

*Nomad***SERVICE BULLETIN**

SUBJECT: REINFORCING CHANNEL FITTED BETWEEN
STUB FIN FORWARD STRINGERS (MOD N477)

1. Planning Information**A. Effectivity****(1) Aircraft Affected**

All Nomad N22-Series and N24-Series aircraft whose log books do not already record the embodiment of Mod N477 or compliance with Service Bulletin NMD-55-16.

Pre-certification implementation of the intent of this service bulletin is recorded in the Airframe Log Book as Mod N477.

(2) Spares Affected

None.

B. Reason

A few instances have been reported in which cracks have appeared in the stub fin side skins, in the region of the forward stringer attachment points, or in the forward stringers themselves.

C. Description

The stub fin forward stringers and side skins are to be inspected for damage and repaired or replaced as necessary. A reinforcing channel is then to be riveted to the stub fin rib and to the stub fin LH and RH forward stringers.

D. Compliance

As soon as possible after receipt of this service bulletin, but not later than the next scheduled service.

E. Approval

The modification detailed herein has been approved pursuant to Air Navigation Regulation 40 and conforms with the type certification requirements.

F. Manpower

Six manhours

G. Material - Price and Availability

The materials required to comply with this service bulletin (Ref Para 3) are to be procured from operator's stock or local sources.

H. Tooling - Price and Availability

None required.

J. Weight and Balance

Negligible effect.

K. References

Maintenance Manual (MM)
Structural Repair Manual (SRM)

L. Publications Affected

None.

2. Accomplishment Instructions

CAUTION: ENSURE FLYING CONTROLS CANNOT BE OPERATED WHILE PERSONNEL ARE WORKING IN THE VICINITY OF THE HORIZONTAL STABILIZER.

- A. Support the rear of the aircraft (Ref MM 7-00-00).
- B. Remove the dorsal fin (Ref MM 55-30-00).
- C. Adjust the flight controls to set the leading edge of the horizontal stabilizer to its fully-up position. Lock the horizontal stabilizer in this position by means of rigging bar P/N 1/N-88-181 (Ref MM 27-40-00).
- D. Inspect the stub fin forward stringers and side skins for damage.
 - (1) Remove the inspection cover on the LH side of the stub fin. Retain the inspection cover and its attaching screws.
 - (2) Using a torch and mirror inspect the stub fin internal structure for damage. In particular, check the bottom end of the forward vertical stringers at their points of attachment to the side skins. Replace or repair damaged stringers in accordance with SRM 53-10-11 Figure 2.
 - (3) Inspect the side skins of the stub fin for damage, particularly along the rivet lines where the skins are attached to the LH and RH forward stringers. Repair any damaged skin in accordance with SRM 53-30-11 Figure 3.

- E. Manufacture the reinforcing channel illustrated in Figure 1.
- F. Install the reinforcing channel.
 - (1) Hold the reinforcing channel in position (Ref Figure 2) and check that the bottom and vertical sections of the channel sit flush against the stub fin bottom rib and forward stringers, respectively. Fashion the channel, as necessary, to achieve correct fit.
 - (2) Clamp the reinforcing channel in position.
 - (3) Using the holes in the reinforcing channel as a drill guide, drill seven 0.1285 inch dia. holes in the stub fin bottom rib and two 0.1285 inch dia. holes in each of the LH and RH front stringers.
 - (4) Rivet the reinforcing channel to the stub fin structure using eleven 0.125 inch dia blind rivets (Ref Para 3.A.).
- G. Replace the inspection cover on the LH side of the stub fin and secure with the original screws.
- H. Remove the horizontal stabilizer rigging bar P/N 1/N-88-181 from the aircraft.
- J. Install the dorsal fin (Ref MM 55-30-00).
- K. Remove the aircraft rear support provided in Para 2.A.

3. Materials Information

A. Parts Required per Aircraft

No kit is issued for the accomplishment of this service bulletin. Operators are to procure the following items from stock or local sources:

<u>Item P/N</u>	<u>Description</u>	<u>Qty</u>
.025-QQ-A-250/5-T3	Aluminium alloy sheet	As required
-	Aluminium alloy primer	As required
MS20600AD4W1	Rivet, 0.125 inch dia. or	11
CR916-4-1	Rivet, 0.125 inch dia.	Alt

B. Parts modified and reidentified by the operator:

None.

C. Parts Required to Modify Spares

None.

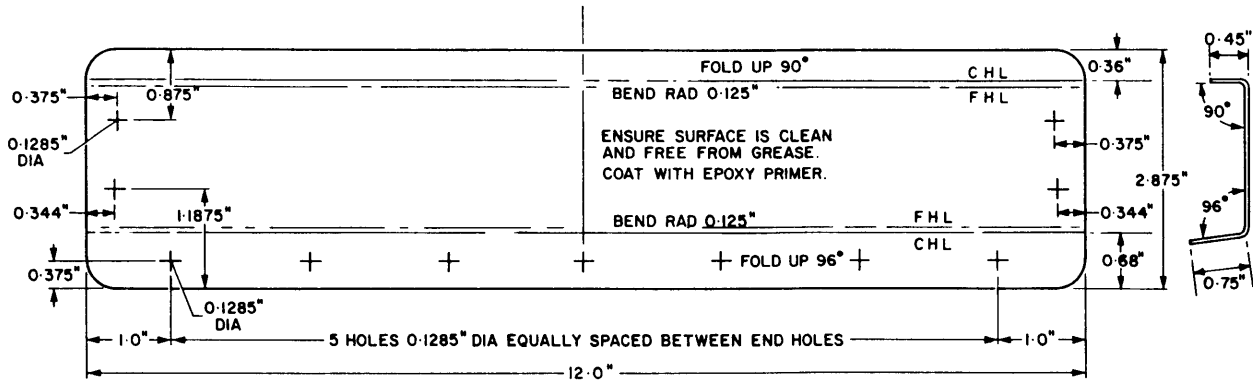
D. Removed Parts

None.

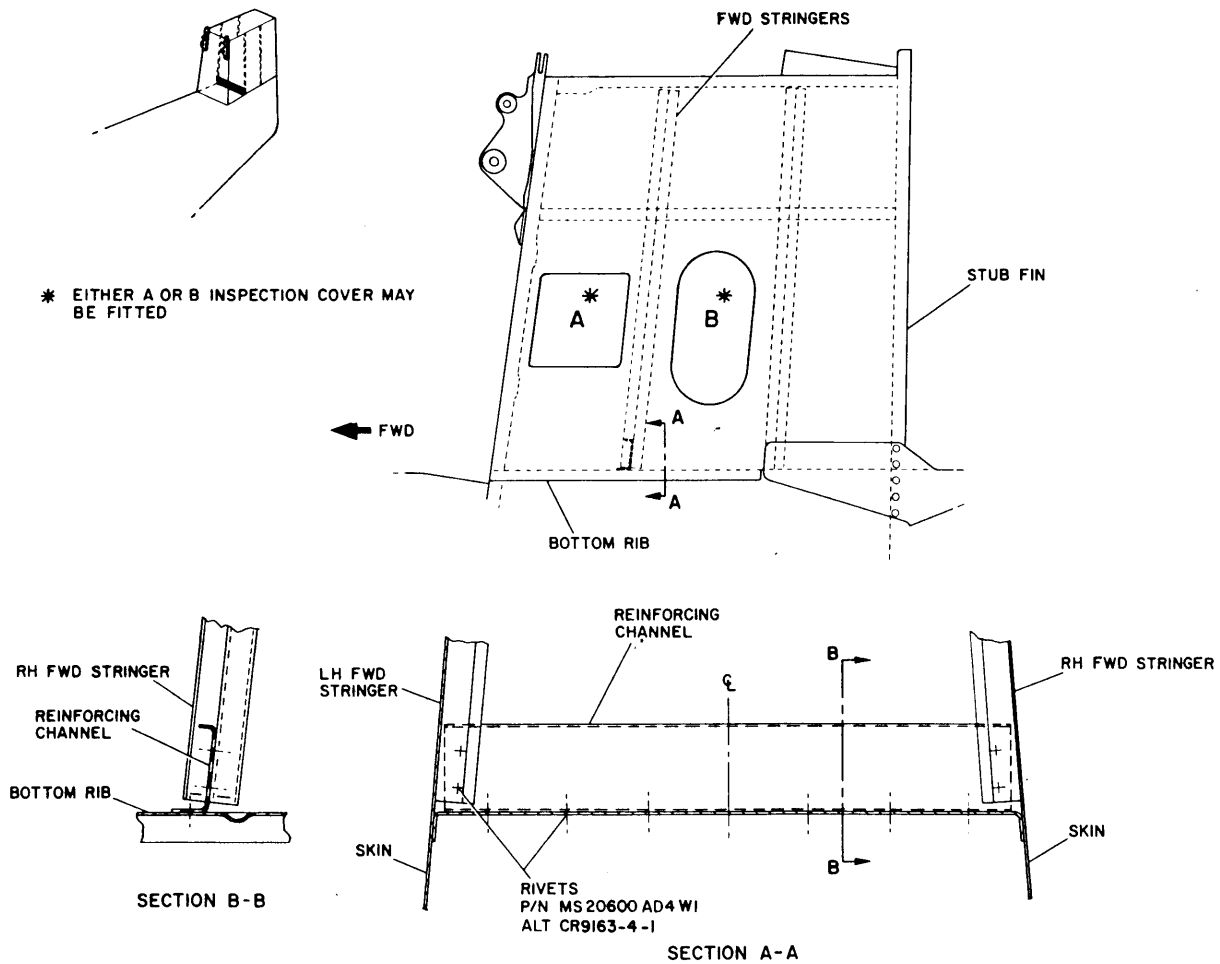
E. Special Tools and Equipment Required

Horizontal stabilizer rigging bar P/N 1/N-88-181.

4. Record compliance with Service Bulletin NMD-55-16 in the airframe log book.



Manufacture of Reinforcing Channel
Figure 1



Installation of Reinforcing Channel
Figure 2