

# Aero Commander service letter **No. SL-AG-9**

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**15 June, 1961**

## **STEEL AILERON HINGE INSTALLATION**

**APPLICABILITY:** All "A" and "B" Models through S/N 1072

A new hinge of 4130N steel has been designed, FAA approved, and installed on all late model aircraft. This new hinge eliminates the spar fatigue problem covered in Service Letter #8. The new hinges can be installed with or without the repair of Letter #8.

Engineering Department.

### **INSTRUCTION:**

- 1 Remove the ailerons from the aircraft.
- 2 Drill out new inspection holes behind each hinge located as follows: Midway between the chordwise row of rivets on each side of the hinge and 3 ¼ inches aft of the first row of rivets underneath the hinge. (see Dwg. 237)
- 3 Insert the inspection hole doubler at the inboard and outboard locations and fasten with eight evenly spaced rivets (AN470 AD3-4). The center hole is through double skin thickness and does not require a doubler.

The following procedure is recommended to assure correct location of the hinges. These distances could be measured directly off the present hinge points; however, any error in measurement could result in misalignment that would make installation difficult or impossible without relocation.

- 4 Remove any one of the old hinges. The new hinges need to have the previous bolt pattern marked on them so they can be drilled correctly for installation. Place a new hinge in its location and bolt the aileron back onto the wing. This will allow the old hinges to hang the aileron properly and allow you to mark or scribe from the back side the correct location of the holes on the new hinge. Remove the aileron. Drill out the bolt hole (3/16" diameter) marked on the hinge and bolt (AN3-4A) the hinge onto the aileron. Use a drill press if available to assure that the holes are true. If the spar repair of Service Letter #8 is being used and the new bolts are too short, your old bolts washered up should be satisfactory. Repeat this process for the other two hinges.
- 5 When you have the three hinges installed and are satisfied with aileron operation, rivet (AN 470 AD4-5) the top and bottom flange of the hinge at the previous rivet locations.
- 6 Repeat for the other aileron.

Kit List (Per Aileron)

<u>No. Required</u>	<u>Item</u>
4	Aileron Hinge Bracket (P/N 235-23)
2	Aileron Push-Pull Hinge Brackets (P/N 235-22)
3	Inspection Hole Doublers
36	AN3-4A Bolts
1	Drawing 237