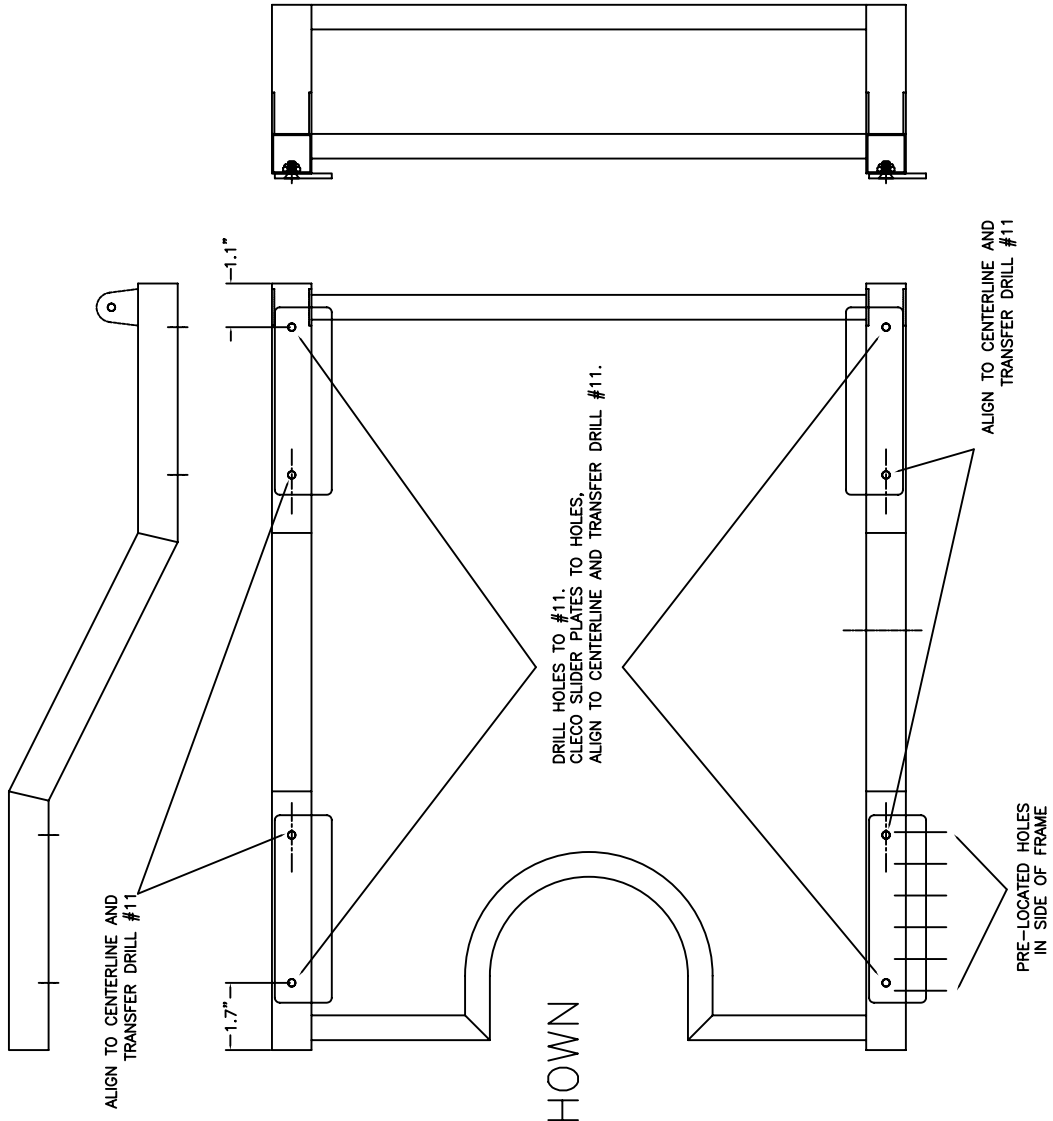


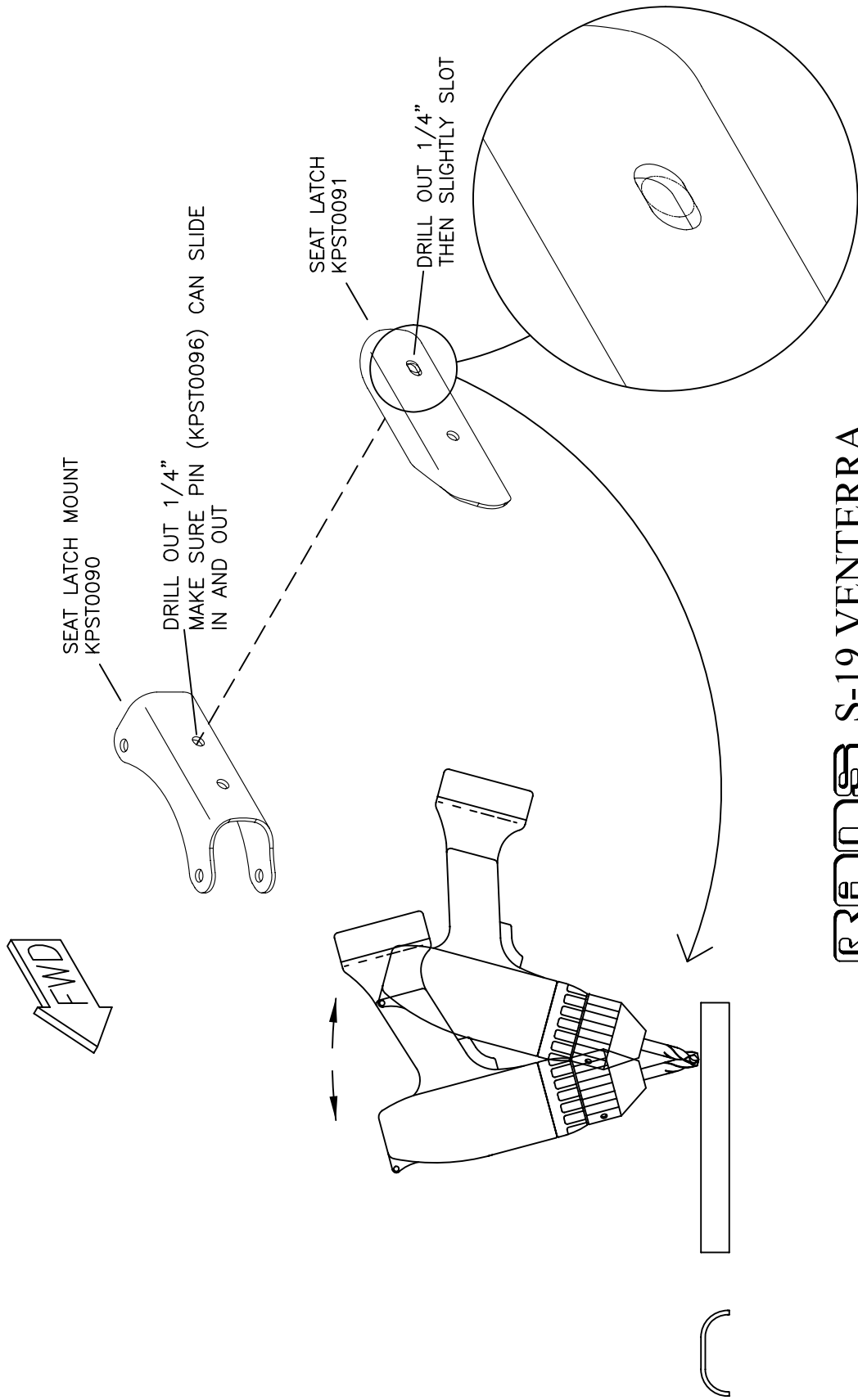
## 11 – SEAT ASSEMBLY AND INSTALLATION

SEAT BOTTOM FRAME DRILLING .....	11-02
SEAT LATCH AND MOUNT MODIFICATION .....	11-04
SEAT BACK ATTACH GUSSET DRILLING .....	11-09
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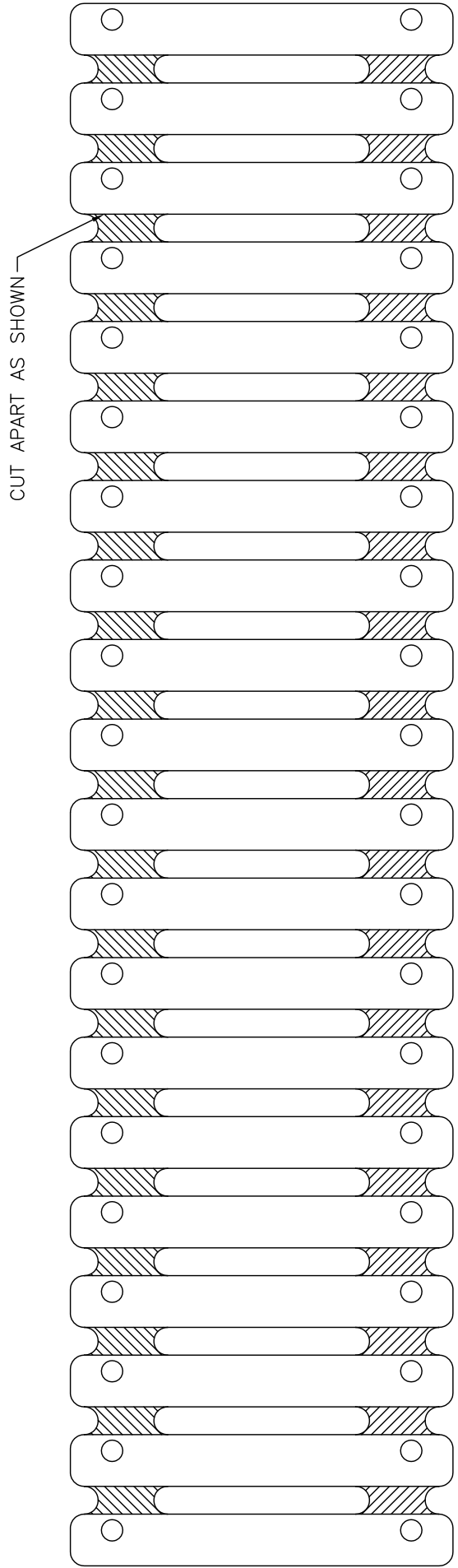
LH FRAME SHOWN

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



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

MD5445

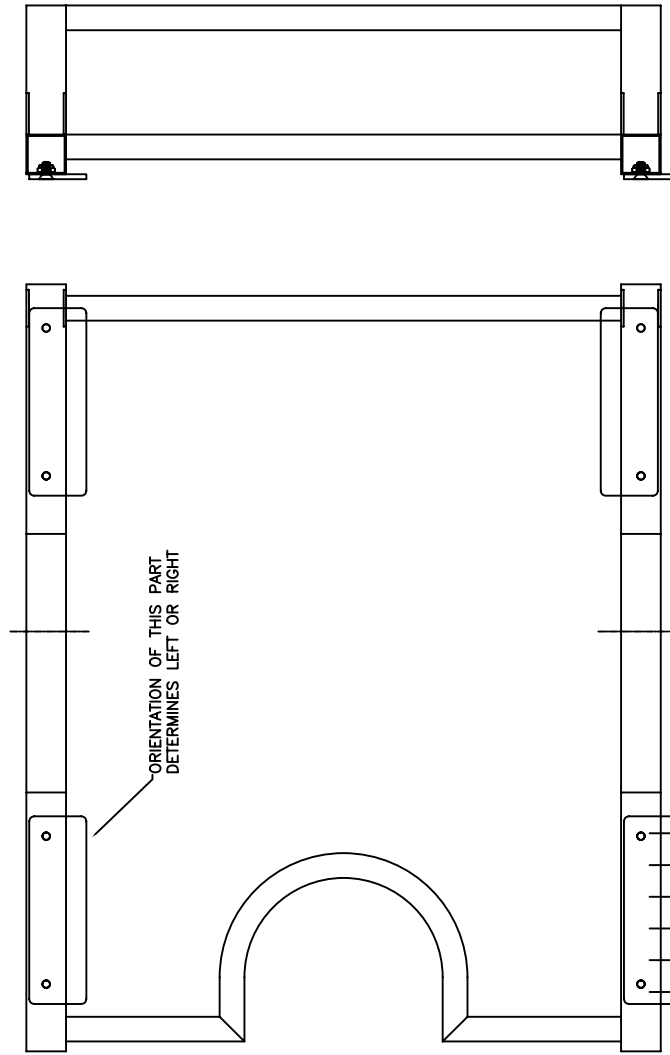
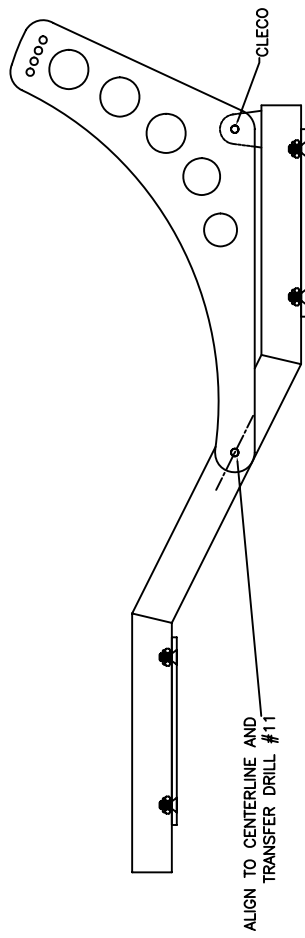


CUT APART AS SHOWN

MAKES 20 PARTS

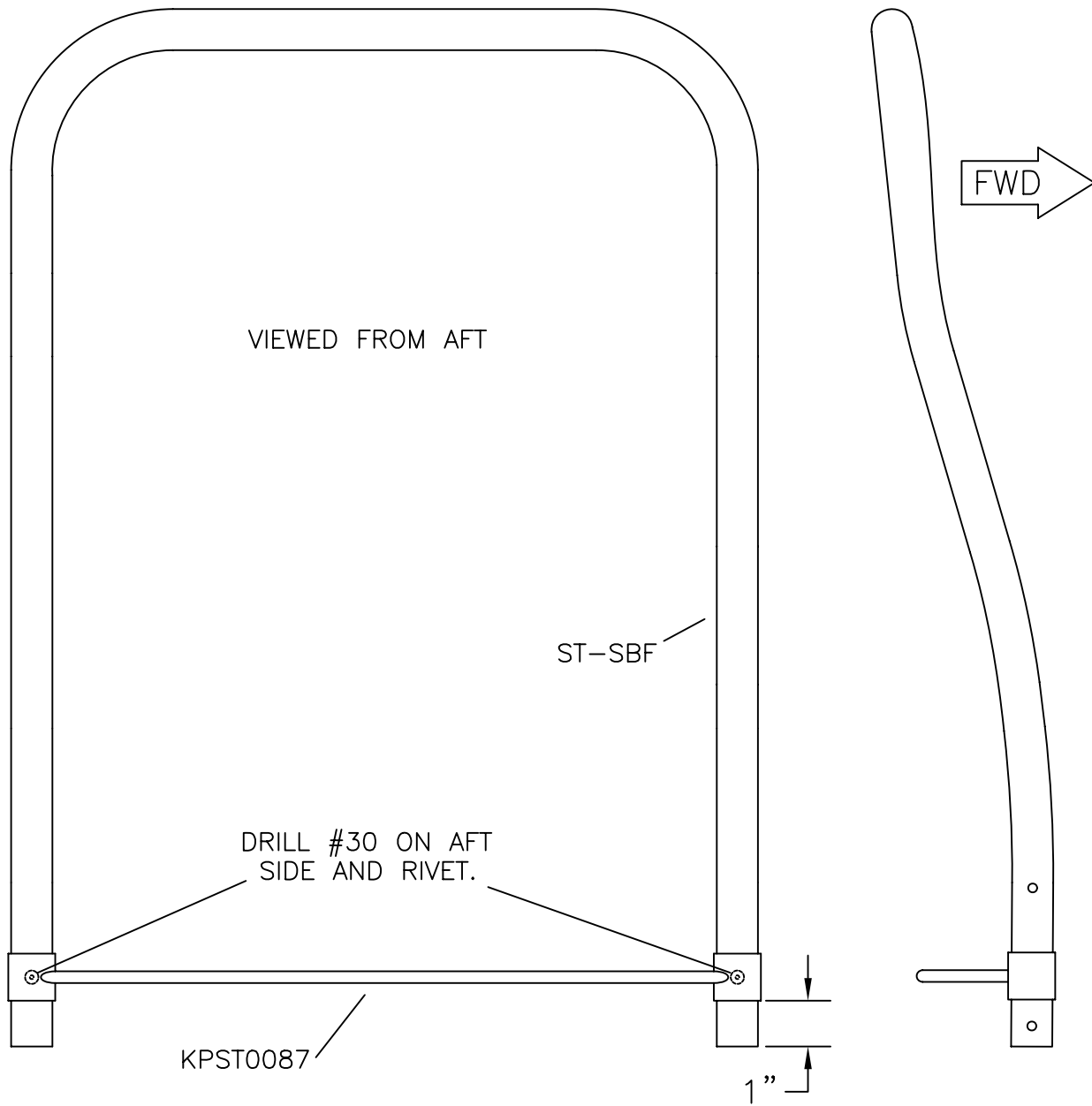
MD5465

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



MD5225

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

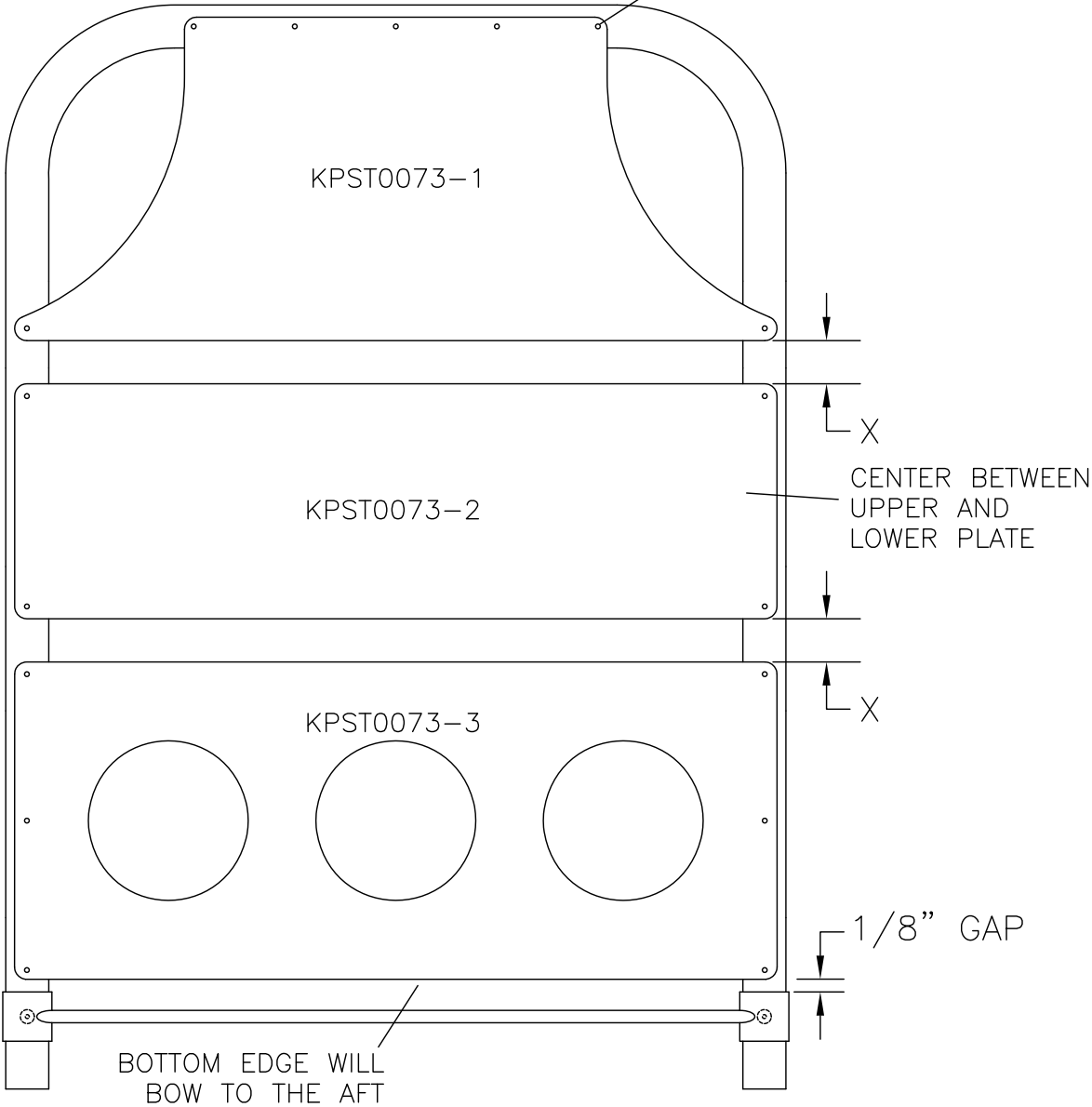


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**RANS S-19 VENTERRA**  
**LOWER SEAT BACK BRACE POSITIONING**  
**FIGURE 11-10**

04/01/2011

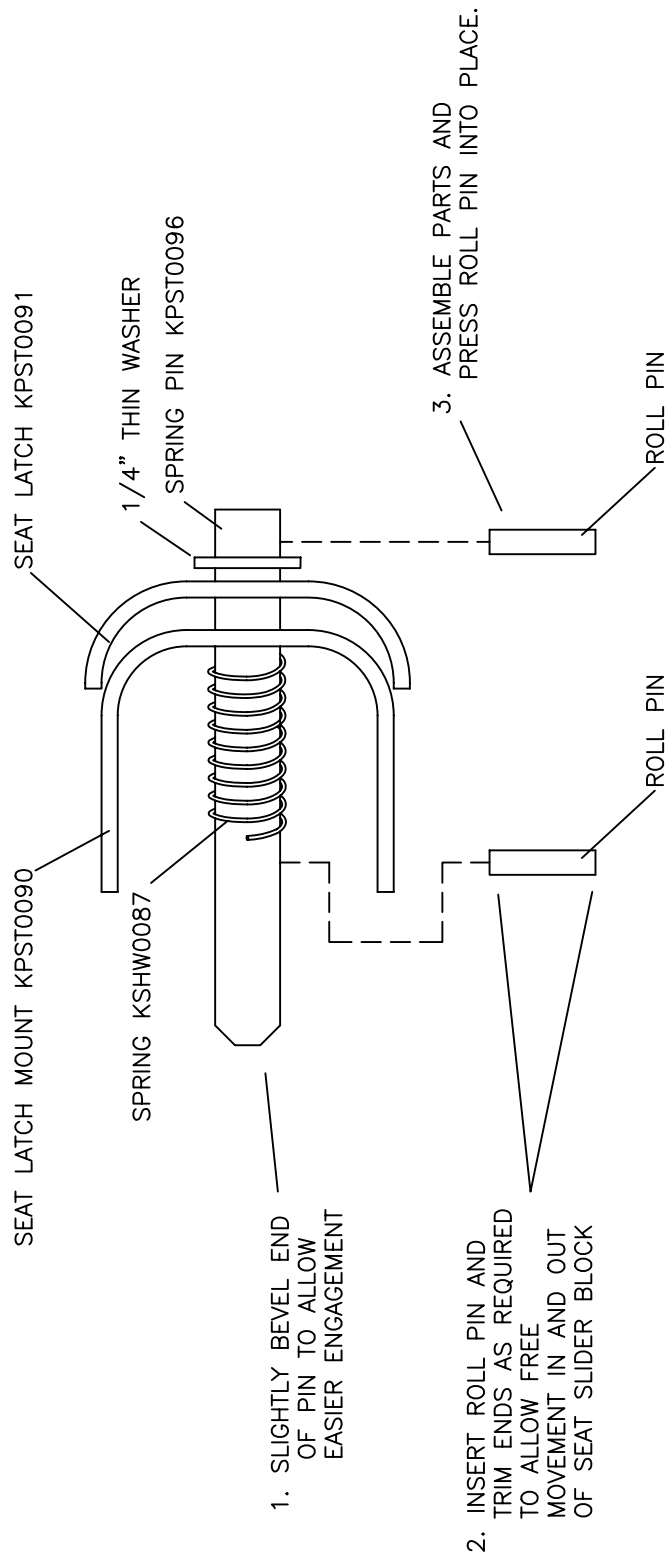
CENTER ALL HOLES  
ON SEAT BACK  
FRAME, DRILL #30  
AND ATTACH WITH  
AVEX RIVETS



VIEWED FROM AFT

MD5534

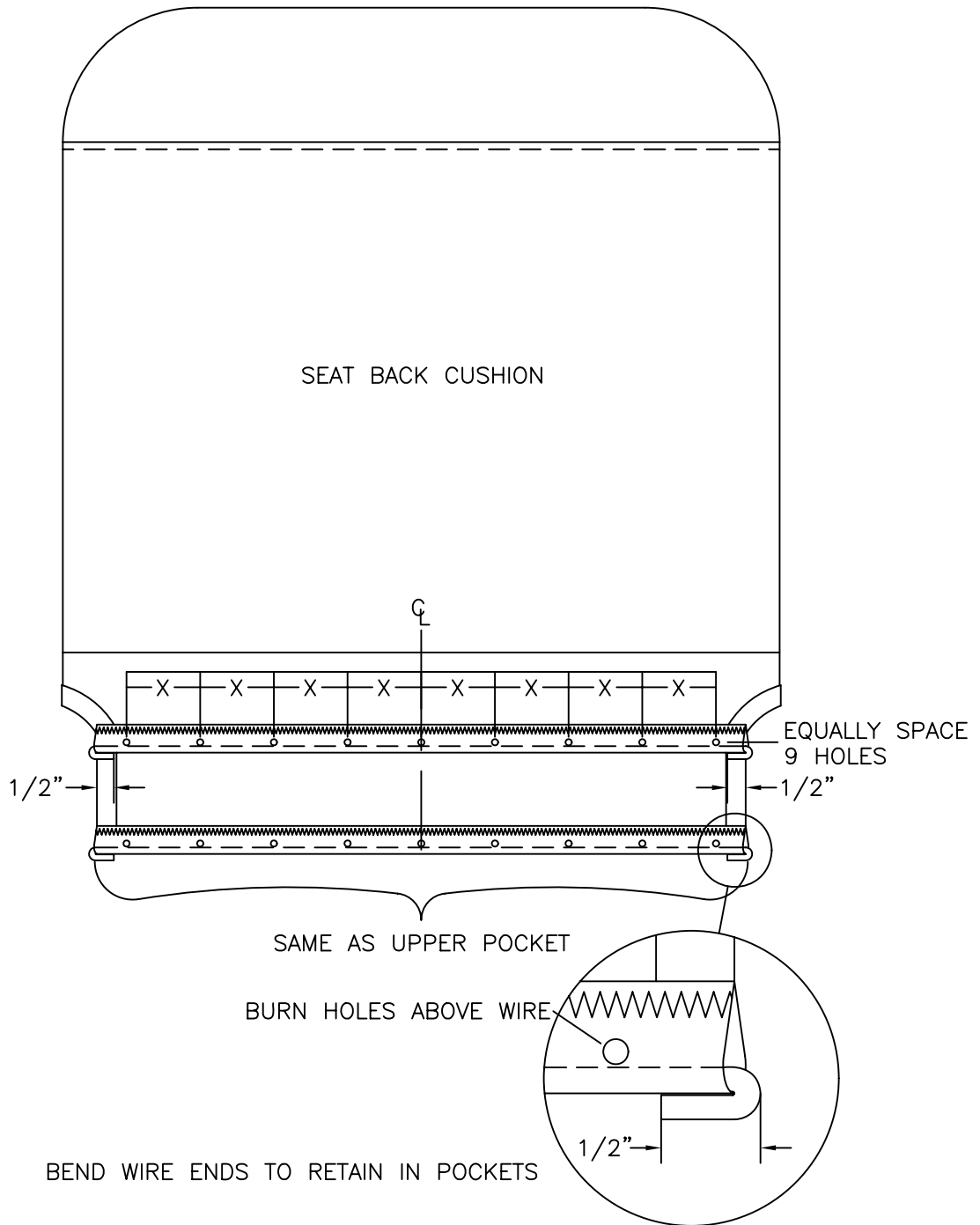
**RANS S-19 VENTERRA**  
**SEAT BACK PLATE DRILLING**  
**FIGURE 11-10A**



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

MD5446

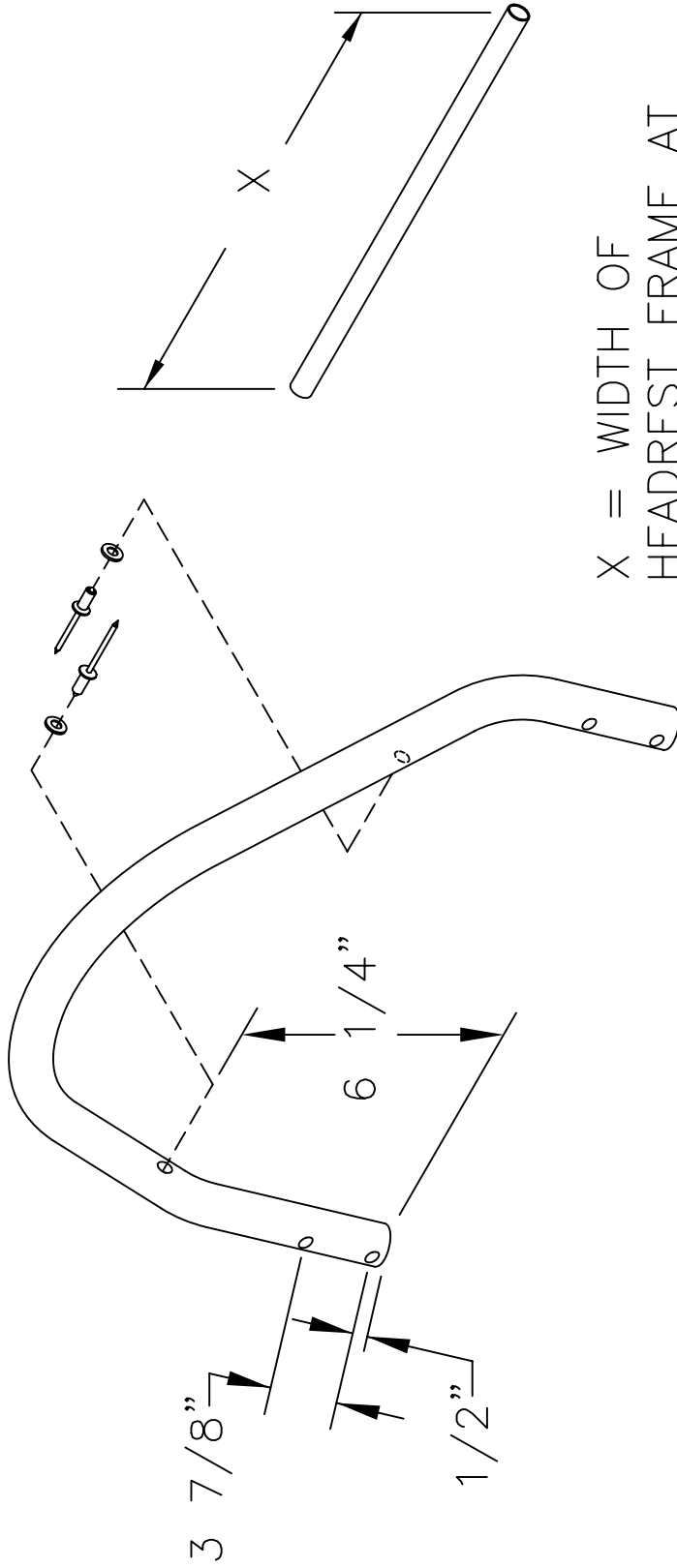




**RANS S-19 VENTERRA**  
**SEAT BACK COVERING DETAIL**  
**FIGURE 11-16**

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04/01/2011



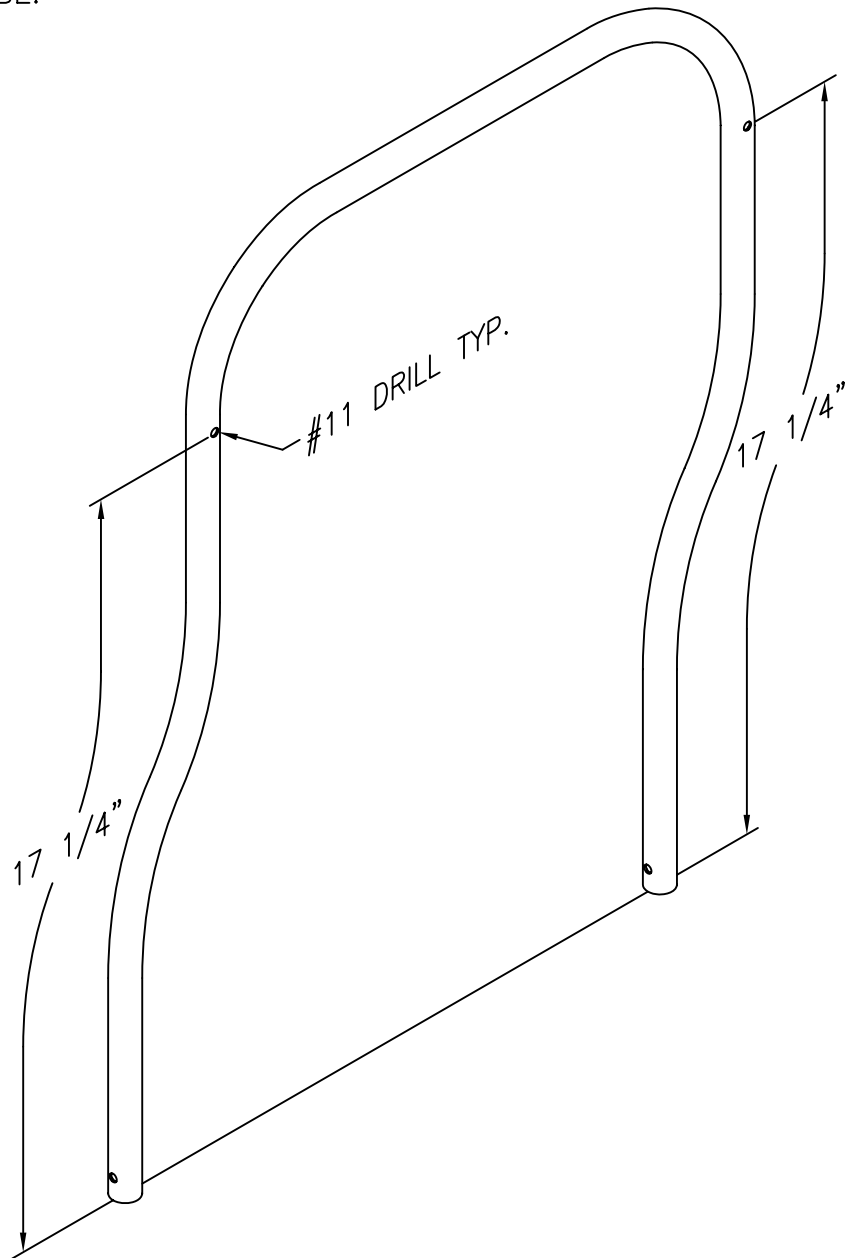
X = WIDTH OF  
HEADREST FRAME AT  
RIVET LOCATION.

MD5109

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



DRILL HOLES ONLY  
THROUGH AFT SIDE OF  
TUBE.



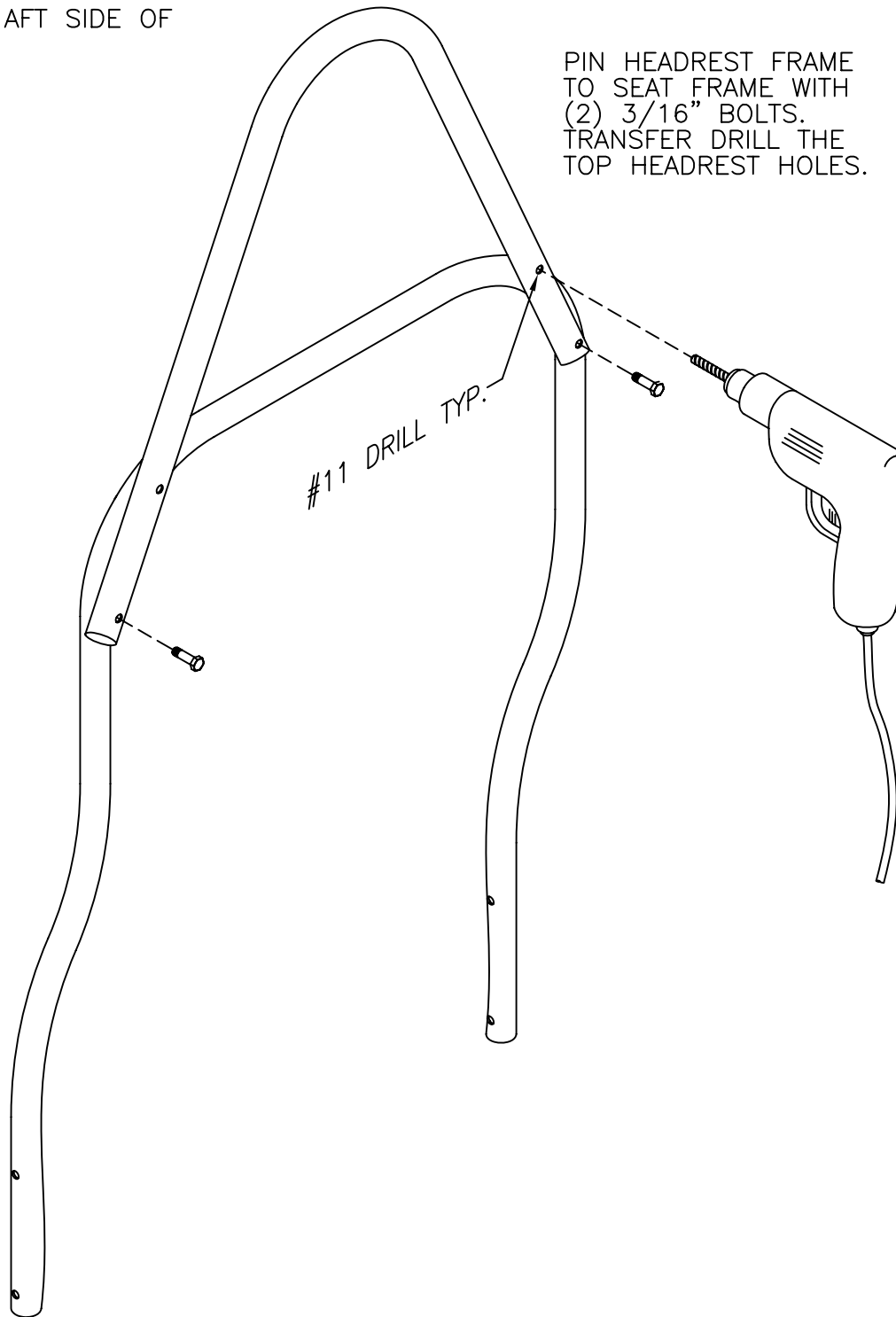
**RANS S-19 VENTERRA**  
**SEAT BACK FRAME DRILLING**  
**FIGURE 11B-03**

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DRILL HOLES ONLY  
THROUGH AFT SIDE OF  
TUBE.

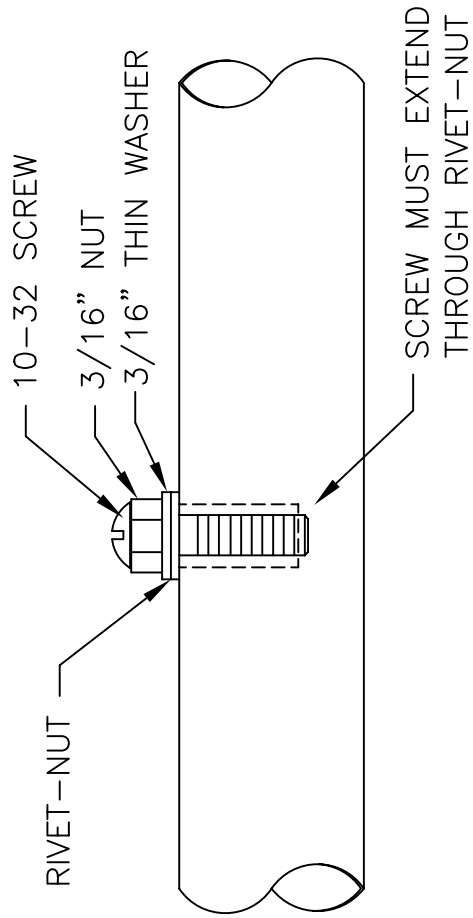
PIN HEADREST FRAME  
TO SEAT FRAME WITH  
(2) 3/16" BOLTS.  
TRANSFER DRILL THE  
TOP HEADREST HOLES.



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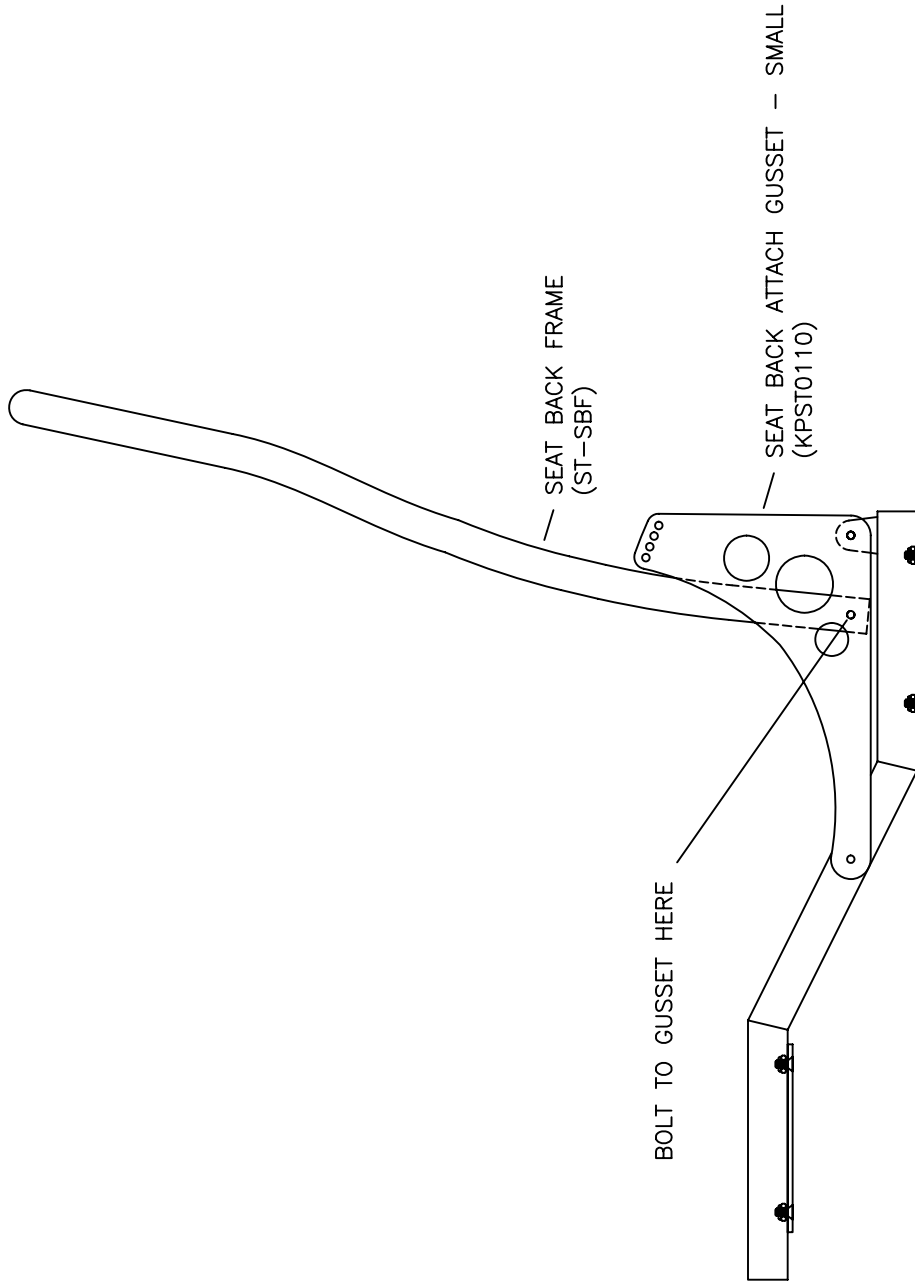
**RANS S-19 VENTERRA**  
**SEAT HEADREST TO SEAT BACK FRAME DRILLING**  
**FIGURE 11B-04**

04/01/2011



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

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



MD5533

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