \)  

**Raw extrusion in accordance with OEM drawing and EN755-9**

**Mass:** 0.69 kg  
**Finish:**

**Dimensions in mm (u.n.o.)**

- \( 400 \text{ mm} \)  
- \( 1000 \text{ mm} \)  
- \( 2000 \text{ mm} \)

- \( 0.2 \text{ mm} \)  
- \( 0.3 \text{ mm} \)  
- \( 0.5 \text{ mm} \)  
- \( 0.8 \text{ mm} \)  

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---

**Title:** Slanted corner gusset
Slanted corner gusset

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Slanted corner gusset</td>
<td>393,9</td>
<td>373,5</td>
<td>208,9</td>
<td>2000-05-0482</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

Issue Drawn: JWR 29-03-2019
Checked: HS 12-04-2019
Approved: JWR 09-05-2019

Dimensions in mm (u.n.o.)

- Mass: 0.69 kg

Tolerances (u.n.o.)

- Bend with V30

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/ Dia</th>
<th>Height/ Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Door post</td>
<td>2506</td>
<td>119.5</td>
<td>48.2</td>
<td>11,2</td>
<td>35.7</td>
<td></td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

- Raw extrusion in accordance with OEM drawing and EN755-9

Mass: 4.45 kg

Finish:

Dimensions in mm (u.n.o.)

Title: Door post

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Stolwijkstraat 57
3079 DN Rotterdam
The Netherlands
vrr.aero
info@vrr.aero
+31 (0)10 479 8100
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>L-extrusion</td>
<td>60</td>
<td></td>
<td></td>
<td>2000-04-6140</td>
<td>AISI 304</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Width/Dia: 60
- Height/Thick.: 120
- 0
- 17,2
- 57,2
- 97,2
- 0
- 12,5
- 47,5

**Tolerances (u.n.o.)**

- ± 0,2
- ± 0,3
- ± 0,5
- ± 0,8

**Mass:** 1.08 kg

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Tel: +31 10 479 8100
3079 DN Rotterdam
The Netherlands
Fax: +31 10 479 5478
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia.</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Fill strip front gusset</td>
<td>396.9</td>
<td>62.5</td>
<td>15</td>
<td>2000-05-1233</td>
<td>Alu. 5754-H22</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Scale:** 1:2  
**Date:** 14-02-2019  
**Drawing no.:** 2000-05-1233  
**Issue:** A  
**Checked:** HS  
**Approved:** JWR  
**Drawn:** JWR  
**Checked:** HS  
**Approved:** JWR  
**Mass:** 0.06 kg  
**Finish:** Dimensions in mm (u.n.o.)

**Title:** Fill strip front gusset

**Tolerances (u.n.o.):**  
- ±0.2, ±0.3, ±0.5, ±0.8

**Dimensions in mm (u.n.o.):**

<table>
<thead>
<tr>
<th></th>
<th>7</th>
<th>30</th>
<th>120</th>
<th>400</th>
<th>1000</th>
<th>2000</th>
<th>&gt; 4000</th>
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</thead>
<tbody>
<tr>
<td>Raw extrusion in accordance with OEM drawing and EN755-9</td>
<td>30.5</td>
<td>30.5</td>
<td>30.5</td>
<td>30.5</td>
<td>30.5</td>
<td>30.5</td>
<td>30.5</td>
</tr>
</tbody>
</table>

Stolwijkstraat 57  
3079 DN Rotterdam  
The Netherlands  
Fax:+31 10 479 5478

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### Locking block

<table>
<thead>
<tr>
<th>Term No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia.</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Locking block</td>
<td>120</td>
<td>26</td>
<td>33</td>
<td>2000-05-1527</td>
<td>Alu. 6062-T6</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.):**
- 400 1000 2000 7 30 120 400 1000 2000
- 0.2 0.3 0.5 0.8

**Tolerances (u.n.o.):**
- ± 0.2 ± 0.3 ± 0.5 ± 0.8

**Mass:** 0.17 kg

**Drawing no.:** 2000-05-1527

**Issue:** A

**Projected by:** JWR

**Checked:** HS

**Approved:** JWR

**Date:**
- Drawn: 01-03-2019
- Checked: 12-04-2019
- Approved: 09-05-2019

**Finish:**
- Dimensions in mm (u.n.o.)

**Remarks:**
- Raw extrusion in accordance with OEM drawing and EN755-9

**This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights**
<table>
<thead>
<tr>
<th>Item No.</th>
<th>Qty.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Thickness</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>10</td>
<td>66</td>
<td>Bk. Rivet Klamp-Tite</td>
<td>4,8</td>
<td>1,3-6,3</td>
<td>Ø4,8</td>
<td>BK-BAPKTR-06W-04</td>
<td>Alu. w. Rub. washer</td>
<td></td>
</tr>
<tr>
<td>9</td>
<td>40</td>
<td>Bk. St. Monobolt</td>
<td>6,4</td>
<td>2,0-15,9</td>
<td>Ø6,4</td>
<td>BK-02771-00824</td>
<td>Steel (MGLP-R8-10)</td>
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</tr>
<tr>
<td>8</td>
<td>2</td>
<td>Grill</td>
<td>490</td>
<td>490</td>
<td>2</td>
<td>2000-05-1525</td>
<td>Alu. 5754-H22</td>
<td></td>
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<tr>
<td>7</td>
<td>1</td>
<td>Slanted corner gusset</td>
<td>401,2</td>
<td>368,4</td>
<td>3</td>
<td>2000-05-0506</td>
<td>Alu. 5754-H22 Bend with V30</td>
<td></td>
</tr>
<tr>
<td>6</td>
<td>1</td>
<td>Outer frame sheet</td>
<td>665,5</td>
<td>173,8</td>
<td>3</td>
<td>2000-05-0388</td>
<td>Alu. 5754-H22 Bend with V30</td>
<td></td>
</tr>
<tr>
<td>5</td>
<td>1</td>
<td>Outer frame sheet</td>
<td>665,5</td>
<td>173,8</td>
<td>3</td>
<td>2000-05-0388</td>
<td>Alu. 5754-H22 Bend with V30</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>1</td>
<td>Slanted corner gusset</td>
<td>401,1</td>
<td>368,5</td>
<td>3</td>
<td>2000-05-0498</td>
<td>Alu. 5754-H22 Bend with V30</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>Frame sheet</td>
<td>2452</td>
<td>150,5</td>
<td>3</td>
<td>2000-05-0481</td>
<td>Alu. 5754-H22 Bend with V30</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>Internal gusset</td>
<td>2388</td>
<td>118,7</td>
<td>2</td>
<td>2000-05-0381</td>
<td>Alu. 5754-H22 Bend with V16</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>DBJ panel slanted</td>
<td></td>
<td></td>
<td></td>
<td>2000-05-0357</td>
<td>DBJ panel slanted</td>
<td></td>
</tr>
</tbody>
</table>

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For more information, please contact:
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Tel: +31 10 479 8100
E-mail: info@vrr-aviation.com

Location: Stolwijkstraat 57
The Netherlands

Projection Sheet: 1 of 3

Dimensions in mm

Title: DBJ panel slanted

Issue Drawing no.

Scale: 1:6

Drafted: JWR
Checked: VvM
Approved: JWR

02-04-2019
17-04-2019
09-05-2019
Place INNO SEAL on 3 / 5 / 6 before placing on panel 1.

Remove excess sealant.

Not that the sealant has a dry time of 2 hours.

Outside
Welding according to procedure VRR-W3-090 except when indicated otherwise

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/ Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>3</td>
<td>4</td>
<td>Tube 40x30x2</td>
<td>485</td>
<td>40/30</td>
<td>2</td>
<td>2000-05-0361</td>
<td>Alu. 6060-T66</td>
</tr>
<tr>
<td>2</td>
<td>2</td>
<td>Tube 30x60x2</td>
<td>595</td>
<td>30/60</td>
<td>2</td>
<td>2000-05-0360</td>
<td>Alu. 6060-T66</td>
</tr>
<tr>
<td>1</td>
<td>2</td>
<td>Tube 60x30x2</td>
<td>2510</td>
<td>60/30</td>
<td>2</td>
<td>2000-05-0359</td>
<td>Alu. 6060-T66</td>
</tr>
</tbody>
</table>

Finish:

Fax:+31 10 479 5478
Tel: +31 10 479 8100
3079 DN Rotterdam
The Netherlands
info@vrr-aviation.com

Projection

Title: Internal panel frame slanted

Dimensions in mm (u.n.o.)

Mass: 6.90 kg

Weld detail

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A
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length (Width/Dia)</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Tube 60x30x2</td>
<td>2510</td>
<td>60/30</td>
<td>2000-05-0359</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Length: 2510
- Width/Dia: 60/30
- Height/Thickn.: 2

**Tolerances (u.n.o.)**

- Mass: 2.27 kg
- Finish: 2000-05-0359

**Issue A**

- Sheet: 1 of 1

**Drawing Information**

- Drawn: JWR 02-04-2019
- Checked: HS 12-04-2019
- Approved: JWR 09-05-2019

**Dimensions**

- 45° 45° 3 0 376 414 934 896 2096 2134 1614 1576 0 5 25

**Sizes**

- 60 30 2

**Projection**

- 60 30 2
<table>
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<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Tube 30x60x2</td>
<td>30</td>
<td>60</td>
<td>2</td>
<td>595</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**
- Mass: 0.50 kg
- Scale: 1:4
- Drawn: JWR 02-04-2019
- Checked: HS 12-04-2019
- Approved: JWR 09-05-2019

**Tolerances (u.n.o.)**
- ± 0.2
- ± 0.3
- ± 0.5
- ± 0.8

**Issue A**
- Raw extrusion in accordance with OEM drawing and EN755-9

**Sheet : 1 of 1**

**Dimensions in mm (u.n.o.)**
- 2000-05-0360
- 45°
- 45°
- 595
- 30
- 60
- 2
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/ Dia</th>
<th>Height/ Thichn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Tube 40x30x2</td>
<td>485</td>
<td>40/30</td>
<td>2</td>
<td>2000-05-0361</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**
- Mass: 0.34 kg
- Tolerances (u.n.o.):
  - +0.2 0.3 0.5 0.8

**Tolerances in accordance with OEM drawing and EN755-9**

- 400 1000 2000
- 7 30 120 400 1000 2000
- ±0.2 ±0.3 ±0.5 ±0.8 ±1.0 ±1.4 ±2

**Raw extrusion in accordance with OEM drawing and EN755-9**

**Issue:**
- Drawing no.: 2000-05-0361
- Sheet: 1 of 1 A
- Issue: A

**Title:**
- Tube 40x30x2

**Scale:** 1:2

**Date:**
- Drawn: 02-04-2019
- Checked: 12-04-2019
- Approved: 09-05-2019
Visible side (smooth side)
<table>
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<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
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<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Insulation panel</td>
<td>2566</td>
<td>665,3</td>
<td>60,4 2000-05-0363</td>
<td>RTM-Plus</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**
- 400  1000  2000
- 7  30  120  400 1000 2000
- ø52, ø53, ø54, ø54, ø1, ø1.4

**Tolerances (u.n.o.)**
- 7  30  120  400 1000 2000
- ø52, ø53, ø54, ø54, ø1, ø1.4

**Issue**
- B

**Drawing no.**
- 2000-05-0363

**Finish:**
- Sheet : 2 of 2

**Mass:**
- 3.39 kg

**Dimensions in mm (u.n.o.)**
- Production in accordance with OEM drawing and EN755-9

**Issue Drawing no.:**
- 2000-05-0363

**Finish:**
- Sheet : 2 of 2

**Dimensions in mm (u.n.o.)**
- Production in accordance with OEM drawing and EN755-9

**Issue:**
- B

**Drawing no.:**
- 2000-05-0363

**Finish:**
- Sheet : 2 of 2

**Dimensions in mm (u.n.o.)**
- Production in accordance with OEM drawing and EN755-9

**Issue:**
- B

**Drawing no.:**
- 2000-05-0363

**Finish:**
- Sheet : 2 of 2

**Dimensions in mm (u.n.o.)**
- Production in accordance with OEM drawing and EN755-9
Visible side (smooth side)

<table>
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<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Outer sheet</td>
<td>2566</td>
<td>665,3</td>
<td>6,8</td>
<td>2000-05-0362</td>
<td>PE-GEGW 0,8 NF</td>
<td></td>
</tr>
</tbody>
</table>

Finish:

- Fax: +31 10 479 5478
- Tel: +31 10 479 8100
- 3079 DN Rotterdam
- The Netherlands
- info@vrr-aviation.com

Dimensions in mm (u.n.o.)
- Mass: 1.82 kg
- 2000-05-0362

Tolerances (u.n.o.)
- ø7 30 120 400 1000 2000
- ø5 15 10 14 2
- Raw extrusion in accordance with OEM drawing and EN755-9

Issue: 2000-05-0362

Computer-aided design (CAD) drawings

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Insert</td>
<td>500</td>
<td>50</td>
<td>8</td>
<td>2000-05-1513</td>
<td>Alu. 6082-T6</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- 400
- 1000
- 2000
- 1.0
- 1.4
- 2

**Tolerances (u.n.o.)**

- 7
- 30
- 120
- 400
- 1000
- 2000
- 0.2
- 0.3
- 0.5
- 0.8

**Dimensions in mm (u.n.o.)**

This drawing is property of Van Riemst Rotterdam b.v. which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Dia</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Internal gusset</td>
<td>2388</td>
<td>118.7</td>
<td>12.5</td>
<td>2000-05-0382</td>
<td>Alu. 5754-H22</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Mass: 1.50 kg

**Issue Tolerances (u.n.o.)**

- Raw extrusion in accordance with OEM drawing and EN755-9

---

**Scale:** 1:7

**Date:** 02-04-2019

**Issue Drawing no.:** 2000-05-0382

**Sheet:** 1 of 1

**Dimensions in mm (u.n.o.)**

- Width/ Dia: < 7, 30, 120, 400, 1000, 2000
- Height/Dia: 7, 30, 120, 400, 1000, 2000
- Tolerance: ±0.1, ±0.15, ±0.5, ±0.8

---

**Title:** Internal gusset

**Issue:** A

**Drawn:** JWR

**Checked:** HS

**Approved:** JWR

**Date:** 02-04-2019

**Date:** 12-04-2019

**Date:** 09-05-2019

---

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**Tel:** +31 10 479 8100

**3079 DN Rotterdam**

**The Netherlands**

**info@vrr-aviation.com**

---

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Frame sheet

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Frame sheet</td>
<td>2452</td>
<td>150.5</td>
<td></td>
<td>2000-05-0481</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

- Mass: 2.98 kg

Tolerances (u.n.o.)

- < 7 30 120 400 1000 2000
- ±0.2 ±0.3 ±0.5 ±0.8 ±1.0 ±1.2 ±1.4 ±2

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**Slanted corner gusset**

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Slanted corner gusset</td>
<td>401.1</td>
<td>368.5</td>
<td>199.3</td>
<td>2000-05-0490</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Raw extrusion in accordance with OEM drawing and EN755-9
- Tolerances (u.n.o.):
  - Mass: 0.70 kg

**Issue Tolerances**

- ± 0.3 mm
- ± 0.5 mm
- ± 0.8 mm
- ± 1.0 mm
- ± 1.4 mm

**Drawn:**

JWR
02-04-2019

**Checked:**

HS
12-04-2019

**Approved:**

JWR
09-05-2019

**Finish:**

- 7
- 30
- 120
- 400
- 1000
- 2000

- 7
- 30
- 120
- 400
- 1000
- 2000

- ± 1.0 mm
- ± 1.4 mm

**This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights**
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Outer Frame sheet</td>
<td>665.5</td>
<td>173.8</td>
<td>86.9</td>
<td>2000-05-0398</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Mass: 0.90 kg

**Tolerances (u.n.o.)**

- +/− 0.2
- +/− 0.3
- +/− 0.5
- +/− 0.8

**Issue**

- Sheet: 1 of 1
- Issue: A
- Drawing no.: 2000-05-0398

**Dimensions in mm (u.n.o.)**

- Dimensions in accordance with OEM drawing and EN755-9

**Projected**

- Projections: A3

**Supplemental Information**

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### Engraving

**Outer frame sheet**

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Outer frame sheet</td>
<td>665.5</td>
<td>173.8</td>
<td>3</td>
<td>2000-05-0390</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Mass: 0.91 kg

**Tolerances (u.n.o.)**

- ± 7
- ± 30
- ± 120
- ± 400
- ± 1000
- ± 2000

- ± 0.5
- ± 0.3
- ± 0.2
- ± 0.1

**Finished size:**

- 90° bend

**Issue:**

- Drawing no.: 2000-05-0390
- Sheet: 1 of 1

**Dimensions in mm (u.n.o.)**

- ± 0.5
- ± 0.3
- ± 0.2
- ± 0.1

**This drawing is property of Van Riemtsdijk Rotterdam b.v. which reserved all rights**
Slanted corner gusset

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Slanted corner gusset</td>
<td>401.2</td>
<td>368.4</td>
<td>3</td>
<td>2000-05-0506</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

Scale: 1:4  
Drawing no.: 2000-05-0506  
Issue: A  
Sheet: 1 of 1

Mass: 0.70 kg

Dimensions in mm (u.n.o.)

Tolerances (u.n.o.)

Issue Drawing no.:

Title: Slanted corner gusset

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Grill</td>
<td>490</td>
<td>490</td>
<td>20</td>
<td>20</td>
<td>5,2</td>
<td>5</td>
</tr>
</tbody>
</table>

### Tolerances (u.n.o.)

| Mass:  | 1.23 kg |

### Issue

<table>
<thead>
<tr>
<th>Drawing no.:</th>
<th>2000-05-1525</th>
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</thead>
<tbody>
<tr>
<td>Issue:</td>
<td>A</td>
</tr>
</tbody>
</table>

### Sheet: 1 of 1

### Dimensions in mm (u.n.o.)

- 7 30 120 400 1000 2000
- ø5 6 7 8 9 10 11 12 13 14

### Remarks

- Raw extrusion in accordance with OEM drawing and EN755-9
NOTE: Use 20mm tube when applying
Stitch the side of the zipper with the Insert Pin to the cover.

Cover with zipper

Stitch zipper half up

Stitch pattern

Start zipper

End zipper

SECTION A-A
SCALE 1 : 1

Item No. QTY. Description Length Width/Dia Height/Thickn. Part Number Material Remarks
2 1 Container connection 6861,4 281,1 2000-05-1638 PVC Cover Color: Grey
1 1 Zipper 10 mm (White) 6760 53 2000-05-1640 Zipper Trisco: Y10MM700

Finish:

Fax:+31 10 479 5478
Tel: +31 10 479 8100
3079 DN Rotterdam
The Netherlands
info@vrr-aviation.com

Projection

NameDateChangesIss.
Size

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A
Flat pattern
Fine side

Cover material according to specification VRR-SP1605

---

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Color:</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Container connection</td>
<td>6861.4</td>
<td>281.1</td>
<td>2000·05·1638</td>
<td>PVC</td>
<td>Grey</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

Tolerances (u.n.o.)

- Mass: 1.25 kg
- Scale: 1:2
- Date: 08-04-2019
- Drawing no.: 2000·05·1638
- Sheet: 1 of 1
- Approved: JWR (JWR)
- Checked: HS
- Drawn: JWR
- Issue A

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/ Dia</th>
<th>Height/ Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Fill strip cover</td>
<td>2458</td>
<td>23</td>
<td>3</td>
<td>2000-05-1688</td>
<td>Alu. 5754-H22</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Mass: 0.45 kg
- Tolerances (u.n.o.):
  - ± 0.2
  - ± 0.3
  - ± 0.5
  - ± 0.8

**Projection**

- Scale: 1:7
- Date: 08-04-2019
- Drawing no.: 2000-05-1688
- Sheet: 1 of 1

**Issue**

- Drawn: JWR
- Checked: HS
- Approved: JWR
- Tolerance A

**Finish**

- Dimensions in mm (u.n.o.)

**Remarks**

- Raw extrusion in accordance with OEM drawing and EN755-9

---

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Item No.</th>
<th>Length</th>
<th>Width/ Dia</th>
<th>Height/ Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Fill strip cover</td>
<td>1969</td>
<td>24,5</td>
<td>24,5</td>
<td>11,5</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>5,2</td>
<td>23</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Project**

Name: Date: Changes: Iss.:

---

**Dimensions in mm (u.n.o.)**

<table>
<thead>
<tr>
<th>Mass:</th>
<th>0.36 kg</th>
</tr>
</thead>
</table>

**Title:** Fill strip cover

---

**Issue:**

Tolerances (u.n.o.):<br>

- ± 0.2<br>- ± 0.3<br>- ± 0.5<br>- ± 0.8

- 2000-05-1689

Sheet: 1 of 1

Dimensions in mm (u.n.o.)

<table>
<thead>
<tr>
<th>Scale: 1:6</th>
<th>Date: 08-04-2019</th>
<th>Drawing no.: 2000-05-1689</th>
<th>Issue A</th>
</tr>
</thead>
<tbody>
<tr>
<td>Drawn: JWR</td>
<td>Checked: HS</td>
<td>Approved: JWR</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- 1,0<br>- 1,4<br>- 2<br>- 4

- 0,2<br>- 0,3<br>- 0,5<br>- 0,8

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Extrusion RR148</td>
<td>2050</td>
<td>23/3.5</td>
<td>2000-05-1690</td>
<td>Alu. 6063-T66</td>
<td></td>
<td>2000-05-1690 A</td>
</tr>
</tbody>
</table>

**FAX:** +31 10 479 5478  
**Tel:** +31 10 479 8100  
**3079 DN Rotterdam**  
**The Netherlands**  
**info@vrr-aviation.com**

---

**Title:** Extrusion RR148

**Scale:** 1:7  
**Date:** 08-04-2019  
**Drawing no.:** 2000-05-1690  
**Issue:** A  
**Tolerances (u.n.o.):**

<table>
<thead>
<tr>
<th>+</th>
<th>7</th>
<th>30</th>
<th>120</th>
<th>400</th>
<th>1000</th>
<th>2000</th>
</tr>
</thead>
<tbody>
<tr>
<td>g02</td>
<td>g03</td>
<td>g04</td>
<td>g05</td>
<td>g10</td>
<td>g16</td>
<td>g24</td>
</tr>
</tbody>
</table>

**Finish:** U001 - Aludon  
**Dimensions in mm (u.n.o.)**

- 24 x 80 = 1920
- 80
- 11.5
- 2.5

**Mass:** kg  
**Dimensions in mm (u.n.o.)**

- 2000-05-1690
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Extrusion RR148</td>
<td>2620</td>
<td>30 x 80</td>
<td>2400</td>
<td>2000-05-1687</td>
<td>Alu. 6063-T66</td>
<td></td>
</tr>
</tbody>
</table>

**Scale:** 1:7

**Issue:** 2000-05-1687

**Dimensions in mm (u.n.o.)**

- Mass: kg
- Tolerances (u.n.o.):
  - ±0.2
  - ±0.3
  - ±0.5
  - ±0.8

**Finish:** U001 - Aludon

**Dimensions:**

- 2610
- 2510
- 2555
- 23
- 3.5

**Title:** Extrusion RR148

**Drawing no.:** 2000-05-1687

**Issue:** A

**Drawn:** JWR 08-04-2019

**Checked:** HS 12-04-2019

**Approved:** JWR 09-05-2019

**Dimensions:**

- 10
- 65
- 110
- 2510
- 2555
- 2610
- 23
- 3.5

** Remarks:**

- Raw extrusion in accordance with OEM drawing and EN755-9

**Projection Size:** A3

**Dimensions:**

- 2620
- 30 x 80 = 2400
- 80
- 5,2

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**Address:** The Netherlands

**Email:** info@vrr-aviation.com

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Welding according to procedure VRR-W3-090
except when indicated otherwise

Note: place self adhesive rubber after welding (inside)

Item | No. | QTY. | Description | Length | Width/Dia | Height/Thickn. | Part Number | Material | Remarks
--- | --- | --- | --- | --- | --- | --- | --- | --- | ---
8 | 6 | Nyloc Hex Nut 10 M4 | BO-10511-04-A2 | AISI 304 | ISO10511/DIN985
7 | 12 | Plain Washer Large 12 M4 | BO-7093-04-A2 | AISI 304 | ISO7093/DIN9021
6 | 6 | Torx Socket Button Screw 25 M4 | BO-7380T-04025-A2 | AISI 304 | ISO7380 torx
5 | 1 | EPDM Foam Rubber 25 30 10 | 2000-07-3408 | Celrub.(EPDM) (Self Adhesive)
4 | 1 | EPDM Foam Rubber 15 30 10 | 2000-07-3409 | Celrub.(EPDM) (Self Adhesive)
3 | 1 | End Stop Block 68.77 31 15 | 2000-07-2648 | HDPE (PE-HD) Colour: black
2 | 1 | Roller Track End Plate 53.5 28.3 2 | 2000-07-3475 | Alu. 5754-H22
1 | 1 | Roller Track Left 1590 107.27 2 | 2000-07-2750 | Alu. 5754-H22 Special bend radius

Finish:
Projection

Size

Material: 0.96 kg

Roller Track Left Assy

Note: place self adhesive rubber after welding (inside)
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>End stop block</td>
<td>88,8</td>
<td>31</td>
<td>15</td>
<td>2000-07-2648</td>
<td>HDPE (PE-HD)</td>
<td>Colour: black</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Mass: 0.03 kg

**Tolerances (u.n.o.)**

- ±1,5

**Issue**

- A

**Drawing no.:** 2000-07-2648

**Sheet:** 1 of 1

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The Netherlands
vrr.aero
info@vrr.aero
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Note: make all three bends with a R5 punch and a V24 V-die.

1590

211,3

46

49,5

29,3

55,5

2

R5

29,3

Engraving

1590

103,9

2000-07-27

30 Alu. 5754-H22 Special bend radius

Finish:

A

Projection

Dimensions in mm (u.n.o.)

Mass: 0.90 kg

Raw extrusion in accordance with OEM drawing and EN755-9

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1590

Engraving  R5

29,3

55,5

2

R5

29,3

Item

No.

QTY.

Description

Length

Width/ Dia

Height/ Thickn.

Part Number

Material

Remarks

1

1

Roller track left

1590

103,9

2

2000-07-2730

Alu. 5754-H22 Special bend radius

Issue

Tolerances (u.n.o.)

< 7 30 120 400 1000 2000

7 30 120 400 1000 2000>

+0,2 +0,1 +0,05 +0,03 +0,01 +0,004

Scale: 1:5

Date:

09-06-2023

08-08-2023

Drawn: MBMH

Checked: PvT

Approved: HS

Drawing no.: 2000-07-2730

Sheet : 1 of 1

Dimensions in mm (u.n.o.)

Title:

Roller track left

Speciﬁc bend radius

Size

A3

Issue

Changes

Date

Name

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>EPDM Foam Rubber</td>
<td>25</td>
<td>30</td>
<td>10</td>
<td>2000-07-3408</td>
<td>Celrub.(EPDM)</td>
<td>(Self Adhesive)</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Mass: 0.00 kg

**Tolerances (u.n.o.)**

- Right: 30, 120, 400, 1000, 2000
- ± 0.3, ± 0.5, ± 1.0, ± 1.4

**Issue Remarks**

- Raw extrusion in accordance with OEM drawing and EN755-9

---

**Title:** EPDM Foam Rubber

---

**Scale:** 1:1  
**Date:** 21-06-2023

**Drawing no.:** 2000-07-3408  
**Issue:** A  
**Sheet:** 1 of 1

**Drawn:** MBMH  
**Checked:** PvT  
**Approved:** HS  
**Mass:** 0.00 kg  
**Dimensions in mm (u.n.o.)**

---

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info@vrr.aero  
+31 (0)10 479 8100
One-side adhesive
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Roller track end plate</td>
<td>53.5</td>
<td>28.3</td>
<td></td>
<td>2000-07-3475</td>
<td>Alu. 5754-H22</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- 400 1000 2000
- 1000 2000 >
- 7 30 120 400 1000 2000
- $g12 \, g1 \, g15 \, g18 \, g10 \, g14 \, g2$

**Tolerances (u.n.o.)**

- $< \, 7 \, 30 \, 120 \, 400 \, 1000 \, 2000 \, >$
- $g12 \, g1 \, g15 \, g18 \, g10 \, g14 \, g2$

*Raw extrusion in accordance with OEM drawing and EN755-9*

**Issue**

- 2000-07-3475

**Sheet:** 1 of 1

**Drawing no.:**

- A

**Issue:**

- A

**Dimensions in mm (u.n.o.)**

- 0.01 kg

**Finish:**

- A3

**Title:** Roller track end plate

---

This drawing is property of VRR which reserved all rights.
Welding according to procedure VRR-W3-090 except when indicated otherwise.

Note: place self adhesive rubber after welding (inside)

---

**Item** | **No.** | **QTY.** | **Description** | **Length** | **Width/ Dia.** | **Height/ Thickn.** | **Part Number** | **Material** | **Remarks**
--- | --- | --- | --- | --- | --- | --- | --- | --- | ---
8 | 6 | Nyloc Hex Nut | 10 M4 | BO-10511-04-A2 | AISI 304 | ISO10511/DIN985 | |
7 | 12 | Plain Washer Large | 12 M4 | BO-7093-04-A2 | AISI 304 | ISO7093/DIN9021 | |
6 | 6 | Torx Socket Button Screw | 25 M4 | BO-7380T-04025-A2 | AISI 304 | ISO7380 torx | |
5 | 1 | EPDM Foam Rubber | 15 30 10 | 2000-07-3408 | Celrub.(EPDM) (Self Adhesive) | |
4 | 1 | EPDM Foam Rubber | 15 30 10 | 2000-07-3409 | Celrub.(EPDM) (Self Adhesive) | |
3 | 1 | End stop block | 187.7 31 10 | 2000-07-3495 | HDPE (PE-HD) | Colour black | |
2 | 1 | Roller track end plate | 53.5 28.3 2 | 2000-07-3475 | Alu. 5754-H22 | |
1 | 1 | Roller track right | 1590 103.87 2 | 2000-07-2976 | Alu. 5754-H22 | Special bend radius | |

---

**Dimensions in mm (u.n.o.)**

| Size | Mass: | 0.96 kg |

---

**Finish: Roller track right assy**

---

**Note:** Welding according to procedure VRR-W3-090 except when indicated otherwise.
Note: make all three bends with a R5 punch and a V24 V-die.
1 | 1 | Guset | 299,8 | 165 | 3 | 2000-05-0386 | Alu. 5754-H22 | Bend with V30 |
---|---|---|---|---|---|---|---|---|
Item No. | QTY. | Description | Length | Width/Dia. | Height/Thickn. | Part Number | Material | Remarks |
---|---|---|---|---|---|---|---|---|
1 | 1 | | | | | | | |

**Dimensions in mm (u.n.o.)**
- Length: 299.8
- Width: 165
- Height: 3

**Tolerances (u.n.o.)**
- Mass: ±0.2 kg
- ±0.2 mm

**Issue**
- A

**Drawn:** JWR 04-04-2019
**Checked:** HS 12-04-2019
**Approved:** JWR 09-05-2019

**Dimensions in mm (u.n.o.)**
- Width: 165
- Height: 3
- Depth: 12.5

**Engraving**
- UP 90° R 5
- Raw extrusion in accordance with OEM drawing and EN755-9

**Title:** Gusset

---

Fax: +31 10 479 5478
Tel: +31 10 479 8100
3079 DN Rotterdam
The Netherlands
info@vrr-aviation.com
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Corner gusset</td>
<td>281.8</td>
<td>203</td>
<td>3</td>
<td>2000-05-0491</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

- Mass: 0.35 kg

Tolerances (u.n.o.):

- ±0.2
- ±0.3
- ±0.5
- ±0.8

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Corner gusset</td>
<td>433.8</td>
<td>203</td>
<td>3</td>
<td>2000-05-0480</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

Tolerances (u.n.o.)
- < 7 30 120 400 1000 2000
- ≥ 0.2 0.3 0.5 0.8

Mass: 0.49 kg

Finish: A

Dimensions in mm (u.n.o.)

This drawing is property of Van Riemtsdijk Rotterdam b.v. which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Front Corner gusset</td>
<td>281,8</td>
<td>203</td>
<td>3</td>
<td>2000-05-0496</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

- Mass: 0.35 kg
- Finish: A
- Sheet: 1 of 1

Tolerances (u.n.o.)

<table>
<thead>
<tr>
<th>Tolerance</th>
<th>Below</th>
<th>Up to</th>
<th>Above</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.2</td>
<td>0.3</td>
<td>0.5</td>
<td>0.8</td>
</tr>
</tbody>
</table>

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Engraving

150 
32  R5 
3 
175.8 
165 
28.9 
12.5  17.5 
15 
UP  90°  R 5 
Engraving

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Gusset</td>
<td>175.8</td>
<td>165</td>
<td>3</td>
<td>2000-05-1280</td>
<td>Alu. 5754-H22</td>
<td>Bend with V30</td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

Tolerances (u.n.o.)

Mass: 0.15 kg

Finish: Raw extrusion in accordance with OEM drawing and EN755-9

Sheet : 1 of 1

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
Item No. | QTY. | Description | Length | Width/Dia | Height/Thickn. | Part Number | Material | Remarks
--- | --- | --- | --- | --- | --- | --- | --- | ---
1 | 1 | Gusset | 178.8 | 165 | 3 | 2000-05-1279 | Alu. 5754-H22 | Bend with V30 Finish:

Dimensions in mm (u.n.o.)

Tolerances (u.n.o.)

Mass: 0.15 kg

2000-05-1279

Sheet: 1 of 1

Issue: A

Date: 04-04-2019

Drawing no.: 2000-05-1279

Checked: HS

Approved: JWR

09-05-2019

04-04-2019

09-05-2019

0.2 0.3 0.5 0.8

Dimensions in mm (u.n.o.)

Title: Gusset
**Title:** Rope profile

**Item:** 1304

**Description:** Rope profile

**Part Number:** 2000-05-1536

**Material:** Alu. 6060-T66

**Remarks:** Finish: U001 - Aludon

**Scale:** 1:4

**Date:** 04-04-2019

**Drawing no.:** 2000-05-1536

**Issue:** A

**Size:** A3

**Dimensions in mm (u.n.o.):**
- Mass: 0.53 kg
- Raw extrusion in accordance with OEM drawing and EN755-9

**Tolerances (u.n.o.):**
- < 7 30 120 400 1000 2000
- > 0.2 0.3 0.5 0.8

**Scale:**
- 1:4

**Drawing Information:**
- Drawn: JWR
- Checked: HS
- Approved: JWR
- 04-04-2019
- 12-04-2019
- 09-05-2019

**Finished: U001 - Aludon**

---

**Dimensions:**

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1304</td>
<td>1</td>
<td>Rope profile</td>
<td>6 x 160 = 960</td>
<td>7.5</td>
<td>6,8</td>
<td>0</td>
<td>21.5</td>
<td>101.5</td>
</tr>
<tr>
<td>Item No.</td>
<td>QTY.</td>
<td>Description</td>
<td>Length</td>
<td>Width/Dia</td>
<td>Height/Thickn.</td>
<td>Part Number</td>
<td>Material</td>
<td>Remarks</td>
</tr>
<tr>
<td>---------</td>
<td>------</td>
<td>-------------------</td>
<td>--------</td>
<td>-----------</td>
<td>----------------</td>
<td>-------------</td>
<td>----------</td>
<td>-----------------------------------</td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.):
- Length: 7,5
- Width/Dia: 6,8
- Height/Thickn.: 0
- 21,5
- 61,5
- 101,5
- 152,5
- 252,5
- 403,5
- 352,5
- 443,5
- 483,5

Tolerances (u.n.o.):
- ±0.2
- ±0.3
- ±0.5
- ±0.8

Mass: 0.20 kg

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1304
6 x 160 = 960

Rope profile

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Rope profile 1304</td>
<td>6,8</td>
<td>7,5</td>
<td>6 x 160 = 960</td>
<td>2000-05-1686</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)
- Raw extrusion in accordance with OEM drawing and EN755-9

Mass: 0.53 kg

Finish: U001 - Aludon

Issue: A
Tolerances (u.n.o.):
- < 7 30 120 400 1000 3000
- > 7 30 120 400 1000 3000
- ± 0.8 ± 0.6 ± 0.4 ± 0.2 ± 0.1 ± 0.05

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Fax: +31 10 479 5478

info@vrr-aviation.com

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>5</td>
<td>25</td>
<td>Bk.Rivet Klamp-Tite</td>
<td>4,8</td>
<td>4,8-9,5</td>
<td>Ø4,8</td>
<td>BK-BAPKTR-06W-06</td>
<td>Alu. w. Rub. washer</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>2</td>
<td>Fill plate cover</td>
<td>532,5</td>
<td>23</td>
<td>3</td>
<td>2000-05-2104</td>
<td>Alu. 5754-H22</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>2</td>
<td>Extrusion RR148</td>
<td>601,5</td>
<td>23/3,5</td>
<td>2,2</td>
<td>2000-05-1510</td>
<td>Alu. 6063-T66</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>Extrusion RR148</td>
<td>700</td>
<td>33,5</td>
<td>2,2</td>
<td>2000-05-1505</td>
<td>Alu. 6063-T66</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>Hose lock cover</td>
<td></td>
<td></td>
<td></td>
<td>2000-05-0509</td>
<td>Assembly</td>
<td></td>
</tr>
</tbody>
</table>

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
**Cover material according to specification VRR-SP1605**

**Sewing thread according to specification VRR-SP1607**

**Zipper part with Retaining box and Slider**

**Zipper part with Insert pin**

**Zipper elements (teeth) on this side**

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Dia</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>2</td>
<td>2</td>
<td>Zipper 10mm (White)</td>
<td>2000-05-1508</td>
<td>Zipper Trisco: Y10MM100</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>Stitched Cover Hose</td>
<td>2000-05-2225</td>
<td>Assembly</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Zipper elements (teeth) on this side**

**Zipper part with Retaining box and Slider**

**Zipper part with Insert pin**

**Front view**

**End zipper**

**Stitching points**

**End zipper**

**Zipper elements (teeth) on this side**

**Zipper part with Insert pin**

**Dimensions in mm (u.n.o.)**

<table>
<thead>
<tr>
<th>Mass:</th>
<th>0.75 kg</th>
</tr>
</thead>
</table>

**Title:** Hose lock cover

**Fax:** +31 10 479 5478

**Tel:** +31 10 479 8100

**3079 DN Rotterdam**

**The Netherlands**

**Projection**

**Drawn:** JWR

**Checked:** VvM

**Approved:** JWR

**Date:**

<table>
<thead>
<tr>
<th>Issue</th>
<th>Drawing no.</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>2000-05-2059</td>
</tr>
</tbody>
</table>

**Tolerances (u.n.o.)**

<table>
<thead>
<tr>
<th>Tolerances</th>
<th>Issue</th>
</tr>
</thead>
<tbody>
<tr>
<td>±0.1 mm</td>
<td>±0.2 mm</td>
</tr>
</tbody>
</table>

**Dimensions:**

<table>
<thead>
<tr>
<th>Mass:</th>
<th>0.75 kg</th>
</tr>
</thead>
</table>

**This drawing is property of Van Riemsdijk Rotterdam b.v. and reserved all rights.**
Make sure that zipper parts can not be taken apart.

Apply SabaContact 70T and fold cover.

SECTION A-A
SCALE 2 : 1

Hose lock cover

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Stitch pattern 5 mm from edge all around

Flip hems to coarse side of cover

Stitched Cover Hose

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
Flat pattern

Cover material according to specification VRR-SP1605

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Cover Hose lock</td>
<td>1917.5</td>
<td>751.8</td>
<td></td>
<td>2000-05-1500</td>
<td>PVC Cover</td>
<td>Color: Grey</td>
</tr>
</tbody>
</table>

Mass: 0.68 kg

Scale: 1:6

Drawing no.: 2000-05-1500

Issue: A

Sheet: 1 of 1

Dimensions in mm (u.n.o.)

Tolerances (u.n.o.):

<table>
<thead>
<tr>
<th>Tolerance</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>±0.2</td>
<td>±0.3</td>
</tr>
<tr>
<td>±0.5</td>
<td>±0.8</td>
</tr>
</tbody>
</table>

Finish: Grey

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Item No. | QTY. | Description | Length | Width/Dia | Height/Thickn. | Part Number | Material | Remarks
--- | --- | --- | --- | --- | --- | --- | --- | ---
1 | 1 | Extrusion RR148 | 700 | 23/3.5 | 2.2 | 2000-05-1505 | Alu. 6063-T66 | 

**Dimensions in mm (u.n.o.)**

- Mass: 0.11 kg
- Raw extrusion in accordance with OEM drawing and EN755-9
- Finish: U001 - Aludon
- Checked: VvM
- Approved: JWR
- Scale: 1:2

**Legend:**
- A - Issue
- 2000-05-1505 - Drawing no.: 1 of 1
- Dimensions in mm (u.n.o.)

**Projection:**

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- 3079 DN Rotterdam
- The Netherlands
- Tel.: +31 10 479 8100
- Fax: +31 10 479 5478

**Email:** info@vrr-aviation.com

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/ Dia</th>
<th>Height/ Thickness</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Extrusion RR148</td>
<td>601,5</td>
<td>23/3,5</td>
<td>2,2</td>
<td>2000-05-1510</td>
<td>Alu. 6063-T66</td>
<td></td>
</tr>
</tbody>
</table>

Finish: U001 - Aludon

Dimensions in mm (u.n.o.)

Mass: 0.09 kg

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### Fill plate cover

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Fill plate cover</td>
<td>532.5</td>
<td>23</td>
<td>5,2</td>
<td>18,5</td>
<td>34</td>
<td>11,5</td>
</tr>
</tbody>
</table>

**Tolerances (u.n.o.)**
- 400 1000 2000
- 0.2 0.3 0.5 0.8

**Dimensions in mm (u.n.o.)**
- 2000-05-2104

**Issue**
- Sheet: 1 of 1

**Material**
- Alu. 5754-H22

**Scale:** 1:2

**Drawn:** JWR 16-04-2019
**Checked:** VvM 18-04-2019
**Approved:** JWR 09-05-2019

**Mass:** 0.10 kg

**Finish:**

**Dimensions in mm (u.n.o.)**
- 34 120
- 30 7 0.2

**Projection**
- Sheet 1

**Title:** Fill plate cover

**Issue:** A

**Dimensions in mm:**
- 2000-05-2104

**Material:** Alu. 5754-H22

**Remarks:**
- Raw extrusion in accordance with OEM drawing and EN755-9
Stick Rubber 5 to Plug top 2 before fastening to Plug bottom 1

Torque load M6: 8.1 Nm

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>5</td>
<td>1</td>
<td>Celrubber 15x5</td>
<td>1231.5</td>
<td>15</td>
<td>5</td>
<td>2000-05-1467</td>
<td>Celrub.(EPDM)</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>4</td>
<td>Torx Socket Button Screw</td>
<td>M6</td>
<td>16</td>
<td>13.5</td>
<td>BO-7380T-06016-A2</td>
<td>AISI 304</td>
<td>ISO7380 torx</td>
</tr>
<tr>
<td>3</td>
<td>4</td>
<td>Nord-Lock Large Washer M6</td>
<td>Ø13.5</td>
<td>M6</td>
<td>2.0</td>
<td>BO-NORDLCK-06SP-A4</td>
<td>AISI 316L</td>
<td>Stainless steel</td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>Plug top</td>
<td>Ø40</td>
<td>4</td>
<td>2000-05-1464</td>
<td>POM-C</td>
<td>Color: White</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>Plug bottom</td>
<td>Ø410</td>
<td>20</td>
<td>2000-05-1463</td>
<td>POM-C</td>
<td>Color: white</td>
<td></td>
</tr>
</tbody>
</table>

Mass: 4.07 kg

Issue: A

Drawing no.: 2000-05-1465

Sheet: 1 of 1

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Plug bottom</td>
<td>Ø410</td>
<td>20</td>
<td>2000-05-1463</td>
<td>POM-C</td>
<td>Color: white</td>
<td></td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

- Mass: 3.30 kg

Tolerances (u.n.o.)

- ±0.2 mm on Ø410
- ±0.3 mm on Ø370
- ±0.5 mm on Ø120
- ±0.8 mm on Ø20

Finish: Raw extrusion in accordance with OEM drawing and EN755-9

Drawing no.: 2000-05-1463

Sheets: 1 of 1

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
<table>
<thead>
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<th>Item No.</th>
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<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Plug top</td>
<td>407</td>
<td>6,6</td>
<td>0</td>
<td>120</td>
<td>120</td>
<td>0</td>
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Scale: 1:3
Drawn: JWR 04-04-2019
Checked: HS 12-04-2019
Approved: JWR 09-05-2019
Mass: 0.72 kg

Title: Plug top

Issue: 2000-05-1464 A

Dimensions in mm (u.n.o.)
Mass: 0.72 kg

Fax: +31 10 479 5478
Tel: +31 10 479 8100
Email: info@vrr-aviation.com

Stolwijkstraat 57
3079 DN Rotterdam
The Netherlands
Fax:+31 10 479 5478

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
Adhesive side

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
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<th>Length</th>
<th>Width</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Celrubber 15x5</td>
<td>1231.5</td>
<td>15</td>
<td>5</td>
<td>2000-05-1467</td>
<td>Celrub. (EPDM)</td>
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Scale: 1:1
Date: 04-04-2019
Drawing no.: 2000-05-1467
Issue: A
Sheet: 1 of 1

Dimensions in mm (u.n.o.)
Mass: 0.01 kg

Sheet : 1 of 1

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Fill plate corner gusset</td>
<td>179.6</td>
<td>112</td>
<td>17</td>
<td>2000-05-1415</td>
<td>Alu. 5754-H22</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

<p>| | | | | | | | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
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<th></th>
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</thead>
<tbody>
<tr>
<td>400</td>
<td>1000</td>
<td>2000</td>
<td>1000</td>
<td>2000</td>
<td>&gt; 1.0</td>
<td>1.4</td>
<td>2</td>
</tr>
<tr>
<td>7</td>
<td>30</td>
<td>120</td>
<td>400</td>
<td>1000</td>
<td>2000</td>
<td>30</td>
<td>120</td>
</tr>
<tr>
<td>0.2</td>
<td>0.3</td>
<td>0.5</td>
<td>0.8</td>
<td>0.2</td>
<td>0.3</td>
<td>0.5</td>
<td>0.8</td>
</tr>
</tbody>
</table>

**Tolerances (u.n.o.)**

- Mass: 0.05 kg
- Drawn: JWR 04-04-2019
- Checked: HS 12-04-2019
- Approved: JWR 09-05-2019

**Finish:**

- Dimensions in mm (u.n.o.)
- This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
Title: Fill plate corner gusset

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>1</td>
<td>Fill plate corner gusset</td>
<td>155.2</td>
<td>112</td>
<td>2</td>
<td>2000-05-1416</td>
<td>Alu. 5754-H22</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

Drawn: JWR 04-04-2019
Checked: HS 12-04-2019
Approved: JWR 09-05-2019

Mass: 0.09 kg

Finish: Dimensions in mm (u.n.o.)

Tolerances (u.n.o.):
- < 7 30 120 400 1000 2000 4000 10000 20000
- ±0.2 ±0.3 ±0.5 ±0.8 ±1.0 ±1.4 ±2

Raw extrusion in accordance with OEM drawing and EN755-9
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Fill plate corner gusset</td>
<td>155,2</td>
<td>112</td>
<td>2000-05-1417</td>
<td>2</td>
<td>Alu. 5754-H22</td>
<td>Bend with V18</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Mass: 0.09 kg

**Tolerances (u.n.o.)**

<table>
<thead>
<tr>
<th>Tolerance</th>
<th>Value</th>
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</thead>
<tbody>
<tr>
<td>±</td>
<td>0.2</td>
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<tr>
<td>±</td>
<td>0.3</td>
</tr>
<tr>
<td>±</td>
<td>0.5</td>
</tr>
<tr>
<td>±</td>
<td>0.8</td>
</tr>
</tbody>
</table>

**Issue**

- Drawing no.: 2000-05-1417

- Sheet: 1 of 1

**Drawn:** JWR 04-04-2019

- Checked: HS 12-04-2019

- Approved: JWR 09-05-2019

**Finish:** Dimensions in mm (u.n.o.)

**Title:** Fill plate corner gusset

---

**Stamp:**

<table>
<thead>
<tr>
<th>Symbol</th>
<th>Information</th>
</tr>
</thead>
<tbody>
<tr>
<td>VRR</td>
<td>Air Cargo Equipment</td>
</tr>
<tr>
<td>Stolwijkstraat 57</td>
<td>3079 DN Rotterdam, The Netherlands</td>
</tr>
<tr>
<td>Tel: +31 10 479 8100</td>
<td>Fax: +31 10 479 5478</td>
</tr>
<tr>
<td><a href="mailto:info@vrr-aviation.com">info@vrr-aviation.com</a></td>
<td>A3</td>
</tr>
</tbody>
</table>

**Note:** This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Fill strip</td>
<td>270</td>
<td>22</td>
<td>3</td>
<td>2000-05-1541</td>
<td>Alu. 5754-H22</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**
- Mass: 0.05 kg
- 0.2 0.3 0.5 0.8

**Tolerances (u.n.o.)**
- ± 7 30 120 400 1000 2000
- ±0.2 0.3 0.5 0.8 ±0.0.8 ±0.1

**Issue**
- 2000-05-1541 Sheet: 1 of 1

**Material**
- Alu. 5754-H22

**Remarks**
- Raw extrusion in accordance with OEM drawing and EN755-9
<table>
<thead>
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<th>Item No.</th>
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<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Fill strip</td>
<td>1185</td>
<td>22</td>
<td>3</td>
<td>2000-05-1540</td>
<td>Alu. 5754-H22</td>
<td></td>
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</table>

**Scale:** 1:4  
**Date:** 04-04-2019  
**Drawing no.:** 2000-05-1540  
**Issue:** A  
**Dimensions in mm (u.n.o.)**

- Length: 400, 1000, 2000  
- Width: 7, 30, 120  
- Height: 30, 120  
- Diameter: 1.0, 1.4

**Tolerances (u.n.o.)**

- Length: ±0.2, ±0.3, ±0.5, ±0.8
- Width: ±0.2, ±0.3, ±0.5, ±0.8
- Height: ±0.2, ±0.3, ±0.5, ±0.8
- Diameter: ±0.2, ±0.3, ±0.5, ±0.8

**Mass:** 0.21 kg

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
Adjust guiding block on door 2 such that door 3 locks vertically, then tighten the bolts of guiding block.

Use torque load M6: 8.1 Nm

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>INNO-SEAL White</td>
<td>290 ml</td>
<td></td>
<td>LI-INNO.SEAL-WIT</td>
<td>Kit</td>
<td></td>
</tr>
<tr>
<td>11</td>
<td>12</td>
<td>Bk.St. Monobolt 4,8</td>
<td>6,4</td>
<td>1,6-11</td>
<td>BK-02771-00012</td>
<td>Steel (MGLP-R6-10)</td>
<td></td>
</tr>
<tr>
<td>10</td>
<td>2</td>
<td>Bk.St. Monobolt 6,4</td>
<td>8,4</td>
<td>2,0-15</td>
<td>BK-02771-00011</td>
<td>Steel (MGLP-R8-10)</td>
<td></td>
</tr>
<tr>
<td>9</td>
<td>12</td>
<td>Hex. Head Screw</td>
<td>M6</td>
<td></td>
<td>BO-4017-06019-A2</td>
<td>AISI 304</td>
<td>ISO4017/DIN933</td>
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<tr>
<td>8</td>
<td>12</td>
<td>Nord-Lock Large Washer M6</td>
<td>ø13,5</td>
<td>M6</td>
<td>BO-NORDLCK-06SP</td>
<td>245 SMO</td>
<td>SMO</td>
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<tr>
<td>7</td>
<td>1</td>
<td>D-Ring 25mm</td>
<td>44</td>
<td>67</td>
<td>2455-VRR-DRNG1</td>
<td>MGLP-32000</td>
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<tr>
<td>6</td>
<td>1</td>
<td>Net Brassier (B8S)</td>
<td>80</td>
<td>67.3</td>
<td>0107-03016</td>
<td>AISI 304</td>
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<td>1</td>
<td>Hinge</td>
<td>2500-05-2212</td>
<td></td>
<td>Assembly</td>
<td></td>
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<tr>
<td>4</td>
<td>4</td>
<td>Door hinge 214S</td>
<td>214S</td>
<td></td>
<td>Assembly</td>
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<tr>
<td>3</td>
<td>1</td>
<td>DBJ BSF M6</td>
<td>2000-05-2419</td>
<td></td>
<td>Assembly</td>
<td></td>
<td></td>
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<tr>
<td>2</td>
<td>1</td>
<td>MIC door left</td>
<td>2000-05-2450</td>
<td></td>
<td>Assembly</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>1</td>
<td>DBJ door 1</td>
<td>2000-05-2411</td>
<td></td>
<td>Assembly</td>
<td></td>
<td></td>
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<tr>
<td>12</td>
<td>1</td>
<td>DBJ door left</td>
<td>2000-05-3478</td>
<td></td>
<td>Assembly</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

This drawing is property of VRR which reserved all rights.
Sealant Instructions

Use INNO-SEAL White

DETAIL E

SCALE 1 : 3

4
1

NOTE: Apply sealant (dashed line) before attaching 4 to 1

Sealant Instructions

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
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<th>Height/Thickn.</th>
<th>Part Number</th>
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<th>Remarks</th>
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<tbody>
<tr>
<td>12</td>
<td>1</td>
<td>INNO-SEAL White</td>
<td>290 ml</td>
<td>LI-INNO.SEAL-WIT Kit</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>11</td>
<td>36</td>
<td>Bk.St. Monobolt 4,8</td>
<td>1,6-11,1 Ø4,8 BK-02771-00617 Steel (MGLP-R6-7)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>10</td>
<td>2</td>
<td>Bk.St. Monobolt 6,4</td>
<td>2,0-15,9 Ø6,4 BK-02771-00824 Steel (MGLP-R8-10)</td>
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<tr>
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<td>12</td>
<td>Nord-Lock Large Washer M6 ø13,5 M6 2,0 BO-NORDLCK-06SP-SMO 245 SMO SMO</td>
<td></td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>7</td>
<td>1</td>
<td>D-Ring 25mm 44</td>
<td>37 ZN-VRR-DRNG2 St52 min.2250daN</td>
<td></td>
<td></td>
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<td></td>
<td></td>
</tr>
<tr>
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<td>1</td>
<td>Net Bracket (SS) 60</td>
<td>67.3 20 RR7.720.085 AISI 304</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>5</td>
<td>4</td>
<td>Hinge 214S</td>
<td>214S SL-NJ214S Assembly</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>1</td>
<td>DBJ Door Left</td>
<td></td>
<td>2000-07-3478 Assembly</td>
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<td></td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>DBJ Door</td>
<td></td>
<td>2000-05-0511 Assembly</td>
<td></td>
<td></td>
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<tr>
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<td>1</td>
<td>DBJ Door Right</td>
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<td>2000-05-0520 Assembly</td>
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<td></td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

Mass: 57.12 kg

Title: DBJ Door Left

Finish:

Preparation: VRR

Sheet: 2 of 2

2000-07-3478

Drawing no.

Issue

Scale: 1:7

Drawn: MBMH

Checked: PvT

Approved: HS

Issue

28-06-2023

31-07-2023

08-08-2023

Dimensions in mm (A.N.S.I.)

Mass: 57.12 kg

Title: DBJ Door Left

Finish:

Preparation: MBMH

Sheet: 2 of 2

2000-07-3478

Drawing no.

Issue

Scale: 1:7

Drawn: MBMH

Checked: PvT

Approved: HS

Issue

28-06-2023

31-07-2023

08-08-2023

Dimensions in mm (A.N.S.I.)

Mass: 57.12 kg

Title: DBJ Door Left

Finish:

Preparation: MBMH

Sheet: 2 of 2

2000-07-3478

Drawing no.

Issue

Scale: 1:7

Drawn: MBMH

Checked: PvT

Approved: HS

Issue

28-06-2023

31-07-2023

08-08-2023

Dimensions in mm (A.N.S.I.)

Mass: 57.12 kg

Title: DBJ Door Left

Finish:

Preparation: MBMH

Sheet: 2 of 2

2000-07-3478

Drawing no.

Issue

Scale: 1:7

Drawn: MBMH

Checked: PvT

Approved: HS

Issue

28-06-2023

31-07-2023

08-08-2023

Dimensions in mm (A.N.S.I.)

Mass: 57.12 kg

Title: DBJ Door Left

Finish:

Preparation: MBMH

Sheet: 2 of 2

2000-07-3478

Drawing no.

Issue

Scale: 1:7

Drawn: MBMH

Checked: PvT

Approved: HS

Issue

28-06-2023

31-07-2023

08-08-2023

Dimensions in mm (A.N.S.I.)

Mass: 57.12 kg

Title: DBJ Door Left

Finish:

Preparation: MBMH

Sheet: 2 of 2

2000-07-3478

Drawing no.

Issue

Scale: 1:7

Drawn: MBMH

Checked: PvT

Approved: HS

Issue

28-06-2023

31-07-2023

08-08-2023

Dimensions in mm (A.N.S.I.)

Mass: 57.12 kg

Title: DBJ Door Left

Finish:

Preparation: MBMH

Sheet: 2 of 2

2000-07-3478

Drawing no.

Issue

Scale: 1:7

Drawn: MBMH

Checked: PvT

Approved: HS

Issue

28-06-2023

31-07-2023

08-08-2023

Dimensions in mm (A.N.S.I.)

Mass: 57.12 kg

Title: DBJ Door Left

Finish:
Welding according to procedure VRR-W3-090 except when indicated otherwise

Placement door lock
- Fasten tubes 7 with monobolt 10
- Check if door lock functions correctly in container
- If door lock works correctly, weld tubes 7 to door handle 3 on inside

Place WHITE INNO SEAL on 2, 3, 4 and 5 before placing on 1
Remove excess sealant
Note that the sealant has a dry time of 2 hours.

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>9</td>
<td>14</td>
<td>Bk. St. Monobolt 4,8</td>
<td>4,8</td>
<td>Ø4,8</td>
<td>2000-05-1127</td>
<td>Steel (MGLP-R6-4)</td>
<td></td>
</tr>
<tr>
<td>9</td>
<td>12</td>
<td>Bk. Rivet Klamp-Tite 4,8</td>
<td>4,8</td>
<td>Ø4,8</td>
<td>2000-00-56W-04</td>
<td>Alu. w. Rub. washer</td>
<td></td>
</tr>
<tr>
<td>8</td>
<td>1</td>
<td>Internal Door Lock</td>
<td>150,4</td>
<td>150,4</td>
<td>2000-00-5277</td>
<td>AISI 1020</td>
<td>RHIWA-1202530</td>
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<tr>
<td>7</td>
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Place WHITE INNO SEAL on ②, ③, ④ and ⑤ before placing on ①
Remove excess sealant
Note that the sealant has a dry time of 2 hours.

Welding according to procedure VRR-W3-090 except when indicated otherwise
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<th>QTY.</th>
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<th>Length</th>
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<th>Height/Thickn.</th>
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<th>Material</th>
<th>Remarks</th>
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**Title:** DBJ panel door

**Dimensions in mm (u.n.o.)**

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<th>Finish</th>
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**Issue Drawing no.:** 2000-05-0512

**Scale:** 1:2

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**Title:** DBJ panel door

**Dimensions in mm**

**Mass:** 7.77 kg

**Drawing no.:** 2000-05-0512

**Issue:** B

**Sheet:** 2 of 2

**Date:** 10-03-2020

**Drawing:**

1. DBJ panel door
2. Raw extrusion in accordance with OEM drawing and EN755-9

**Contact:**

vrr.aero
info@vrr.aero
+31 (0)10 479 8100

This drawing is property of VRR which reserved all rights.
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<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
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<th>Length</th>
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**Dimensions in mm (u.n.o.)**

- Mass: 2.66 kg
- Tolerances (u.n.o.):
  - ±0.2
  - ±0.3
  - ±0.5
  - ±0.8

**Specifications**

- This drawing is property of VRR which reserved all rights.
- Dimensions in accordance with OEM drawing and EN755-9
- Raw extrusion in accordance with OEM drawing and EN755-9
- Finish: B

**Contact Information**

- Stolwijkstraat 57
- 3079 DN Rotterdam
- The Netherlands
- VRR
- info@vrr.aero
- +31 (0)10 479 8100
<table>
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Dimensions in mm (u.n.o.)

- Mass: 0.10 kg

Tolerances (u.n.o.)

- Raw extrusion in accordance with OEM drawing and EN755-9

Issue B

Sheet: 1 of 1

Drawn: PvT 21-07-2017
Checked: JWR 21-09-2017
Approved: WvdV 21-09-2017
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**Dimensions in mm (u.n.o.)**

- Length: 7-30-120-400-2000
- Width/Dia: >7
- Height/Thickn.: 0.2-0.3-0.5-0.8

**Tolerances (u.n.o.)**

- Length: ±0.15
- Width/Dia: ±0.15
- Height/Thickn.: ±0.08

**Mass:** 0.04 kg

**Issue:** B

**Drawing no.:** 2000-04-1388

Sheet: 1 of 1

**Title:** Lock insert

*This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights*
<table>
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<td>4</td>
<td>2000-04-1389</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

- **Issue**: B
- **Drawing no.**: 2000-04-1389
- **Sheet**: 1 of 1
- **Dimensions in mm**:
  - Length: 400, 1000, 2000
  - Width/Dia: 1000, 2000
  - Height/Thickn.: > 7, 30, 120
- **Tolerances** (u.n.o.):
  - Length: ± 0.2, 0.3, 0.5, 0.8
  - Width/Dia: ± 0.2, 0.3, 0.5, 0.8
  - Height/Thickn.: ± 0.2, 0.3, 0.5, 0.8

**Title**: Lock insert

**Dimensions**:

- **A3**
- **Projection**: Scale: 1:1

**Drawn**: PvT 21-07-2017
**Checked**: JWR 21-09-2017
**Approved**: WvdV 21-09-2017

**Mass**: 0.01 kg

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
<td>1</td>
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<td>Reinforcement sheet</td>
<td>170</td>
<td>80</td>
<td>8</td>
<td>2000-05-1344</td>
<td>Alu. 6082-T6</td>
<td></td>
</tr>
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</table>

**Dimensions in mm (u.n.o.)**
- Mass: 0.29 kg
- Tolerances (u.n.o.):
  - ± 7 30 120 400 1000 2000 3000 4000 5000 6000 7000 8000 9000 10000
  - ± 0.2 ± 0.3 ± 0.5 ± 0.8

**Issue**
- Sheet: 1 of 1

**Dimensions in mm (u.n.o.)**
- Raw extrusion in accordance with OEM drawing and EN755-9

**Title:** Reinforcement sheet

**Scale:** 1:1
**Date:** 21-02-2019
**Drawing no.:** 2000-05-1344
**Issue:** A

**Finished:**

**Dimensions in mm (u.n.o.):**
- ± 7 30 120 400 1000 2000 3000 4000 5000 6000 7000 8000 9000 10000
- ± 0.2 ± 0.3 ± 0.5 ± 0.8

**Mass:** 0.29 kg

**Dimensions in mm (u.n.o.):**
- Raw extrusion in accordance with OEM drawing and EN755-9

**Title:** Reinforcement sheet

- **Issue:** A
- **Sheet:** 1 of 1
- **Dimensions in mm (u.n.o.):**
  - ± 7 30 120 400 1000 2000 3000 4000 5000 6000 7000 8000 9000 10000
  - ± 0.2 ± 0.3 ± 0.5 ± 0.8

**Mass:** 0.29 kg
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Tube (30x30x2)</td>
<td>955.3</td>
<td>30/30</td>
<td>2</td>
<td>2000-05-0929</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.):
- Length: 400
- Width/Dia: 1000
- Height/Thickn.: 
  - 7
  - 30
  - 120
  - 400
  - 1000
  - 2000
  - 0.2
  - 0.3
  - 0.5
  - 0.8

Tolerances (u.n.o.):
- Raw extrusion in accordance with OEM drawing and EN755-9

Mass: 0.57 kg

Issue: 2000-05-0929

Sheet: 1 of 1

Dimensions in mm (u.n.o.)

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Tel: +31 10 479 8100
3079 DN Rotterdam
The Netherlands
info@vrr-aviation.com

A3

Projection

Size

Iss. Changes Date Name

Item No. Title
Tube (30x30x2)

Scale 1:1

Finish: Dimensions in mm (u.n.o.)
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Tube 40x20x2</td>
<td>29</td>
<td>40/20</td>
<td>2</td>
<td>2000-05-2106</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

Mass: 0.02 kg

Tolerances (u.n.o.)

Raw extrusion in accordance with OEM drawing and EN755-9

Issue 2000-05-2106 A

Sheet: 1 of 1

Finish:

Dimensions in mm (u.n.o.)

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
Title: Sheet; door frame

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/ Dia</th>
<th>Height/ Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>551.5</td>
<td>153.4</td>
<td>1.5</td>
<td>2000-05-0446</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

Scale: 1:2

Date: 25-03-2019

Drawing no.: 2000-05-0446

Issue: B

Tolerances (u.n.o.):

Sheet: 1 of 1

Dimensions in mm (u.n.o.)

Mass: 0.90 kg

Finish:

Dimensions in mm (u.n.o.)

Material: AISI 304

Remarks: Bend with V16

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The Netherlands
vrr.aero
info@vrr.aero
+31 (0)10 479 8100

Flat pattern corrected - 26-11-2019

HS

Projection

Size A3

This drawing is property of VRR which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
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<th>Length</th>
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<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>551.5</td>
<td>153.4</td>
<td>1.5</td>
<td>2000-05-1367</td>
<td>AISI 304</td>
<td>Bend with V16</td>
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</table>

**Scale:** 1:2  
**Date:** 25-03-2019  
**Drawn:** HS  
**Checked:** VvM  
**Approved:** JWR  
**Mass:** 0.90 kg  
**Finish:** B  
**Issue:** 2000-05-1367  
**Date:** 26-11-2019  
**Drawn:** HS  
**Checked:** VvM  
**Approved:** JWR  

**Dimensions in mm (u.n.o.)**

- Width: 1000, 2000  
- Height: > 1.0, < 0.2  
- Thickness: 0.3, 0.5, 0.8  
- Projection: > 7, > 0.5  
- Raw extrusion in accordance with OEM drawing and EN755-9

**Tolerances (u.n.o.)**

- Flat pattern corrected

---

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
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<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>2039</td>
<td>153.4</td>
<td>1.5</td>
<td>2000-05-1257</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

Mass: 3.64 kg

Finish:

Title:
Sheet; door frame

Dimensions in mm (u.n.o.)

Mass: 3.64 kg

Finish:

Title:
Sheet; door frame

Dimensions in mm (u.n.o.)

Mass: 3.64 kg

Finish:

Title:
Sheet; door frame

Dimensions in mm (u.n.o.)

Mass: 3.64 kg

Finish:

Title:
Sheet; door frame

Dimensions in mm (u.n.o.)

Mass: 3.64 kg

Finish:
<table>
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<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>1</td>
<td>Center block</td>
<td>25.8</td>
<td>26.2</td>
<td>10</td>
<td>2000-00-5783</td>
<td>Alu. 6082-T6</td>
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</table>

**Dimensions in mm (u.n.o.)**

<table>
<thead>
<tr>
<th>Mass</th>
<th>0.01 kg</th>
</tr>
</thead>
</table>

**Tolerances (u.n.o.)**

- 7 30 120 400 1000 2000
- g12 g11 g10 g9 g8 g7 g6 g5 g4 g3 g2

- Raw extrusion in accordance with OEM drawing and EN755-9

**Issue**

- B
- Sheet: 1 of 1

**Drawing no.:**

- 2000-00-5783

**Scale:**

- 3:1

**Date:**

- Drawn: 27-9-2012
- Checked: 15-04-2022
- Approved: 19-04-2022

**Finish:**

- B

**B - Tab. + Radius**

**Projection**

**Size:**

- A3

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<table>
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<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
<td></td>
<td>1</td>
<td>Tube 16x2</td>
<td>1019.5</td>
<td>16</td>
<td>2</td>
<td>2000-05-1421</td>
<td>AISI 304</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Raw extrusion in accordance with OEM drawing and EN755-9

**Mass:** 0.72 kg

**Drawing no.:** 2000-05-1421

**Issue:** A

**Sheet:** 1 of 1

**Title:** Tube 16x2

**Finish:**

**Dimensions in mm (u.n.o.)**

- 7 30 120 400 1000 2000
- ±0.2 ±0.3 ±0.5 ±0.8 ±0.1 ±0.14 ±0.2

**Tolerances (u.n.o.):**
Place WHITE INNO SEAL on 2, 3, 4, 5, 6, 7, 8, 9, 10, 11 before placing on 11.
Remove excess sealant

Note that the sealant has a drying time of 2 hours.

Make sure to rivet L-Extrusion 16 to Sheet 3 before putting it on the insulation panel (applies to both top and bottom corner)
Remove excess sealant

Note that the sealant has a drying time of 2 hours.

Place WHITE INNO SEAL on 2 3 4 5 6 7 8 9 10 11 before placing on 1

No rivets in these areas.
(tobe used for hinge later on)

Tighten Screw 26 after assembling total door and adjusting the position of Guide 13

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>24</td>
<td>3</td>
<td>Hex. Socket Cap Screw</td>
<td>M4</td>
<td></td>
<td>BO-19842-04022-A2</td>
<td>AISI 304</td>
<td>ISO10642/DIN7991</td>
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<tr>
<td>22</td>
<td>6</td>
<td>Bk. Male Nut 6,8</td>
<td>M4</td>
<td>8 15</td>
<td>BK-0277100617</td>
<td>Steel</td>
<td>EN14399-2/1104</td>
</tr>
<tr>
<td>20</td>
<td>6</td>
<td>Hex. Socket Head Screw</td>
<td>M6</td>
<td>10 12</td>
<td>BO-19842-04016-A2</td>
<td>AISI 304</td>
<td>ISO4762/DIN912</td>
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<tr>
<td>18</td>
<td>10</td>
<td>Bk. Rivet Klamp-Tite 4,8 1,6-6,3 Ø4,8</td>
<td>BK-BAPKTR06W04</td>
<td>Alu.</td>
<td>w. Rub. washer</td>
<td></td>
<td></td>
</tr>
<tr>
<td>16</td>
<td>1</td>
<td>Bk. Monobolt 4,8 1,6-11 Ø4,8</td>
<td>BK-0277100617</td>
<td>Steel</td>
<td>(MGLP-R6-7)</td>
<td></td>
<td></td>
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<tr>
<td>14</td>
<td>4</td>
<td>Rubber L-extrusion 51 25/15 3 2000-05-132</td>
<td>suraSil FR60</td>
<td></td>
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<tr>
<td>13</td>
<td>2</td>
<td>Extrusion Door (Rubber) 65</td>
<td>2000-05-1243</td>
<td>suraSil FR60</td>
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<tr>
<td>12</td>
<td>1</td>
<td>Extrusion Door (Rubber) 65</td>
<td>2000-05-1243</td>
<td>suraSil FR60</td>
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<tr>
<td>11</td>
<td>2</td>
<td>Extrusion Door (Rubber) 65</td>
<td>2000-05-1243</td>
<td>suraSil FR60</td>
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<tr>
<td>10</td>
<td>4</td>
<td>Steel Blind rivet nut M4 HT 0,5-2,0 Ø6,75 10,7</td>
<td>BO-ALS3T47020</td>
<td>Steel 1010</td>
<td>Onkh 080320</td>
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</tr>
<tr>
<td>9</td>
<td>4</td>
<td>Steel Cap Screw 16 M4</td>
<td>BO-4762-04016-A2</td>
<td>AISI 304</td>
<td>ISO4762/DIN912</td>
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<td>8</td>
<td>1</td>
<td>Rubber L-extrusion 698 65,4 1,5</td>
<td>2000-05-0525</td>
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<tr>
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<td>1</td>
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<tr>
<td>6</td>
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<td>Sheet; door frame 639,8 153,4 1,5</td>
<td>2000-05-1071</td>
<td>AISI 304</td>
<td></td>
<td></td>
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<tr>
<td>5</td>
<td>1</td>
<td>Sheet; door frame 639,8 153,4 1,5</td>
<td>2000-05-1071</td>
<td>AISI 304</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>1</td>
<td>Sheet; door frame 639,8 153,3 1,5</td>
<td>2000-05-1071</td>
<td>AISI 304</td>
<td></td>
<td></td>
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<tr>
<td>3</td>
<td>1</td>
<td>Sheet; door frame 639,8 153,4 1,5</td>
<td>2000-05-1071</td>
<td>AISI 304</td>
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<td></td>
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</tr>
<tr>
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<td>1</td>
<td>Sheet; door frame 639,8 153,4 1,5</td>
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<td>AISI 304</td>
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<tr>
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<td>2000-05-1071</td>
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Finish:
Project
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<th>Width/ Dia.</th>
<th>Height/ Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
<td>5</td>
<td>1</td>
<td>Tube 20x20x2</td>
<td>2000-04-8840</td>
<td>Alu. 6060-T6</td>
<td>6060-T6</td>
<td></td>
<td></td>
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<tr>
<td>4</td>
<td>2</td>
<td>Reinforcement sheet</td>
<td>2000-05-1209</td>
<td>Alu. 6082-T6</td>
<td>6082-T6</td>
<td></td>
<td></td>
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<tr>
<td>3</td>
<td>1</td>
<td>Outer sheet</td>
<td>2000-05-1208</td>
<td>PE-GEGW 0,8</td>
<td>0,8 NF</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>Insulation</td>
<td>2000-05-1209</td>
<td>RTM-X</td>
<td></td>
<td></td>
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<tr>
<td>1</td>
<td>1</td>
<td>Inner Sheet</td>
<td>2000-05-1207</td>
<td>PE-GEGW 0,8</td>
<td>0,8 NF</td>
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Finish: Projection

Name: B

Issue: 1 of 2

Dimensions in mm (±0.5)
<table>
<thead>
<tr>
<th>No.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
<td>5</td>
<td>Tube 20x20x2</td>
<td>29</td>
<td>20/20</td>
<td>2</td>
<td>2000-04-8840</td>
<td>Alu. 6060-T6</td>
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</tr>
<tr>
<td>4</td>
<td>Reinforcement sheet</td>
<td>4</td>
<td>69,5</td>
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<td>3</td>
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<td>2234,5</td>
<td>194,5</td>
<td>1,8</td>
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<td>PE-GEGW 0,8 HF</td>
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<tr>
<td>2</td>
<td>Insulation</td>
<td>2234,5</td>
<td>724,8</td>
<td>60,4</td>
<td>2000-05-1209</td>
<td>RTM X30</td>
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<tr>
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<td>1946,5</td>
<td>200,8</td>
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Mass: 1.94 kg

Finish: Projection

Drawing no.: 2000-05-0521

Issue: B

Sheet: 1 of 2

Dimensions in mm (u.n.o.)

DBJ panel door

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
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<tbody>
<tr>
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<td>1</td>
<td>Insulation</td>
<td>2034.5</td>
<td>724.8</td>
<td>60.4</td>
<td>2000-05-1209</td>
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**Material:** RTM-X

**Remarks:**
- **Issue:** B
- **Date:** 28-03-2019
- **Drawing no.:** 2000-05-1209
- **Approved:** JWR
- **Checked:** VvM
- **Drawn:** HS

**Tolerances (u.n.o.):**
- 7 30 120 400 1000 2000
- 0.2 0.3 0.5 0.8

**Dimensions in mm (u.n.o.):**
- 0.2 0.3 0.5 0.8

**Mass:** 0.93 kg

**Finish:**

**Title:** Insulation

**Issue:** B

**Dimensions:**
- SECTION A-A
- SCALE 1 : 5

**Drawn:** HS

**Checked:** VvM

**Approved:** JWR

**Mass:** 0.93 kg

**Finish:**

**Title:** Insulation

**Issue:** B

**Dimensions:**
- SCALE 1 : 5

**Drawn:** HS

**Checked:** VvM

**Approved:** JWR

**Mass:** 0.93 kg

**Finish:**

**Title:** Insulation

**Issue:** B

**Dimensions:**
- SCALE 1 : 5

**Drawn:** HS

**Checked:** VvM

**Approved:** JWR

**Mass:** 0.93 kg

**Finish:**

**Title:** Insulation

**Issue:** B

**Dimensions:**
- SCALE 1 : 5

**Drawn:** HS

**Checked:** VvM

**Approved:** JWR

**Mass:** 0.93 kg

**Finish:**

**Title:** Insulation

**Issue:** B

**Dimensions:**
- SCALE 1 : 5

**Drawn:** HS

**Checked:** VvM

**Approved:** JWR

**Mass:** 0.93 kg

**Finish:**

**Title:** Insulation

**Issue:** B

**Dimensions:**
- SCALE 1 : 5

**Drawn:** HS

**Checked:** VvM

**Approved:** JWR

**Mass:** 0.93 kg

**Finish:**
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Outer sheet</td>
<td>2034.5</td>
<td>684.8</td>
<td>0.8</td>
<td>2000-05-1208</td>
<td>PE-GEGW 0.8 NF</td>
<td>0.8 NF</td>
</tr>
</tbody>
</table>

**Sizes**

- Dimensions in mm (u.n.o.)
- Mass: 0.59 kg

**Tolerances (u.n.o.)**

<table>
<thead>
<tr>
<th>400</th>
<th>1000</th>
<th>2000</th>
<th>&gt;1000</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.0</td>
<td>1.4</td>
<td>2</td>
<td>2</td>
</tr>
<tr>
<td>20</td>
<td>30</td>
<td>120</td>
<td>30</td>
</tr>
</tbody>
</table>

**Finished Product**

- Raw extrusion in accordance with OEM drawing and EN755-9

**Drawn:** HS  
**Checked:** VvM  
**Approved:** JWR  
**Date:** 28-03-2019  
**Drawing no.:** 2000-05-1208  
**Sheet:** 1 of 1  

**Issue A**

**Dimensions in mm (u.n.o.)**

<table>
<thead>
<tr>
<th>400</th>
<th>1000</th>
<th>2000</th>
<th>&gt;1000</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.0</td>
<td>1.4</td>
<td>2</td>
<td>2</td>
</tr>
<tr>
<td>20</td>
<td>30</td>
<td>120</td>
<td>30</td>
</tr>
</tbody>
</table>

**Mass:** 0.59 kg

**Finish:**
Engraving 4

Item No. | QTY. | Description | Length | Width/Dia | Height/Thickn. | Part Number | Material | Remarks
---|---|---|---|---|---|---|---|---
1 | 1 | Reinforcement sheet | 100 | 69.5 | 4 | 2000-05-1206 | Alu. 6082-T6 |

Finish:

Fax: +31 10 479 5478  
Tel: +31 10 479 8100  
3079 DN Rotterdam  
The Netherlands  
info@vrr-aviation.com  

Dimensions in mm (u.n.o.)

Mass: 0.08 kg

Tolerances (u.n.o.)

Sheet : 1 of 1  

Title: Reinforcement sheet  

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Tube 20x20x2</td>
<td>29</td>
<td>20</td>
<td>2</td>
<td>2000-04-8840</td>
<td>Alu. 6060-T66</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.):**
- 400 1000 2000
- 1.0 1.4 2

**Tolerances (u.n.o.):**
- 7 30 120 400 1000 2000
- ±0.2 ±0.3 ±0.5 ±0.8

**Mass:** 0.01 kg

**Finish:**

**Issue:** 2000-04-8840

**Sheet:** 1 of 1

**Drawing no.:**

**Dimensions in mm (u.n.o.):**

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**Item No.** | **QTY.** | **Description** | **Length** | **Width/Dia** | **Height/Thickn.** | **Part Number** | **Material** | **Remarks**
--- | --- | --- | --- | --- | --- | --- | --- | ---
1 | 1 | Sheet; door frame | 729.3 | 153.4 | 1.5 | 2000-05-0522 | AISI 304 | Bend with V16

**Dimensions in mm (u.n.o.)**
- Mass: 1.21 kg

**Tolerances (u.n.o.)**
- \( \pm 0.2 \)
- \( \pm 0.3 \)
- \( \pm 0.5 \)
- \( \pm 0.8 \)

**Scale:** 1:3  
**Date:** 27-03-2019
**Drawing no.:** 2000-05-0522

**Issue:** A  
**Sheet:** 1 of 1

**Dimensions in mm (u.n.o.)**
- Sheet; door frame

**Dimensions:**
- 729.3
- 31.4
- 80
- 25.1
- 16.3
- 153.4
- 70.5
- 26.5
- 65
- 1,5

---

**This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights**
Sheet; door frame

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>2039</td>
<td>65.7</td>
<td>1.5</td>
<td>2000-05-1433</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

Scale: 1:1

Mass: 1.59 kg

Finish: 

Dimensions in mm (u.n.o.)

Flat pattern corrected

Raw extrusion in accordance with OEM drawing and EN755-9

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info@vrr.aero
+31 (0)10 479 8100
**Sheet; door frame**

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>102.2</td>
<td>64.9</td>
<td>1.5</td>
<td>2000-05-0523</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Scale:** 1:1

**Drawing no.:** 2000-05-0523

**Issue:** A

**Date:** 18-04-2019

**Mass:** 0.05 kg

**Dimensions in mm (u.n.o.)**

- \(< 7\)
- 30
- 120
- 400
- 1000
- 2000

- \(\geq 7\)
- 30
- 120
- 400
- 1000
- 2000

**Tolerances (u.n.o.)**

- ±0.2
- ±0.3
- ±0.5
- ±0.8

**Title:** Sheet; door frame

**Date:** 27-03-2019

**Checked:** VvM

**Approved:** JWR

**Drawn:** HS

**Dimensions:**

- Width: 16.5 mm
- Height: 75 mm
- Thickness: 1.5 mm
- Diameter: 5.5 mm

**Engraving:**

- Down 90° R 2.5

**Finish:**

- Mass: 0.05 kg

**Remarks:**

- Raw extrusion in accordance with OEM drawing and EN755-9
<table>
<thead>
<tr>
<th>Item No.</th>
<th>Description</th>
<th>Length</th>
<th>Width/ Dia.</th>
<th>Height/ Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Sheet; door frame</td>
<td>1848.1</td>
<td>153.4</td>
<td>1.5</td>
<td>2000-05-0525</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- 400 1000 2000
- 0.2 0.3 0.5 0.8

**Tolerances (u.n.o.)**

- ±400 ±1000 ±2000
- ±0.2 ±0.3 ±0.5 ±0.8

**Mass:** 3.19 kg

**Issue:** C

**Finish:** Dimensions in mm (u.n.o.)

**Drawing no.:** 2000-05-0525

**Sheet no.:** 1 of 1

**Date:** 04-11-2019

**Scale:** 1:8

**Drawn:** HS

**Checked:** VvM

**Approved:** JWR

**Flat pattern corrected ~Cut out**

**Raw extrusion in accordance with OEM drawing and EN755-9**

---

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The Netherlands

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The Netherlands

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+31 (0)10 479 8100
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>639.8</td>
<td>153.4</td>
<td>1.5</td>
<td>2000-05-1068</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Length: 639.8, Width/Dia: 153.4, Height/Thickn: 1.5

**Mass:** 1.04 kg

---

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Sheet; door frame

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/ Dia</th>
<th>Height/ Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>698</td>
<td>65.3</td>
<td>1.5</td>
<td>2000-05-1069</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Iss.**

- **Issue**
  - A

**Dimensions in mm (u.n.o.)**
- Mass: 1.22 kg
- Finish:
- Tolerances (u.n.o.):
  - 400 1000 2000
  - 0.2 0.3 0.5 0.8

**Drawn**
- HS
  - 27-03-2019

**Checked**
- VvM
  - 18-04-2019

**Approved**
- JWR
  - 10-05-2019

**Size**
- A3
<table>
<thead>
<tr>
<th>Item No.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Sheet; door frame</td>
<td>162</td>
<td>72.5</td>
<td>1.5</td>
<td>2000-05-1073</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Width: 7 – 30 – 120 – 400 – 1000 – 2000
- Thickness: 0.5 – 0.8

**Tolerances (u.n.o.)**

- Width: ± 0.2
- Thickness: ± 0.3
- Bend: ± 0.5
- Height: ± 0.8

**Issue**

- Drawing no.: 2000-05-1073
- Sheet: 1 of 1
- Issue: A

**Mass:** 0.11 kg

**Finish:**

- Raw extrusion in accordance with OEM drawing and EN755-9

---

**Scale:** 1:1

**Date:**

- Drawn: 27-03-2019
- Checked: 18-04-2019
- Approved: 10-05-2019

**Dimensions:**

- Width: 31
- Diameter: 12
- Height: 162

**Material:**

- AISI 304

---

**Engraving**

- 2000-05-1073
- Sizes: 11, 26.5, 40.8, 2.5, 1.5, 5.2, 72.5, 162, 9.6, 25.1, 31, 12, 31

---

**Title:** Sheet; door frame

---

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**Tel:** +31 10 479 8100
**3079 DN Rotterdam The Netherlands**

---

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Engraving

Sheet; door frame

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>161.6</td>
<td>72.5</td>
<td>1.5</td>
<td>2000-05-1285</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

Mass: 0.11 kg

Dimensions in mm (u.n.o.)

Scale: 1:1

Issue: A

Tolerances (u.n.o.):

- ± 7 30 120 400 1000 2000
- ± 0.2 0.5 1 1.5 2 3 4 5

Drawn: HS 28-03-2019
Checked: VvM 18-04-2019
Approved: JWR 10-05-2019

Stolwijkstraat 57
3079 DN Rotterdam
The Netherlands
Fax:+31 10 479 5478
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thichn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>2039</td>
<td>75.7</td>
<td>1.5</td>
<td>2000-05-2458</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.):**

- Mass: 1.78 kg
- Tolerances (u.n.o.): +/- 0.2, 0.3, 0.5, 0.8

**Issue**: 2000-05-2458

Sheet: 1 of 1

**Finish**: UP 90° R 2.5

**Checkered Panel**: DOWN 90° R 2.5

**Projection**: Scale 1:8

**Issue Drawing no.**: 06-05-2019

**Drawing no.**: 04-11-2019

**Approved by**: JWR

**Checked by**: HS

**Drawn by**: HS

**Title**: Sheet; door frame

**Dimensions in mm (u.n.o.):**

- 7 < 400 < 2000
- 7 30 < 120 < 500 < 1000 < 2000
- 7 0.2 < 0.3 < 0.5 < 0.8

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2 x Ø 5.5 \( \approx \) 11.9
Ø 10 \( \approx \) 4.4

2000-05-1321
A

Guide

A3

Dimensions in mm (u.n.o.)

Mass: 0.04 kg

Finish:  

Tolerances (u.n.o.)

Raw extrusion in accordance with OEM drawing and EN755-9

1 Guide 50 25 6 2000-05-1321 AISI 304

Drawn: HS 27-03-2019
Check: VvM 18-04-2019
Approved: JWR 10-05-2019

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Tel: +31 10 479 8100 Fax:+31 10 479 5478

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Detent</td>
<td>28</td>
<td>4.5</td>
<td></td>
<td>2000-05-3877</td>
<td>AISI 304</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**
- B < 7
- 7 ≤ D ≤ 30
- 120 ≤ D ≤ 400
- 1000 ≤ D ≤ 2000
- ±0.2 ≤ Ø2 ≤ ±0.1
- ±0.5 ≤ Ø3 ≤ ±0.4

**Mass:** 0.08 kg

**Issue:** B

**Drawing no.:** 2000-05-3877

**Sheet:** 1 of 1

**Date:** 09-04-2020

**Dimensions:**
- B: 104.8
- 68.5
- 55.5
- 42.5
- 12.5
- 10
- 6.3
- 0

**Remarks:**
- Dimensions in accordance with OEM drawing and EN755-9
3 x Ø 3.3 THRU ALL
M4 THRU ALL

### Detent; back

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Detent; back</td>
<td>111</td>
<td>16.5</td>
<td>15</td>
<td>2000-05-3880</td>
<td>AISI 304</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- 7
- 30
- 120
- 400
- 1000
- 2000

- ø0.2
- ø0.3
- ø0.5
- ø0.8

**Tolerances (u.n.o.)**

- ±0.1
- ±0.15
- ±0.3
- ±0.5
- ±0.8

**Mass:** 0.15 kg

**Issue No.:** 2000-05-3880

**Drawn:** HS 05-09-2019

**Checked:** HS 09-04-2020

**Approved:** JWR 10-04-2020

**Dimensions in mm (u.n.o.)**

- ø0.2
- ø0.3
- ø0.5
- ø0.8

**Raw extrusion in accordance with OEM drawing and EN755-9**
**Item No.** | **QTY.** | **Description** | **Length** | **Width/ Dia** | **Height/ Thickn.** | **Part Number** | **Material** | **Remarks**
---|---|---|---|---|---|---|---|---
1 | 1 | L-Extrusion 80x80x8 | 24 | 80/80 | 8 | 2000-05-2448 | Alu. 6060-T66 | 2 x Ø 6,8 THRU ALL M8 THRU ALL

**Scale:** 1:1  
**Issue:** 2000-05-2448  
**Issue Drawing no.:** A  
**Sheet :** 1 of 1

**Dimensions in mm (u.n.o.)**

<table>
<thead>
<tr>
<th>Dim.</th>
<th>Tolerances (u.n.o.)</th>
<th>Mass:</th>
<th>Finish:</th>
</tr>
</thead>
<tbody>
<tr>
<td>80 x 80 x 8</td>
<td>Ø2 Ø3 Ø4 Ø5 Ø6 Ø7 Ø8</td>
<td>0.07 kg</td>
<td></td>
</tr>
</tbody>
</table>

**Tolerances:**

- Ø2, Ø3, Ø4, Ø5, Ø6, Ø7, Ø8
- Dimensional allowances and tolerances in accordance with OEM drawing and EN755-9

**Drawing no.:** 2000-05-2448  
**Drawing n.:** A  
**Sheet no.:** 1 of 1

**Dimensions in mm:**

- 0.07 kg
- 2 x Ø 6,8 THRU ALL M8 THRU ALL

**Title:** L-Extrusion 80x80x8

---

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Extrusion Door (Rubber)</td>
<td>65</td>
<td></td>
<td></td>
<td>2000-05-0528</td>
<td>Rubber</td>
<td>Almet (AN625)</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**
- Length: 400, 1000, 2000
- Width/Dia: 7, 30, 120
- Height/Thickn.: > 0.2, 0.3, 0.5, 0.8

- Mass: 0.01 kg

**Tolerances (u.n.o.)**
- ± 7, ± 30, ± 120
- ± 0.2, ± 0.3, ± 0.5, ± 0.8

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Sheet 2: Rivet usage
Sheet 3: Details lock and door handle

Place WHITE INNO SEAL on 2 3 4 5 6 7 8 9 before placing on 1
Remove excess sealant
Note that the sealant has a drying time of 2 hours.

<table>
<thead>
<tr>
<th>Item</th>
<th>No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>28</td>
<td>111</td>
<td>1</td>
<td>Bk.Rivet Klamp-Tite</td>
<td>4,8</td>
<td>1,3-6,3 Ø4,8</td>
<td>BK-BAPKTR-06W-04</td>
<td>Alu. w. Rub. washer</td>
<td></td>
</tr>
<tr>
<td>27</td>
<td>24</td>
<td>2</td>
<td>Bk.St. Monobolt</td>
<td>4,8</td>
<td>1,6-11,1 Ø4,8</td>
<td>BK-02771-00617</td>
<td>Steel (MGLP-R6-7)</td>
<td></td>
</tr>
<tr>
<td>26</td>
<td>2</td>
<td>2</td>
<td>St. Blind rivet nut M4 HT</td>
<td>0,5-2,0</td>
<td>Ø6,75 10,7</td>
<td>BO-ALS3T-470-2,0</td>
<td>Steel 1010 Onkh 080320</td>
<td></td>
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Finish:
Projection
Place WHITE INNO SEAL on 2 3 4 5 6 7 8 9 before placing on 1. Remove excess sealant.

Note that the sealant has a drying time of 2 hours.

Leave holes open shown in details G - K

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Finish:
Projection
Details lock and door handle

Shorten shaft of Doorhandle 20 so body of Doorhandle 21 is in contact with Rosette 13.

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<td>Sheet: Door frame 407.7 540</td>
<td>407.7</td>
<td>2000-05-0307</td>
<td>AISI 304</td>
<td>Band with V16</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>1</td>
<td>Sheet: Door frame 1719.5 773</td>
<td>1719.5</td>
<td>2000-05-0307</td>
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<td>3</td>
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<td>1772</td>
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SECTION A-A
SCALE 1 : 5

DETAIL B
SCALE 1 : 2

<table>
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<th>Height/Thickn.</th>
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<th>Material</th>
<th>Remarks</th>
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<tr>
<td>1</td>
<td>1</td>
<td>Insulation</td>
<td>1767.5</td>
<td>597.3</td>
<td>60.4</td>
<td>2000-05-1186</td>
<td>RTM-Plus</td>
<td></td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

Mass: 2.57 kg

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The Netherlands
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## Inner sheet

<table>
<thead>
<tr>
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<th>QTY.</th>
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<th>Length</th>
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<th>Height/Thickn.</th>
<th>Part Number</th>
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<th>Remarks</th>
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<tbody>
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<td>1</td>
<td>Inner sheet</td>
<td>1767.5</td>
<td>597.3</td>
<td>0.8</td>
<td>2000-05-1185</td>
<td>PE-GEGW 0.8 NF</td>
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</table>

### Holes Ø5

- 587
- 566.1
- 545.8
- 460.8
- 375.8
- 355.5

### Holes Ø5.2

- 587
- 567.7

---

**Smooth side (visible side)**

**Finish:**

- B

**Drawing no.:** 2000-05-1185

**Issue:** B

**Tolerances (u.n.o.):**

- ± 0.2
- ± 0.3
- ± 0.5
- ± 0.8

**Mass:** 1.28 kg

**Dimensions in mm (u.n.o.):**

- Width: 1000
- Height: 2000
- Thickness: 7, 30, 120, 400, 1000, 2000

**Raw Extrusion in accordance with OEM drawing and EM755-9**

---

**Title:** Inner sheet

**Legend:**

- B: Cut-out, holes

**Remarks:**

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Lock insert

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
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<tr>
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<td>1</td>
<td>Lock insert</td>
<td>224</td>
<td>30</td>
<td>4</td>
<td>2000-05-1316</td>
<td>Alu. 6060-T66</td>
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</table>

Finish: B

Issue: Sheet: 1 of 1

Dimensions in mm (u.n.o.)

- Mass: 0.07 kg

Title: Lock insert

Scale: 1:1

Drawing no.: 2000-05-1316

Issue: B

Tolerances (u.n.o.):
- ±0.2 ±0.3 ±0.5 ±0.8 ±1.0 ±1.4 ±2

Raw extrusion in accordance with OEM drawing and EN755-9

Dimensions:
- Width: 224
- Thickness: 30
- Height: 4

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Lock insert

Item No. | QTY. | Description | Length | Width/Dia | Height/Thickn. | Part Number | Material | Remarks
---|---|---|---|---|---|---|---|---
1 | 1 | Lock insert | 198.5 | 30 | 4 | 2000-05-1319 | Alu. 6060-T66 | Finish:

Dimensions in mm (u.n.o.)
- Mass: 0.06 kg
- Raw extrusion in accordance with OEM drawing and EN755-9

Tolerances (u.n.o.)
- $\pm 0.1\,\mu\text{m}$

Issue
- Sheet: 1 of 1

Drawn: HS 29-03-2019
Checked: VvM 18-04-2019
Approved: JWR 10-05-2019

Scale: 1:1

Issue Drawing no.: 2000-05-1319

Dimensions in mm (u.n.o.)

Engraving
Engraving

Item No. | QTY. | Description | Length | Width/Dia | Height/Thickn. | Part Number | Material | Remarks
--- | --- | --- | --- | --- | --- | --- | --- | ---
1 | 1 | Lock insert | 258,5 | 38,9 | 4 | 2000-05-1320 | Alu. 6082-T6 | 

Finish:

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Tel: +31 10 479 8100
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info@vrr-aviation.com

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<table>
<thead>
<tr>
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<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
<td></td>
<td>1</td>
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<td>1772</td>
<td>59.9</td>
<td>1.5</td>
<td>2000-05-0533</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Dimensions in mm**

- A3 (u.n.o.)
- Scale: 1:5
- Flat pattern corrected
- Drawn: HS 29-03-2019
- Checked: VvM 06-11-2019
- Approved: JWR 26-11-2019
- Mass: 1.26 kg
- Finish: B
- Issue: 2000-05-0533

**Tolerances (u.n.o.):**

- 7 30 120 400 1000 2000
- d02 d01 d00 d08 d10 d12
- 0 ±0.2 ±0.3 ±0.5 ±0.8

**Dimensions in mm:**

- 400 1000 2000
- 30 120
- 7 30 120 400 1000 2000

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### Sheet: door frame

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
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<th>Height/Thickn.</th>
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<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>1719.6</td>
<td>77.5</td>
<td>1.5</td>
<td>2000-05-0534</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- 2000-05-0534
- A

**Drawn:** HS 29-03-2019

**Checked:** VvM 18-04-2019

**Approved:** JWR 10-05-2019

**Mass:** 1.57 kg

**Issue:** Sheet: 1 of 1

**Tolerances** (u.n.o.):

- Raw extrusion in accordance with OEM drawing and EN755-9

**Title:** Sheet; door frame
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY</th>
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<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>601 7</td>
<td>59 9</td>
<td>1.5</td>
<td>2000-05-1337</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Scale:** 1:2  
**Date:** 29-03-2019  
**Drawing no.:** 2000-05-1337  
**Issue:** B  
**Sheet:** 1 of 1  
**Dimensions in mm (u.n.o.)**  
- 0.2 < 0.3 < 0.5 < 0.8  
- 7 < 10 < 12 < 20 < 100 < 1000 < 2000  

**Tolerances (u.n.o.)**  
- ±0.1  
- ±1.6  
- ±3.1  
- ±4.6  
- ±6.1  
- ±7.6  
- ±9.1  
- ±10.6

**Size:** A3  
**Projection:**  
**Material:** AISI 304  
**Remarks:** Bend with V16
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>601.7</td>
<td>59.9</td>
<td>1.5</td>
<td>2000-05-0536</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Raw extrusion in accordance with OEM drawing and EN755-9

**Tolerances (u.n.o.)**

- \( \pm 7 \, 30 \, 120 \, 400 \, 1000 \, 2000 \)
- \( \pm 0.2 \, \pm 0.3 \, \pm 0.5 \, \pm 0.8 \)

**Issue**

- B

**Drawing no.:**

- 2000-05-0536

**Sheet:** 1 of 1

**Mass:** 0.42 kg

**Finish:** B

**Dimensions in mm (u.n.o.)**

- Sheet; door frame

---

**Projection:**

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- The Netherlands
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- info@vrr.aero
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---

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Thickness/Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>544.9</td>
<td>77</td>
<td>1.5</td>
<td>2000-05-1281</td>
<td>AISI 304</td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Length: 544.9
- Width: 77
- Thickness: 1.5
- Part Number: 2000-05-1281
- Material: AISI 304
- Remarks: Bend with V16

**Tolerances (u.n.o.)**

- Flat pattern corrected

**Issue**

- Drawing no.: 2000-05-1281
- Sheet: 1 of 1

**Title:** Sheet; door frame

**Drawn:** HS 29-03-2019
**Checked:** VvM 06-11-2019
**Approved:** JWR 26-11-2019
**Mass:** 0.48 kg

**Finish:** B

**Dimensions in mm (u.n.o.)**

- Length: 544.9
- Width: 77
- Thickness: 1.5
- Part Number: 2000-05-1281
- Material: AISI 304
- Remarks: Bend with V16

**Tolerances (u.n.o.)**

- Flat pattern corrected

**Issue**

- Drawing no.: 2000-05-1281
- Sheet: 1 of 1

**Title:** Sheet; door frame
<table>
<thead>
<tr>
<th>Item No.</th>
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<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tr>
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<td>Sheet; door frame</td>
<td>1719.5</td>
<td>77.5</td>
<td>1.5</td>
<td>2000-05-0538</td>
<td>AISI 304</td>
<td>Bend with V16</td>
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</table>

**Scale:** 1:1

**UP 90° R 2.5**

**DOWN 90° R 2.5**

**Dimensions in mm**

- L = 1719.5
- W = 77.5
- H = 1.5

**Area involved**

- 1.50 kg

**Issue**

- C

**Drawing no.** 2000-05-0538

**Sheet:** 1 of 1

**Dimensions in mm (u.n.o.)**

- Mass: 1.50 kg

**Tolerances (u.n.o.)**

- ± 0.2
- ± 0.3
- ± 0.5
- ± 0.8

**Flat pattern corrected**

- Raw extrusion in accordance with OEM drawing and EN755-9

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**The Netherlands**

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<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
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<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
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<td>Sheet; door frame</td>
<td>1772</td>
<td>59.9</td>
<td>1,5</td>
<td>2000-05-0539</td>
<td>AISI 304</td>
<td>Bend with V16</td>
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</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- 400: 1000 2000
- 0.2: 0.3 0.5 0.8

**Tolerances (u.n.o.)**

- +7 120 12 400 1000 2000
- ±0.05 ±0.1 ±0.15 ±0.18 ±0.1 ±0.18 ±0.1 ±0.14 ±0.1 ±0.14

**Mass: 1.26 kg**

**Issue: 2000-05-0539**

**Sheet: 1 of 1**

**Title: Sheet; door frame**

**Scale: 1:6**

**Drawn: HS** 29-03-2019

**Checked: VvM** 04-11-2019

**Approved: JWR** 04-11-2019

**Projector:**

**VRR**

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<th>Height/ Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tr>
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<td>1</td>
<td>Sheet door handle</td>
<td>247.9</td>
<td>221.5</td>
<td>1.5</td>
<td>2000-05-0978</td>
<td>AISI 304</td>
<td>Bend with V16</td>
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**Title:** Sheet door handle

**Issue:** 2000-05-0978

**Dimensions in mm (u.n.o.)**

- **Mass:** 0.62 kg
- **Finish:** B

**Tolerances (u.n.o.)**

- ±0.2
- ±0.3
- ±0.5
- ±0.8

**Scale:** 1:2

**Drawn:** HS
**Checked:** VvM
**Approved:** JWR

**Dimensions**

- Width: 247.9 mm
- Height: 221.5 mm
- Thickness: 1.5 mm

**Projection**

- Projection of scale 1:2

**Issue Date:** 11-09-2019
**Drawing no.:** 2000-05-0978
**Sheet:** 1 of 1

**Dimensions in mm**

- Length: 247.9 mm
- Width: 221.5 mm
- Height: 1.5 mm

**Mass:** 0.62 kg

**Finish:** B

**Remarks:** Bend with V16

---

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1 X 45°
63
12,5
25
2 x 3,3 11,5
M4 - 6H 8
16,3
0
12,5
31,5
50,5

Item No. QTY. Description Length Width/Dia Height/Thickn. Part Number Material Remarks
1 1 Rosette outside 63 25 15 2000-05-3886 AISI 304

Finish: B
Projection

Dimensions in mm (u.n.o.)
Mass: 0.15 kg

Title: Rosette outside

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<table>
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<th>Length</th>
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<th>Height/Thickn.</th>
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<th>Material</th>
<th>Remarks</th>
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<td>Guide pin</td>
<td>27</td>
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</table>

Dimensions in mm (u.n.o.)

- Mass: 0.01 kg

2000-05-1366

Sheet: 1 of 1

Guide pin

Issue: A

Tolerances (u.n.o.): ± 0.2

Dimensions in mm (u.n.o.): ± 0.2

Mass: 0.01 kg

Finish:

Scale: 5:1

Date: 29-03-2019

Drawing no.: 2000-05-1366

Checked: VvM

18-04-2019

Approved: JWR

10-05-2019

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Extrusion Door (Rubber)

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tr>
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<td>1</td>
<td>Extrusion Door (Rubber)</td>
<td>1752.5</td>
<td></td>
<td></td>
<td>2000-05-0540</td>
<td>Rubber</td>
<td>Almet (AN625)</td>
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</table>

Dimensions in mm (u.n.o.)
- Mass: 0.18 kg

Tolerances (u.n.o.)
- ± 7 30 120 400 1000 2000
- ±0.2 ±0.3 ±0.5 ±0.8

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
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<th>Width/ Dia</th>
<th>Height/ Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tr>
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<td>1</td>
<td>Extrusion Door (Rubber)</td>
<td>582</td>
<td></td>
<td></td>
<td>2000-05-0541</td>
<td>Rubber</td>
<td>Almet (AN625)</td>
</tr>
</tbody>
</table>

**Title:** Extrusion Door (Rubber)

**Drawing Details:**
- **Scale:** 1:1
- **Issue:** B
- **Drawing no.:** 2000-05-0541
- **Date:** 12-09-2019
- **Material:** Rubber
- **Remarks:** Almet (AN625)

**Dimensions in mm (u.n.o.):**
- Length: 400, 1000, 2000
- Width: 7, 30, 120
- Height: 30, 120
- Thickness: 0.2, 0.3, 0.5, 0.8

**Tolerances (u.n.o.):**
- Length: ±0.1, ±0.2, ±0.3, ±0.4
- Width: ±0.1, ±0.2
- Height: ±0.1, ±0.2
- Thickness: ±0.1, ±0.2

**Mass:** 0.06 kg

**Finish:**
- Dimensions in mm

**Issue Details:**
- Drawn: HS (29-03-2019)
- Checked: MH (11-09-2019)
- Approved: JWR (12-09-2019)

**Notes:**
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<table>
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<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Piano Hinge</td>
<td>60x2</td>
<td>2500</td>
<td>60</td>
<td>SL-7663410B</td>
<td>Stainless</td>
<td>Bosch (7663410)</td>
</tr>
</tbody>
</table>

Finish: 

Fax: +31 10 479 5478  
Tel: +31 10 479 8100

The Netherlands

info@vrr-aviation.com

Projection

NameDateChangesIss.

IssueDrawing no.

Title: Piano Hinge

Dimensions in mm (u.n.o.)

Sheet: 1 of 1

Tolerances (u.n.o.)

Raw extrusion in accordance with OEM drawing and EN755-9

Mass: 0.10 kg

---

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### Net Bracket (SS)

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
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<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
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<tr>
<td></td>
<td></td>
<td>Net Bracket (SS)</td>
<td>60</td>
<td>67.3</td>
<td>20</td>
<td>RR7.720.085</td>
<td>AISI 304</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

<table>
<thead>
<tr>
<th>Mass:</th>
<th>0.02 kg</th>
<th>Finish:</th>
<th>Dimensions in mm (u.n.o.)</th>
</tr>
</thead>
</table>

**Issue Tolerances (u.n.o.)**

- 7 30 120 400 1000 2000
- 0.2 0.3 0.5 0.8

**New**

Remove sharp edges (barrel finishing)

**Drawn:** PvT 10-09-2009
**Checked:** WvdV 06-10-2011
**Approved:** BH 30-03-2012

**Sheet:** 1 of 1
Adjust guiding block on door 2 such that door 3 locks vertically, then tighten the bolts of guiding block.

DETAIL A
SCALE 1 : 2

Use torque load M6: 8.1 Nm

DETAIL B
SCALE 1 : 2

DETAIL C
SCALE 1 : 2

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Thick.</th>
<th>Notes</th>
</tr>
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<tbody>
<tr>
<td>12</td>
<td>1</td>
<td>INNO-SEAL White</td>
<td>290 ml</td>
<td></td>
<td>LI-INNO.SEAL-WIT Kit</td>
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<tr>
<td>11</td>
<td>2</td>
<td>Bk.St. Monobolt 6 4,8</td>
<td>2,0-15,9 Ø6,4</td>
<td></td>
<td>BK-02771-00824 Steel</td>
</tr>
<tr>
<td>10</td>
<td>36</td>
<td>Bk.St. Monobolt 4,8</td>
<td>1,6-11,1 Ø4,8</td>
<td></td>
<td>BK-02771-00617 Steel</td>
</tr>
<tr>
<td>9</td>
<td>12</td>
<td>Hex. Head Screw</td>
<td>M6</td>
<td>25</td>
<td>BO-4017-06025-A2 AISI 304 ISO4017/DIN933</td>
</tr>
<tr>
<td>8</td>
<td>12</td>
<td>Nord-Lock Large Washer M6 ø13,5 M6</td>
<td>2,0</td>
<td>BO-NORDLCK-06SP-SMO 245 SMO</td>
<td></td>
</tr>
<tr>
<td>7</td>
<td>1</td>
<td>D-Ring 25mm</td>
<td>44</td>
<td>37</td>
<td>ZN-VRR-DRNG2 Zinc</td>
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<tr>
<td>6</td>
<td>1</td>
<td>Bolt Bk-St.</td>
<td>40</td>
<td>87,5</td>
<td>BK-02771-00617 Steel</td>
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<tr>
<td>5</td>
<td>6</td>
<td>Hinge</td>
<td>2000-05-2212 Assembly</td>
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<tr>
<td>4</td>
<td>4</td>
<td>Door hinge 214S</td>
<td>SL-NJ214S Assembly</td>
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<td></td>
</tr>
<tr>
<td>3</td>
<td>1</td>
<td>DBJ door 3</td>
<td>2000-05-0511 Assembly</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>1</td>
<td>DBJ door right 2</td>
<td>2000-05-1234 Assembly</td>
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<td></td>
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<tr>
<td>1</td>
<td>1</td>
<td>DBJ door right</td>
<td>2000-05-0511 Assembly</td>
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<td></td>
</tr>
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DBJ Door Right

Title:         2000-07-3476
Drawing no:    A
Issue: 1
Dimensions in mm
Mass: 57.36 kg

This drawing is property of VRR which reserved all rights.
Use INNO-SEAL White

Detail D
Scale 1:3

NOTE: Apply sealant (dashed line) before attaching 4 to 1.

<table>
<thead>
<tr>
<th>Item No.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>INNO-SEAL White</td>
<td>250 ml</td>
<td></td>
<td></td>
<td>LI-INNO.SEAL-W1 Kit</td>
<td>Steel</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>BK-St. Monobolt 6.4</td>
<td>6.4</td>
<td>2.0-15.9</td>
<td></td>
<td>BK-02771-00824</td>
<td>Steel</td>
<td>(MGLP-R8-10)</td>
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<tr>
<td>3</td>
<td>BK-St. Monobolt 8.8</td>
<td>8.8</td>
<td>2.0-11.1</td>
<td></td>
<td>BK-02771-00617</td>
<td>Steel</td>
<td>(MGLP-R6-7)</td>
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<tr>
<td>4</td>
<td>Hex. Head Screw 25 M6</td>
<td>25</td>
<td>M6</td>
<td></td>
<td>BO-4017-025-AQ</td>
<td>AISI 304</td>
<td></td>
</tr>
<tr>
<td>5</td>
<td>Hex-Lock Large Washer M6</td>
<td>d13.5</td>
<td>M6</td>
<td>2.5</td>
<td>BO-4017-156-BP</td>
<td>SMO</td>
<td>(SMO)</td>
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<tr>
<td>6</td>
<td>Lifting Profile 44/37</td>
<td>44</td>
<td>37</td>
<td></td>
<td>JA-06050014/02/03</td>
<td>Steel</td>
<td>(SMO)</td>
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<tr>
<td>7</td>
<td>Net Bracket 56/2.5/20</td>
<td>60</td>
<td>2.5</td>
<td>25</td>
<td>BO-4017-025-AQ</td>
<td>AISI 304</td>
<td></td>
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<tr>
<td>8</td>
<td>Hinge</td>
<td></td>
<td></td>
<td></td>
<td>2000-05-2122</td>
<td>Assembly</td>
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<td>Door Hinge 2143</td>
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<td>SC-2143</td>
<td>Assembly</td>
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</tr>
<tr>
<td>10</td>
<td>DUB Door Right 3</td>
<td></td>
<td></td>
<td></td>
<td>2000-05-31767</td>
<td>Assembly</td>
<td></td>
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<td>DUB Door Right 2</td>
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<td></td>
<td>2000-05-31334</td>
<td>Assembly</td>
<td></td>
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<tr>
<td>12</td>
<td>DUB Door 1</td>
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<td></td>
<td></td>
<td>2000-05-31111</td>
<td>Assembly</td>
<td></td>
</tr>
</tbody>
</table>

Finish: DBJ Door Right

Issue Drawing no. 2000-07-3476 Sheet: 2 of 2

Mass: 57.36 kg

Dimensions in mm (U.N.O.)

Stolwijkstraat 57
3079 DN Rotterdam
The Netherlands
vrr.aero
info@vrr.aero
+31 (0)10 479 8100
Make sure to rivet Reinforcement sheet 15 to Sheet 2 before putting it on the insulation panel (applies for both top and bottom corner)

Place WHITE INNO SEAL on 2 3 4 5 6 7 8 9 10 before placing on 1

Remove excess sealant

Note that the sealant has a drying time of 2 hours.

Item No. | QTY. | Description | Length Width/Dia Height/Thickn. | Part Number | Material | Remarks
---|---|---|---|---|---|---
23 | 4 | Plain Washer Normal M5 BO-7089-05-PA | | | Nylon ISO7089/DIN125A |
22 | 178 | Bk. Rivet Klamp-Tite 4,8 1,3-6,3 Ø4,8 BK-BAPKTR-06W-04 | | | Alu. w. Rub. washer |
21 | 21 | Bk. St. Monobolt 4,8 1,6-11,1 Ø4,8 BK-02771-00617 | | | Steel (MGLP-R6-7) |
20 | 4 | St. Blind nut M4 HT 0,5-2,0 Ø6,75 10,7 BO-ALS3T-470-2,0 | | | Steel 1010 Onkh 080320 |
19 | 3 | Hex. Socket Cap Screw 20 M4 BO-10642-04020-A2 | | | AISI 304 ISO10642/DIN7991 |
18 | 4 | Hex. Socket Cap Screw 16 M4 BO-4762-04016-A2 | | | AISI 304 ISO4762/DIN912 |
17 | 6 | Rubber L-extrusion 51 30/25 3 2000-04-1446 SEBS70 Technirub VRR001r |
16 | 2 | Extrusion Door (Rubber) 65 | 2000-05-1623 | | | Rubber (MME25) |
15 | 2 | Extrusion Bodkin | | 2000-05-2448 | | Alu. 6050-T66 |
14 | 1 | Detent back | | 2000-05-3880 | | | AISI 304 |
13 | 1 | Detent | | 2000-05-3877 | | | AISI 304 |
12 | 2 | Guide | | 2000-05-1317 | | | AISI 304 |
11 | 2 | | | 2000-05-0524 | | | AISI 304 |
10 | 1 | Sheet: door frame | | 2000-05-1073 | | | AISI 304 Band with V16 |
9 | 1 | Sheet: door frame | | 2000-05-1389 | | | AISI 304 Band with V16 |
8 | 1 | Sheet: door frame | | 2000-05-1377 | | | AISI 304 Band with V16 |
7 | 1 | Sheet: door frame | | 2000-05-1072 | | | AISI 304 Band with V16 |
6 | 1 | Sheet: door frame | | 2000-05-1323 | | | AISI 304 Band with V16 |
5 | 1 | Sheet: door frame | | 2000-05-0527 | | | AISI 304 Band with V16 |
4 | 1 | Sheet: door frame | | 2000-05-1312 | | | AISI 304 Band with V16 |
3 | 2 | Sheet: door frame | | 2000-05-1488 | | | AISI 304 Band with V16 |
2 | 1 | Sheet: door frame | | 2000-05-1238 | | | AISI 304 Band with V16 |
1 | 1 | DBJ panel door | | 2000-05-1244 | | Assembly |

Place WHITE INNO SEAL on 2 3 4 5 6 7 8 9 10 before placing on 1

Remove excess sealant

Note that the sealant has a drying time of 2 hours.
Place WHITE INNO SEAL on ②③④⑤⑥⑦⑧⑨⑩ before placing on ①.
Remove excess sealant

Note that the sealant has a drying time of 2 hours.

Tighten Screw ⑮ after assembling total door and adjusting the position of Guide ⑲.
<table>
<thead>
<tr>
<th>No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/ Dia</th>
<th>Height/ Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>5</td>
<td>1</td>
<td>Tube 20x20x2</td>
<td>2000</td>
<td>40,0</td>
<td>40,0</td>
<td>2000-04-8840</td>
<td>Alu. 6060-T6</td>
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</tr>
<tr>
<td>4</td>
<td>2</td>
<td>Reinforcement sheet</td>
<td>2000</td>
<td>44,8</td>
<td>44,8</td>
<td>2000-05-1206</td>
<td>Alu. 6082-T6</td>
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<tr>
<td>3</td>
<td>1</td>
<td>Outer sheet</td>
<td>2034,5</td>
<td>62,0 ±0,5</td>
<td>62,0 ±0,5</td>
<td>2000-05-1246</td>
<td>PE-GEGW 0,8 NF</td>
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</tr>
<tr>
<td>2</td>
<td>1</td>
<td>Insulation</td>
<td>2034,5</td>
<td>730,8 ±1,0</td>
<td>730,8 ±1,0</td>
<td>2000-05-1247</td>
<td>RTM-X</td>
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</tr>
<tr>
<td>1</td>
<td>1</td>
<td>Inner sheet</td>
<td>1946,5</td>
<td>400</td>
<td>400</td>
<td>2000-05-1245</td>
<td>PE-GEGW 0,8 NF</td>
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</tr>
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</table>

**Dimensions in mm (u.n.o.)**

<table>
<thead>
<tr>
<th>No.</th>
<th>Description</th>
<th>Length</th>
<th>Width</th>
<th>Height</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>5</td>
<td>Tube 20x20x2</td>
<td>2000</td>
<td>40,0</td>
<td>40,0</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>Reinforcement sheet</td>
<td>2000</td>
<td>44,8</td>
<td>44,8</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>Outer sheet</td>
<td>2034,5</td>
<td>62,0 ±0,5</td>
<td>62,0 ±0,5</td>
<td>PE-GEGW 0,8 NF</td>
</tr>
<tr>
<td>2</td>
<td>Insulation</td>
<td>2034,5</td>
<td>730,8 ±1,0</td>
<td>730,8 ±1,0</td>
<td>RTM-X</td>
</tr>
<tr>
<td>1</td>
<td>Inner sheet</td>
<td>1946,5</td>
<td>400</td>
<td>400</td>
<td>PE-GEGW 0,8 NF</td>
</tr>
</tbody>
</table>

**Finish:**

**Projection**

**Issue:**

Drawing no.: 2000-05-1244

Approved: JWR

Approved: VVM

Checaked: VVM

Drawn: HS

Date: 01-04-2019

Date: 10-09-2019

Date: 10-09-2019

Mass: 2.01 kg

Title: DBJ panel door

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3079 DN Rotterdam
The Netherlands
vrr.aero
info@vrr.aero
+31 (0)10 479 8100
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Outer sheet</td>
<td>2034.5</td>
<td>650.8</td>
<td>0.8</td>
<td>2000-05-1246</td>
<td>PE-GGW 0.8 NF</td>
<td></td>
</tr>
</tbody>
</table>

**Dimensions in mm (u.n.o.)**

- Mass: 0.50 kg
- Tolerances (u.n.o.):
  - < 7
  - 7-30
  - 30-120
  - 120-400
  - 400-1000
  - 1000-2000
  - > 2000

**Drawn by:** HS
**Checked:** VvM
**Approved:** JWR

**Issue:** A

**Drawing no.:** 2000-05-1246

**Sheet:** 1 of 1

**Dimensions in mm (u.n.o.)**

- Dimensions: 0.20, 0.30, 0.50, 0.80

**Scale:** 1:10

This drawing is property of Van Riemisdijk Rotterdam b.v. which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>639,8</td>
<td>153,4</td>
<td>1,5</td>
<td>2000-05-0527</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

**Engraving**

Dimensions in mm (u.n.o.)

- Raw extrusion in accordance with OEM drawing and EN755-9
- Tolerances (u.n.o.)
  - 7 30 120 400 1000 2000
  - ±0.2 ±0.1 ±0.06 ±0.04 ±0.02 ±0.01

Mass: 1.04 kg

---

**Sheet; door frame**

Issue: A

Drawn: HS 01-04-2019
Checked: VvM 18-04-2019
Approved: JWR (VvM) 10-10-2019

Finish: Dimensions in mm (u.n.o.)
Item No. | QTY. | Description | Length | Width/Dia | Height/Thickn. | Part Number | Material | Remarks |
---|---|---|---|---|---|---|---|---|
1 | 1 | Sheet; door frame | 735.3 | 153.4 | 1.5 | 2000-05-1238 | AISI 304 | Bend with V16 |

Scale: 1:3  Date: 01-04-2019  Drawing no.: 2000-05-1238  Issue: Sheet: 1 of 1

Issue: A  Tolerances (u.n.o.)

Dimension in mm (u.n.o.)

Finish: Dimensions in mm (u.n.o.)

Dimensions in mm (u.n.o.)

This drawing is property of Van Riemslidijk Rotterdam b.v. which reserved all rights.
Sheet; door frame

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>1848.1</td>
<td></td>
<td>153.4</td>
<td>1.5</td>
<td>2000-05-1070</td>
<td>AISI 304</td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

- > 7 30 120 400 1000 2000 400 g1.6 g1.5 g1.4 g1.0 g1.4 g1.5 g1.6
- < 7 30 120 400 1000 2000 400

Mass: 3.19 kg

Finish: B

Issue: 2000-05-1070

Sheet: 1 of 1

Scale: 1:6

Drawn: HS 01-04-2019
Checked: VvM 10-09-2019
Approved: JWR 10-09-2019
Sheet; door frame

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thickn.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>735.3</td>
<td>153.4</td>
<td>1.5</td>
<td>2000-05-1377</td>
<td>AISI 304</td>
<td>Bend with V16</td>
</tr>
</tbody>
</table>

Dimensions in mm (u.n.o.)

- Width: 80
- Length: 735.3
- Height: 153.4
- Thickness: 1.5

Tolerances (u.n.o.)

- Width: ±0.2
- Length: ±0.3
- Height: ±0.5
- Thickness: ±0.8

Mass: 1.22 kg

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<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia</th>
<th>Height/Thick.</th>
<th>Part Number</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
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<td>1</td>
<td>Sheet; door frame</td>
<td>161.6</td>
<td>72.5</td>
<td>1.5</td>
<td>2000-05-1396</td>
<td>AISI 304</td>
<td>Bend with V16</td>
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</tbody>
</table>

**Engraving**

- **DOWN 90° R 2.5**
- **UP 90° R 2.5**

**Dimensions in mm (u.n.o.)**

- Mass: 0.11 kg

**Tolerances (u.n.o.)**

- Raw extrusion in accordance with OEM drawing and EN755-9

**Issue**

- **A**

**Drawing no.:**

- **2000-05-1396**

**Sheet: 1 of 1**

**Title:** Sheet; door frame

**Drawn:** HS 01-04-2019

**Checked:** VvM 18-04-2019

**Approved:** JWR 10-05-2019

**Dimensions in mm (u.n.o.)**

- 400 1000 2000
- 1.0 1.4 2
- 7 30 120

**Fax:** +31 10 479 5478

**Tel:** +31 10 479 8100

**3079 DN Rotterdam**

**The Netherlands**

**info@vrr-aviation.com**

**This drawing is property of Van Riemst Rotterdam b.v. which reserved all rights**
Place WHITE INNO SEAL on the rivets before placing them on the panels. Remove excess sealant. Note that the sealant has a drying time of 2 hours.

### Rivet Usage

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/Dia.</th>
<th>Height/Thickn.</th>
<th>Material</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
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<td>2</td>
<td>Torx Socket Csk. Screw 30</td>
<td>M6</td>
<td></td>
<td></td>
<td>AISI 304</td>
<td>ISO14581 torx</td>
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<td>27</td>
<td>2</td>
<td>Torx Socket Csk. Screw 35</td>
<td>M4</td>
<td></td>
<td></td>
<td>AISI 304</td>
<td>ISO14581 torx</td>
</tr>
<tr>
<td>26</td>
<td>2</td>
<td>Torx Socket Csk. Screw 16</td>
<td>M4</td>
<td></td>
<td></td>
<td>AISI 304</td>
<td>ISO14581 torx</td>
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<tr>
<td>25</td>
<td>111</td>
<td>Bl Blind rivet nut M4 4.8</td>
<td>3.6-11</td>
<td>M4.8</td>
<td>15.7</td>
<td>Steel</td>
<td>MBLP-0476-L</td>
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<tr>
<td>24</td>
<td>2</td>
<td>St Blind rivet nut M8 HTH</td>
<td>3.6-11</td>
<td>M8.0</td>
<td>15.7</td>
<td>Steel</td>
<td>MBLP-08332</td>
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<tr>
<td>23</td>
<td>1</td>
<td>Door handle</td>
<td></td>
<td></td>
<td></td>
<td>Steel</td>
<td>Intersteel</td>
</tr>
<tr>
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<tr>
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<tr>
<td>1</td>
<td>1</td>
<td>DBJ panel door</td>
<td>1.5</td>
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<td>Steel</td>
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</table>

Finish:
- **Projection:** [Details]
- **Name:** [Details]
- **Date:** [Details]
- **Changes:** [Details]
Rivet usage

Place WHITE INNO SEAL on ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨ before placing on ①

Remove excess sealant

Note that the sealant has a drying time of 2 hours.
Details lock and door handle

Shorten shaft of Doorhandle 21 so body of Doorhandle 20 is in contact with Rosette 13.
<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
<th>Width/ Dia</th>
<th>Height/ Thickn.</th>
<th>Part Number</th>
<th>Material</th>
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<td>4</td>
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<td>244</td>
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<td>4</td>
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<tr>
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<td>597.3</td>
<td>0.8</td>
<td>2000-05-1232</td>
<td>RTM-Plus</td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>1</td>
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<td>1767.5</td>
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<td>0.8</td>
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<td>PE-GEGW 0.8</td>
<td>NF</td>
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<tr>
<td>3</td>
<td>1</td>
<td>Outer sheet</td>
<td>1687.5</td>
<td>517.3</td>
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<td>PE-GEGW 0.8</td>
<td>NF</td>
</tr>
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</table>

Finish:

Projection

Name: Date: Changes: Iss.

Issue Drawing no.

Title:

Dimensions in mm

Mass: 5.42 kg

DBJ panel door

This drawing is property of VRR which reserved all rights.
Insulation

<table>
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<th>Item No.</th>
<th>QTY.</th>
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<th>Length</th>
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<th>Remarks</th>
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<td>60.4</td>
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<td>RTM-Plus</td>
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</tr>
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Dimensions in mm (u.n.o.)

- Raw extrusion in accordance with OEM drawing and EN755-9

Drawing no.: 2000-05-1232

Issue: C

Sheet: 1 of 1

Finish:

Mass: 2.57 kg

Date: 09-03-2020

This drawing is property of VRR which reserved all rights.
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<th>Part Number</th>
<th>Material</th>
<th>Bend with V16</th>
<th>Remarks</th>
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</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet; door frame</td>
<td>1719.5</td>
<td>77.5</td>
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<td>2000-05-1410</td>
<td>AISI 304</td>
<td></td>
<td>Sheet : 1 of 1</td>
</tr>
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**Dimensions in mm (u.n.o.)**

- Mass: 1.50 kg
- Finish: B

**Issue Tolerances (u.n.o.)**

- Sheet 1 of 1
- Drawn: HS 01-04-2019
- Checked: VvM 10-09-2019
- Approved: JWR 11-09-2019

**Title:** Sheet; door frame

---

This drawing is property of VRR which reserved all rights.
Sheet door handle

<table>
<thead>
<tr>
<th>Item No.</th>
<th>QTY.</th>
<th>Description</th>
<th>Length</th>
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<th>Part Number</th>
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<th>Remarks</th>
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</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>Sheet door handle</td>
<td>289.4</td>
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<td>2000-05-1249</td>
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</table>

Dimensions in mm (u.n.o.)

- Mass: 0.88 kg
- Issue: B
- Finish: 
- Dimensions: Sheet : 1 of 1

Tolerances (u.n.o.):

- Mass: ±0.1 kg
- Dimensions: ±0.1 mm
- Angles: ±0.5°
- Tolerances: ±0.1 mm

This drawing is property of VRR which reserved all rights.
\[
28 \times 25.4 = 711.2
\]

\[
25.4
\]

\[
19.9 \pm 0.12
\]

\[
6.6 \text{ Csk.}
\]

\[
0
\]

\[
1
\]

\[
24.4
\]

\[
735.6
\]

\[
761
\]

\[
0
\]

\[
10
\]

\[
634
\]

\[
750
\]

\[
24.4
\]

\[
126
\]

\[
7.8
\]

\[
50
\]

\[
11
\]

\[
15
\]

\[
760
\]

\[
A
\]

\[
B
\]

\[
C
\]

\[
H
\]

\[
\text{(For M6 CSK bolt)}
\]

\[
\text{(Revision C)}
\]

\[
\text{Dimensions in mm (u.n.o.)}
\]

\[
\text{Raw extrusion in accordance with OEM drawing and EN755-9}
\]

\[
\text{Mass: 0.97 kg}
\]

\[
2000-04-8885
\]

\[
\text{Alu. 6061-T6}
\]

\[
\text{Finish: U001 - Aludon}
\]

\[
\text{Sheet : 1 of 1}
\]

\[
\text{Dimensions in mm (u.n.o.)}
\]

\[
\text{Raw extrusion in accordance with OEM drawing and EN755-9}
\]

\[
\text{Mass: 0.97 kg}
\]

\[
2000-04-8885
\]
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<td>ø11,3</td>
<td>VE-D-115E</td>
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<td>Plunger pin</td>
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<td>25</td>
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<td>Plunger</td>
<td>10</td>
<td>ø19</td>
<td>2000-02-5680</td>
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<tr>
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<td>Stud bracket</td>
<td>101,6</td>
<td>26</td>
<td>2000-04-8887</td>
<td>Alu. 6082-T6</td>
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</tr>
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This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
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<td>25</td>
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<td>Alu. 6082-T6</td>
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</table>

**Dimensions in mm (u.n.o.)**
- Raw extrusion in accordance with OEM drawing and EN755-9

**Tolerances (u.n.o.)**
- \( \pm 0.07 \)

**Issue**
- B

**Finish**
- Dimensions in mm (u.n.o.)

**Mass**
- 0.08 kg

**Drawn**
- HS

**Checked**
- HS

**Approved**
- JWR

**Date**
- 10-03-2020

**Drawing no.**
- 2000-04-8887

**Sheet : 1 of 1**

**Title:** Stud bracket

---

**Stolwijkstraat 57**
3079 DN Rotterdam
The Netherlands

vrr.aero
info@vrr.aero
+31 (0)10 479 8100

---

This drawing is property of VRR which reserved all rights.
<table>
<thead>
<tr>
<th>Item No.</th>
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Weight: 0.01 Kg.

Sheet: 1 of 1

Dimensions in mm (u.n.o.)

- Tolerances (u.n.o.):
  - Raw extrusion in accordance with OEM drawing and EN755-9

Drawing:

- Scale: 5:1
- Date: 28-05-2015
- Drawing no: 2000-02-5680
- Sheet: 1 of 1
- Issue: A

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights
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<td>-</td>
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</tbody>
</table>

**Dimensions in mm (u.n.o.)**
- Mass: 0.01 kg

**Tolerances (u.n.o.)**
- ±0.2
- ±0.3
- ±0.5
- ±0.8

**Issue**
- Drawing no.: 2000-05-2117
- Sheet: 1 of 1

**Title:** Plunger Pin

**Drawn:** HS 05-04-2019
**Checked:** VvM 15-04-2019
**Approved:** JWR 09-05-2019

**Dimensions in mm (u.n.o.)**
- 400 1000 2000
- < 7 30 120 400 1000 2000
- > ±0.2 ±0.3 ±0.5 ±0.8 ±1.0 ±1.4 ±2

Raw extrusion in accordance with OEM drawing and EN755-9

**Finish:**
- Dimensions in mm (u.n.o.)

**Issue:** A

This drawing is property of Van Riemsdijk Rotterdam b.v. which reserved all rights.
Weigh container for exact tare and update this drawing
Solidworks Weight: 825 kg
Weighed Weight: xxx kg, xxx lb
(ME Weight = Manufacturer's Empty Weight
MOGW = Max Operational Gross Weight)
RR 335
Structural Substantiation Report
DBJ-container
P/N 1283-40-0000; 1283-40-0001
Issue 3.00 / 07-08-2023
Record of revision

<table>
<thead>
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<th>Date of Revision</th>
<th>Effect on pages</th>
<th>Reason for Revision</th>
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<td>1.00</td>
<td>03-05-2019</td>
<td>All</td>
<td>Initial revision</td>
</tr>
<tr>
<td>2.00</td>
<td>24-09-2019</td>
<td>Pages 8, 16 to 27 (Base results)</td>
<td>Thickness bottom sheet changed from 3.0 to 2.5 mm</td>
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<tr>
<td>3.00</td>
<td>07-08-2023</td>
<td>Front page, header, page 2, 3, 4 &amp; 5</td>
<td>P/N 1283-40-0001 added to report</td>
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</table>

Role | Name            | Function            | Date        |
-----|-----------------|---------------------|-------------|
Prepared | Danielle de Vreede | Compliance Engineer | 25-07-2023 |
Checked  | Anthony Choi    | Compliance Engineer | 04-08-2023 |
Approved | Evelien Vogelaar | Senior Compliance Engineer | 07-08-2023 |

Document control is managed by an electronic PDM-system, therefore script signatures are not used.
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1. General

1.1. Notations

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<th>List of used symbols and abbreviations</th>
<th>Description</th>
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<td>CoG</td>
<td>Centre of Gravity</td>
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<td>CSK</td>
<td>Countersunk</td>
</tr>
<tr>
<td>N</td>
<td>Newton</td>
</tr>
<tr>
<td>daN</td>
<td>Deca Newton</td>
</tr>
<tr>
<td>kN</td>
<td>Kilo Newton</td>
</tr>
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<td>MPa</td>
<td>Mega Pascal</td>
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<tr>
<td>Rf</td>
<td>Reserve factor</td>
</tr>
<tr>
<td>ULD</td>
<td>Unit Load Device</td>
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<tr>
<td>DBJ</td>
<td>IATA ULD Code: D = Non-certified aircraft container, for B-size pallet, J-contour</td>
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</table>

1.2. References

Reference in this substantiation report have been made to the following:

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<th>Ref.</th>
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<td>Air Cargo Unit Load Devices - Performance Requirements and Test Parameters</td>
<td>AS 36100 A</td>
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<td>Air Cargo Unit Load Devices - Load Distribution Model</td>
<td>AS 36101</td>
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<td>Air Cargo Unit Load Devices - Testing Methods</td>
<td>AS 36102</td>
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<td>Multi-Spring representation of fasteners for MSC/NASTRAN Modelling, By Boeing Commercial Airplane Group Strut Structures Technology.</td>
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<td>FEMAP v11.4, SIEMENS 2017</td>
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<td>6</td>
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<td>7</td>
<td>VRR Drawing set for DBJ-container</td>
<td>1283-40-0000; 1283-40-0001</td>
</tr>
<tr>
<td>8</td>
<td>Rivet joint test analyses</td>
<td>R100247-02-1</td>
</tr>
<tr>
<td>9</td>
<td>Interface Lifting &amp; Tie-down provisions</td>
<td>MIL-STD-209K</td>
</tr>
<tr>
<td>10</td>
<td>Testreport_seattrack</td>
<td>RR327</td>
</tr>
</tbody>
</table>

1.3. Drawings

Below a list of applicable drawings

<table>
<thead>
<tr>
<th>Drawing number</th>
<th>Drawing title</th>
<th>Issue</th>
<th>Pages</th>
</tr>
</thead>
<tbody>
<tr>
<td>1283-40-0000</td>
<td>DBJ container</td>
<td>A</td>
<td>4</td>
</tr>
<tr>
<td>1283-40-0001</td>
<td>DBJ container</td>
<td>A</td>
<td>4</td>
</tr>
</tbody>
</table>
2. Substantiation strength DBJ-container

2.1. Introduction

The figure below shows the DBJ-container with its outside dimensions. Figure 2.1.2 shows the container interior.

Differences between P/N 1283-40-0000 and 1283-40-0001 are not structural and will not influence the results stated in this report. See VRR drawing set for DBJ-container (ref. 7) for construction details.
2.2. Purpose

The purpose of this VRR internal report is to demonstrate that the strength of the DBJ-container complies with the airworthiness requirements.

The strength will be substantiated by means of Finite Element Analysis of the base and shelf. And by means of hand calculations.
3. Substantiation strength base in DBJ-container

3.1. Introduction

The DBJ-container is equipped with a forkliftable base (see figure below).

In this chapter the strength of the base will be substantiated by means of Finite Element Analyses.

Fig. 3.1.1 Base of DBJ-container
3.2. Material properties

The figures below show the material properties of the parts in the base.

**Fig. 3.2.1 Base - properties**

- Seat track: AL 6061-T6
- Top sheets: AL 5754-H22, 2.0 mm
- Bottom sheet: AL 7021-T6, 2.5 mm
- Door post: SS 304 AISI, 2.0 mm
- Bent sheet: AL 5754-H22, 3.0 mm
- ISO corner: AL 6082-T6
- Bent sheet (side forklift pocket): AL 5754-H22, 3.0 mm

**Fig. 3.2.2 Base – properties section view**

- Bent sheet: AL 6060-T66, 3.0 mm
- Tubes: AL 6060-T66, 3.0 mm
3.3. Loads

The DBJ-container must be able to be hoisted by a helicopter. Document MIL-STD-209K, Interface Lifting & Tie-down provisions [ref. 9] shows how to determine the helicopter sling load (HSL) material lift point load factor (LF). This LF is used to calculate the design limit load for the hoisting simulation for the DBJ-container.

For the helicopter sling load weight (HSLWT) the MGW of the DBJ-container is used, this is 10000 lb. The Maximum Projected Frontal Area (MPFA) of the DBJ-container is 83 sq ft. See figure 3.3.1 for visualization of the MPFA for a single point lift with a helicopter.

See table 3.3.2 for LF calculation. HSLWT / MPFA = 10000 lb / 83 sq ft = 120 lb/sq ft.

\[ LF = 3.2 \]

Fig. 3.3.1 MPFA single point lift

<table>
<thead>
<tr>
<th>HSLWT/MPFA (lb/sq ft)</th>
<th>HSLWT (lb)</th>
<th>Load Factor</th>
</tr>
</thead>
<tbody>
<tr>
<td>&lt;45</td>
<td>&lt;5,000</td>
<td>5.9</td>
</tr>
<tr>
<td>&lt;45</td>
<td>5,000 - 15,000</td>
<td>5.6</td>
</tr>
<tr>
<td>&lt;45</td>
<td>15,001 - 36,000</td>
<td>3.2 {0.000038x(HSLWT-15,000)}+2.4</td>
</tr>
<tr>
<td>&gt;45 but &lt;60</td>
<td>&lt;5,000</td>
<td>3.5+[0.16x(60-(HSLWT/MPFA))]</td>
</tr>
<tr>
<td>&gt;45 but &lt;60</td>
<td>5,000 - 15,000</td>
<td>3.2+[0.16x(60-(HSLWT/MPFA))]</td>
</tr>
<tr>
<td>&gt;45 but &lt;60</td>
<td>15,001 - 36,000</td>
<td>3.2-[0.000038x(HSLWT-15,000)] +[0.16x(60-(HSLWT/MPFA))]</td>
</tr>
<tr>
<td>&gt;60</td>
<td>&lt;5,000</td>
<td>3.2</td>
</tr>
<tr>
<td>&gt;60</td>
<td>5,000 - 15,000</td>
<td>3.2</td>
</tr>
<tr>
<td>&gt;60</td>
<td>15,001 - 36,000</td>
<td>3.2-[0.000038x(HSLWT-15,000)]</td>
</tr>
</tbody>
</table>

Table 3.3.2 Calculation of lift point LF
**Design Limit Load**

The design limit load for the DBJ-container is calculated using the HSL material lift point LF (=3,2) and the MGW of the container. No plastic deformation is allowed with this load.

In the simulation two loads will be applied on the base, namely a body load and cargo load. Both loads are applied in downward direction (see figure below).

A body load of $3,2 \text{ g}$ in downward direction is used, which is an acceleration of structure mass. The body load is calculated as follows:

$$9,81 \times 3,2 = 31,392 \text{ m/s}^2$$

The maximum gross weight of the DBJ-container is 4536 kg.

The mass of the base model is 304,5 kg.

The applied downward load is calculated as follows:

$$(4536-304,5) \times 9,81 \times 3,2 = 123835 \text{ [N]}$$

**Ultimate load**

No failure in the structure is allowed with this load. The ultimate load is calculated as follows:

$$\text{Design limit load } \times 1.5 = 199253 \text{ [N]}$$

### 3.4. Load application

The load has been applied by means of a nodal load on a RBE2 element in combination with soft DOF spring elements, taking in account the cg-offset of 10% in x- and y-direction. This way, static load application by means of pressurized aircushion is simulated. The applicable acceleration per §3.3 has been applied as a body load.
Since the element size on the sheets differs from the element size on the extrusion profiles two different DOF-spring stiffness are used for applying the load.

The stiffness of the DOF-springs applied on the sheets is 5 N/mm.
The size of plate elements of the sheets is $40 \times 40 = 1600 \text{ mm}^2$ and the size of the plate elements of the extrusion profiles is $20 \times 20 = 400 \text{ mm}^2$.

$$\frac{1600}{400} = 4$$

So the elements of the sheets are 4 times as large as the elements on the extrusion profiles.

Therefore the stiffness of the DOF-springs applied on the extrusion profiles is divided by 4:

$$\frac{5}{4} = 1.25 \text{ N/mm}$$

### 3.5. Centre of gravity

A centre of gravity shift of 10% is used. The shift of the centre of gravity is towards the front and towards one side of the container.

This is considered to be a critical but realistic load case.
3.6. Restraints

Hoisting will be done at the ISO-corners. The base is restrained in the 4 ISO-corners by a hoisting tool which is fastened one or two openings per ISO-corner.

Since the hoisting procedure is not exactly specified, all following hoisting situations are analysed:
- 1 side per ISO-corner, only at the sides (see Fig. 3.6.2)
- 1 side per ISO-corner, only at the front and aft (see Fig. 3.6.3)
- 2 sides per ISO-corner, so both sides and front and aft (see Fig. 3.6.4)
Fig. 3.6.2 Degrees of freedom per ISO-corner (restraints on sides only)

Fig. 3.6.3 Degrees of freedom per ISO-corner (restraints on front and aft only)
3.7. Finite element model

The figure below shows the finite element model of the base.
Since the hull and doors add a lot of stiffness to the base, they are partly simplified modelled and included in analyses, see figure below.

The entire top structure, door portal and door rubbers are excluded from analyses. The door panels and door locks are partly excluded from analyses, only the lower part is included in the model.

**Fig. 3.7.2 Finite element model of base with hull and door panels**
3.8. Analyses results – Limit load (ISO-restraints on sides only)

The results below are calculated with a limit load of 4536 kg x 3,2 G (see §3.3). The load is applied on the entire surface of the base with a 10% centre of gravity shift. The stress may not exceed the yield strength during this load case.

During this calculation the base was supported in the 4 ISO-corners on the sides only, so restraints according to Fig. 3.6.2.

Fig. 3.8.1 Deformation, downward limit load [mm]

Fig. 3.8.2 VonMises Stress, downward limit load [MPa]
<table>
<thead>
<tr>
<th>Material</th>
<th>Maximum stress</th>
<th>Yield strength</th>
<th>Tensile strength</th>
<th>Reserve factor on yield strength</th>
</tr>
</thead>
<tbody>
<tr>
<td>AL 5754-H22</td>
<td>130,6</td>
<td>130</td>
<td>245</td>
<td>1,00</td>
</tr>
<tr>
<td>AL 6060-T66</td>
<td>141,0</td>
<td>160</td>
<td>215</td>
<td>1,13</td>
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<tr>
<td>AL 7021-T6</td>
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<td>1,26</td>
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<table>
<thead>
<tr>
<th>Fastener</th>
<th>Shear force [N]</th>
<th>Tensile force [N]</th>
<th>separate components</th>
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<tr>
<td></td>
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<td>max</td>
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<td>789</td>
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<td>4880</td>
<td>14792</td>
<td>653</td>
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</tbody>
</table>

Some stress peaks of AL 5754-H22 and SS 304 AISI are just above their yield value. These peaks occur at the front of the pallet. Since the entire top structure, door panels (partly), door locks (partly), door portal and door rubbers are excluded from analyses (conservative approach) all material stresses and fastener forces are considered within the allowable.
3.9. **Analyses results – Ultimate load (ISO-restraints on sides only)**

The results below are calculated with ultimate loads, so the load and body load of the previous paragraph are multiplied by 1,5 (see §3.3). During this load case the stress may not exceed the tensile strength.

During this calculation the base was supported in the 4 ISO-corners on the sides only, so restraints according to Fig. 3.6.2.

![Deformation](image1)

![VonMises Stress](image2)

**Fig. 3.9.1 Deformation, downward ultimate load [mm]**

**Fig. 3.9.2 VonMises Stress, downward ultimate load [MPa]**
### Material Strength Table

<table>
<thead>
<tr>
<th>Material</th>
<th>Maximum stress (MPa)</th>
<th>Yield strength (MPa)</th>
<th>Tensile strength (MPa)</th>
<th>Reserve factor on tensile strength</th>
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</thead>
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<tr>
<td>AL 5754-H22</td>
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<td>130</td>
<td>245</td>
<td>1.85</td>
</tr>
<tr>
<td>AL 6060-T66</td>
<td>161.4</td>
<td>160</td>
<td>215</td>
<td>1.33</td>
</tr>
<tr>
<td>AL 6061-T6</td>
<td>32.3</td>
<td>240</td>
<td>260</td>
<td>8.05</td>
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<tr>
<td>AL 6082-T6</td>
<td>180.6</td>
<td>260</td>
<td>310</td>
<td>1.72</td>
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<td>341.0</td>
<td>350</td>
<td>400</td>
<td>1.17</td>
</tr>
<tr>
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<td>517</td>
<td>2.44</td>
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### Fastener Table

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<th>Tensile force [N]</th>
<th>separate components</th>
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<tbody>
<tr>
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<td>max</td>
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<td>5800</td>
<td>1058</td>
</tr>
<tr>
<td>Monobolt Steel 6,4 Rivets</td>
<td>9006</td>
<td>11000</td>
<td>2635</td>
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<td>Csk. Monobolt Steel 6,4 Rivets</td>
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<td>7196</td>
<td>14792</td>
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</table>

All material stresses and fastener forces are within the allowable.
3.10. Analyses results – Limit load (ISO-restraints on front and aft only)

The results below are calculated with a limit load of 4536 kg x 3.2 G (see §3.3). The load is applied on the entire surface of the base with a 10% centre of gravity shift. The stress may not exceed the yield strength during this load case.

During this calculation the base was supported in the 4 ISO-corners on the front and aft only, so restraints according to Fig. 3.6.3.

![Deformation, downward limit load (mm)](image1)

![VonMises Stress, downward limit load (MPa)](image2)
<table>
<thead>
<tr>
<th>Material</th>
<th>Maximum stress</th>
<th>Yield strength</th>
<th>Tensile strength</th>
<th>Reserve factor on yield strength</th>
</tr>
</thead>
<tbody>
<tr>
<td>AL 5754-H22</td>
<td>130,8</td>
<td>130</td>
<td>245</td>
<td>0,99</td>
</tr>
<tr>
<td>AL 6060-T66</td>
<td>142,6</td>
<td>160</td>
<td>215</td>
<td>1,12</td>
</tr>
<tr>
<td>AL 6061-T6</td>
<td>23,5</td>
<td>240</td>
<td>260</td>
<td>10,20</td>
</tr>
<tr>
<td>AL 6082-T6</td>
<td>103,9</td>
<td>260</td>
<td>310</td>
<td>2,50</td>
</tr>
<tr>
<td>AL 7021-T6</td>
<td>293,3</td>
<td>350</td>
<td>400</td>
<td>1,19</td>
</tr>
<tr>
<td>SS 304 AISI</td>
<td>209,2</td>
<td>205</td>
<td>517</td>
<td>0,98</td>
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<table>
<thead>
<tr>
<th>Fastener</th>
<th>Shear force [N]</th>
<th>Tensile force [N]</th>
<th>separate components</th>
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<tr>
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<td>5800</td>
<td>767</td>
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<tr>
<td>Monobolt Steel 6,4 Rivets</td>
<td>5949</td>
<td>11000</td>
<td>238</td>
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<td>418</td>
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</tbody>
</table>

Some stress peaks of AL 5754-H22 and SS 304 AISI are just above their yield value. These peaks occur at the front of the pallet. Since the entire top structure, door panels (partly), door locks (partly), door portal and door rubbers are excluded from analyses (conservative approach) all material stresses and fastener forces are considered within the allowable.
3.11. Analyses results – Ultimate load (ISO-restraints on front and aft only)

The results below are calculated with ultimate loads, so the load and body load of the previous paragraph are multiplied by 1.5 (see §3.3). During this load case the stress may not exceed the tensile strength.

During this calculation the base was supported in the 4 ISO-corners on the sides only, so restraints according to Fig. 3.6.3.

Fig. 3.11.1 Deformation, downward ultimate load [mm]

Fig. 3.11.2 VonMises Stress, downward ultimate load [MPa]
<table>
<thead>
<tr>
<th>Material</th>
<th>Maximum stress</th>
<th>Yield strength</th>
<th>Tensile strength</th>
<th>Reserve factor on tensile strength</th>
</tr>
</thead>
<tbody>
<tr>
<td>AL 5754-H22</td>
<td>134,1</td>
<td>130</td>
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<td>1,83</td>
</tr>
<tr>
<td>AL 6060-T66</td>
<td>161,7</td>
<td>160</td>
<td>215</td>
<td>1,33</td>
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<tr>
<td>AL 6061-T6</td>
<td>35,3</td>
<td>240</td>
<td>260</td>
<td>7,37</td>
</tr>
<tr>
<td>AL 6082-T6</td>
<td>158,1</td>
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<td>310</td>
<td>1,96</td>
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<tr>
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<td>352,3</td>
<td>350</td>
<td>400</td>
<td>1,14</td>
</tr>
<tr>
<td>SS 304 AISI</td>
<td>216,2</td>
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<td>2,39</td>
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<td>max allowed</td>
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<td>1159 4400</td>
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</tr>
<tr>
<td>Monobolt Steel 6,4 Rivets</td>
<td>7253 11000</td>
<td>2603 8200</td>
<td>OK</td>
</tr>
<tr>
<td>Csk. Monobolt Steel 6,4 Rivets</td>
<td>7392 11000</td>
<td>2568 8200</td>
<td>OK</td>
</tr>
<tr>
<td>Hex. Socket Screw SS M8</td>
<td>5473 14792</td>
<td>647 10620</td>
<td>OK</td>
</tr>
</tbody>
</table>

All material stresses and fastener forces are within the allowable.
3.12. Analyses results – Limit load (all ISO-restraints)

The results below are calculated with a limit load of 4536 kg x 3.2 G (see §3.3). The load is applied on the entire surface of the base with a 10% centre of gravity shift. The stress may not exceed the yield strength during this load case.

During this calculation the base was supported in the 4 ISO-corners on both the sides and front and aft, so restraints according to Fig. 3.6.4.
### Material Properties

<table>
<thead>
<tr>
<th>Material</th>
<th>Maximum stress</th>
<th>Yield strength</th>
<th>Tensile strength</th>
<th>Reserve factor on yield strength</th>
</tr>
</thead>
<tbody>
<tr>
<td>AL 5754-H22</td>
<td>130,9</td>
<td>130</td>
<td>245</td>
<td>0.99</td>
</tr>
<tr>
<td>AL 6060-T66</td>
<td>142,3</td>
<td>160</td>
<td>215</td>
<td>1.12</td>
</tr>
<tr>
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<td>23,5</td>
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<td>260</td>
<td>10.21</td>
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<tr>
<td>AL 6082-T6</td>
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<td>310</td>
<td>2.62</td>
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<tr>
<td>AL 7021-T6</td>
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<td>400</td>
<td>1.21</td>
</tr>
<tr>
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<td>208,8</td>
<td>205</td>
<td>517</td>
<td>0.98</td>
</tr>
</tbody>
</table>

### Fastener Properties

<table>
<thead>
<tr>
<th>Fastener</th>
<th>Shear force [N]</th>
<th>Tensile force [N]</th>
<th>separate components</th>
</tr>
</thead>
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</table>

Some stress peaks of AL 5754-H22 and SS 304 AISI are just above their yield value. These peaks occur at the front of the pallet. Since the entire top structure, door panels (partly), door locks (partly), door portal and door rubbers are excluded from analyses (conservative approach) all material stresses and fastener forces are considered within the allowable.
3.13. Analyses results – Ultimate load (all ISO-restraints)

The results below are calculated with ultimate loads, so the load and body load of the previous paragraph are multiplied by 1.5 (see §3.3). During this load case the stress may not exceed the tensile strength.

During this calculation the base was supported in the 4 ISO-corners on the sides only, so restraints according to Fig. 3.6.4.

![Deformation diagram](image1)

**Fig. 3.13.1 Deformation, downward ultimate load [mm]**

![VonMises Stress diagram](image2)

**Fig. 3.13.2 VonMises Stress, downward ultimate load [MPa]**
<table>
<thead>
<tr>
<th>Material</th>
<th>Maximum stress</th>
<th>Yield strength</th>
<th>Tensile strength</th>
<th>Reserve factor on tensile strength</th>
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</tr>
<tr>
<td>AL 6060-T66</td>
<td>161,4</td>
<td>160</td>
<td>215</td>
<td>1,33</td>
</tr>
<tr>
<td>AL 6061-T6</td>
<td>34,5</td>
<td>240</td>
<td>260</td>
<td>7,54</td>
</tr>
<tr>
<td>AL 6082-T6</td>
<td>181,5</td>
<td>260</td>
<td>310</td>
<td>1,71</td>
</tr>
<tr>
<td>AL 7021-T6</td>
<td>352,3</td>
<td>350</td>
<td>400</td>
<td>1,14</td>
</tr>
<tr>
<td>SS 304 AISI</td>
<td>214,2</td>
<td>205</td>
<td>517</td>
<td>2,41</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Fastener</th>
<th>Shear force [N]</th>
<th>Tensile force [N]</th>
<th>separate components</th>
</tr>
</thead>
<tbody>
<tr>
<td>Csk. Monobolt Steel 4,8 Rivets</td>
<td>4217</td>
<td>1149</td>
<td>OK</td>
</tr>
<tr>
<td>Monobolt Steel 6,4 Rivets</td>
<td>7240</td>
<td>2620</td>
<td>OK</td>
</tr>
<tr>
<td>Csk. Monobolt Steel 6,4 Rivets</td>
<td>7182</td>
<td>2576</td>
<td>OK</td>
</tr>
<tr>
<td>Hex. Socket Screw SS M8</td>
<td>5296</td>
<td>642</td>
<td>OK</td>
</tr>
</tbody>
</table>

All material stresses and fastener forces are within the allowable.

3.14. Conclusion base – hoisting load cases

During all analysed hoisting load cases all material stresses and fastener forces are within the allowable.

The maximum deformation of the base at the location of a door lock is 11,09 mm, so the doors remain closed when this deformation occurs considering the length of the lock pins (overlap is 20 mm).
3.15. Analyses results – floor load

Maximum floor load
The figure below shows the top view of the base of the DBJ container. Three critical areas are highlighted. The 2 mm AL 5754-H22 top sheet is not supported underneath these areas.

Area 1 (A1): 10 x 10 mm = 1 cm²
Area 2 (A2): 25,4 x 25,4 mm = 1 inch²
Area 3 (A3): 304,8 x 304,8 mm = 1 foot²

![Top view of base with critical surface areas](image)

The following load cases are analysed, see table below.

<table>
<thead>
<tr>
<th>Load</th>
<th>Surface</th>
</tr>
</thead>
<tbody>
<tr>
<td>200 kg</td>
<td>1 cm²</td>
</tr>
<tr>
<td>440 lb</td>
<td>1 inch²</td>
</tr>
<tr>
<td>2200 lb</td>
<td>1 foot²</td>
</tr>
</tbody>
</table>
In the figures below the Von Mises stress is shown in the top sheet of the base during the different floor load cases. The alloy of the top sheet is aluminium 5754-H22, which has a yield strength of 130 MPa.

**Fig. 3.15.2 VonMises stress in top sheet, load case 200 kg / cm²**

**Fig. 3.15.3 VonMises stress in structure, load case 440 lb / inch²**
3.16. Conclusion base – floor load

During all floor load cases the material stresses in the entire pallet do not exceed the yield strength.
4. Substantiation strength shelf in DBJ-container

4.1. Introduction

The DBJ-container is equipped with a forkliftable shelf (see figure below). This shelf is supported by loading blocks which can be connected to the seat tracks in the DBJ-container.

In this chapter the allowed amount of load on the shelf and the corresponding conditions will be substantiated.

Fig. 4.1.1 Shelf in DBJ-container
4.2. Material properties

The figures below show the material properties of the parts in the shelf.

**Fig. 4.2.1 Shelf - properties**

- **Seat track**
  - AL 6061-T6

- **Top sheets**
  - AL 6082-T6
  - 3.0 mm

- **Tubes**
  - AL 6060-T66
  - 3.0 mm

**Fig. 4.2.2 Shelf – properties bottom view**

- **Bent gussets**
  - AL 5754-H22
  - 3.0 mm

- **Bent sheets**
  - AL 5754-H22
  - 2.0 mm

- **Corner gussets**
  - AL 6082-T6
  - 3.0 mm

- **Forklift pockets**
  - AL 5754-H22
  - 3.0 mm

- **Tubes**
  - AL 6060-T66
  - 2.0 mm
4.3. Loads

Two loads will be applied on the shelf, namely a body load and cargo load. Both loads are applied in downward direction (see figure below).

A body load of 3,2 g in downward direction is used, which is an acceleration of structure mass. The body load is calculated as follows:

\[ 9.81 \times 3.2 = 31.392 \text{ m/s}^2 \]

The applied cargo load is 1000 kg. The applied downward load is calculated as follows:

\[ 1000 \times 9.81 \times 3.2 = 31392 \text{ N} \]
4.4. Centre of gravity

A centre of gravity shift of 15% is used. The shift of the centre of gravity is towards the front and towards one side of the container.

This is considered to be a critical but realistic load case.
4.5. Restraints

The red areas in the figure below show all locations of the vertical seat tracks where loading blocks can be placed.

FEM-analyses are performed on the shelf with at least the 4 locking blocks marked with orange circles in the figure below.

To prevent horizontal shifting of the shelf during FEM-analyses, the shelf-model is constrained in Y-direction on the aft side and constrained in X-direction on the left side of the shelf.
The figure below shows a loading block which is used for supporting the shelf in the DBJ-container.

According to seat track tests (see report RR327) the maximum break force in X-direction for a slightly weaker aluminium alloy is 18894 N. The maximum tensile break force in Z-direction according seat track tests is 26617 N for a double stud, so for a single stud: $\frac{26617}{2} = 13308.5$ N.

$$Z = X \frac{L_1}{L_2} \Rightarrow Z = 18894 \times \frac{54}{120} = 8502 \text{ N}$$

This value in Z-direction is lower than the tested value, so the force in Z is not critical when X is loaded to its maximum value.

$$F = Z_{max} \frac{L_2}{L_1} \Rightarrow F = 13308.5 \times \frac{120}{54} = 29574 \text{ N}$$

So the maximum load at F until break is 29574 N. The maximum load at F until yield is $\frac{29574}{2} = 19715$ N.

Each seat track profile is fastened with 36 Monobolt 4.8 mm rivets, which have a maximum shear force of 5800 N per rivet. Since the direction of the load on the loading blocks is only downward and the seat track is well fastened in that direction the calculation for the maximum load on the loading block can be based on the test values of the seat track tests (most critical part of this construction). So the maximum load in F-direction = 19715 N. This means that each loading block can withstand +/- 1970 kg before plastic deformation of the seat track starts.

The mass of a fully loaded shelf is 1100 kg, multiplied by the load factor 3,2 this is 3520 kg.
4.6. Finite element model

The figure below shows the finite element model of the shelf.

![Finite element model of shelf in DBJ-container](image1)

**Fig. 4.6.1 Finite element model of shelf in DBJ-container**

4.7. Analyses results

The results below are calculated with a load of 1000 kg (load factor 3.2), applied on the entire surface of the shelf (see Fig. 4.3.2). During this calculation the shelf was supported in the 4 corners and in the middle of the aft side.

![Deformation, downward load case](image2)

**Fig. 4.7.1 Deformation, downward load case [mm]**
All material stresses and fastener forces are within the allowable.

<table>
<thead>
<tr>
<th>Material</th>
<th>Maximum stress</th>
<th>Tensile strength</th>
<th>Reserve factor</th>
</tr>
</thead>
<tbody>
<tr>
<td>AL 5754-H22</td>
<td>130,3</td>
<td>245</td>
<td>1,88</td>
</tr>
<tr>
<td>AL 6060-T66</td>
<td>102,6</td>
<td>215</td>
<td>2,10</td>
</tr>
<tr>
<td>AL 6061-T6</td>
<td>24,1</td>
<td>260</td>
<td>10,79</td>
</tr>
<tr>
<td>AL 6082-T6</td>
<td>122,0</td>
<td>310</td>
<td>2,54</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Fastener</th>
<th>Shear force [N]</th>
<th>Tensile force [N]</th>
<th>separate components</th>
</tr>
</thead>
<tbody>
<tr>
<td>Monobolt Steel 4,8 Rivets</td>
<td>1717</td>
<td>5800</td>
<td>64</td>
</tr>
<tr>
<td>Csk. Monobolt Steel 4,8 Rivets</td>
<td>2759</td>
<td>5800</td>
<td>876</td>
</tr>
<tr>
<td>Monobolt Steel 6,4 Rivets</td>
<td>2579</td>
<td>11000</td>
<td>595</td>
</tr>
<tr>
<td>Csk. Monobolt Steel 6,4 Rivets</td>
<td>5714</td>
<td>11000</td>
<td>762</td>
</tr>
</tbody>
</table>

The maximum downward force on a loading block is 15094 N. This is well below the yield force.
The results below are calculated with a load of 1000 kg (load factor 3.2), applied on a small area around the centre of gravity (see Fig. 4.3.3). During this calculation the shelf was only supported in the 4 corners.

Fig. 4.7.3 Deformation, downward load case [mm]

Fig. 4.7.4 VonMises Stress, downward load case [MPa]
<table>
<thead>
<tr>
<th>Material</th>
<th>Maximum stress</th>
<th>Tensile strength</th>
<th>Reserve factor</th>
</tr>
</thead>
<tbody>
<tr>
<td>AL 5754-H22</td>
<td>131,9</td>
<td>245</td>
<td>1,86</td>
</tr>
<tr>
<td>AL 6060-T66</td>
<td>158,3</td>
<td>215</td>
<td>1,36</td>
</tr>
<tr>
<td>AL 6061-T6</td>
<td>43,5</td>
<td>260</td>
<td>5,97</td>
</tr>
<tr>
<td>AL 6082-T6</td>
<td>179,3</td>
<td>310</td>
<td>1,73</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Fastener</th>
<th>Corresponding</th>
<th>Rf,min</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>shear force [N]</td>
<td>axial force [N]</td>
</tr>
<tr>
<td>Monobolt Steel 4,8 Rivets</td>
<td>3042</td>
<td>0</td>
</tr>
<tr>
<td>Csk. Monobolt Steel 4,8 Rivets</td>
<td>4233</td>
<td>1456</td>
</tr>
<tr>
<td>Monobolt Steel 6,4 Rivets</td>
<td>3447</td>
<td>0</td>
</tr>
<tr>
<td>Csk. Monobolt Steel 6,4 Rivets</td>
<td>9507</td>
<td>1323</td>
</tr>
</tbody>
</table>

The maximum downward force on a loading block is 19835 N. This is approximately the yield force according to the seat track test results with a slightly weaker alloy. So if the shelf is only supported at the 4 corners and the 3,2 G load is shifted 15% in both lateral and longitudinal directions, the seat track of the most critical corners reaches the yield stress. Since the test values are based on a weaker alloy with the same seat track thickness, it can be concluded that the stress in the seat track is within the allowables during this load case and it does not exceed the yield value.

**4.8. Conclusion shelf**

A load of maximum 1000 kg can be placed on the shelf, when taking into account the following:

- When using the shelf, **never** use supports at the location of the forklift pockets. The forklift pockets are not able to withstand these local high forces.
- The shelf has to be supported by at least 4 loading blocks in the corners, at the locations marked in orange (see Fig. 4.5.2). It is advised to use more loading blocks to support the shelf, the 4 at the corners, as mentioned before, is the absolute minimum amount.
5. Loading Limits

5.1. Centre of Gravity (CoG)

The Maximum Gross Weight (MGW) of the container is limited to 4536 kg (10000 lb).

When loaded to this MGW of 4536 kg (10000 lb), the Centre of Gravity (CoG) of the loaded container has to be within the following limits:
- Height of CoG, measured from the pallet bottom, must be below 1219 mm (48 inch).
- In the X-direction (parallel to the long side), the CoG must be in the centre of the container base (1321 mm / 52 inch from the side edge) with a tolerance of ± 10% (264 mm / 10.4 in).
- In the Y direction (parallel to the short side), the CoG must be in the centre of the container base (1067 mm / 42 inch from the front edge) with a tolerance of ± 10% (213 mm / 8.4 in).

Fig. 5.1.1 Centre of gravity area
From document SAE AS36101 – Load distribution model [Ref. 2] is known that when the actual ULD gross weight is lower than the max gross weight (4536 kg / 10000 lb), linear trade-off may be used for increased CoG eccentricity limits in proportion of the lower gross weight. See figure 5.1.2 for this trade-off.

![Allowable CoG offset](image)

**Fig. 5.1.2 Allowable CoG offset**

Figure 5.1.2 illustrates, as an example, that for payload that weighs only 50% of the MGW, the lateral and longitudinal CoG offset can vary up to +/- 30% instead of +/- 10% at Maximum gross weight.

Whether at maximum gross weight or the lower gross weight trade-off limitation of fig. 5.1.2, the reference load distribution model shall not be used as a method for actually distributing cargo on a container base at ULD build-up. If a piece of cargo will occupy only part of the base surface, it shall be centred on the base and not in a corner. If only a partial load is planned, stacking shall start in the base centre area rather than at the edge [Ref. 2].

During ULD build-up all steps should be taken to provide a loaded ULD CoG location as closely as possible to its geometric centre. When the nature or shape of cargo makes this impossible in practice, the objective should be to limit CoG offset to one direction only, either longitudinal or lateral, not exceeding the maximum allowable offset in that direction. Only as a last resort should both longitudinal and lateral maximum CoG offset be simultaneously used [Ref. 2].
Example calculation CoG

See figure 5.1.4 for example dimensions
The file ‘CoG_calculation_CTBTO.xlsx’ is used for calculating the centre of gravity.

The origin of this calculation is chosen at the left corner at the back of the container, positive x-direction is to the right, positive y-direction is to the front of the container, positive z-direction is upwards. See figure 5.1.3. for location of origin.

For this example the following loads are used:

M1 = weight of empty container = 827 [kg]
M2 = weight of shelf = 128 [kg]
M3 = bulk on shelf = 500 [kg]
M4 = bulk on base = 3000 [kg]

Locations of loads are shown in the table below and in figure 5.1.4

<table>
<thead>
<tr>
<th>M</th>
<th>Mass [kg]</th>
<th>X [mm]</th>
<th>Y [mm]</th>
<th>Z [mm]</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>827</td>
<td>1250</td>
<td>1000</td>
<td>690</td>
</tr>
<tr>
<td>2</td>
<td>128</td>
<td>1250</td>
<td>1000</td>
<td>1440</td>
</tr>
<tr>
<td>3</td>
<td>500</td>
<td>2250</td>
<td>1300</td>
<td>1540</td>
</tr>
<tr>
<td>4</td>
<td>3000</td>
<td>650</td>
<td>1800</td>
<td>40</td>
</tr>
</tbody>
</table>

Total mass = 4455 [kg]

Total mass < MGW*

*The total mass must be smaller than the MGW of the container (= 4536 [kg])
With a moment calculation around the origin the location of the CoG can be obtained in x-, y- and z-direction.

<table>
<thead>
<tr>
<th>Mass * X</th>
<th>Mass * Y</th>
<th>Mass * Z</th>
</tr>
</thead>
<tbody>
<tr>
<td>1033750</td>
<td>827000</td>
<td>570630</td>
</tr>
<tr>
<td>160000</td>
<td>128000</td>
<td>184320</td>
</tr>
<tr>
<td>1125000</td>
<td>650000</td>
<td>770000</td>
</tr>
<tr>
<td>1950000</td>
<td>5400000</td>
<td>120000</td>
</tr>
<tr>
<td><strong>SUM</strong></td>
<td><strong>7005000</strong></td>
<td><strong>1644950</strong></td>
</tr>
</tbody>
</table>

The CoG shift is obtained by dividing the sum of the moments by the total mass. See figure 5.1.5 for allowed CoG limits.

<table>
<thead>
<tr>
<th>CoG shift</th>
<th>X shift</th>
<th>Y shift</th>
<th>Z shift</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>CoG</strong></td>
<td>958</td>
<td>1572</td>
<td>369</td>
</tr>
<tr>
<td><strong>Limits</strong></td>
<td>986 - 1514</td>
<td>787 - 1213</td>
<td>0 - 1040</td>
</tr>
</tbody>
</table>
The way of loading the container in this example is insufficient. The CoG shift in x- and y- direction is outside the limits set in chapter 5.1.

One solution is to shift the bulk on the base to a location where the container will be more in equilibrium.

Current location M4 \([x; y] = [650; 1800]\).
New location M4 can be \([850; 1200]\).

The CoG shift will now be within the limits, see table below.

<table>
<thead>
<tr>
<th>CoG shift</th>
<th>X(_{shift})</th>
<th>Y(_{shift})</th>
<th>Z(_{shift})</th>
</tr>
</thead>
<tbody>
<tr>
<td>Limits</td>
<td>986 - 1514</td>
<td>787 - 1213</td>
<td>0 - 1040</td>
</tr>
<tr>
<td>CoG shift</td>
<td>1093</td>
<td>1168</td>
<td>369</td>
</tr>
</tbody>
</table>

A second solution is to lower the weight of the bulk. When minimizing the load, the limits of the CoG shifts are expanded according to figure 5.1.2.
5.2. Seattrack / T-track

Seattrack tests are performed at VRR, results are stated in report: RR327_i1_Testreport_Seattrack [Ref. 10]. Extrusion RR172 is comparable with the new Seattrack/T-track extrusion for the DBJ container. The maximum force until break for RR172 is shown in the table below. Directions of load are shown in Fig. 5.2.1. Tests are performed with double stud connections, values for maximum force are translated to single stud connection values.

<table>
<thead>
<tr>
<th>RR172</th>
<th>Direction</th>
<th>Double $F_{\text{break}}$ [N]</th>
<th>Single $F_{\text{break}}$ [N]</th>
</tr>
</thead>
<tbody>
<tr>
<td>X</td>
<td>18894</td>
<td>18894</td>
<td></td>
</tr>
<tr>
<td>Y</td>
<td>15767</td>
<td>7883</td>
<td></td>
</tr>
<tr>
<td>Z</td>
<td>26617</td>
<td>13308</td>
<td></td>
</tr>
</tbody>
</table>

**Fig. 5.2.1 Seattrack with orientation**

**Maximum load capacity seattrack / T-track extrusion in hull**

Fig. 5.2.2 shows the structure of the hull of the DBJ-container. The side wall is considered most critical.

**Fig. 5.2.2 Seattrack and T-track in hull**
Test values:
7800 [N] every 25.4 [mm] in all directions

Rivets:
Maximum Tensile Force for Ø4.8 ST Monobolt is 4400 [N]. Seatrack is fastened with two rivets every 127 [mm]. So (4400*2) = 8800 [N] can be applied on the seatrack extrusion every 127 [mm].

Construction tubes in the side panels:
Length = 2000 [mm]
$I_z$ = 126875 [mm$^4$]
$e_t$ = 16 [mm]
$\sigma_{AL\,6061 \,T6} = 240$ [MPa]
$W = I_z / e_t = 8000$
$F_{max} = (4*\sigma*W) / length = 3800$ [N]*

The distance between two load applications must be minimal 1000 [mm]*.

*When the load decreases, distance linear decreases with load.

To summarize:

<table>
<thead>
<tr>
<th></th>
<th>Test</th>
<th>Rivets</th>
<th>Construction</th>
</tr>
</thead>
<tbody>
<tr>
<td>$F_{max}$ [N]</td>
<td>7800</td>
<td>8800</td>
<td>3800</td>
</tr>
<tr>
<td>Span [mm]</td>
<td>25.4</td>
<td>127</td>
<td>1000</td>
</tr>
</tbody>
</table>

Table 5.2.1 maximum load seatrack side panels

The construction of the side panels is the most critical factor concerning the maximum loading capacity of the seatrack / T-track extrusions.

Conclusion side panels
Concerning the maximum loading capacity of the seattrack / T-track extrusion for the hull of the DBJ-container, the construction of the panels is the critical factor.

Static:
$F_{max} = 3800$ [N] in all directions
Minimum distance between loads = 1000 [mm]*

Dynamic:
In flight applies a load factor of 3.2 in downward direction. This extra load does not affect the structure. From the seattrack test results (see table in paragraph 5.3) there is known that the maximum force in the downward direction is 18894 [N].

$18894 / 3.2 = 5900$ [N]

According to AS36100 a flight load factor of 1.53 applies in sideward direction. This extra load does affect the structure and therefore the maximum load is $3800 / 1.53 = 2484$ [N]

$F_{max} = 2484$ [N] in all directions.
Minimum distance between loads = 1000 [mm]*

*When the load decreases, distance linear decreases with load.

For example:
Applied load on seattrack is $F_{max} / 3 = 828$ [N]; minimum distance is $1000 / 3 = 334$ [mm].
Conclusion roof panel
The length of the construction tubes in the roof panel is shorter than in the side panels (L=1550 [mm]). So maximum load can be higher:

\[ F_{\text{max}} = \frac{4\sigma W}{\text{length}} = 4900 \text{ [N]} \]

From table 5.2.1 can be seen that the construction of the roof panel is still the critical factor. In flight applies a load factor of 3,2 in downward direction. This immediately affects the structure.

\[ F_{\text{max}} = \frac{4900}{3.2} = 1530 \text{ [N]} \]

Minimum distance between loads = 1000 [mm]*

*When the load decreases, distance linear decreases with load.

Maximum load capacity seattrack / T-track extrusion in base
Fig. 5.2.3 shows the structure of the base of the DBJ-container. The part spanning the fork pockets is considered most critical.

Test values:
7800 [N] every 25,4 [mm] in all directions

Rivets:
Maximum Tensile Force for Ø4,8 ST Monobolt is 4400 [N]. Seattrack is fastened with two rivets every 100[mm]. So \((4400\times2) = 8800\) [N] can be applied on the seattrack extrusion every 100 [mm].
Construction tubes in the base:
Length = 350 [mm]
$I_z = 2237640$ [mm$^4$]
$e_t = 40$ [mm]
$\sigma_{AL\,6061\,T6} = 250$ [MPa]
$W = I_z / e_t = 54000$ [mm$^3$]
$F_{\text{max}} = (4*\sigma*W) / \text{length} = 140000$ [N]

To summarize:

<table>
<thead>
<tr>
<th></th>
<th>Test</th>
<th>Rivets</th>
<th>Construction</th>
</tr>
</thead>
<tbody>
<tr>
<td>$F_{\text{max}}$ [N]</td>
<td>7800</td>
<td>8800</td>
<td>140000</td>
</tr>
<tr>
<td>Span [mm]</td>
<td>25,4</td>
<td>100</td>
<td>1000</td>
</tr>
</tbody>
</table>

The test value of the extrusion and the rivet connection to the structure are the most critical factors concerning the maximum loading capacity of the seattrack / T-track extrusions.

**Conclusion base**
Concerning the maximum loading capacity of the seattrack / T-track extrusion for the base of the DBJ-container, the design of the extrusion and the rivet connection to the base are the critical factors.

According to AS36100 a flight load factor of 2,2 applies in upward direction. This extra load has immediately effect on the extrusion and its rivet connection. Therefore the maximum load is $7800 / 2,2 = 3545$ [N]

$F_{\text{max}} = 7800/2,2 = 3545$ [N]
Minimum distance between loads = 100 [mm]

**Maximum load capacity track bar**
Fig. 5.2.3 shows the horizontal track bar fastened in the vertical seattrack / T-track extrusions of the side wall. For each track bar counts the same maximum load as for the seattrack / T-track extrusions of the side wall: $F_{\text{max}} = 2484$ [N] in all directions.
5.3. Conclusion allowable loads on Seatrack / T-track

Seattrack is considered more critical than T-track.
Conservative approach because strength and stiffness of panels is disregarded.
Loads in all directions.

<table>
<thead>
<tr>
<th></th>
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*When the load decreases, distance linear decreases with load.
6. Conclusion

6.1. Conclusion

All loads and stresses are within the acceptable values in all load cases. The rivet loads are within the allowable determined in Appendix A.

Therefore it is concluded that the VRR DBJ-container 1283-40-0000 and 1283-40-0001 is in compliance with the requirements as set by VRR.
7. Appendix A

7.1. Rivets 4, 8 and 6,4 mm steel Monobolt

At VRR Monobolt rivets and Magna-Lok rivets are interchangeable. To accomplish this interchangeability, the values for maximum shear force and tensile force are set to the lowest value of both rivets in FEM calculations. The values for Magna-Lok rivets are used in this case. This approach is conservative.

**Monobolt® 2771**

For installation information please refer to the tooling overview and manuals on our website www.ordel-global.com.

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* BS 3311 Type 9 SAE 10621 DIN 1664 2232
** BS 3311 Type 10 SAE 10835 DIN 1664 3532

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ST Monobolt 4.8 mm
Shear strength 6400 N
Axial strength 5100 N

ST Monobolt 6.4 mm
Shear strength 11700 N
Axial strength 10400 N
Huck® Magna-Lok

- **Head Style Options**

- **Installed Values in Nominal Grip**

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- **ST Magna-Lok 4.8 mm**
  - Shear strength 1300 lbf = 5700 N
  - Axial strength 1000 lbf = 4400 N

- **ST Magna-Lok 6.4 mm**
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DBJ Container / 1283-40-0001
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The technical content of this document is approved under the Authority of EASA ref. AP103 and have been produced in accordance with alternative procedure to DOA nr. EASA.AP103
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1. Introduction

1.1. General

This component maintenance manual (CMM) has been compiled in accordance with the requirements set out in specification ATA 100. It is intended for provision as necessary for an approved maintenance facility to return an unserviceable assembly/component/part in a serviceable condition.

An illustrated part list (IPL) is also included.

1.2. Layout of manual

This manual contains a general description and operation followed by data for maintenance, disassembly and assembly of the ULD. This is followed by an illustrated parts list providing detailed information.

1.3. Revision service

Revision of the product will result in an update of the manual. Service bulletins may be issued separately. These will become available on the customer portal when relevant, and their applicability will be stated in the Service Bulletin itself.
1.4. Reporting of Failures, Malfunctions and Defects

VRR Design Organisation has a system for collecting, investigating and analysing reports of and information related to failures, malfunctions, defects or other occurrences which cause or might cause adverse effects on the continuing airworthiness of any part, appliance or article identified in this manual.

In case of any failure, malfunction, defect or other occurrence related to a part, appliance or article identified in this manual which has resulted in or may result in an unsafe condition, please submit the following information:

- Organisation name
- Approval reference (if relevant)
- Information necessary to identify the aircraft (call-sign) and/or the part affected (part-number / serial number and manufacturer)
- Location, date and time of occurrence (UTC Date and Time)
- A written summary of the occurrence, including damage and injuries if applicable.
- Any other specific information required, including if the unsafe condition has already been reported to a reporting entity, if there was third party damage, the risk classification (if applicable), the status of the part
- The contact person in case of additional questions.

The email address for submitting the information listed above is Quality@vrr.aero
2. Description and operation

2.1. Part number and certification

This component maintenance manual is applicable to:

Type: Container
Model: DBJ - 0628
Part number: 1283-40-0001

The ULD is a non-certified unit.

2.2. Description

The ULD contains a 84” x 104” (2134mm x 2642mm) base. The construction consists of aluminium extrusions, (bent) sheets and sandwich panels. The height of the ULD is 89,9” (2284mm). The ULD is designed to facilitate efficient replacement of parts.
2.3. Technical data

2.3.1. Weight ULD

Theoretical ME Weight 825 kg 1819 lb

2.3.2. General cargo

Maximum Operational Gross Weight 4536 kg 10000 lb
Maximum Net weight 3711 kg 8181 lb
Maximum Height Centre of Gravity 1219 mm 48,0 inch

2.3.3. Outside dimensions (max)

Width 2182 mm 85,9 inch
Length 2672 mm 105,2 inch
Height 2284 mm 89,9 inch

2.3.4. Inside dimensions

Internal volume 9,7 m$^3$ 343 ft$^3$

2.3.5. Door opening

Width 2432 mm 95,7 inch
Height 1989 mm 78,3 inch
2.4. Operation

The ULD shall be checked for damages prior to loading, as damaged ULDs may damage the aircraft loading and/or the restraint system invalidating the certified airworthiness. To ensure that a unit is in a serviceable condition, it must be inspected before each use.

Serviceability limits are indicated in the chapter "Check prior to use".

2.4.1. General

Try to visualize the whole ULD load before commencing to pack, leave heavy and/or big items on the bottom. Spread load equally.

The local-base loading must not exceed:

- 200 kg/cm²
- 440 lb/inch²
- 2200 lb/foot²
- 1000 kg/m²

Cargo must be tied down to the seatrack in the ULD. For details on the maximum loads in the ULD and on the shelf as well as limitations on the location of the Centre of Gravity, refer to the operation manual (RRM628-OM).

Before transporting the ULD on dollies, transporters or other vehicles, ensure that restraint stops, locks or other securing devices have been applied correctly.

The ULD can be transported by a forklift truck. The base is designed to lift a fully loaded ULD.

⚠️ **CAUTION**

» Door must be properly closed when ULD is moved.

» When the container is moved, the hose locks must be closed off by the gaskets, locked with the handles, and covered by zipping up the hose lock covers.

2.4.2. Transport by aircraft

The DBJ is a non-certified container without a pallet base. Before transport the DBJ needs to be placed on a certified aircraft pallet such as an HCU/6E or a PMC pallet and fastened to the pallet with a certified cargo net.

Refer to the operation manual (RRM628-OM) for further details, as well as details on transport by truck.
3. Disassembly

3.1. General

The ULD is built up from insulating panels with internal tube frames. These are joined with sheets, gussets and rivets. Some gussets are fastened with bolts or blind rivets (for example Monobolt rivets).

The doors are joined with bolts.

When disassembling the ULD blind rivets should be drilled out.
4. Cleaning

The interior and exterior faces of the ULD may be cleaned with any good grade industrial detergent, cleaner and/or water. The interior has to be wiped dry with a clean cloth. There are no objections to blowing out the ULD with compressed air or using a vacuum cleaner.

In extremely contaminated condition, steam cleaning is permissible but only with a maximum temperature of 70 degrees Celsius.

If sealing is damaged or missing it shall be restored immediately.

It's permitted to clean the interior and exterior of the ULD with a high pressure cleaner but with a maximum pressure of 2,5 bar.

⚠️ CAUTION

» Never use aggressive agents or chemicals.
» The use of household chemicals is preferred. Iso-Propyl Alcohol (IPA) or Phenolic-based disinfection agents (with the correct dilution ratio) are allowed.
5. **Check prior to use**

5.1. **General**

The DBJ container is a non-certified assembly, and as such not airworthy without the use of a certified net and a certified pallet.

Although not mandatory it is recommended that the container is also checked for each shipment.

The DBJ container has to be used by the airline in combination with a certified pallet and air cargo net.
5.2. **Limitations of damages**

Due to non-airworthiness of the container, limitation of damages could be used as reference and are not mandatory to follow. Due to possible effect to aircraft when entering the cargo hold with damaged equipment, we strongly recommend to adhere to our damage limitations.

If any damages are found that exceed the limitations described below, the unit has to be taken out of services for repair.

5.2.1. **Limitations: damaged top sheet base**

Damage to the top sheet base is allowed, as long as:

- cracks or holes do not exceed an area of more than 50 x 200mm (2” x 8”);
- the distance between extrusion / assembly fasteners and crack (or hole) is not less than 50mm (2”);
- the maximum number of unpatched cracks or holes per sheet does not exceed 3;
- the distance between two cracks/holes is not less than 200mm (8”).

5.2.2. **Limitations: damaged bottom sheet base**

Damage to the bottom sheet base is allowed, as long as:

- there shall be no cracks or holes in the bottom sheet of the pallet;
- no more than 5 mm indentation in a local area of Ø200 mm (Ø8”).
5.2.3. **Limitations: damaged seat track lips**

Damage to the seat track of an edge pallet is allowed, as long as:

- the distance between 2 usable seat track holes is no more than 125mm (5”);
- the distance between 2 damaged areas is no less than 100mm (4”);
- there are no more than 5 damaged areas per long side;
- there are no more than 3 damaged areas per short side.

Damaged seat track lips should be clearly marked and repaired as soon as possible.

5.2.4. **Limitations: damaged internal extrusions base**

- there shall be no cracks or holes in the internal extrusions (through holes or cracks in the sheets).
5.2.5. Limitations: damaged frame extrusions

Damage to the frame extrusions is allowed, as long as:

- There is not more than 1 crack per extrusion.
- The crack in the extrusion does not exceed 12mm (½").

- A permanent deformation of an extrusion does not exceed 25mm (1").
- The deformation does not interfere with the function of the extrusion.
5.2.6. **Limitations: damaged frame sheets**

Damage to frame sheets is allowed, as long as:

- Length of cracks or holes do not exceed 75mm (3”).
- The distance between extrusion / assembly fastener and crack (or hole) is more than 50mm (2”).
- The maximum number of unpatched cracks or holes per sheet (smaller than 75mm (3”)) do not exceed 2.

**Important notice:** **Taping is not a substitute for patching.**

- Cracks and holes smaller than 20mm (0,8”) can be covered by 3M™ aluminium foil tapes 425 or an equivalent. This tape can also be used for temporary taping holes smaller than 75mm.
- The maximum number of covered holes with 3M™ aluminium foil tapes 425 does not exceed 4.

**Important notice:** **This is no repair method.**
5.2.7. Limitations: damaged monopan panel

Damage to Monopan panels is allowed, as long as:

- The length of cracks or holes does not exceed 75mm (3").
- The distance between extrusion / assembly fastener and crack (or hole) is not less than 50mm (2").
- The maximum number of unpatched cracks or holes per sheet, smaller than 75mm (3"), does not exceed 2.
- Panels with a crack or hole with an area of more than Ø300mm, and through both skins, shall be replaced.

**Important notice:** Taping is not a substitute for patching.

Temporary covering cracks and holes:

- 3M™ aluminium foil tapes 425 or an equivalent can be used for temporary covering holes smaller than 75mm.
- The maximum number of covered holes with 3M™ aluminium foil tapes 425 does not exceed 4.

**Important notice:** This is no repair method.
5.2.8. **Limitations: damaged insulation panel**

Damage to insulation panels is allowed, as long as:

- The length of cracks or holes does not exceed 75mm (3’").
- The distance between extrusion / assembly fastener and crack (or hole) is not less than 50mm (2”).
- The maximum number of unpatched cracks or holes per sheet, smaller than 75mm (3’”), does not exceed 2.
- Panels with a crack or hole with an area of more than Ø300mm, and through both skins, shall be replaced.

Although cracks smaller than 75mm does not need to be repaired, in respect to insulation values all damages must be repaired.

**Important notice:** Taping is not a substitute for patching.

Temporary covering cracks and holes:
- 3M™ aluminium foil tapes 425 or an equivalent can be used for temporary covering holes smaller than 75mm.
- The maximum number of covered holes with 3M™ aluminium foil tapes 425 does not exceed 4.

**Important notice:** This is no repair method.

5.2.9. **Limitations: damaged weldments**

Damage in the welds is allowed, as long as:

- Cracks in weld does not exceed 15mm (0,6”).
- The crack is no longer than 50% of total length of weld.

5.2.10. **Limitations: damaged door**

Damage to the doors is allowed, as long as:

- The door panels are not distorted so that the safe and secure closing and latching of the door is affected.
- The deformation of the doors does not exceed the normal external shape of the container.
- There are no damaged or missing door catches or hinge mechanisms.
- The length of cracks or holes do not exceed 50mm (2”).
- There are no more than two damaged areas in one panel.
5.2.11. **Limitations: damaged cover**
Damage to the cover is allowed, as long as:

- the length of a tear does not exceed 100mm (4”);
- There are no worn out or broken stitches.

5.2.12. **Limitations: missing fasteners (screws/bolts/washers/nuts)**
There shall be no missing fasteners (screws/bolts/washers/nuts).

5.2.13. **Limitations: missing rivets**
Missing or damaged rivets on a container are allowed, as long as:

- No more than 10 % of the rivets of one panel are missing or damaged.
- The distance between two missing rivets is not less than 250mm (10”).

- There are no missing rivets on strap handles.
- There are no missing rivets on gussets.

5.2.14. Limitations: damaged or missing manufacturing plate

Damages on the manufacturing plate is not allowed. The manufacturing plate should be replaced when:

- the manufacturing plate is missing or damaged;
- the manufacturing plate is not readable.

If the container is not omni-directional (indicating the direction of loading), the applicable marking must be clearly visible and readable.

5.2.15. Limitations: damaged seattrack, tie-down points

Damage to seat track/tie down points is not allowed.

Seat track/tie down points may only be used when:

- There are no missing rivets or bolts on the tie-down points.
- There are no missing lips on the seat track.

- The tie-down points are not clogged.
6. Repair methods

6.1. General
Repair of the ULD should only be performed by a Part-145 approved repair station. Any substitute material that is not sourced through the manufacturer directly should be approved by the manufacturer before implementation.

6.2. Prior to repair work
Define a 'record classification of damage' for damages and define repairs on a repair work record form. Record ULD p/n as engraved on the TSO marking. Check that p/n corresponds to the CMM, latest issue, which can be found on the VRR customer portal.

6.3. Repair work in process
Check that all materials and repair methods are according to this CMM. Check that all repair methods are in accordance with methods, techniques and standards accepted by aviation authorities.

6.4. Replace work in process
All parts that are damaged beyond the limitations stated in Chapter 5 should to be replaced. The replaced parts should be installed on the ULD in the same manner as the original part. A complete list of replacement parts can be found in the IPL.

6.5. After repair work
Determine that all repair work has been completed and that the markings are complete. Record all performed work, defined damages etc. in the ULD maintenance log. Release ULD back to service with an EASA Form1 or equivalent.
6.6. **Standard patches**

Standard patches are available from VRR. Patches are equipped standard with Ø5 holes (not countersunk). Part numbers for the patches are issued as followed:

RR1.P2030-15-60 where:
- RR1.P is standard for all VRR patches.
- 2030 is the dimensions of the patch in cm (centimetre).
- 15 is the thickness of the patch in mm (millimetre) in which the comma has been left out.
- 60 is the material code; -60 for Alu. 6082-T6 and -70 for Alu. 7021-T6/7075-T6.
- PC is the material code for polycarbonate.
- TW is the material code for Twintex skin.

Example 1:
RR1.P2030-08-60 is a patch of 200x300mm and 0.8mm thick from Alu. 6082-T6.

Example 2:
RR1.P1530-15-60 is a patch of 150x300mm and 1.5mm thick from Alu. 6082-T6.

Example 3:
RR1.P2525-40-70 is a patch of 250x250mm and 4.0mm thick from Alu. 7021-T6/7075-T6.

Example 4:
RR1.P3030-10-TW is a patch of 300x300mm and 1.0mm thick from Twintex skin.

6.7. **Standard patches sandwich panels**

Standard patches for sandwich panels are available from VRR.

Part numbers for the patches are issued as followed:

SP2030_1234-56-7890 where:
- SP is sandwich patch.
- 2030 is the dimensions of the patch in cm (centimetre).
- 1234-56-7890 is the part number of the panel for which the patch is required; (see IPL for part number)

Example 1:
SP2030_2000-04-1324 is a patch of 200x300mm for DRY ICE DOOR PANEL (p/n 2000-04-1324).

Example 2:
SP1530_2000-04-1246 is a patch of 150x300mm for BOTTOM PANEL (p/n 2000-04-1246).
## 6.8. Repair material list

The following aluminium alloys and other (raw) materials and parts are used for repairing the ULD:

- The use of salvaged material from a ULD with identical part number is acceptable, subject to the use of such material being within the scope of work of the Part-145 repair station.

<table>
<thead>
<tr>
<th>Description</th>
<th>Material</th>
<th>Part number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Extrusion</td>
<td>Alu. 7003-T5</td>
<td>See IPL</td>
</tr>
<tr>
<td></td>
<td>Alu. 6061-T6</td>
<td></td>
</tr>
<tr>
<td>Sheet</td>
<td>Alu. 5754-H22</td>
<td>See IPL</td>
</tr>
<tr>
<td>Gusset</td>
<td>Alu. 5754-H22</td>
<td>See IPL</td>
</tr>
<tr>
<td>Blind Rivet</td>
<td>Steel/Alu./Stainless steel</td>
<td>See IPL</td>
</tr>
<tr>
<td>Sealant</td>
<td>Acrylic/Silicone</td>
<td></td>
</tr>
</tbody>
</table>
6.9. Repair top sheet of base with patches

If the cracks and holes in the sheet are beyond the limits described in the damage limitations, the sheet shall be repaired according to the following procedure within the following limitations:

Limitations:

- If any stiffener extrusions are damaged, enlarge the patch so the damaged extrusions can be removed easily;
- Incorporating an existing patch into a new larger patch repair is acceptable. (old patch is replaced by one larger patch);
- The maximum surface of the patches shall not exceed 50% of the surface per segmented part;
- To make sure the patch is making full contact with the sheet, cut away any excess material and make sure the sheet is flat.
- Holes in the patch need to be Ø5mm and spaced no more than 25mm. The holes need to be at least 10mm from the edge of the patch.

Procedure:

- Drill Ø 5,0mm holes at the end of the cracks to prevent further cracking.

- Cracks and / or holes have to be covered by an aluminium (6082-T6) sheet of at least the same thickness as the sheet being patched. For patches on the top panel aluminium 7021-T6/7075-T6 may be used as well;
- Make sure the crack is at least overlapped by 25mm (1") of the patch;
- When placing 2 patches close to each other, it is best that the top patch overlaps the bottom patch;
- It is preferred to use bigger patches for multiple cracks.

6.10. **Repair bottom sheet with patches**

If the cracks and holes in the sheet are beyond the limits described in the damage limitations, the sheet shall be repaired according to the following procedure within the following limitations:

**Limitations:**

- Incorporating an existing patch into a new larger patch repair is acceptable. (old patch is replaced by one larger patch);
- The maximum surface of the patches shall not exceed 50% of the surface of the repaired sheet.

**Procedure:**

- Locate the place of the crack or hole by drawing a square or rectangular box around the crack on the pallet (using a marker). The box drawn should overlap a minimum of 25 mm around the crack or hole.
- Carefully cut out the drawn box of the sheet by using a sheet-cutter or vertical grinder;
- If the cut-out is within 20mm from an inner extrusion, the cut-out has to be extended to 20mm over the inner extrusion. Make sure the corners of the cut-out have a radius of 5mm.

- Drill and countersunk holes (Ø5mm) around the cut out (centreline of holes to be 10mm from the edge of sheet cut-out) with a maximum distance of 30 mm between the holes.

- Install an aluminium strip of 40x3 mm on the internal face of the bottom sheet (overlap minimum 20 mm);
- When there are internal extrusions under the edge of the cut-out, no strip has to be installed at this location.
- Drill holes Ø5mm into the strip by matching the holes around the cut out;
- Fasten the aluminium strip with blind rivets (Ø4.8mm type BK-MGL100-R6-6);

- Fabricate a patch which will fit exactly (tolerance: 1mm) into the cut-out. The thickness of the patch must be the same as the thickness of the bottom sheet (check with p/n in IPL);
- Drill and countersunk holes (Ø5mm) at the edges. The centreline of holes shall be 10mm from the edge of sheet cut out. The maximum distance is 30mm between each hole;
- Mount the patch with countersunk rivets (Ø4.8mm, BK-MGL100-R6-6);
- Apply silicone to seal the edges of the patch.

When Ø4.8mm countersunk rivets (type BK-MGL100-R6-6) are not available, then it is allowed to use countersunk rivets: Ø6.4mm BK-MGL100-R8-8;.

Patches in bottom sheets may also be fastened with an AK countersunk rivet (closed type rivet).

The maximum distance between each hole is 15mm.

6.11. Repair aluminium sheet with patches

If the cracks and holes in the sheet are beyond the limits described in the damage limitations, the sheet shall be repaired according to the following procedure within the following limitations:

Limitations:

- Incorporating an existing patch into a new larger patch repair is acceptable. (old patch is replaced by one larger patch);
- The maximum surface of the patches shall not exceed 50% of the surface per segmented part;
- To make sure the patch is making full contact with the sheet, cut away any excess material and make sure the sheet is flat.
- Holes in the patch need to be Ø5mm and spaced no more than 35mm. The holes need to be at least 10mm from the edge of the patch.
**Procedure:**

- To prevent further cracking, drill Ø 5,0mm holes at the end of the cracks.

- Cracks and / or holes have to be covered by an aluminium (6082-T6) sheet of at least the same thickness as the sheet being patched;

- Make sure the crack is at least overlapped by 25mm (1”) of the patch.

- When placing 2 patches close to each other, it is best that the top patch overlaps the bottom patch.

- It is preferred to use bigger patches for multiple cracks.
6.12. **Repair of bent extrusions**
Straighten the bent edge rail by pressing it in opposite direction.

When using heat, keep in mind that:

- the temperature of the extrusion may not exceed 200°C (392°F);
- the heating period should not be longer than 10 minutes.

6.13. **Replacement of damaged frame extrusions**
Remove the damaged frame extrusion by removing the rivets.

Replace the damaged extrusion by a new one and drill holes (when necessary) for the rivets by matching these holes with the holes on the sheet.

6.14. **Welding of extrusions**
Although the container is a non-welded construction, welding can be used to repair extrusions in case of a crack. The length (lengthwise of extrusion) of the weld may not exceed 150mm (6”). The length (width wise of extrusion) of the weld may not exceed 20mm (0.75”). The distance between two welded cracks should not be less than 500mm (20”). Only crack welding permitted.

Use MIG or TIG welding equipment and welding wire:

- AA5183 - AlMg4.5Mn /
- AA5356 - AlMg5.

6.15. **Repair Monopan panel (of modular roof)**
If damages to the Monopan panel are beyond the limitations described in the damage limitations, the MonoPan panel should be repaired according to one of the following two procedures:
Crack through skin only

- Cut a piece of Twintex skin which should overlap the crack by 30mm on each side;
- Clean the Twintex skin and the panel with IsoPropyl Alcohol (IPA);
- Apply Saba Primer 4518 to the face of the Twintex skin and to the face of the panel and let dry for 15 minutes.

- Apply adhesive to the face of the Twintex Skin and the panel.
- Fix the Twintex skin on the panel;
- The adhesive is dry after 48 hours.

Crack through panel

- Cracks and holes which are through both Twintex skins have to be cut out;
- Make a panel-insert with exact the same dimensions as the cut out piece.
6.16. Repair of insulation material

When the insulation is damaged or missing due to damages of the outer and or the inner sheets, the following actions have to be taken:

- Remove the insulation material in the area around the hole with a sharp knife
- It is advised to cut at an angle by which the open side is smaller than the opposite side
- Clean the hole with a vacuum cleaner;
- Use self-expanding insulation foam and spray it into the hole;

- When the self-expanding foam is dry and fully expanded, cut away excess material;

- Patch the skin of the panel.
- Seal all patch edges.

6.17. Repair of delamination

If there is any delamination of the panel (inside or outside) the delaminated part of the panel sheet should be cut out and repaired with a patch.
6.18. **Repair of damaged sandwich panel**

If damages to a sandwich panel are beyond the limitations described in the damage limitations, the sandwich panel should be repaired according to the following procedure:

- Determine the material of the sheet being patched.
- For composite panel, place patches according to the ‘composite’ description.
- For aluminium panel, place patches according to the ‘aluminium’ description.

**Damage to the composite sheet:**

- Damages to the sheet only can be patched in the same way a single sheet would be.

**Damage to the panel (composite sheet):**

- Cut out the damage to the panel;
- Make a panel-insert with a clearance of 1mm on all sides from the cut out piece.

See STANDARD PATCHES SANDWICH PANELS for ordering panel inserts.

- The materials to be bonded should be dry and dust free.
- Clean all joints with IsoPropyl Alcohol (IPA) and let dry.
- Apply SABA Primer 4518 and allow to dry for at least 15min. The maximum drying time is approximately 4 hours.
- Apply SABA Activator 9400 to the aluminium parts (with a soft / lint-free cloth).
- Apply structural adhesive in small beads and insert the insert into the panel. Allow adhesive to cure for 24 hours per 3mm of bead thickness.

**Damage to the aluminium sheet:**

- Damages to the sheet only can be patched in the same way a single sheet would be.
Damage to the panel (aluminium sheet):

- Cut out the damage to the panel;

- Make a panel-insert with a clearance of 1mm on all sides from the cut out piece.

See STANDARD PATCHES SANDWICH PANELS for ordering panel inserts.

- Place the new insert in the cut hole and place patches on both sides of the panel;
- Drill holes (Ø5mm, 25mm apart and 10mm from the edge) through the patches and the panel skins.
- Install Ø 4,8 mm rivets BK-AD064SB or BK-AD066SB, which is a blind type.

Substitute rivets should have a minimum shear strength of 1810 N (=185kg or 407lbs).

6.19. **Replacing rubber door extrusions**

When the door seals (being rubber and plastic extrusions) are damaged beyond the limitations described in the damage limitations, the seals should be repaired according to the following method:

**Remove damaged extrusion**
- Remove any rivets that keep the extrusion in place;
- Remove the extrusion gently, for the extrusions are glued to the panel;

**Clean door panel and replacement extrusion**
- Use a cleaner to clean the parts holding the seal extrusion;
- Clean the seal extrusion;

**Replace extrusion**
- Apply sealant to the new seal extrusion.
- Directly after applying the sealant, place the seal onto the door panel.
- Fasten the extrusion with Masterbulb rivets (See IPL to see which rivet to use);
- Let the sealant dry.

6.20. **Repair of cover**

If the cover is damaged beyond the limits described in the damage limitations the cover has to be repaired according to the following procedure and within the following limitations:

**Limitations:**
- Tears and holes need to be covered by a patch;
- The patch shall have at least the same strength as the cover that is being repaired;
- The patch shall be at least as thick as the cover that is being repaired;
- Preferred direction of patch is parallel to frame;
- Tears close to existing patches are preferred to be patched by a larger patch, covering both tears. This replaces the existing patch;
- Stitches shall be repaired using the original pattern and thread size;
- Sewing shall be done in a ‘locking stitch’ pattern;
- The area of the patches does not exceed 50% of the part of the cover being repaired.
**Patch procedure**

- To prevent further tearing, cut holes in all tear ends.
- Use an overlap of 25mm (1"). Round off corners of the patch;
- Stitch 5mm (0.2") from the edge of the patch.

When thermal welding, the temperature in the weld must be between 170°C (340°F) and 205°C (400°F). Press patch firmly on cover during welding.

- When patching on the edge of the cover, flip 50mm of the patch to aft side of cover. Stitch 5mm (0.2") from the edges of the patch.

Replaced (additional) pieces of cover or Velcro has to be stitched all around, 5mm (0.2") from all edges.
6.21. **Missing rivets**

Replacement of rivets should be in conformity with the illustrated spare part list. When possible, the new rivets should be larger than the original.

Below the table that describes the interchangeability of commonly used rivets:

<table>
<thead>
<tr>
<th>Rivet</th>
<th>Ø4.8</th>
<th>Equivalent</th>
<th>Ø4.8</th>
<th>Equivalent</th>
</tr>
</thead>
<tbody>
<tr>
<td>Monobolt</td>
<td>BK-02771-00613</td>
<td>Magna-lok</td>
<td>BK-MGLP-R6-4</td>
<td></td>
</tr>
<tr>
<td>Monobolt</td>
<td>BK-02761-00615</td>
<td>Csk.</td>
<td>BK-MGL100-R6-6</td>
<td></td>
</tr>
<tr>
<td>Ø4.8 Csk.</td>
<td>BK-02721-00615</td>
<td>Ø4.8 Csk.</td>
<td>BK-MGL100-U6-6</td>
<td></td>
</tr>
<tr>
<td>Monobolt</td>
<td>BK-02771-00817</td>
<td>Ø6.4</td>
<td>BK-MGLP-R8-6</td>
<td></td>
</tr>
<tr>
<td>Monobolt</td>
<td>BK-02771-00824</td>
<td>Ø6.4</td>
<td>BK-MGLP-R8-10</td>
<td></td>
</tr>
<tr>
<td>Monobolt</td>
<td>BK-02761-00821</td>
<td>Ø6.4</td>
<td>BK-MGL100-R8-8</td>
<td></td>
</tr>
<tr>
<td>Monobolt</td>
<td>BK-02721-00821</td>
<td>Ø6.4</td>
<td>BK-MGL100-U8-8</td>
<td></td>
</tr>
</tbody>
</table>

6.22. **Guidelines for replacing Nord-Lock securing washers**

Use below torque values for fastening bolts with Nord-Lock rings.
Apply CU/C paste (copper/graphite paste A2-70, A4-70).

<table>
<thead>
<tr>
<th>Size</th>
<th>Torque</th>
</tr>
</thead>
<tbody>
<tr>
<td>M4</td>
<td>3,0 Nm</td>
</tr>
<tr>
<td>M5</td>
<td>5,5 Nm</td>
</tr>
<tr>
<td>M6</td>
<td>8,1 Nm</td>
</tr>
<tr>
<td>M8</td>
<td>18,0 Nm</td>
</tr>
<tr>
<td>M10</td>
<td>26,0 Nm</td>
</tr>
<tr>
<td>M12</td>
<td>41,0 Nm</td>
</tr>
<tr>
<td>M16</td>
<td>108,0 Nm</td>
</tr>
</tbody>
</table>
6.23. **Missing bolts**
Replacement of bolts should be in conformity with the illustrated spare part list.

Below the table that describes the interchangeability of commonly used bolts:

<table>
<thead>
<tr>
<th>Bolt</th>
<th>Equivalent</th>
</tr>
</thead>
<tbody>
<tr>
<td>ISO 4762 hexagonal / torx head bolts – class 70 or higher</td>
<td>ISO 14579 TORX – class 70 or higher</td>
</tr>
<tr>
<td>ISO 10642 hexagonal and torx head bolts – class 70 or higher</td>
<td>ISO 14581 TORX – class 70 or higher</td>
</tr>
</tbody>
</table>

6.24. **Repair / Restore of the sealed edges in the container**
When sealed edges are damaged or missing, they should be restored immediately.

The edges should be cleaned and degreased using a non-corrosive degreaser such as IsoPropyl Alcohol (IPA) or household degreaser/dish washing soap.

For restoring the sealing the appropriate sealant should be used, which can be found in the repair material list.

6.25. **Repair of corrosion protection**
The doors are provided with steel hardware, which has a zinc-based coating from the manufacturer. Due to intense operational use in a humid environment, as well as bumps and scratches, corrosion might occur.

If corrosion occurs, remove the corrosion with a wire brush, and use a zinc-based etch primer on the corroded parts. This method should also be used for corrosion on powdercoated (white) skin sheets, but should in that case be followed with a colour-matched, 1K automotive finishing paint.

Apply a mild grease (MIL-PRF-81322 or similar) on moving parts, for smooth operation and as protection against environmental elements.
7. Assembly

The ULD will be delivered fully assembled in accordance to the applicable drawings.
8. **Fits and clearances**

Not applicable
9. **Special tools, fixtures and equipment**

Not applicable
10. **Illustrated parts list**

The illustrated parts list describes all parts required for the unit listed on the title page.

The item numbers in the bill of material correspond to the numbers on the illustrations of the applicable assembly.

The following version of the container are indicated in this IPL:

<table>
<thead>
<tr>
<th>Partname</th>
<th>DBJ Container</th>
</tr>
</thead>
<tbody>
<tr>
<td>Partnumber</td>
<td>1283-40-0001</td>
</tr>
</tbody>
</table>
### DBJ CONTAINER

P/N 1283-40-0001

<table>
<thead>
<tr>
<th>ITEM NO.</th>
<th>PART NUMBER</th>
<th>DESCRIPTION</th>
<th>QTY.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>2000-07-2725</td>
<td>DBJ base level 1</td>
<td>1</td>
</tr>
<tr>
<td>2</td>
<td>2000-07-2646</td>
<td>Hull DBJ</td>
<td>1</td>
</tr>
<tr>
<td>3</td>
<td>2000-07-3478</td>
<td>DBJ Door Left</td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>2000-07-3476</td>
<td>DBJ Door Right</td>
<td>1</td>
</tr>
<tr>
<td>5</td>
<td>2000-07-3488</td>
<td>Track bar</td>
<td>2</td>
</tr>
<tr>
<td>6</td>
<td>2000-07-2969</td>
<td>Manufacturer plate</td>
<td>1</td>
</tr>
<tr>
<td>7</td>
<td>BK-BAPKTR-06W-04</td>
<td>Bk.Rivet Klamp-Tite 4,8</td>
<td>4</td>
</tr>
<tr>
<td>8</td>
<td>BO-NORDLCK-08SP-SMO</td>
<td>Nord-Lock Large Washer M8</td>
<td>16</td>
</tr>
<tr>
<td>9</td>
<td>BO-4017-08025-A2</td>
<td>Hex. Head Screw</td>
<td>16</td>
</tr>
<tr>
<td>10</td>
<td>BO-14581T-08025-A2</td>
<td>Torx Socket Csk. Screw</td>
<td>8</td>
</tr>
<tr>
<td>11</td>
<td>LI-INNO.SEAL-WIT</td>
<td>INNO-SEAL White</td>
<td>1</td>
</tr>
</tbody>
</table>

![DBJ Container Diagram](image-url)
DBJ CONTAINER
P/N 1283-40-0001
## DBJ BASE LEVEL 1

**P/N 2000-07-2725**

<table>
<thead>
<tr>
<th>ITEM NO.</th>
<th>PART NUMBER</th>
<th>DESCRIPTION</th>
<th>QTY.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>2000-07-2726</td>
<td>DBJ base Level 2</td>
<td>1</td>
</tr>
<tr>
<td>2</td>
<td>2000-05-1114</td>
<td>Seat/T-track beam</td>
<td>1</td>
</tr>
<tr>
<td>3</td>
<td>2000-05-1117</td>
<td>Seat/T-track beam</td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>2000-05-1083</td>
<td>Seat/T-track beam</td>
<td>5</td>
</tr>
<tr>
<td>5</td>
<td>2000-05-0272</td>
<td>top base sheet</td>
<td>4</td>
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<tr>
<td>6</td>
<td>2000-05-0273</td>
<td>top base sheet</td>
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</tr>
<tr>
<td>7</td>
<td>2000-05-0394</td>
<td>top base sheet</td>
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</tr>
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<td>8</td>
<td>2000-05-1098</td>
<td>top base sheet</td>
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<td>9</td>
<td>2000-04-8710</td>
<td>outside doorpost</td>
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<td>10</td>
<td>2000-04-8713</td>
<td>Inside doorstep</td>
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<tr>
<td>11</td>
<td>2000-04-8336</td>
<td>Door rubber Extrusion</td>
<td>1</td>
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<tr>
<td>12</td>
<td>2000-05-1764</td>
<td>Doorkeeper base</td>
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<tr>
<td>13</td>
<td>2000-05-1763</td>
<td>Locking block</td>
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<tr>
<td>14</td>
<td>SL-1201436</td>
<td>Keeper</td>
<td>2</td>
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<tr>
<td>15</td>
<td>2000-05-0265</td>
<td>upper floor</td>
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<tr>
<td>16</td>
<td>2000-05-0268</td>
<td>Topfloor Aft Edge</td>
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<td>17</td>
<td>2000-05-0916</td>
<td>Top floor edge Front</td>
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<tr>
<td>18</td>
<td>2000-05-1097</td>
<td>Leg bracket</td>
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<tr>
<td>19</td>
<td>2000-05-1116</td>
<td>Leg bracket</td>
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P/N 2000-07-2726

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P/N 2000-07-2726
### BASE EDGE REAR

P/N 2000-07-2727

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P/N 2000-07-2727
## BASE EDGE SIDE

P/N 2000-07-2728

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## Illustrated Parts List

### Base Edge Front

**P/N 2000-07-2968**

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BASE EDGE FRONT

P/N 2000-07-2968
# SEAT/T-TRACK BEAM

P/N 2000-05-1114

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P/N 2000-05-1114
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# SEAT/T-TRACK BEAM

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HULL DBJ
P/N 2000-07-2646

Illustrated parts list
HULL DBJ
P/N 2000-07-2646
# DBJ PANEL LEFT

**P/N 2000-07-2647**

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DBJ PANEL LEFT
P/N 2000-07-2647
### DBJ PANEL RIGHT

**P/N 2000-07-2972**

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P/N 2000-07-2972
### DBJ PANEL REAR

**P/N** 2000-07-2685

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DBJ PANEL REAR

P/N 2000-07-2685
# DBJ PANEL TOP

P/N 2000-07-3665

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DBJ PANEL TOP
P/N 2000-07-3665
### DBJ PANEL SLANTED

**P/N 2000-05-0357**

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P/N 2000-05-0357
# ROLLER TRACK LEFT ASSY

P/N 2000-07-2750

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![Diagram of roller track left assembly]
ROLLER TRACK RIGHT ASSY
P/N 2000-07-2975

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### COVER CONNECTION ASSY
P/N 2000-05-2107

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COVER CONNECTION ASSY
P/N 2000-05-2107
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P/N 2000-05-1507

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![Diagram of hose lock cover]
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DBJ DOOR LEFT
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P/N 2000-07-3478
### DBJ DOOR 1

P/N 2000-05-0511

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P/N 2000-05-0520

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P/N 2000-05-0520
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P/N 2000-07-3479

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P/N 2000-07-3479
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P/N 2000-07-3476

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DBJ DOOR RIGHT 3
P/N 2000-07-3477
DBJ DOOR RIGHT 3
P/N 2000-07-3477
## TRACK BAR

P/N 2000-07-3488

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![Track Bar Diagram](image)
**TRACK BAR STUD**
P/N 2000-05-2116

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![Diagram of Track Bar Stud]
## EXTENDIBILITY PACK

**P/N 2000-07-2624**

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P/N 2000-07-2624
RAMP
P/N 2000-04-9116

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### MODULAR ROOF

P/N 2000-07-2626

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MODULAR ROOF
P/N 2000-07-2626
MODULAR ROOF

P/N 2000-07-2626
**TOP DOOR HANDLE**

P/N 136.061-250

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![Diagram of TOP DOOR HANDLE](image-url)
# CARDAN JOINT

**P/N 2000-02-0921**

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![Diagram of Cardan Joint](image)
ROOF SUPPORT BRACKET
P/N 2000-07-2774

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PLUNGER-ASSY
P/N 2000-01-6016

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![Diagram of PLUNGER-ASSY P/N 2000-01-6016]

SECTION A-A
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SHELF
P/N 2000-05-0438
## PANEL BRACKET
P/N 2000-04-8893

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## CONTOUR GUIDANCE PIECES

P/N 2000-07-2664

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TUNNEL
P/N 2000-05-1667

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![Tunnel Diagram](image-url)
STATEMENT OF CONFIRMATION

On behalf of (name of firm or organization): _______________________________. I hereby attest and confirm that:

a) The firm/organization possesses the legal status and capacity to enter into legally binding contracts with the Commission for the supply of equipment, supplies, services or work.

b) The firm/organization is not insolvent, in receivership, bankrupt or being wound up, and not under administration by a court or a judicial officer, and that it is not subject to the suspension of its business or legal proceedings for any of the foregoing reasons.

c) The firm/organization has fulfilled all its obligations to pay taxes and social security contributions.

d) The firm/organization has not, and that its directors and officers have not, within the last five years been convicted of any criminal offense related to professional conduct or the making of false statements or misrepresentations as to their capacity or qualifications to enter into a procurement or supply contract.

e) The Commission, in the event that any of the foregoing should occur at a later time, will be duly informed thereof, and in any event, will have the right to disqualify the firm/organization from any further participation in procurement proceedings.

f) The firm/organization did not/will not attempt to influence any other bidder, organization, partnership or corporation to either submit or not submit a proposal/bid/quotation.

g) The firm/organization will not, in the absence of a written approval from the Commission, permit a person to contribute to, or participate in, any process relating to the preparation of a Quotation/Bid/Proposal or the procurement process if the person:

   a. at any time during the 12 months immediately preceding the date of issue of the Solicitation was an official, agent, servant or employee of, or otherwise engaged by the Commission;
   b. at any time during the 24 months immediately preceding the date of issue of the Solicitation was an employee of the Commission personally engaged, directly or indirectly, in the definition of the requirements, project or activity to which the Solicitation relates.

h) Neither the organization/firm, its parent entities (if any), nor any of its subsidiary or affiliated entities (if any) have been identified on, or associated with any individual, groups, undertakings and entities identified on, the list established pursuant to the UN Security Council Resolution 1267 (Consolidated Sanctions List).¹

i) Neither the organization/firm, its parent entities (if any), nor any of its subsidiary or affiliated entities (if any) are subject to any form of sanction imposed by an organization or body within the United Nations System, including the World Bank.

¹The Consolidated United Nations Security Council Sanctions List can be found on the following website: https://www.un.org/securitycouncil/content/un-sc-consolidated-list
j) Neither the organization/firm, its parent entities (if any), nor any of its subsidiary or affiliated entities (if any), is engaged in any practice inconsistent with the rights set forth in the Convention on the Rights of the Child, including Article 32 thereof, which, inter alia, requires that a child shall be protected from performing any work that is likely to be hazardous or to interfere with the child’s education, or to be harmful to the child’s health or physical, mental, spiritual, moral, or social development.

k) Neither the organization/firm, its parent entities (if any), nor any of its subsidiary or affiliated entities (if any) will use the funds received under contracts/purchase orders with the Commission to provide support to individuals, groups, undertakings or entities associated with terrorism.

l) The prices in the firm/organization’s proposal/bid/quotations have been arrived at independently, without consultation, communication or agreement with any other interested companies, competitor or potential competitor with a view to restricting competition.

m) The Commission shall have the right to disqualify the firm/organization from participation in any further procurement proceedings, if it offers, gives or agrees to give, directly or indirectly, to any current or former staff member of the Commission a gratuity in any form, an offer of employment or any other thing of service or value, as an inducement with respect to an act or a decision of, or a procedure followed by, the Commission in connection with a procurement proceeding.

n) The Commission shall have the right to disqualify the firm/organization from participation in any further procurement proceedings if it does not disclose to the Commission any situation that may appear as a conflict of interest, and if it does not disclose to the Commission if any official or professional under contract with the Commission have an interest of any kind in the firm/organization’s business or any kind of economic ties with the firm/organization.

o) The firm/organization expressly agrees to abide by the United Nations Supplier Code of Conduct.¹

Name (print): ___________________________ Signature: ___________________________

Title/Position: __________________________

Place (City and Country): __________________________ Date: __________________________

# VENDOR PROFILE FORM (VPF) – FOR PRODUCTS/SERVICES/WORK

1. **Name of Company:**

2. **Street Address:**

3. **Telephone:**

4. **E-Mail:**

5. **Website:**

6. **Contact Person:**

7. **Title:**

8. **Year Established:**

9. **Number of Employees:**

10. **Gross Corporate Annual Turnover (US$m)**:

11. **Annual Export Turnover (US$m)**:

12. **Type of Business/Products:**

   - Manufacturer
   - Sole Agent
   - Supplier
   - Other (please explain)

13. **Type of Business/Services/Work:**

   - Engineering
   - Civil Work
   - Governmental Institution
   - Other (please explain)

14. **References (your main customers, country, year and technical field of products, services or work):**

15. **Previous Supply Contracts with United Nations Organizations (over the last 3 years):**

   **Organization:**
   - **Value in US$ Equivalent:**
   - **Year:**

   **Organization:**
   - **Value in US$ Equivalent:**
   - **Year:**

16. **Summary of any changes in your company’s ownership during the last 5 years:**

* Please provide a copy of the most recent audited annual report and accounts. Note: Export includes services or work performed abroad or for foreign clients.

** Please provide supplementary documentation on these items.
17. List of Products/Services/Work offered:

<table>
<thead>
<tr>
<th>Product/Service/Work #</th>
<th>Product/Service/Work Description</th>
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18. This section shall be **signed and stamped** by an official legally authorized to enter into contracts on behalf of your organization:

Name:                                                                 Title:  Signature:  Date:

**Bank Details**

Bank Name:          
Bank Address:       
Exact Account Holder Name:

**Beneficiary Details**

Beneficiary Name: (exactly as stated on bank statements)
IBAN: (if applicable)
Account number:
SWIFT/BIC:         
ABA/Sort Code:     

**Additional Details** (if applicable)

Correspondent bank:       
Correspondent account number:    
Correspondent SWIFT/BIC:         
Tax Identification Number:

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* Please provide a copy of the most recent audited annual report and accounts. Note: Export includes services or work performed abroad or for foreign clients.  
** Please provide supplementary documentation on these items.