



SERVICE BULLETIN

SUBJECT: HORIZONTAL STABILIZER - ADDITIONAL DRAINAGE HOLES
(Mod N618)

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 N618 or compliance with Service Bulletin NMD-55-22.

(2) Spares Affected

<u>Part No</u>	<u>Nomenclature</u>	<u>Recommended Disposition</u>
1/N-03-625	Horizontal Stabilizer Assy) (Post Mod N439/Ref) S/B NMD-55-12)	
201/N-30-178/ NMD-55-18	Horizontal Stabilizer Assy) (Post Mod N568/Ref) S/B NMD-55-18)	
202/N-30-178/ NMD-55-18	Horizontal Stabilizer Assy) (Post Mod N568/Ref) S/B NMD-55-18)	Rework
*1/N-30-238	Horizontal Stabilizer Assy) (Basic))	as per Para 2
2/N-30-238	Horizontal Stabilizer Assy) (Post Mod N462))	
3/N-30-238	Horizontal Stabilizer Assy) (Post Mod N520))	
4/N-30-238	Horizontal Stabilizer Assy) (Post Mod N502))	
5/N-30-238	Horizontal Stabilizer Assy) (Post Mod N568))	

*Includes Mods N388, N398, N211 (N22-Series) or N211-24 (N24-Series)

B. Reason

Additional drainage holes in bottom skins of horizontal stabilizer provided to improve drainage.

C. Description

Thirteen new 5.1mm dia drainage holes are drilled in each of the horizontal stabilizer's LH and RH bottom skins (Ref Figure 1).

D. Compliance

Incorporation of this Service Bulletin is strongly recommended.

E. Approval

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

F. Manpower

Two manhours.

G. Material - Price and Availability

Not applicable.

H. Tooling - Price and Availability

None required.

J. Weight and Balance

Negligible effect.

K. References

MM - Maintenance Manual

L. Publications Affected

MM

2. Accomplishment Instructions

- A. Immobilise the horizontal stabilizer by fitting the internal flying control surface gust lock (Ref MM 27-70-00, Maintenance Practices).

- B. Using a soft lead pencil mark the positions of the new drainage hole centres on the bottom skins of the horizontal stabilizer (Ref Figure 1).
- C. Drill the new 26 drainage holes, at the positions marked at step B, with a 5.1mm (0.20in) dia drill. Debur the holes and remove drill swarf from inside the stabilizer.

NOTE: The skin thickness is .020 inches. Take care not to damage the skin when drilling holes.

- D. Treat bare metal at new holes with Alodine 1200 then prime with epoxy primer. Touch up external paint finish where damaged around new holes (Ref MM Chap 11).
- E. Remove and stow, if required, the internal flying control surface gust lock (Ref MM 27-70-00, Maintenance Practices).

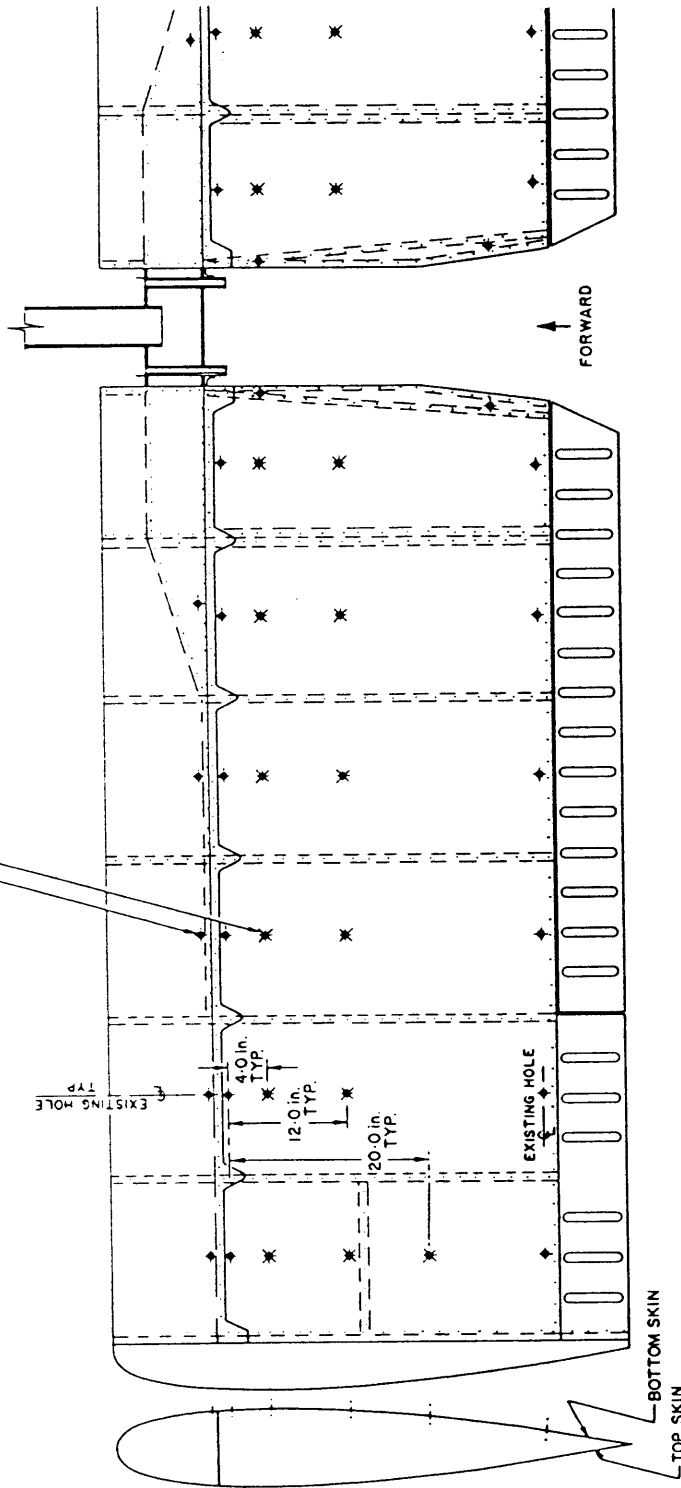
3. Material Information

Not applicable.

4. Recording Action

- A. Record compliance with Service Bulletin NMD-55-22 (Mod N618) in the airframe logbook.
- B. Add S/B NMD-55-22 to Part Number on the horizontal stabilizer, e.g. 1/N-30-238/NMD-55-22.

◊ EXISTING DRAIN HOLES 38 PLACES TYP.
 * NEW DRAIN HOLES
 DRILL 5.1mm DIA.
 BOTTOM SURFACE ONLY
 TYP. 26 PLACES



INVERTED PLAN VIEW OF HORIZONTAL STABILIZER

Drill Plan for Mod N618