Specifications
Main Rotor Diameter: 19 ft.
Tail Rotor Diameter: 3.6 ft.
Height: 6.9 ft.
Length: 12.5 ft.
Max Gross Wt.: 700 lbs.
Empty W.: 325 lbs.
Payload (with full fuel) 350 lbs.
Fuel Capacity: 8 gal.
Seats: 1
Range: 80 sm.
Takeoff distance: 0 ft.
Landing Distance: 0 ft.
Vmax: 95 mph (max allowable speed
-level flight sea level, std. Day)
Vcr: 70 mph
Climb rate @ msl: 1.100 fpm
Service Ceiling: 12.500 ft
Engine: Rotax 65 hp

PART LIST

Key number / Name / (Quantity)

1 - Pivot head (2)
2 - Blade grip (4)
3 - Reinforcement strap (4)
4 - Bolt AN3 (2)
5 - Claw (4)
6 - Shell type bearing BK1514RS (2)
7 - Axle A (2)
8 - Elastic stop nut AN 364-1032 (2)
9 - Shell type bearing BK1522 (2)
10 - Thrust bea. AXW15 - (2)
washers AS1528 (2)
LS1528 (2)

11 - Axle B (2)
12 - Axle housing (2)
13 - Axle grip (2)
14 - Elastic stop nut AN 365-524 (4)
15 - Blade control horn (2)
16 - Center plates (3)
17 - Bolt AN3 (8)
18 - Bolt AN4 (8)
19 - Bolt AN3 (2)
20 - Bolt AN5 (4)
Not shown:
Elastic stop nuts AN 365-428 (8)
Elastic stop nuts AN 365-1032 (8)
Top View

Section A-A

Bearing: A= Shell Type BK1514 RS (sealed) 2 Req’d. B= Shell Type BK1522 (2 Req’d.) C= Thrust (needle roller) AX15 - Washers AS 1528 and LS 1528 (2 of each one req’d)

Bearings from INA Catalog
INA BEARING COMPANY, INC.
One Ina Drive, Cheraw,
South Carolina 29520
Phone: (803) 537-9341
Key number / Name / (Quantity)
1) Blade control master horn
2) Control sliding axle
3) Ball
4) Shell type bearing HK 1522
5) Main rotor axe
6) Bearing cover
7) Bushing
8) Race / bushing
9) Pivot head
10) Center plates
11) Gasket
12) Bearing 7013
13) Main gear
14) Gearbox housing upper half
15) Gearbox housing lower half
16) Gearbox attachment ring
17) Race / nut
18) Ball / Bearing housing
19) Ball race
20) Nut B
21) Cyclic/Collective central link
22) Main rotor mast
23) Bearing 6002 Z
24) Nut A
25) Central uniball housing
26) Central Push-Pull tube
27) Pinion shaft
28) Gasket
29) Snap ring
30) Bearing 6205
31) Pinion housing
32) Push-Pull axle
33) Bushing
34) Pin
35) Pinion
36) Gearbox lid
**Part List**

**Key number / name / Quantity**

1) Main rotor shaft
2) Main gear
3) Bolt AN3 (25)
4) Gearbox housing upper half
5) Gasket (3)
6) Bolt AN3 (10)
7) Gearbox lid
8) Ball bearing 7013 (2)
9) Gearbox housing lower half
10) Elastic stop nut AN 365-1032 (25)
11) Pinion
12) pinion shaft
13) Ball Bearing 6205 (2)
14) Pinion housing
15) Gaskets

*Not shown:
*main shaft woodoff keys (3)
* Pinion housing internal snap ring.
Part List

Key number/name/quantity
1) Main rotor gearbox
2) Gearbox attachment ring
3) Bolt AN4 (6)
4) Main rotor mast
5) Bushing (2)
6) Bushing A (2)
7) Ball
8) Main rotor axle
9) Pin
10) Control sliding axle
11) Bushing
12) Push-Pull axle
13) Race-nut
14) Ball bearing housing
15) Bearing 620 Z (1)
16) Nut A
17) Nut B
18) Ball race
19) Central uniball housing
20) Elastic stop nut AN364-1032 (1)
21) Central Push-Pull tube
22) Bolt AN3 (1)
Key number / Name / (Quantity)
1) Collective central push-pull tube
2) Main rotor tube mast
3) Cyclic push-pull tube
4) Bushing spacers (4)
5) Cyclic upper bellcranck (2)
6) Cotter pin (6)
7) Clevis pin AN394 (4)
8) Elastic stop nut AN364-428 (2)
9) Upper Bellcranck mounting bracket (2)
10) Rod end HMVV-4 (2)
11) Locking nut AN316-4R (2)
12) Control linkage (2)
13) Locking nut AN316-4L (2)
14) Rod end HMLVV-4 (2)
15) Clevis pin AN394 (2)
16) Cyclic/collective central link (1)
17) Bolt AN4 (2)
18) Bolt AN9 (8)
19) Bellcranks central bracket
20) elastic stop nut (not shown) AN365-1032 (8)
Attach tail rotor hub here
TAIL ROTOR GEARBOX
Part List - page 12

1) Pinion
2) Gasket
3) Bolt AN3
4) Flat Washer
5) Bearing Cover (Large)
6) Bearing 16005
7) Pitch Control Axle
8) Bolts AN3
9) Bolts AN3
10) Gearbox Lid
11) Gearbox Housing
12) Oil Screws
13) Bearing EE5
14) Bushing Spacer
15) Bolt AN3
16) Nut C
17) Gasket
18) Bolt AN3
19) Bearing Cover (Small)
20) Gearbox Rear Cap
21) Flat Washer
22) Bolts AN4
23) Bearing
24) Gasket
25) Nut D
26) Steel Bushing
27) Gear

TAIL ROTOR ASSEMBLY
Part List - page 11

1) Tail Rotor Blade
2) Bolt AN3
3) Tail Blade Grip
4) Bearing 6200
5) Axle Nut
6) Bearing FAG 525277
7) Blade Grip Nut
8) O’Ring
9) Pitch Control Horn
10) Flat Washer
11) Elastic Stop Nut
12) Axle
13) Tail Rotor Hub
14) Axle Pivot Nut
15) Axle Pivot Screw
16) Pin
17) Pitch Control Head Guide
18) Retainer Nut
19) Safety Wire Spring
20) Bolt AN4
21) Conical Washer
22) Rod End Male HMLV4
23) Nut AN316-4R
24) Control Linkage
25) Nut AN316-4R
26) Rod End Male HMVV4
27) Flat Washer
28) Clevis Pin
29) Cotter Pin
30) Pitch Control Head
31) Flat Washer
32) Castle Nut
33) Cotter Pin
34) Elastic Stop Nut
35) Flat Washer
36) Bushing
37) Bolt AN4
38) Flat Washer
39) Flat Washer
40) Elastic Stop Nut

TAIL ROTOR PITCH CONTROL ASSEMBLY
Part List - Page 13

1) Tail Rotor Gearbox
2) Scissors Hinge
3) Bolt AN3H
4) Scissors B and Axle
5) Lever
6) Scissors A
7) Bearing Housing
8) Bearing
9) Internal Snap Ring
10) Self Locking Castle Nut/Cotter Pin
11) Bolt AN3
12) Turnbuckle Assy. AN150-16L
13) Elastic Stop Nut AN364-1032
14) Pulley Arm
15) Bolt AN4
16) Control Cable Galvanized 1/8”-7x19
17) Cable Clamp

11

12

13

FURIA HELICOPTER -
PART LIST - PAGES 11-12-13
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Key number / Name (Quantity)
1) Retaining washer (3)
2) Nylon bushing (3)
3) Internal bracket (3)
4) Elastic stop nut AN365-1032 (18)
5) Bolt AN3 (9)
6) Shaft ends (2)
7) Elastic stop nut AN364-428 (4)
8) Bolt AN4 (4)
9) Shaft
10) Raceway (3)
11) Tail boom tube
12) Bolt AN3 (9)
13) Inspection hole cover (3)
14) Sheet metal screws (6)
Key number / Name / (Quantity)

1) Left control pedal
2) Right control pedal
3) Main lever
4) Bolt AN4-6A (2)
5) Rod ends male threaded HMVV-4 (2)
6) Rod ends male threaded HMVV-4 left hand thd. (2)
7) Locking nut AN316-4R (thin check nut) (2)
8) Locking nut AN316-4L (thin check nut) (2)
9) Control linkage
10) Control linkage
11) Control linkage
12) Control linkage
13) Control linkage
14) Control linkage
15) Control linkage
16) Control linkage
17) Control linkage
Material: 4130 Steel tubing

FURIA HELICOPTER - PRIMARY STRUCTURE

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DETAIL A
Reinforcements
4130 Steel 2.3 (.090)

DETAIL B
Skids Caps
Mat: Aluminum 4 Req'd

40 Dia
(1-9/16”)

Bevel

To fit inside skid tubes

O.D. 40 - 2.4 Wall Thickness 4130 Steel
(1-9/16” x .095 W.Thk)

SIDE VIEW
DETAIL A  Rotor mast attachment brackets

- Inner ring
  - Mat: Steel (.198)
  - W. Thk.:
- Pop Rivet ring in proper position, then drill and tap according to brackets

DETAIL B  Main rotor mast
- Mat: 4130 Steel
  - 2 (.080) Thk
  - Length: 40 (1.57)

- Drill and tap for AN4-H
- Bolts 1/4" - 28
- USE SAFETY WIRE

DETAIL C  Tail boom
- Landing gear skid seat
  - Mat: 4130 Steel 2 (.080) Thk
  - 4 req'd

- 26 Dia (.1024)
- 6.35 D (.250)
- 36 (1.417)
- 44 (1.732)
- 16 (.630)
- 10 (.394)
- 7.6 (0.3)
- 55 (2.165)
- 34 (1.338)
- 125 (.4921)
- 6.35 D (.250)

- 2) 4130 Steel tubes
  - 3/4" O.D.
  - .065 wall thk

DETAIL D  Tail skid
- Pedals brackets mat: 4130 Steel 2
  - (.080) Thk 2 req’d

- Flat washer welded
**TAIL BOOM BRACKETS**

Material: 4130 Steel

**TAIL SKID (Tail rotor protector)**

Material: 4130 steel tubes 0.8 (.035) Wall Thickness
Front View

Suggested instruments
1- ALTIMETER
2- R.P.M.
3- AIRSPEED
4- IGNITION KEY
5- TURN and BANK
6- CYLINDER HEAD TEMP
7- EXHAUST GAS TEMP

Material: 3 (1.181) thk 6061-T6 aluminum
Center Plate
Mat: 2024-T3 Aluminum 5 (.197) Thk (3) Req’d.
Bend along centerline to match pivot head (4 degrees)

Reinforcement Strap
Mat: 2024-T3 Aluminum 5 (.197) Thk (4) Req’d.
Axle Housing
Mat: 2024-T3 Aluminum
(2) Req’d.

Axle Grip
Mat: 2024-T3 Aluminum
(2) Req’d.

Axles
(2) of each req’d.
Mat: 8620 Steel
Heat Treatment: Case hardening
Minimum surface hardness: 58 Rockwell C
Effective case depth: 0.3 (.012)
(after finish grinding)

Axle A
40 (1.576)

Axle B
51 (2.00)
BLADE CONTROL
MASTER HORN
Mat: 1045 Steel
(1) req’d

BUSHING
Mat: Steel (1) Req’d.

CLAW
Mat: 4140 Steel
(4) Req’d.

H Bearing housing
Shell type bearings are installed here with the aid of a press

FURIA HELICOPTER -
MAIN ROTOR COMPONENTS
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BLADE CONTROL HORN
Mat: 2024-T3 Aluminum (2) req’d

PIN
Mat Steel (1) req’d.
Lengtgh and chamfer according sliding axle

CONTROL SLIDING AXLE
Mat: 41410 Steel (1) req’d.

FULL SIZE
BALL
Mat: 8620 Steel (1) req'd.
Heat Treatment: Case Hardening
58 Rockwell C

FULL SIZE

29,989 (1.1803)
29,990 (1.1772)

Woodruff keyseats

SECTION
A-A

MAIN ROTOR SHAFT
Mat: 4140 Steel (1) req'd.

FULL SIZE

FURIA HELICOPTER -
MAIN ROTOR COMPONENTS

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GEARBOX HOUSING
Lower Half
Mat: Aluminum casting

SECTION A-A

FURIA HELICOPTER -
MAIN GEARBOX HOUSING

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GEARBOX HOUSING
Upper half
Mat: Aluminum casting

GEARBOX LID
Mat: Aluminun (1.157) Thk.
(1) Req’d.

FURIA HELICOPTER -
MAIN GEARBOX HOUSING

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GEAR

PINION
Full Size

CUTTING DATA

*) To fit in main rotor shaft

NUMBER OF TEETH 95 23
DIAMETRAL PITCH 10 10
PITCH DIAMETER 9.5 2.3
OUTSIDE DIAMETER 9.7 2.5
CENTERDISTANCE 5.9 5.9
ADDENDUM .1 .1
DEEDDUM .1157 .1157
CLEARANCE .0157 .0157
WHOLE DEPTH .2157 .2157
PINION HOUSING

Mat: Aluminum (1) req’d.

FULL SIZE
GEARBOX ATTACHMENT RING
Mat: 4130 Steel

MAIN ROTOR MAST
Mat.: 6061-T6 Aluminum Tube
O.D. 400 (101.6)
I.D. 97 (3.819) (Approx.)

Holes for belcrank mounting ring

FURIA HELICOPTER -
MAIN ROTOR MAST

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**RACE/NUT**
Mat: 1050 Steel (1) req’d

**BALL/BEARING HOUSING**
Mat: 1050 Steel (1) req’d

**CENTRAL UNIBALL HOUSING**
Mat: 1045 Steel (1) req’d

**BALL RACE**
Mat: 1050 Steel (1) req’d

**NUT A**
Mat.: 1045 Steel (1) req’d

**HEAT TREATMENT**
Ball and races must have hardened surfaces (raceways)
Minimum surface hardness: 58 Rockwell C
CYCLIC CONTROL
PUSH-PULL TUBES
Mat: 6061-T6 aluminum tubes
19 Dia (3/4") 1.5 (.058) wall thk
(1) of each req’d
Threaded ends: (see page #36)

FULL SIZE

CENTRAL BRACKET
Mat: 4130 steel 2 (.80) thk
(1) req’d

FULL SIZE
**TORQUE TUBE**
Mat: 6061-T6 Aluminum 1.6 (.065) wall thk. (1) req’d.

**INNER REINFORCEMENT TUBE**
Mat: 4130 Steel 2.10 (.083) wall thk (1) req’d

**SPACER**
Mat: Aluminum (1) req’d

**NYLON BUSHING**
Press to install (1) req’d

**LEVER**
Mat: 2024-T3 or 6063-T6 aluminum (1) req’d

---

**FURIA HELICOPTER - CONTROL SYSTEM**

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MAIN GEARBOX REAR BRACKET

Mat: 4130 Steel 2 (0.80) Thk
(1) req'd
CYCLIC CONTROL STICK HOLDER
Mat: 4130 Steel (1) req'd

LATERAL STOP
Mat: 4130 Steel
2 (.08) Thk

TORQUE TUBE BRACKET
Mat: 2024-T3 aluminum 5 (.197) (1) req'd
CYCLIC CONTROL PUSH-PULL TUBE

6061-T6 Aluminum Tube 22.2 (3/4") 1.50 (.058) Wall Thk. (1) req'd

TRAVEL LIMITING STOP  Mat: 4130 Steel (.095) Wall Thk (1) Req'd

LIMITING BAR  Mat: Steel (1) req'd

STICK HOLDER CAPS  Mat: Aluminum (1) of each req'd
THROTTLE LEVER
Mat: 4130 Steel (1) Req'd

UPPER CYCLIC BELLCRANKS MOUNTING BRACKET

CYCLIC CONTROL STICK
Mat: 4130 Steel (1) Req'd
22,2 (7/8") O.D. 1.65 (.065) Wall Thk (1) Req'd

FULL SIZE

FURIA HELICOPTER -
CONTROL SYSTEM
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MAIN ROTOR BLADE CROSS SECTIONS

SECTION A-A
- Blade root reinforcement plates
- Blade seat
- Reinforcements (upper and inner)
- Lower Steel plate

SECTION B-B
- 4130 Steel tube
- 6061-T6 Aluminum tubes
- 2024-T3 Aluminum bars

MAIN BLADE SKIN SECTION
Mat: 2024-T3 Aluminum 0.5 (.020) Thk
Length: 2680 (105.51) (2) Req’d
Bend the aluminum sheet to conform this shape
A) Setting wood jigs, check alignment and determine jigs #1 and #2. You can add wood stringers between the jigs to make the assembly stronger.
B) Mount the tubes and bars over the jig so you can rivet them together. Check that tubes follow the twist. (6°)
C) After cutting the tubes to allow fit counterweight at the tip (see page # 50).
D) Remove the pack of tubes and bars from the jig and place the prebend aluminum skin (page # 47) over the jig, now you can place the pack of tubes and bars inside the open skin.
E) Close the skin and start riveting the trailing edge, don’t forget to include the inner reinforcement strips between the skins.
F) Use soft rivets to hold skins and tubes.
G) Finish root and tip sections, placing reinforcement plates and tip cover.

Blades must be balanced
**STEEL PIN**
(2) Req’d

**PITCH CONTROL LINKAGE**
Mat: 1/2" hex aluminum bar (2) Req’d

**PITCH CONTROL HEAD**
Mat: 2024-T3 Aluminum
(1) Req’d

**BLADE GRIP NUT**
Mat: 4130 Steel (2) Req’d

---

**FURIA HELICOPTER - TAIL ROTOR**

---

Rods are installed with the aid of a press
BE CAREFUL: do not bend rods
Mat: Steel
TAIL BLADE GRIP

Mat: 6061-T6 or 2024-T3 Aluminum (2) Req'd

PITCH CONTROL HORN

Mat: 2024-T3 Aluminum 4 (.157) Thk (2) Req'd

AXLE NUT

Mat: Steel (2) Req'd
TAIL ROTOR HUB

Keyway 3.5 x 2 (.138 x .0787)

AXLE PIVOT SCREWS AND NUTS
(Mat: Steel (2) Req’d)

(ENLARGED)

FASTEN SCREWS WITH ADHESIVE (Loctite)

RETAINER NUT
(Mat: Steel (1) Req’d)

FULL SIZE

SECTION A-A ENLARGED

TAIL ROTOR HUB
(1) Req’d
Mat: 2024-T3 Aluminum with Bronze inserts (tapered bushings)
Use anaerobic adhesive to fix bushings in place (Loctite®)
**TAIL ROTOR GEARS**

**GEARS CUTTING DATA**

<table>
<thead>
<tr>
<th>PINION</th>
<th>GEAR</th>
</tr>
</thead>
<tbody>
<tr>
<td>NUMBER OF TEETH</td>
<td>18</td>
</tr>
<tr>
<td>DIAMETRAL PITCH</td>
<td>12</td>
</tr>
<tr>
<td>PITCH DIAMETER</td>
<td>1.5</td>
</tr>
<tr>
<td>ADDENDUM</td>
<td>.0833</td>
</tr>
<tr>
<td>WHOLE DEPTH</td>
<td>.18433</td>
</tr>
<tr>
<td>CIRCULAR THICKNESS</td>
<td>.1309</td>
</tr>
<tr>
<td>SHAFT ANGLE</td>
<td>90°</td>
</tr>
<tr>
<td>DEEDENDUM</td>
<td>.10103</td>
</tr>
<tr>
<td>CLEARANCE</td>
<td>.01773</td>
</tr>
</tbody>
</table>

**NUT C**

Mat: Steel (1) Req'd

**NUT D**

Mat: Steel (2) Req'd

*To suit Pitch-Control Axle (must slide freely)*
TAIL ROTOR GEARBOX
Mat: Aluminum (2) Req'd

**Note A:**
Diameter
35.000
35.025
(1.3789)

**Note B:**
Diameter
47.000
47.025
(1.85040)
(1.85138)

FULL SIZE
SHAFT END

Mat: 1045 Steel (2) Req’d

SECTION A-A

To Suit Tail Shaft I.D.

Broached end to match with Gear Shaft

Chamfer

Dia 30 (.118)

30 (1.181)

50 (1.968)

Holes for Tail Gearbox

TAIL BOOM TUBE

Mat: 6061-T6 Aluminum 101.6 (4.00) - 2 (.083) Wall Thk

INSPECTION HOLE COVER

Mat: Aluminum (.020) Thk (3) Req’d

Holes for Tail Gearbox

FULL SIZE

FURIA HELICOPTER -
TAIL BOOM

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**BUSHING**
Mat: Black Grillon (with Molikote) (3) Req’d

**CONTROL PULLEY ASSY**

**CONTROL PULLEY**
Mat: 2024-T3 Aluminum (1) Req’d

**RACEWAY**
Mat: 8620 Steel (3) Req’d
HEAT TREATMENT
CASE HARDENING
Min Surface Hardness 58 Rockwell C
Effective Case Depth 0.3 (.012)
(After Finish Grinding)

---

**FULL SIZE**

---

**FURIA HELICOPTER - TAIL BOOM**
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PEDALS AXLE
Mat: 4130 Steel tubing 15.8 (5/8") O.D. - 2.4 (.095) Wall Thk.
(1) Req'd

DIRECTIONAL CONTROL PEDALS

LEFT PEDAL  FRONT VIEW
NOTE: Left pedal is fixed to axle by Clevis Pin
Right pedal is free to rotate

FURIA HELICOPTER -
CONTROL SYSTEM / PEDALS
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SKIN
Mat: 2024-T3 Aluminum 0.5 (.020) Thk

REINFORCEMENT
Mat: 2024-T3 Aluminum 0.5 (.020) Thk (4) Req’d One on each side (inner side only)

BLADE TIP
Mat: 2024-T3 Aluminum (2) Req’d

BLADE ROOT
Mat: 2024-T3 Aluminum (2) Req’d
CENTRAL GEARBOX
END VIEW

1/4" -28 UNF
4 Holes Eq. Sp.

Dia 64 (2.520")

2 (0.078")

Material: Aluminum 1-Reqd.

TOP VIEW

80 (3.15")

42 (1.65")

9 (.35")

10-32 UNF
(see Bearing cover for hole position details)

Dia. 70 (2.75")
Recess to suit upper Bearing Cover

Dia. 45 (1.77")

FURIA HELICOPTER -
CENTRAL GEARBOX

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COUPLING (Long Axle Central Gearbox)

Mat Steel - 1 Req'd.

See Details of gear cutting data on page #59

CENTRAL GEARBOX
SECTION A-A

LONG AXLE
Mat Steel - 1 Req'd

FURIA HELICOPTER -
CENTRAL GEARBOX

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Plans Delivery.com
MAIN ROTOR GEARBOX
PINION AXLE

PULLEY SUPPORT
Mat. Aluminum 1 Req’d.

Dia 84
(3.30”)

Dia 6.35
(.250”)
6 Holes
Eq.Sp.

Dia 40
(1.57”)

Dia 8 (.314”) 4
Holes Eq. Sp.

Dia 90
(3.54”)
2-Req’d. 2 (.078”) Thk

Dia 68
(2.67”)

Dia 42
(1.65”)
29
(1.14”)

78
(2.99”)

171
(6.73”)

16
(.629”)

14
(.55”)

31
(1.22”)

16
(.629”)

Dia 25
(.984”)

10
(.39”)

3/8-16
UNF

55
(2.16”)

R 6 (.236”)

Connecting
Rings
ENGINE PULLEY
Mat: Aluminum - 1 Req’d
MAIN GEARBOX

Note: some elements have not been depicted to simplify views

PINION

PINION AXLE

PINION AXLE COUPLING

CONNECTING DISK

SHAFT COUPLING

SHAFT

MAST TUBE
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