



Thrush Aircraft, Inc.

Service Letter # SL-AG-109

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TORQUE CHART UPDATE

MODELS AFFECTED: All Model S2R aircraft.

REASON FOR PUBLICATION: To provide the latest updated Torque Chart for maintenance operations reference.

COMPLIANCE: At the earliest convenience.

BY WHOM THE WORK WILL BE ACCOMPLISHED: Owner or authorized representative.

APPROVAL: Thrush Aircraft, Inc. Engineering Manager.

MAN HOURS REQUIRED: Negligible.

SPECIAL TOOLS: None.

PROCEDURE:

Insert the accompanying Maintenance Manual Supplement (updated Torque Chart) in the servicing section (Section 2) of the corresponding Airplane Maintenance Manual next to the existing torque chart.

The Updated Torque Chart contains the latest torque information reference and should be used in place of the old one.

WEIGHT AND BALANCE: No Change.

PUBLICATIONS AFFECTED: Airplane Maintenance Manual.

MAINTENANCE MANUAL SUPPLEMENT
TORQUE CHART: UPDATED 10/5/05

BOLTS		FINE THREAD SERIES ONLY	BOLTS							
STEEL - TENSION			STEEL - TENSION	STEEL - SHEAR	STEEL					
AN 3 thru AN 20 AN 42 thru AN 49 AN 73 thru AN 81 AN 173 thru AN 186 AN 509 NK9 AN 525 NK525 MS 20033 thru MS 20046 MS 20073 MS 24604 MS 27039			MS 20004 thru MS 20024 NAS 144 thru NAS 158 NAS 624 thru NAS 644 NAS 1202 thru NAS 1210 NAS 1303 thru NAS 1320 NAS 6603 thru NAS 6620 NAS 172 NAS 174 NAS 517	NAS 333 thru NAS 340 NAS 464 NAS 583 thru NAS 590 NAS 1103 thru NAS 1120 NAS 6203 thru NAS 6220	ANY					
NUTS		NUTS								
STEEL - TENSION	STEEL - SHEAR	STEEL - TENSION	STEEL - SHEAR							
AN 310 AN 315 AN 363 AN 365 MS 17829F MS 20365 MS 20500 MS 21042 MS 21044N MS 21045 NAS 1021	AN 320 AN 364 MS 17825 MS 20364 MS 21083N MS 21245 NAS 679 NAS 1022N or A NAS 1291	AN310 AN315 AN363 AN365 MS18729F MS20365 MS20500 MS21042 MS21044N MS21045 NAS 1021	AN320 AN364 MS 17825 MS 20364 MS 21083N MS 21245 NAS 679 NAS 1022N or A NAS 1291	MS17826						
Torque Limits, in#		Torque Limits, in#	Torque Limits, in#							
Min.	Max.	Min.	Max.	NUT/BOLT SIZE	Min.	Max.	Min.	Max.	+/- 5%	
12	15	7	9	8-36	--	--	--	--	--	
20	25	12	15	10-32	25	30	15	20	16	
50	70	30	40	1/4-28	80	100	50	60	35	
100	140	60	85	5/16-24	120	145	70	90	70	
160	190	95	110	3/8-24	200	250	120	150	100	
450	500	270	300	7/16-20	520	630	300	400	180	
480	690	290	410	1/2-20	770	950	450	550	240	
800	1,000	480	600	9/16-18	1,100	1,300	650	800	320	
1,100	1,300	660	780	5/8-18	1,250	1,550	750	950	480	
2,300	2,500	1,300	4,500	3/4-16	2,650	3,200	1,600	1,900	880	
2,500	3,000	1,500	4,800	7/8-14	3,550	4,350	2,100	2,600	1,500	
3,700	4,500	2,200	3,300	1-14	4,500	5,500	2,700	3,300	2,400	
5,000	7,000	3,000	4,200	1 1/8-12	6,000	7,300	3,600	4,400	4,000	
9,000	11,000	5,400	6,600	1 1/4-12	11,000	13,400	6,600	8,000	5,600	

CAUTION: Torques given are for dry threads. Clean bolts/nuts suspected of oil contamination with acetone.

NOTE: Tension nuts may be used on shear bolts, but shear nuts may not be used on tension bolts.