

Nomad SERVICE BULLETIN

Reference No. 202

TRANSMITTAL SHEET FOR NOMAD SERVICE BULLETIN

SERVICE BULLETIN NO: NMD-52-7

DATED: 9th February, 1990

TITLE: Doors - Aft Passenger Door - Improved Mechanical Stop
(Modification N638)

REVISION NO:

DATE:

ACTION: Insert Service Bulletin NMD-52-7 into Service Bulletin
publication and annotate index accordingly.

REASON: To strengthen the diaphragm in the vicinity of the mechanical
stop.

REMARKS:

9th February, 1990

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- +
G. Refit lower trim to the door.

3. MATERIAL INFORMATION

- A. Parts required per aircraft.

<u>New Part No</u>	<u>Qty</u>	<u>Title</u>	<u>Old P/N</u>	<u>Disposition</u>
1A/N-11-1377SB	1	Bracket		Note 2
1B/N-11-1377SB	1	Angle		Note 2
MS20470AD4-5	11	Rivet		
MS20600AD4W2	11	Rivet (Alt)		Note 1
MS20426AD3-5	2	Rivet		

Note 1: CR 3213-4-2 is also an acceptable alternative

Note 2: Made from 0.050 inch Al Alloy QQ-A-250/5 T3

4. SPECIAL TOOLS AND EQUIPMENT

None

5. RECORDING ACTION

Record compliance with Service Bulletin NMD-52-7 in Airframe Log Book.

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DOORS - AFT PASSENGER DOOR-
IMPROVED MECHANICAL STOP
(MODIFICATION N638)

1. PLANNING INFORMATION

A. Effectivity

All Nomad N22 Series and N24 Series aircraft whose log books do not record the embodiment of Mod N638 or compliance with Service Bulletin NMD-52-7.

Aircraft Serial No N22S-159 to N22S-165 inclusive have this modification incorporated as basic.

B. Reason

To strengthen the diaphragm in the vicinity of the mechanical stop.

C. Description

The under side of the diaphragm is strengthened by the addition of a re-inforcing bracket and angle.

D. Compliance

Recommended.

E. Approval

The modification detailed herein has been approved pursuant to CAR 35 and conforms with type certification requirements.

F. Manpower

Three manhours.

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G. Material - Price and Availability

Material to be obtained from ASTA. Price and availability on request.

H. Tooling

Nil required.

J. Weight and Balance

None

K. References

IPC - Illustrated Parts Catalogue 52-15-02.

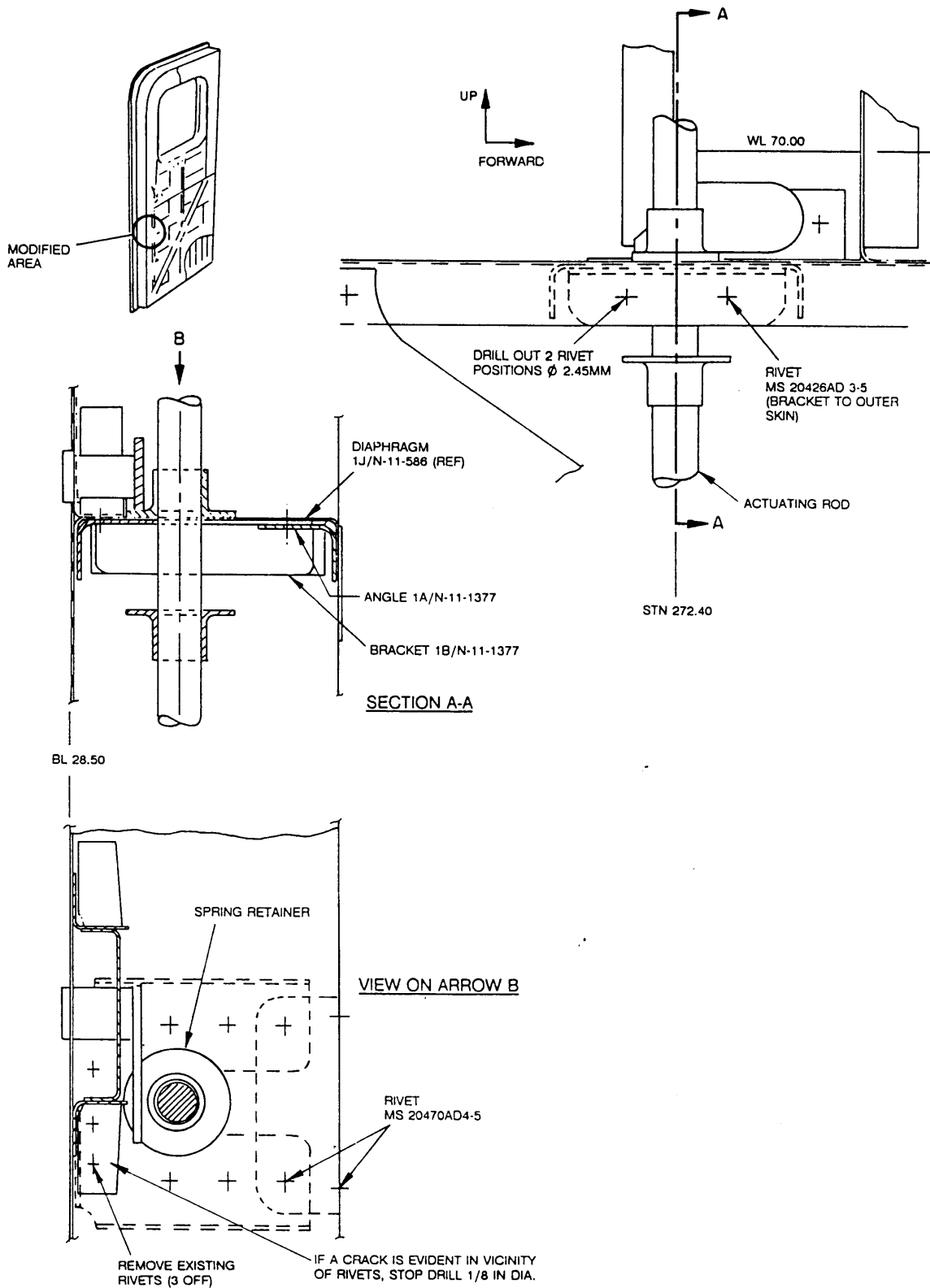
L. Publications Affected

Nil.

2. ACCOMPLISHMENT INSTRUCTIONS

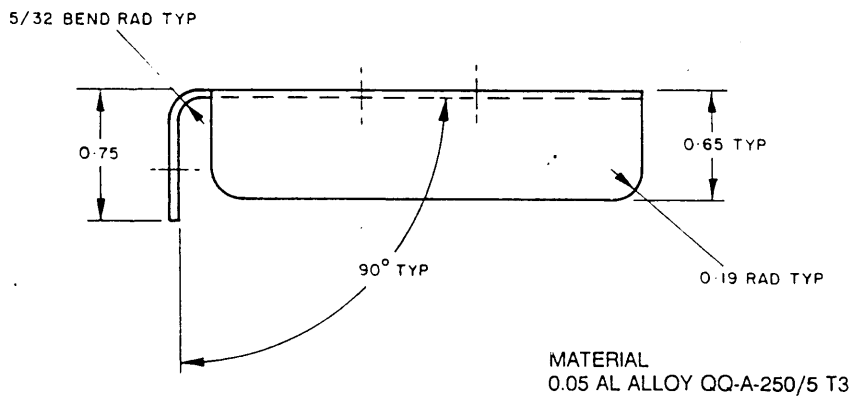
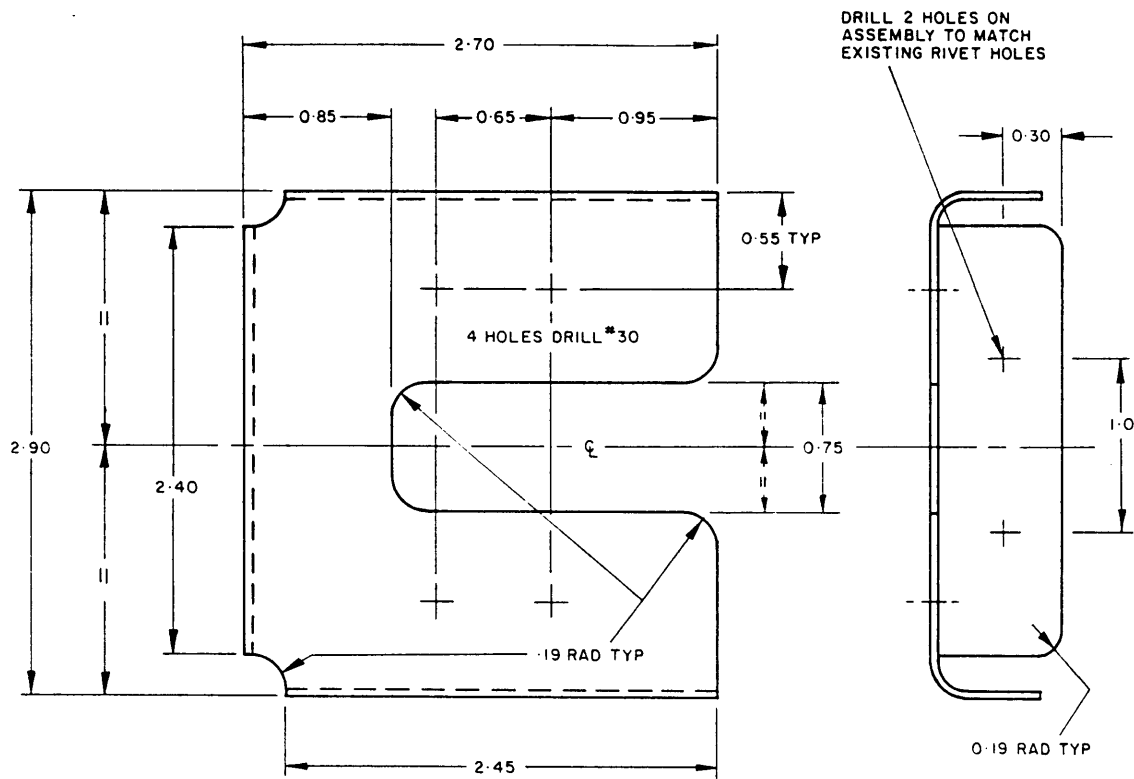
- A. Remove the lower trim from the passenger door.
- B. Drill out the two rivets as shown in Figure 1 View on Arrow B. Inspect area around rivet holes for any signs of cracking. If the area is cracked, stop drill using a 1/8 in dia drill.
- C. Make a bracket 1A/N-11-1377SB and angle 1B/N-11-1377SB as shown in Figs 2 and 3 respectively.
- D. Position the bracket and angle and, using the bracket and angle as templates, drill rivet holes in the diaphragm and door frame with a #30 drill. Using a ϕ 2.45 mm drill, drill out two rivets from the outer skin to match the bracket as shown in Figure 1. Deburr all holes.
- E. Rivet bracket and angle to diaphragm using MS20470AD4-5 rivets. Rivet bracket to outer skin using MS20426AD3-5 rivets and angle to door frame using MS20470AD4-5 rivets.
- F. Clean all swarf from inside door. Alodine and epoxy prime any bare metal.

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Re-Inforcing of Aft Passenger Door
Figure 1

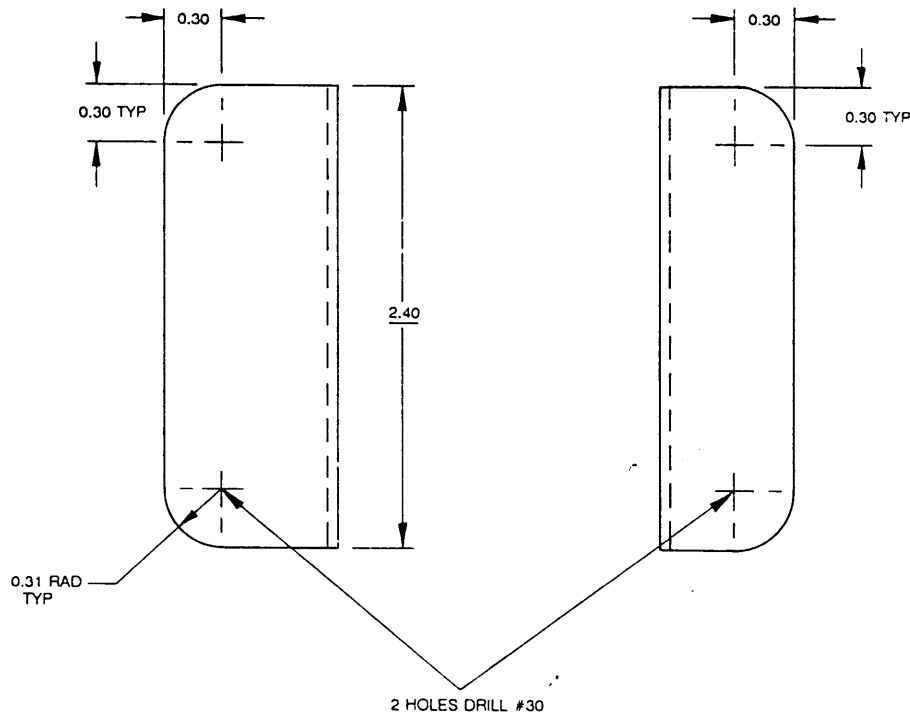
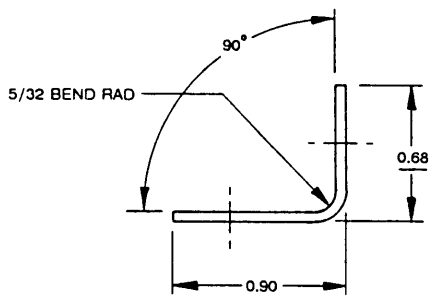
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PART NUMBER IA/N-II-1377 SB

Bracket Manufacturing Details
Figure 2

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MATERIAL 0.05 AL ALLOY QQ-A-250-5 T3

PART NUMBER 1B/N-11-1377SB

Angle Manufacturing Details
Figure 3

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