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CUSTOM KIT

CK-AG-49

Initial Release: 02/18/2020

Step Upgrade

AIRPLANES AFFECTED:

MODEL

S2R-T34

SERIAL NUMBERS

ALL

A handwritten signature in blue ink, appearing to read "Levan Tabidze", is written over a horizontal line.

Levan Tabidze

Vice President of Engineering

LOG OF REVISIONS

NOTE: Reformatting and correction of typographical errors is not considered revision. True revisions are indicated by a dark vertical line at the right margin of the lines revised.

Rev.	Page	Description of Revision	By:
IR	All	New Document Initial Release.	K. Pierce 02/18/2020

CONTENTS

1. PURPOSE/REASON FOR PUBLICATION:	3
2. SCOPE/COMPLIANCE:	3
3. BY WHOM WORK WILL BE ACCOMPLISHED:	3
4. APPROVAL:	3
5. MAN HOURS:	3
6. SPECIAL TOOLS:	3
7. PARTS LIST	3
8. ACCOMPLISHMENT INSTRUCTIONS:	3
9. RECORD OF COMPLIANCE:	7
10. RESPONSE CARD	7

1. PURPOSE/REASON FOR PUBLICATION:

This Custom Kit provides instructions and parts for the installation of the Thrush Aircraft stainless steel step (PN Insert Here) to be installed on all S2R-T34 aircraft.

2. SCOPE/COMPLIANCE:

This Custom Kit is recommended for Thrush models S2R-T34.

3. BY WHOM WORK WILL BE ACCOMPLISHED:

The work is to be accomplished by a FAA Certified A&P mechanic or foreign equivalent.

4. APPROVAL:

This Custom Kit is approved by the Vice President of Engineering at Thrush Aircraft LLC.

5. MAN HOURS:

2 hours will be required.

6. SPECIAL TOOLS:

No special tools required.

7. PARTS LIST

QUANTITY	PART NUMBER	DESCRIPTION
2	11003T001	Lower Side Skin
1	10700T024	Step Assy R/H
1	10700T023	Step Assy L/H

8. ACCOMPLISHMENT INSTRUCTIONS:

NOTE: Installations are the same for Single and Dual Control.

1. Make sure Aircraft is in a Secure and Stable position with wheels chocked.
2. Remove Lower Side Skin (R/H Shown in Figure 1) 11003T001.



Figure 1: Lower Side Skin Removal (R/H Shown)

3. Using 7/16" wrenches, remove the steel step bolts from 3 places (Figures 2 and 3). Access to the head of the upper bolt is inside the cockpit.

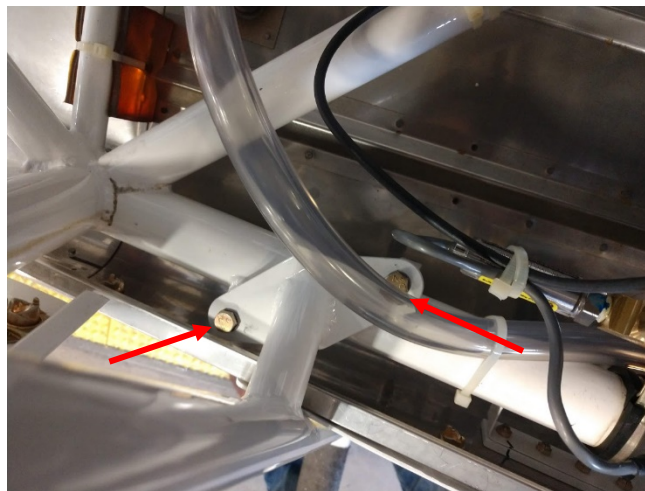


Figure 2: Step Bolt Removal



Figure 3: Step Bolt Removal

4. Align new steps in the lower two holes using bolts or pins. Refer to Figure 4



Figure 4: Step Bolt Removal (LH)

5. Mark the missing top hole through the bushing in the floorboard using either a drill at low speed or a center punch. Refer to Figure 5

6. Remove the step from the fuselage lower attach and inspect for Edge Distance. Hole Diameter will be .25" (1/4).

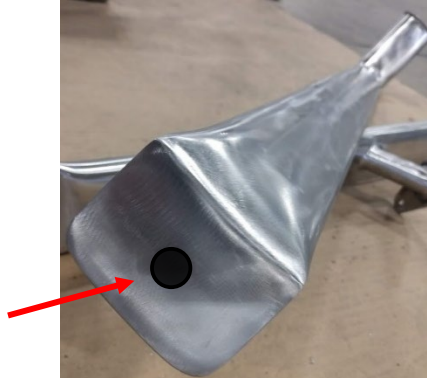


Figure 5: Top Hole of Step

7. IF CONFIDENT in hole location, drill the upper flange to .25" and deburr.
8. Install new step to fuselage (3 places). Torque bolts to 50-70 In/Lbs.
9. Install skin and mark area around step to be trimmed. If you find the gap to be excessive, scrap and replace the skin.
10. Trim the area around the step to prevent chaffing and corrosion. Leave approximately 1/8" – 1/4" of space. Refer to Figure 6. If needed, deburr, prime and paint trimmed edges with Polyurethane.



Figure 6: Step Assembly installed on Aircraft

9. RECORD OF COMPLIANCE:

Make appropriate entry in airplane maintenance records as follows:

“Thrush Custom Kit CK-AG-49 Rev. IR complied with at _____ total hours on aircraft.”

Modification accomplished by:

Name & Certificate #	Date
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10. RESPONSE CARD

The final step in compliance with this Custom Kit is to complete and return the compliance card on the next page. It may be mailed, Faxed, or scanned and e-mailed.

Fax to:	Ed Rusk	229-317-8225
Email to:	Ed Rusk	Ed.Rusk@thrushaircraft.com

Custom Kit CK-AG-49 Rev. IR Compliance Report

Aircraft S/N:	Aircraft Owner:
Aircraft Registration #:	Address of Owner:
Airframe total time:	City & State:
Engine total time:	Physical location:
Complied with by:	Date of Compliance:
Signature:	Certificate #:

PLEASE RETURN THIS REPORT ONLY AFTER MODIFICATION IS MADE

This response card may be mailed, faxed to (229) 439-9760, or emailed to ed.rusk@thrushaircraft.com.

Fold, Tape & Mail (Do Not Staple)

Return Address

Thrush Aircraft LLC.
Attn: Ed Rusk
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