



GOVERNMENT AIRCRAFT FACTORIES

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In Reply Quote

AS/B ANMD-55-13
Revision 1

22nd August, 1980

SUBJECT: NOMAD ALERT SERVICE BULLETIN ANMD-55-13 - REVISION 1

Ladies and Gentlemen,

Alert Service Bulletin ANMD-55-13 is now issued at Revision 1 and incorporates the following changes.

(1) Page 1 of 4 Para 5B Note 2 4th line.

"and through the side lug" added after "spar web".

(2) Page 2 of 4 Para 5D 1st line.

".063 in" added inside brackets.

(3) Page 3 of 4 Para 5.H.1, 4th line.

".063 in" added inside brackets.

(4) Page 3 of 4 Para 5H.1.5th line.

".032 in" added inside brackets.

(5) Page 3 of 4 Para 5H.3.1st line.

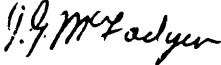
"Fit one NAS 1303-6 bolt in the side lug in each bracket" added at start of line.

(6) Page 3 of 4 Para 5H.6.6th line.

New line added "(alt MS21299-C3)".

(7) Page 4 of 4 Para 5K.

Para 5K revised.


I.G. McFADYEN
PRODUCT SUPPORT MANAGER

ALERT SERVICE BULLETIN

(ORIGINAL TRANSMITTED BY TELEX 22-7-80)
(Telex revisions S551, S559, S560 included)

FROM GOVERNMENT AIRCRAFT FACTORIES

NOMAD ALERT SERVICE BULLETIN ANMD-55-13

1. SUBJECT - HORIZONTAL STABILISER PIVOT BRACKETS - LOOSE ATTACHMENT BOLTS.
2. APPLICABILITY - ALL NOMAD N22 AND N24 SERIES AIRCRAFT.
3. COMPLIANCE -

WITHIN 120 HOURS TIME IN SERVICE AFTER JULY 16TH, 1980, OR BEFORE SEPTEMBER 16TH, 1980, WHICHEVER OCCURS FIRST.

4. REASON - LOSS OF TORQUE OF HORIZONTAL STABILISER PIVOT BRACKET ATTACHMENT BOLTS.

5. ACCOMPLISHMENT INSTRUCTIONS -

A. REMOVE HORIZONTAL STABILISER (REF M.M. CHAPTER 55-20-00).

B. (REF IPC 55-10-01, FIG 1, DETAIL A).

REMOVE BOTH HORIZONTAL STABILISER PIVOT BRACKETS (ITEM 9) PN 1A/N-30-127 FROM SPAR OF HORIZONTAL STABILISER.

NOTE 1: IDENTIFY BRACKETS TO ENSURE EACH IS RETURNED TO ORIGINAL LOCATION.

NOTE 2: IPC 55-10-01, FIG 1, DETAIL A, SHOWS PIVOT BRACKETS ATTACHED BY 9 OFF NAS 1303-6 BOLTS. SOME AIRCRAFT HAVE NAS 1303-6 BOLTS IN THE TWO VERTICAL HOLES, IN THE EXTREME UPPER AND LOWER HOLES THROUGH THE SPAR WEB AND THROUGH THE SIDE LUG. THE REMAINING BOLTS THROUGH THE SPAR WEB ARE NAS 1103-6.

- C. CLEAN EXCESS PAINT, PIGMENTED JOINTING COMPOUND, BURRS, SWARF, CORROSION, ETC FROM BETWEEN BRACKETS AND SPAR, FROM UNDER BOLT HEADS ON INSIDE OF SPAR, AND UNDER WASHERS ON BRACKET.
INSPECT THROUGH LIGHTENING HOLE THE INTERIOR OF HORIZONTAL STABILISER CENTRE SECTION TORQUE BOX FOR CRACKS. IN PARTICULAR INSPECT FOR CRACKS ORIGINATING FROM EXTREME UPPER AND LOWER PIVOT BRACKET ATTACHMENT BOLT HOLES IN UPPER AND LOWER SPAR CAP FLANGES. REPORT FINDINGS OF THIS INSPECTION TO GAF PRODUCT SUPPORT TLX NOMAD - AA 34397.

- D. MANUFACTURE FROM EXISTING AN 960-C10 (.063 IN THICK) WASHERS ONE OFF COUNTERSUNK WASHER FOR EACH BOLT. CHAMFER INSIDE DIA .030 X 45 DEG ON ONE FACE ONLY. ALT MS 21299-C3 CSK WASHERS MAY BE USED IF AVAILABLE.
- E. REFIT BRACKETS TEMPORARILY TO SPAR USING 7 BOLTS THROUGH SPAR WEB ONLY. FIT CSK WASHERS UNDER HEAD OF EACH BOLT, WITH CSK FACING HEAD. TORQUE TIGHTEN 35-40 LB. IN. (4-4.5 NM) ON NAS 1303 BOLTS IN EXTREME TOP AND BOTTOM LOCATIONS AND 20-25 LB. IN. (2.3-2.8 N.M.) ON REMAINING FIVE NAS 1103 BOLTS IN SPAR WEB. ENSURE BRACKETS ARE CLAMPED CLEANLY TO SPAR WEB.
- F. CHECK ALIGNMENT AND SIZE OF TWO VERTICAL HOLES THROUGH CHANNELS ON TOP AND BOTTOM OF CENTRE SPAR WITH HOLES IN ENDS OF BRACKET. IF ALIGNMENT IS NOT PERFECT OR IF HOLES IN CHANNEL ARE ELONGATED DRILL AND REAM HOLES OVERSIZE TO SUIT NAS 6203-6X OR NAS 6203-6Y STRUCTURAL REPAIR BOLTS. BOLTS TO BE LIGHT PUSH FIT IN HOLES. REMOVE UPPER STOP BOLT BLOCK FROM CHANNEL ABOVE RIGHT HAND PIVOT BRACKET TO GAIN ACCESS TO UPPER VERTICAL BOLT HOLE FOR INSPECTION AND REWORK.
- BLOCK MAY BE REPLACED USING EITHER MS20470AD6-20 RIVETS OR ALTERNATIVE NAS1303-16 BOLTS, MS21042-3 NUTS, AND AN960-10 WASHERS (OR SUITABLE ALTERNATIVE).
- NOTE WHEN DRILLING AND REAMING VERTICAL BOLT HOLES, ENSURE BRACKET IS FIRMLY CLAMPED AGAINST SPAR. IF NECESSARY, CLEARANCE FOR DRILL AND REAMER MAY BE IMPROVED BY TEMPORARILY INSTALLING EXTREME UPPER AND LOWER (HORIZONTAL) BOLTS IN SPAR WEB WITH HEADS REVERSED AND WITHOUT WASHERS UNDER HEAD.
- G. REMOVE BRACKETS, DEBURR HOLES AND REMOVE SWarf, ETC.
- H. INSTALL BRACKETS -
INSTALL BOLTS AND BRACKET USING BARIUM CHROMATE PIGMENTED JOINTING COMPOUND AS FOLLOWS:

NOTE ENSURE CSK WASHERS ARE FITTED UNDER ALL BOLT HEADS WITH CSK FACING BOLT HEAD.

1. FIT TWO BOLTS (NAS 1303-6 OR NAS 6203-6X OR NAS 6203-6Y (REF F ABOVE)) THROUGH VERTICAL HOLES IN ENDS OF BRACKET AND CHANNELS FITTING CSK WASHERS UNDER BOLT HEADS INSIDE BRACKET AND TWO WASHERS - ONE AN 960-C10 (.063 IN THICK) AND ONE AN 960-C10L (.032 IN THIN) UNDER NUT (CLEAN AND USE EXISTING WASHERS).
 2. SUPPLY AND FIT NAS 1303-7 BOLTS IN EXTREME UPPER AND LOWER HORIZONTAL HOLES THROUGH SPAR WEB. FIT CSK WASHER UNDER HEADS OF BOLTS INSIDE SPAR. FIT TWO WASHERS - ONE THICK AND ONE THIN UNDER NUTS.
 3. FIT ONE NAS 1303-6 BOLT IN THE SIDE LUG IN EACH BRACKET. FIT NAS 1103-6 BOLTS IN REMAINING 4 HOLES IN EACH BRACKET. FIT CSK WASHER UNDER BOLT HEAD AND ONE THICK AND ONE THIN WASHER UNDER EACH NUT.
 4. TORQUE TIGHTEN NAS 1303, NAS 6203 BOLTS TO 35-40 LB IN (4-4.5 N.M) TORQUE TIGHTEN NAS 1103 BOLTS TO 20-25 LB IN (2.3 - 2.8 N.M).
 5. MEASURE AND ADD RUNNING TORQUE OF STIFFNUTS TO TORQUE FIGURES QUOTED.
 6. PARTS REQUIRED TO BE SUPPLIED BY OPERATORS:
NAS 1303-7 BOLTS - 4 OFF
NAS 6203-6X BOLTS - AS REQUIRED
NAS 6203-6Y BOLTS - AS REQUIRED
AN 960-C10 WASHERS - AS REQUIRED
(ALT MS21299-C3)
- I. REINSTALL HORIZONTAL STABILISER (REF M.M 55-20-00).
- J. RECORDING ACTION -
RECORD COMPLIANCE WITH THIS BULLETIN IN AIRFRAME LOG BOOK.
THIS BULLETIN IS AN APPROVED SCHEME FOR COMPLIANCE WITH AD/GAF - N22/39.

22nd August, 1980

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K. APPROVAL:

THE MODIFICATION DETAILED HEREIN HAS BEEN APPROVED PURSUANT TO AIR
NAVIGATION REGULATION 40 AND CONFORMS WITH THE TYPE CERTIFICATE
REQUIREMENTS

PRODUCT SUPPORT: *J. M. Lashy*

POST DESIGN SECTION: *Peter J. Shaw*

FOR GOVERNMENT AIRCRAFT FACTORIES