



A Mahindra Aerospace Company

PO Box 881, Morwell, Victoria 3840, Australia

Ph + 61 (0) 3 5172 1200

Fax + 61 (0) 3 5172 1201

www.gippsaero.com

SB-GA8-2009-53

Issue 6

OPTIONAL

Service Bulletin

Subject:

Undercarriage Access Panel Retrofit

Applicability:

GA8-04-045, GA8-04-051, GA8-04-053, GA8-04-057, GA8-04-065, GA8-05-073, GA8-06-100, GA8-06-104, GA8-07-112, GA8-07-116, GA8-07-117, GA8-07-119, GA8-TC 320-09-120, GA8-08-129, GA8-TC 320-08-130, GA8-TC 320-08-134, GA8-TC 320-09-145, GA8-TC 320-09-146, GA8-TC 320-09-149, GA8-TC 320-09-150, GA8-TC 320-09-151, GA8-TC 320-09-152, GA8-TC 320-09-154, GA8-TC 320-09-155, GA8-TC 320-10-156.

Amendments:

Issue 1: Nil (initial issue).

Issue 2: Applicability increased to include GA8-TC 320-10-156.

Issue 3: Applicability increased.

Issue 4: GA8-07-116, GA8-07-119, GA8-TC 320-09-120, GA8-TC 320-08-134, GA8-TC 320-09-150 included in applicability.

Issue 5: GA8-TC 320-09-145, GA8-TC 320-09-151, GA8-TC 320-09-152, GA8-TC 320-09-154, GA8-TC 320-09-155 included in applicability.

Issue 6: GA8-07-112 included in applicability.

Background:

To improve access to Main Landing Gear attachments two kits have been designed.

Kit 1: This kit requires the existing skins to be modified using the template.

Kit 2: This kit requires the existing skins to be removed and replaced with new fwd and mid cabin belly skins.

Compliance:

For applicable aircraft this optional Service Bulletin may be incorporated at the owner's discretion.

Weight and Balance:

Negligible effect on weight and balance.

Approval:

This modification has been internally approved following the justification given in the form GAE12-694.

Parts:**Kit 1 (available as P/N SB-GA8-2009-53-1)**

Item	Part Number	Description	Qty
1	GA8-945321-021	DRILL-OFF TEMPLATE	1
2	MS21073L3	CORNER LEG ANCHOR NUT	4
3	MS20426AD3-6	RIVET	8
4	MS21051L3	ONE LEG ANCHOR NUT	8
5	NAS1097AD3-5	RIVET	68
6	MS21047L3	ANCHOR NUT	26
7	GA8-112011-401	PLACARD	1
8	AN525-10R8	STRUCTURAL SCREW	38
9	GA8-533021-129	ACCESS PANEL	1

Kit 2 (available as P/N SB-GA8-2009-53-2)

Item	Part Number	Description	Qty
1	MS21073L3	CORNER LEG ANCHOR NUT	4
2	MS20426AD3-6	RIVET	8
3	MS21051L3	ONE LEG ANCHOR NUT	4
4	NAS1097AD3-5	RIVET	68
5	MS21047L3	ANCHOR NUT	26
6	MS21071L3	ONE LEG ANCHOR NUT	4
7	GA8-112011-401	PLACARD	1
8	GA8-533021-129	ACCESS PANEL	1
9	GA8-533021-113	FWD CABIN BELLY SKIN	1
10	GA8-533021-115	MID CABIN BELLY SKIN	1

Parts Availability:

New parts can be obtained directly from GippsAero.

Tel.: +61 03 5172 1200

Fax: +61 03 5172 1201

Email: spares@gippsaero.com

Labour:

3 hour should be allocated to the incorporation of this service bulletin.

Warranty:

Not applicable.

Procedure:

Installation of Kit 1

1. Jack aircraft as required.
2. Drill out and remove the domed head rivets within the dotted boundary shown in Figure 1 in the belly surrounding the existing undercarriage access panel.

WARNING:

BE AWARE OF CABLES LINES AND OTHER FITTINGS WHEN DRILLING RIVETS AND CUTTING SKINS.

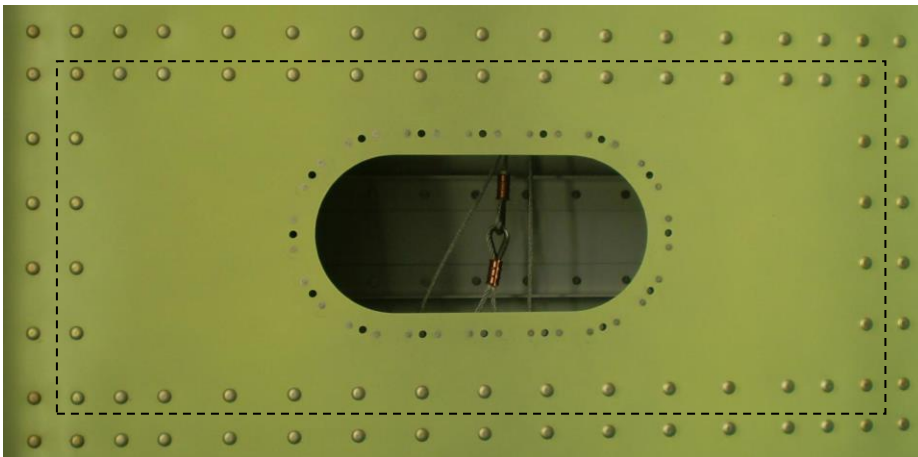


Figure 1: Rivets to be removed from belly (only the inside rows of rivets of the double rows shown).

3. If the existing access panel is secured, unscrew and remove it.
4. Using the same screws for securing the existing access panel, secure drill-off template (P/N GA8-945321-021) to the belly in place of the existing access panel. Refer to Figure 2.

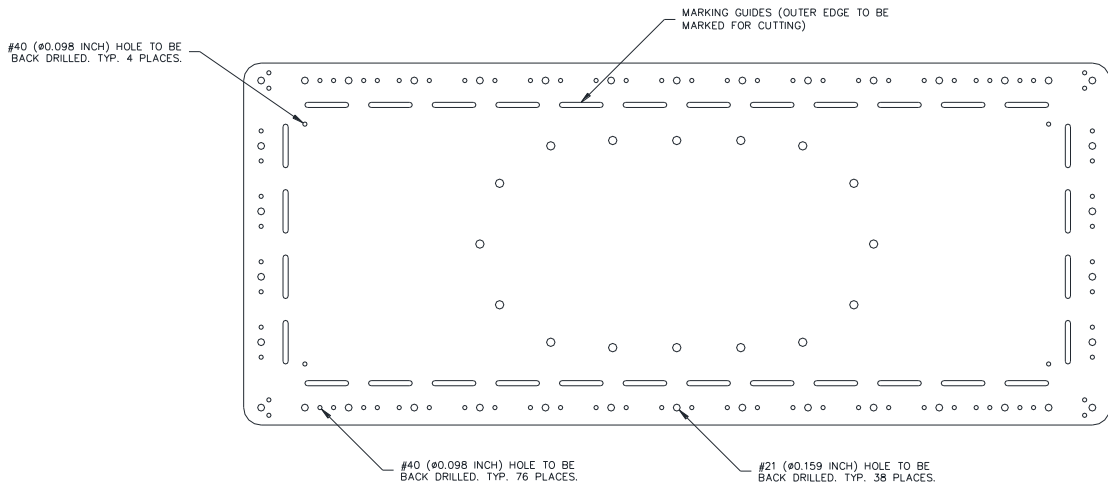


Figure 2: Drill-off template detail.

5. Drill the #21 (0.159 inch diameter) and #40 (0.098 inch diameter) anchor nut holes around the edge of the drill-off template, further securing the template as required by pinning it to the belly as holes are drilled.
6. Drill the four #40 (0.098 inch diameter) holes inside the corners of the marking guides of the drill-off template.
7. Mark the the new access hole using the marking guides in the drill-off template. The outside edges of the inch-long slots are the edges to be marked.
8. Remove the drill-off template and ensure the spacing of the cutting marks is 6.5 inches in the longitudinal direction and 18.0 inches in the lateral direction.
9. Open the four #40 (0.098 inch diameter) holes inside the corners of the cutting marks to 7/8 inch diameter.
10. Cut and remove the section of doubled belly skins inside the cutting marks to create the new enlarged access hole.
11. Deburr the edges of the new access hole and remove trapped chips from between skins.
12. Treat and repaint bare metal.
13. Open out the anchor nut screw holes to #10 (0.1929 inch diameter).
14. Countersink the #40 (0.098 inch diameter) holes around the new access hole for NAS1097AD3 rivets.
15. Install an MS21073-L3 corner leg anchor nut in each corner using MS20426AD3-6 rivets.
16. Install two MS21051-L3 one leg anchor nuts inboard of each corner leg anchor nut using NAS1097AD3-5 rivets.
17. Install MS21047-L3 anchor nuts in remaining locations using NAS1097AD3-5 rivets.
18. Touch up the edges of the new inspection hole with primer and topcoat as required.
19. Install placard (P/N GA8-112011-401) onto the inside face of the new access panel (P/N GA8-533021-129).
20. Install the new access panel using AN525-10R8 screws.

Installation of Kit 2

1. Jack aircraft as required.
2. Remove the existing mid cabin belly skin (P/N GA8-533021-25) and fwd cabin belly skin (P/N GA8-533021-13) surrounding the existing undercarriage access panel and replace it with GA8-533021-115 (mid cabin belly skin) and GA8-533021-113 (fwd cabin belly skin).

WARNING:

BE AWARE OF CABLES LINES AND OTHER FITTINGS WHEN DRILLING RIVETS AND CUTTING SKINS.

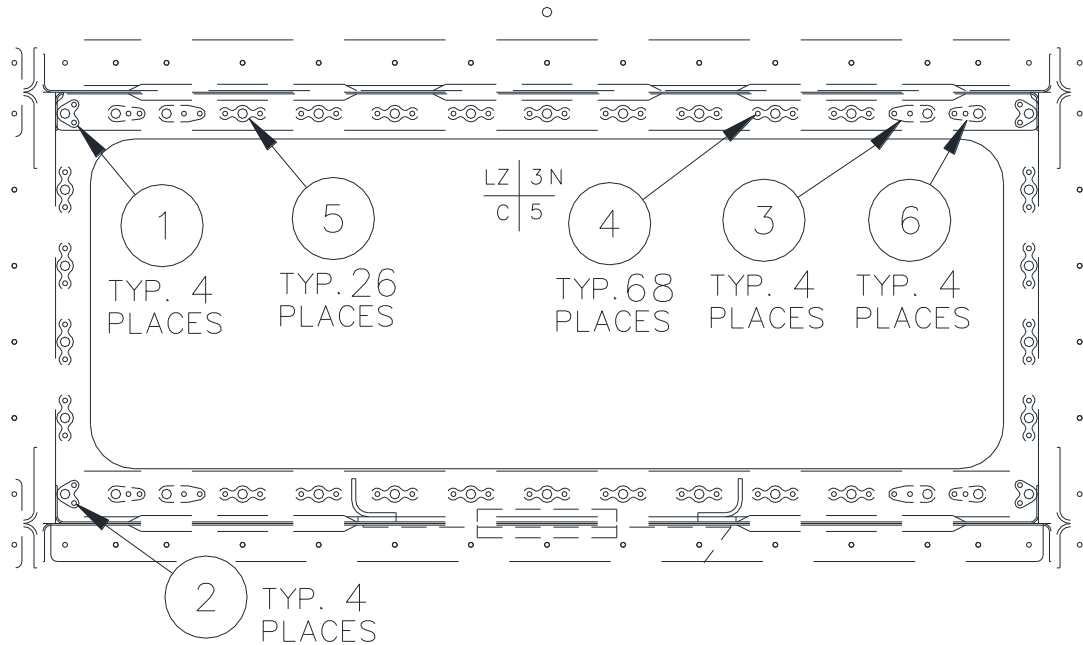


Figure 1: Hardware to be installed on belly skins

3. Install four MS21073L3 corner leg anchor nut in each corner using MS20426AD3-6 rivets.
4. Install four MS21051-L3 one leg anchor nuts inboard of each corner leg anchor nut using NAS1097AD3-5 rivets.
5. Install MS21047-L3 anchor nuts and MS21071-L3 one leg anchor nut in remaining locations using NAS1097AD3-5 rivets.
6. Install placard (P/N GA8-112011-401) onto the inside face of the new access panel (P/N GA8-533021-129).
7. Install the new access panel using AN525-10R8 screws.

NOTE:

Use of replacement skin P/N GA8-533021-113 and GA8-533021-115 will comply with the requirement to cut the larger hole in the existing skins.

Documentation:

Update aircraft log book to reflect incorporation of this Service Bulletin. Insert Service Manual Supplement C05-96-14 into Supplements Section of the aircrafts Service Manual.

Continuing Airworthiness:

There are no additional continuing airworthiness requirements as part of the implementation of this Service Bulletin.

Compliance Notice:

Complete the Document Compliance Notice and return to GippsAero by mail, fax or email.

DOCUMENT COMPLIANCE NOTICE



A Mahindra Aerospace Company

Document:

SB-GA8-2009-53

Issue 6

Aircraft Serial Number: GA8-_____

Service Bulletin SB-GA8-2009-53 Issue 6 has been incorporated in the above aircraft.

Date: _____

Signed

Print Name: _____

Please email, post or fax this compliance notice to:

GippsAero
Attn: Technical Records
Email: techrec@gippsaero.com
P.O. Box 881
Morwell Victoria 3840
Australia
Fax: +61 03 5172 1201