

Nomad

SERVICE LETTER

02-1

TAILPLANE PIVOT BOLT — REMOVAL AND INSTALLATION

INSTRUCTIONS

Insert Service Letter 02-1 into the Service Letter binder and annotate the index accordingly.

CONTENTS

A. Introduction

Instances have been reported of difficulties that have been encountered in the removal/replacement of the tailplane pivot bolts.

Pivot bolts exhibiting signs of wear on surfaces contacting the bushes may be difficult to remove due to misalignment. Removing the pivot bolts by levering under the bolt head can cause damage to the tailplane skin. The pivot bolts can also be damaged during removal, requiring replacement of the pivot bolts, which is costly to the operator.

A special pivot bolt extractor tool has been designed to facilitate the removal of the tailplane pivot bolts without causing damage to the tailplane skin, pivot bolts or bushes.

B. Purpose

The purpose of this Service Letter is to provide extraction and installation instructions for the tailplane pivot bolts using the special Tailplane Pivot Bolt Extractor Tool and 'Bullet' Kit (Ref Figure 1).

C. Instructions for Extraction of Tailplane Pivot Bolt

- (1) Support the tailplane.
- (2) Remove the cotter pin, washer and nut from the tailplane pivot bolt.
- (3) Screw the extractor bolt through the tool body until the tip of the bolt is flush with the surface of the tool body.
- (4) Fit the slotted sections of the tool body over the inboard flange of the tailplane hinge bracket and align the extractor bolt with the pivot bolt (Ref Figure 2).
- (5) Gradually screw in the extractor bolt so the hollow end passes over the threaded end of the pivot bolt. When the pivot bolt bottoms in the end of the extractor bolt, resistance will be felt as the pivot bolt is pushed through the bushes.
- (6) Once the extractor bolt is screwed fully home, remove the pivot bolt.
- (7) If the tailplane is not to be removed, the extractor tool may be left in position to support the tailplane. Do not apply heavy loads to the tailplane while the extractor tool is supporting the tailplane. This will damage the tool and possibly the tailplane pivot bushes.

D. Instructions for Installation of Tailplane Pivot Bolt

- (1) Fit the 'bullet' over the threaded end of the pivot bolt. Apply sufficient grease (MIL-G-21164D, AeroShell 17 or equivalent) to the hollow end of the 'bullet' to stop it from falling off the pivot bolt if the bolt is inverted. Apply a small amount of the same grease to the nose of the 'bullet' to ease its passage between the bushes.
- (2) Install the pivot bolt with its head facing outwards. If the extractor tool has been left in position to support the tailplane, progressively unscrew the extractor bolt as the pivot bolt is installed.

Page 1

Nomad

SERVICE LETTER

- (3) Remove the 'bullet' and any remaining grease from the end of the pivot bolt.
- (4) Install the washer and nut to the tailplane pivot bolt. Torque tighten nut to between 30 and 40 lb in and install new cotter pin.

E. Price and Availability

Price and availability of Tailplane Pivot Bolt Extractor Tool and 'Bullet' Kit (Part No SL 02-1) is available upon request from Nomad Customer Support - Boeing Aerospace Support - ASTA.

Kit Part Number SL 02-1 consists of:

- (1) Extractor Tool PN 1630-4017, and
- (2) Bullet PN 1630-4018.

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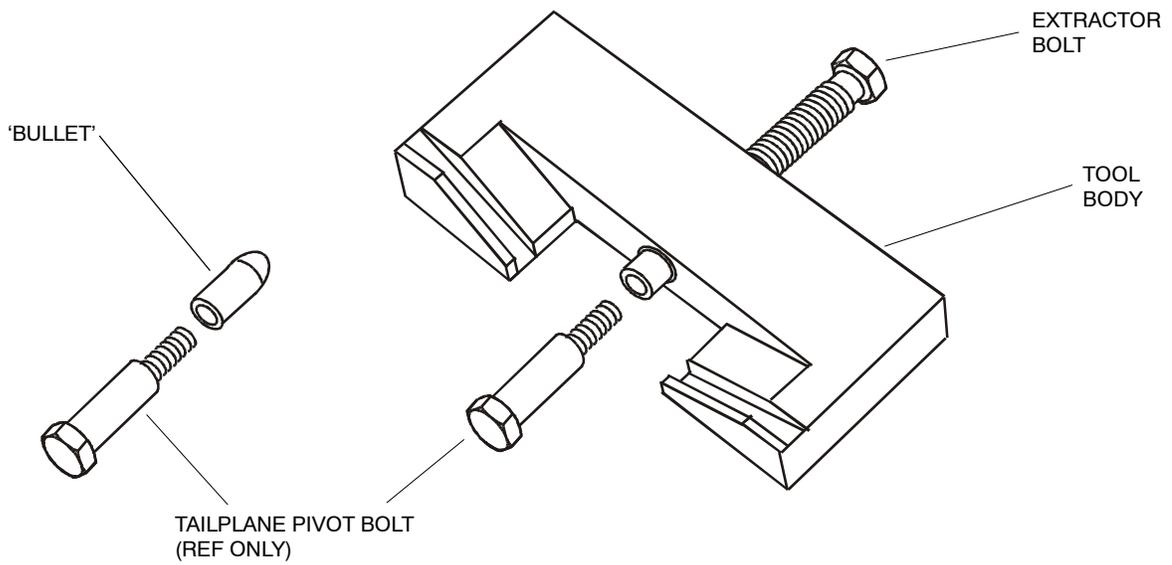


Figure 1 Tailplane Pivot Bolt Extractor Tool Kit

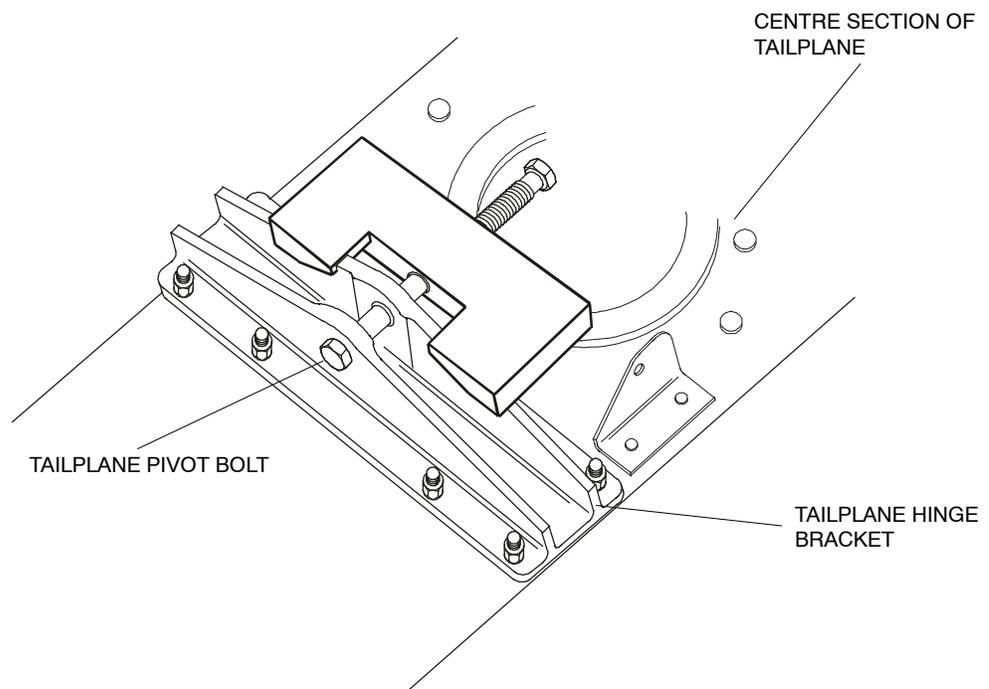


Figure 2 Tailplane Pivot Bolt Extractor Tool Installation