

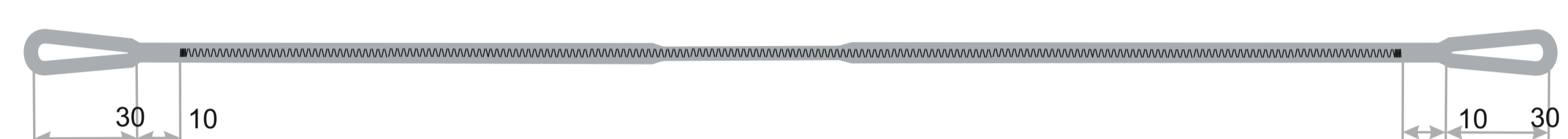
# XG 63 rev1 M,L - repaired 2022-2-8

- The „repaired” points:
1. The accelerator Samson line has to be stretched after splicing and sewing (the same way as D-Pro 3mm and DC 300) including the tie-ball knot (after the knot which is inside the tie ball has been made) with force of 100 daN (to avoid stretching during life span of a wing)
  2. The B-riser D-Pro 3 mm line is sewn with zig-zag stitching all the way long
  3. The gliders (or spare risers) will be delivered with following spare parts:
    - 3.1.: D-Pro 3 mm B-riser line.....1 pair
    - 3.2.: DC 300 AIII-riser line.....1 pair(will be packed in a small plastic bag)

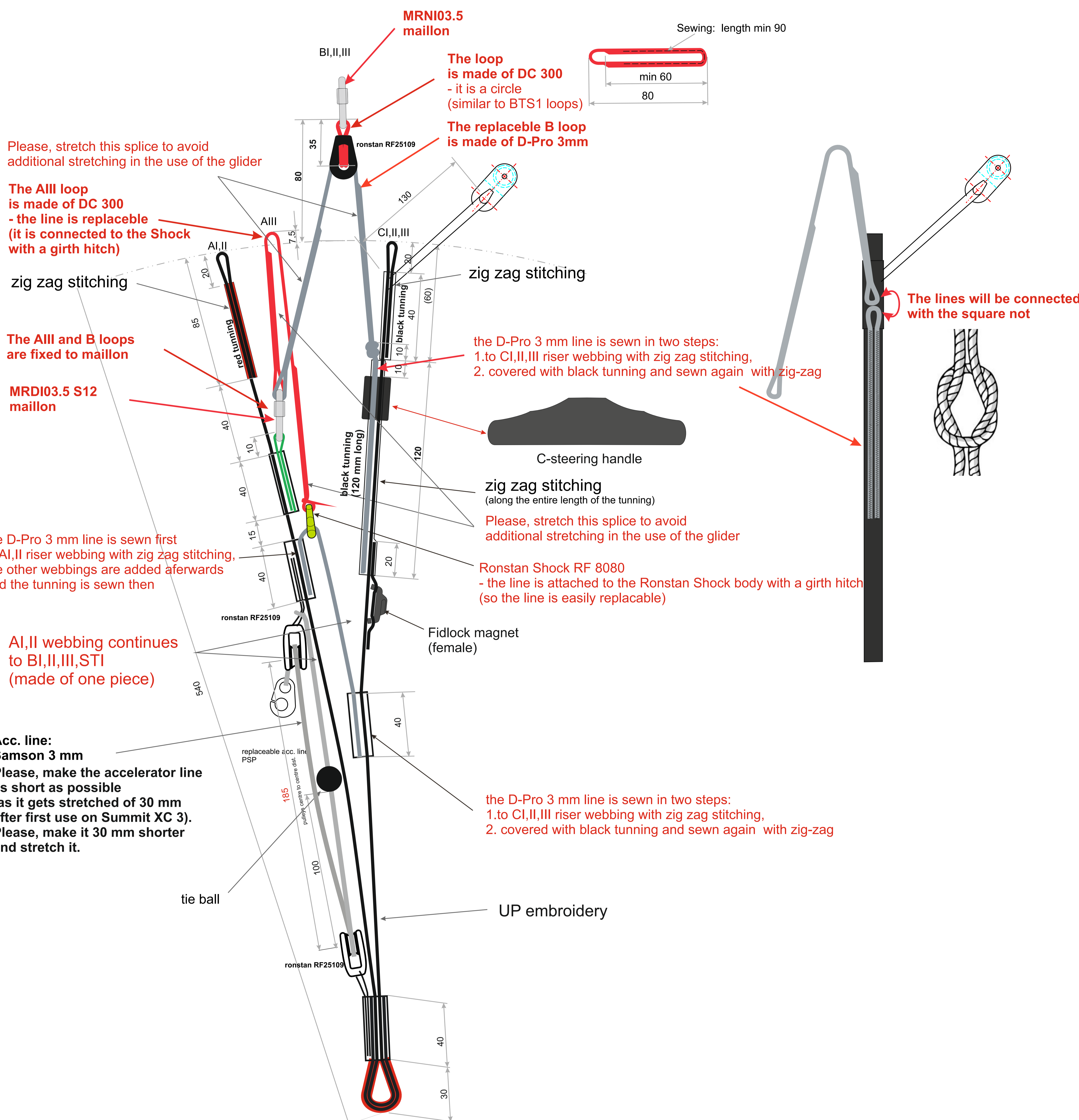
- The risers are based on Kangri risers
- some important points:
1. The AI,II riser and the CI,II,III risers are made of one pice
  2. The main carabiner loop is made of two webbing layers
  3. The BI,II,III maillon is sliding - connected with pulley
  4. The BI,II,III loop is made of D-Pro 3mm, it is connected to a loop made of D-Pro 3 mm on the CI,II,III riser
  5. There is an additional loop for AIII line made of DC 300

Material:  
Riser webbing Cousin - Kevlar 12 mm - drawn with black lines  
DC 300 RED - drawn with red line  
D-Pro 3mm GREY - drawn with grey line  
Softer 12 mm webbing (used for accelerator webbing of Summit XC r3 risers) - drawn with green line

- Instruction for the DC 300 line and D-Pro 3 mm line splicing:
- the seam allowance is 100 mm,
  - the splice length is 70 mm
  - stitching length is continuos from one to the another loop
  - the loop length is 30 mm
  - bar tack (on each end of stitching), the thread ends are melted
  - the lines have to be stretched after splicing and sewing with force of 100 daN (to avoid stretching during lifespan of a wing)



Maillons:  
AI,II maillons: Standard delta shape MRDI03.5 S12  
BI,II,III,STI maillons: **Standard oval MRNI03.5**  
CI,II,III maillons: Standard delta shape MRDI03.5 S12  
AIII maillons: Oval shape smaller diameter MRNI02.5



Length of risers - trim speed:	Length of risers - fully accelerated (pulley to pulley):
AI,II: 540mm	AI,II: 375mm
AIII: 547,5 mm	AIII: 424 mm
BI,II,III,STI: 620mm	BI,II,III,STI: 537,5mm
CI,II,III: 540mm	CI,II,III: 540mm

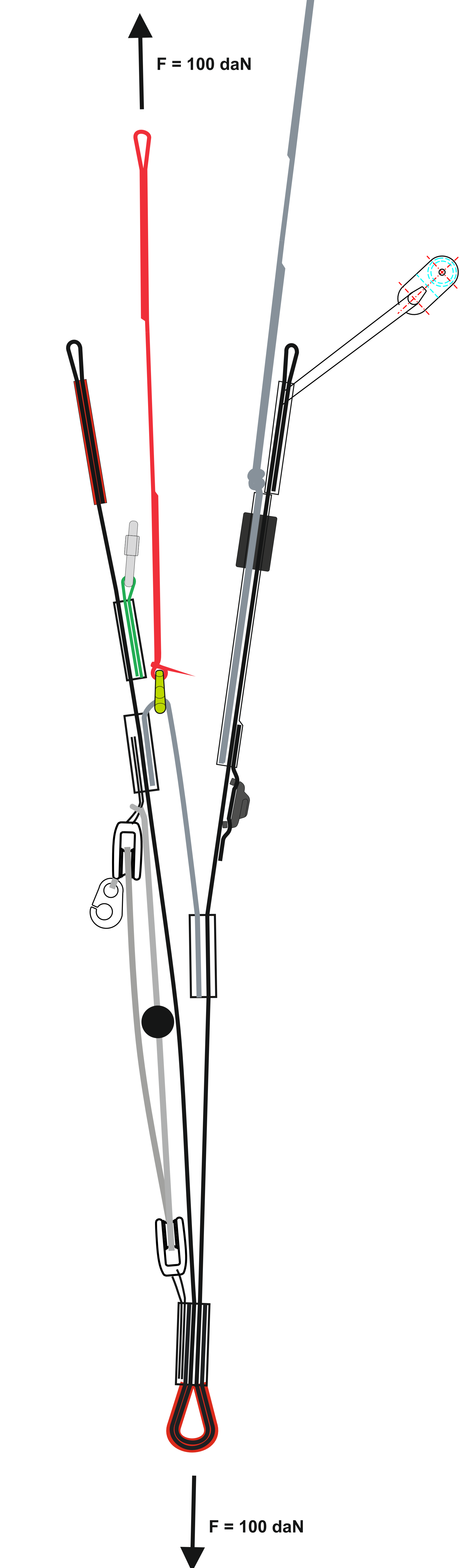
## Stretching instruction

1. B-riser D-Pro 3mm line is stretched after connecting to the C riser
2. AIII-riser DC 300 line is stretched after connecting to the Shock
3. Accelerator line and spare lines are stretched without connecting to the risers

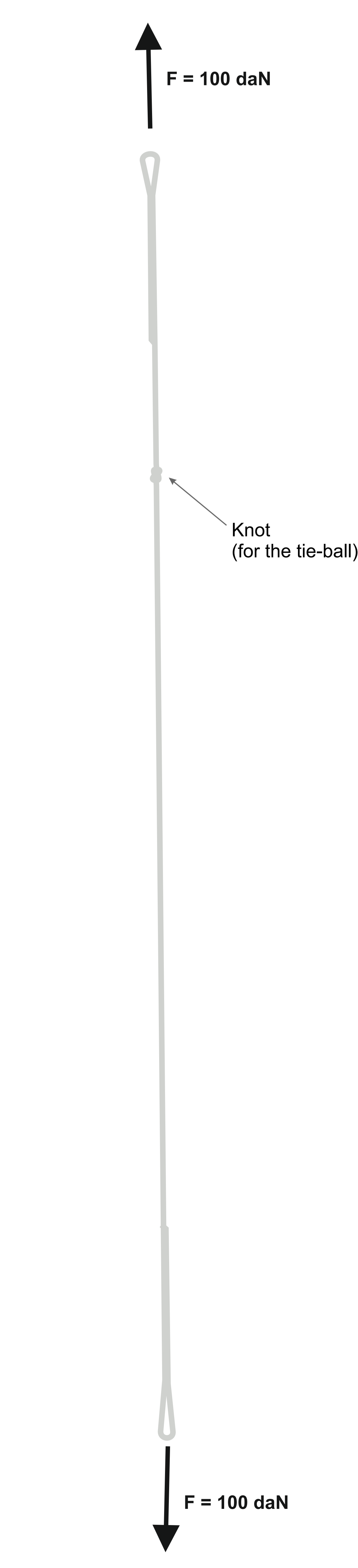
### D-Pro 3 mm B-riser line



### DC 300 AIII-riser line



### Samson accelerator line



### Spare D-Pro 3mm and DC 300 lines (delivered with a glider (or spare risers))

