

Rockwell service bulletin

International

No. SB-AG-12

P.O. BOX 3090 ALBANY, GEORGIA 31706-3090 PHONE 229/883-1440 FAX 229/439-9790

Service Bulletin No. SB-AG-12
13 July 1977

RIGHT WING RIB RIVET INSPECTION AND/OR RIB REPLACEMENT

MODELS AFFECTED: MODEL S-2R, SERIAL NO'S 5000 THRU 5084

REASON FOR PUBLICATION: ON SOME AIRCRAFT, LOOSE RIVETS AND CRACKS HAVE BEEN FOUND ON TWO (2) RIBS OUTBOARD OF THE WING FUEL CELL ON THE RIGHT WING. THIS SERVICE BULLETIN IS BEING ISSUED TO ALLEVIATE THIS SITUATION.

COMPLIANCE: WITHIN NEXT TWENTY-FIVE (25) HOURS TIME IN SERVICE.

NOTE

IF ANY PROBLEMS ARE ENCOUNTERED WHILE COMPLYING WITH THIS SERVICE BULLETIN, CONTACT YOUR NEAREST THRUSH COMMANDER DEALER OF YOUR THRUSH COMMANDER REGIONAL SERVICE MANAGER.

BY WHOM WORK WILL BE ACCOMPLISHED: A & P MECHANIC OR EQUIVALENT.

APPROVAL: FAA DER Approved.

ESTIMATED MAN HOURS: PART I – INSPECT AND REPLACE LOOSE OR FAULTY RIVETS – TWELVE (12) HOURS.

PART II – REPLACE CRACKED RIBS – SEVENTY (70) HOURS.

PARTS DATA: Parts required to comply with Part II of this Service Bulletin may be purchased through your nearest Thrush Commander Dealer. Reference this Service Bulletin, aircraft model and factory serial number when ordering Service Bulletin No. SB-AG-12 kit consisting of the following.

QTY	PART NO.	DESCRIPTION
2 ea.	241-7R	Rib
20 ea.	CR2249-4-2	Blind Rivet
225 ea.	MS20470AD4-4	Rivet
50 ea.	MS20470AD4-6	Rivet
80 ea.	MS20470AD5-7	Rivet
45 ea.	MS20470AD5-8	Rivet
10 ea.	MS20470AD5-9	Rivet
30 ea.	MS20470AD6-6	Rivet
1 ea.	Service Bulletin No.SB-AG-12	Instructions

SPECIAL TOOL: NONE

ACCOMPLISHMENT INSTRUCTIONS:

PART I – INSPECT AND REPLACE LOOSE OR FAULTY RIVETS

1. Remove two (2) lower wing access covers from right wing just outboard of wing fuel tank.
2. Inspect wing ribs at WS 72.25 and WS 82.25 for loose rivets and possible cracks in ribs.
3. If any cracks are found in either rib at WS 72.25 or WS 82.25, proceed to Part II.

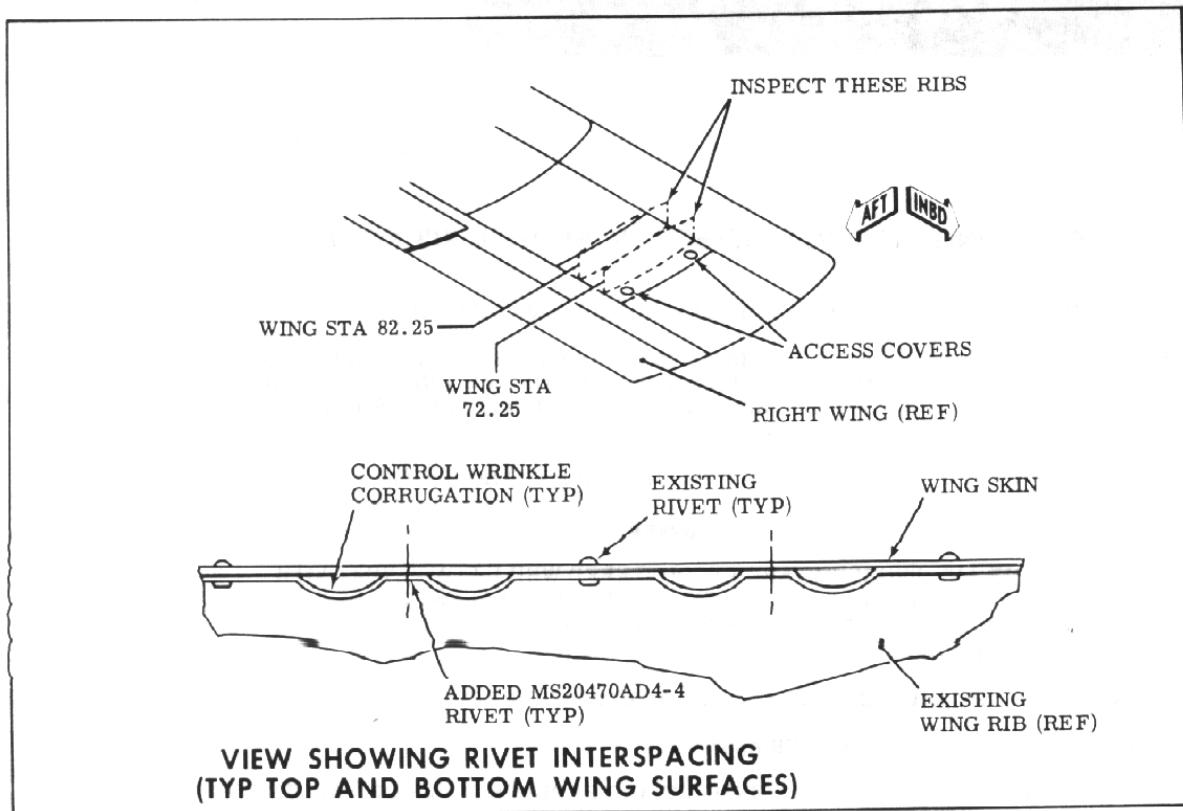


Figure 1.

4. If no cracks are found in ribs, proceed as follows:
 - a. Remove and loose rivets found during inspection and replace with MS20470AD4-4 rivet.

NOTE

If holes are oversize, it is permissible to use MS20470AD5-4 rivets.

- b. Add interspaced MS20470AD4-4 rivets between existing rivets on upper and lower flanges of wing ribs (See Figure 1).

Note

Added rivets to upper flange of wing ribs will have to be individually located to center on flat area between control wrinkle corrugations.

5. Reinstall wing access covers.
6. Process to RECORD COMPLIANCE.

PART II – REPLACEMENT OF RIBS

1. Defuel airplane as outlined in the Airplane Maintenance Manual, Section II.
2. Drill out rivets and remove upper center wing skin just outboard of right fuel tank (see Figure 2.).
3. Remove and discard existing wing ribs at WS 72.25 and WS 82.25 (see Figure 2.).

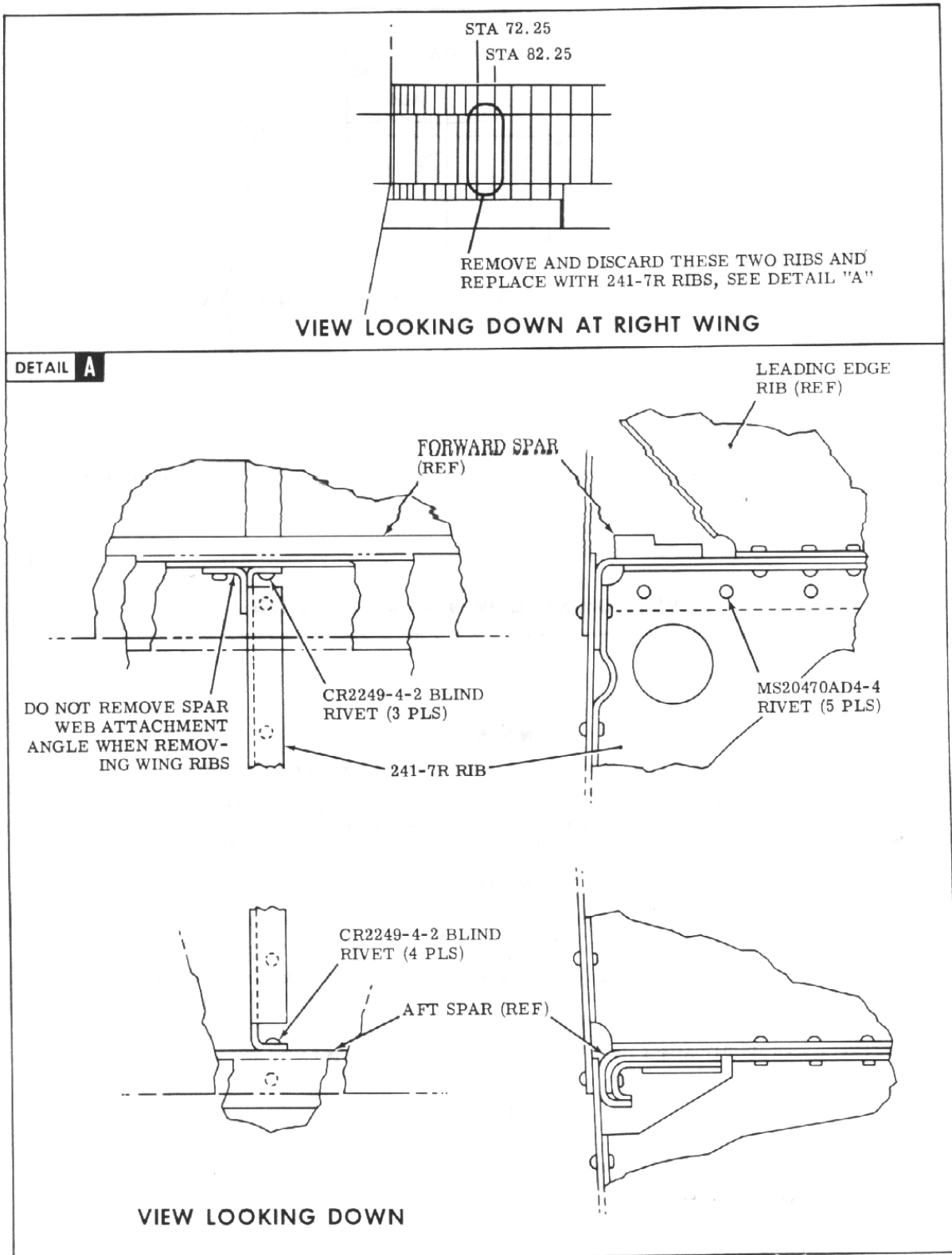


Figure 2.

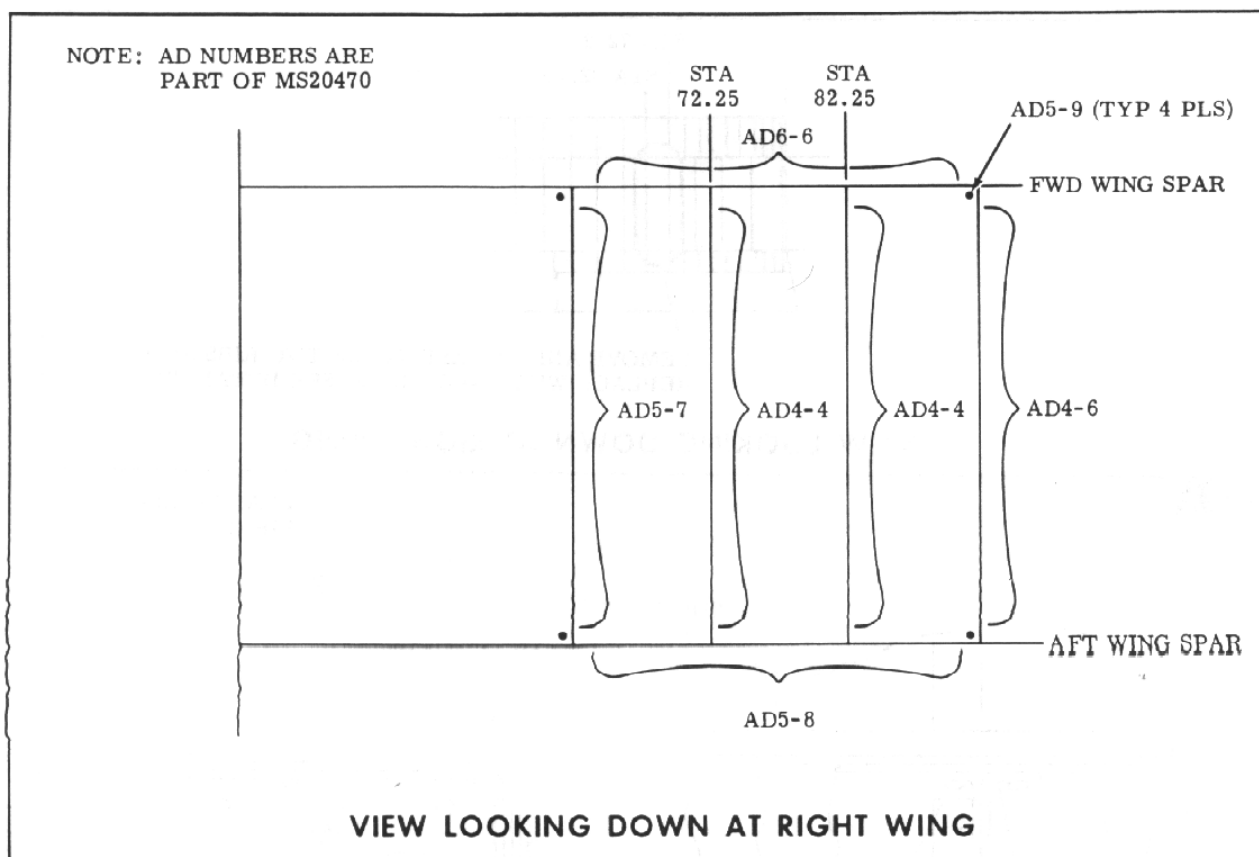


Figure 3.

NOTE

Do not remove forward spar web attachment angles when removing ribs.

4. Install 241-7R rib (2 places) with MS20470AD4-4 rivets (lower flange of ribs) and CR2249-4-2 blind rivet (in forward and aft flanges of ribs) picking up existing holes in lower wing skin and in spars. Add interspaced MS20470AD4-4 rivet between existing rivets in lower skin and ribs (see Figures 2 and 3).

NOTE

If any of the existing rivets holes are oversized, it is permissible to increase rivet diameter one size.

5. Install existing upper center wing skin and pickup existing holes in wing skin and seal wing skin in area of fuel tank as outlined in the Airplane Maintenance Manual, Section V under Resealing After Complete Skin Removal.
6. Add interspaced MS20470AD4-4 rivets between existing rivets in upper wing skin and new ribs (see Figures 2 and 3.).

NOTE

If any of the existing rivet holes are oversized, it is permissible to use MS20470AD5-4 rivets.

7. Reinstall lower wing access covers.
8. Refuel airplane as outlined in the Airplane Maintenance Manual, Section II.

ELECTRICAL LOAD: NO CHANGE

WEIGHT AND BALANCE: NO CHANGE

PUBLICATIONS
AFFECTED:

The Illustrated Parts Catalog Change required by this document will be incorporated at the next scheduled change/revision.

RECORD COMPLIANCE:

Make appropriate entry in airplane maintenance records as follows: Service Bulletin No. SB-AG-12, dated 18 April 1977, entitled "Right Wing Rib Rivet Inspection and/or Rib Replacement", accomplished _____ (date)_____.

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Service Bulletin No. SB-AG-12
Revision No. 1
13 July 1977

RIGHT WING RIB RIVET INSPECTION AND/OR RIB REPLACEMENT

APPROVAL: FAA-DER Approved.

Page 1 of 5 – ACCOMPLISHMENT INSTRUCTIONS:

Add: To Step 4.

NOTE

In areas not accessible for bucking rivets, it is acceptable to substitute CR2249 blind rivets of same size for MS20470AD rivets.

Page 4 of 5

CHANGE: Note under Step 4. To read:

NOTE

If any of the existing rivet holes are oversize, it is permissible to increase rivet diameter one size. In areas not accessible for bucking rivets, it is acceptable to substitute CR2249 blind rivets of same size for MS20470AD rivets.

CHANGE: Note under Step 6. To read:

NOTE

If any of the existing rivet holes are oversize, it is permissible to use MS20470AD5-4 rivets. In areas not accessible for bucking rivets, it is acceptable to substitute CR2249 blind rivets of same size for MS20470AD rivets.