



CUSTOM KIT

CK-AG-73

Rev IR: 07/01/2026

DORSAL FIN REINFORCEMENT

Affected Aircraft Models	Serial Number Range
S2R-T660	-193 & Sub.

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LOG OF REVISIONS

NOTE: Reformatting and correction of typographical errors is not considered revision.

REV	PAGE	DESCRIPTION OF REVISION	BY:
IR	All	New Document Initial Release.	T. Surratt 07/01/2026

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1. PURPOSE/REASON FOR PUBLICATION

This Custom Kit is issued in response to one or more customer(s) reports of visible cracks in the dorsal fin.

2. SCOPE/COMPLIANCE

This Custom Kit outlines the procedure for installing dorsal fin ribs to reinforce the structure and prevent cracks from forming.

3. BY WHOM WORK WILL BE ACCOMPLISHED

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

4. APPROVAL

This Custom Kit is approved by the FAA and the Director of Engineering at Thrush Aircraft, LLC.

5. MAN HOURS

Approximately 12 hours

6. SPECIAL TOOLS

N/A

7. PARTS LIST

7.1 INCLUDED IN KIT

PART NUMBER	NOMENCLATURE	KITS & QUANTITIES	
		(A)	(B)
553400012-001	DORSAL RIB	1	/
553400012-003	DORSAL RIB	1	/
553400012-005	DORSAL RIB	1	/
553400012-007	DORSAL RIB	1	/
553400012-009	DORSAL RIB	1	/
553400012-011	DORSAL RIB	/	1
553400012-013	DORSAL RIB	/	1
553400012-015	DORSAL RIB	/	1
553400012-017	DORSAL RIB	/	1
553400012-019	DORSAL RIB	/	1

7.2 NOT INCLUDED IN KIT

PART NUMBER	NOMENCLATURE	QTY
MS20470AD4	RIVET	A/R
CR3243-4	BLIND RIVET (SC)	A/R
B2 SEALANT	SEALANT	A/R

7.3 KIT ORDERING KEY

Use the list below to determine the appropriate kit needed for order placement.

- CK-AG-92 (A) – Single Cockpit
- CK-AG-92 (B) – Dual Cockpit

8. INSTRUCTIONS

1. Remove existing dorsal fin and place on appropriate work surface.
2. Locate each rib accordingly (90° or perpendicular to dorsal fin edge) as shown in Figures 1-3 then match drill and Cleco in place.

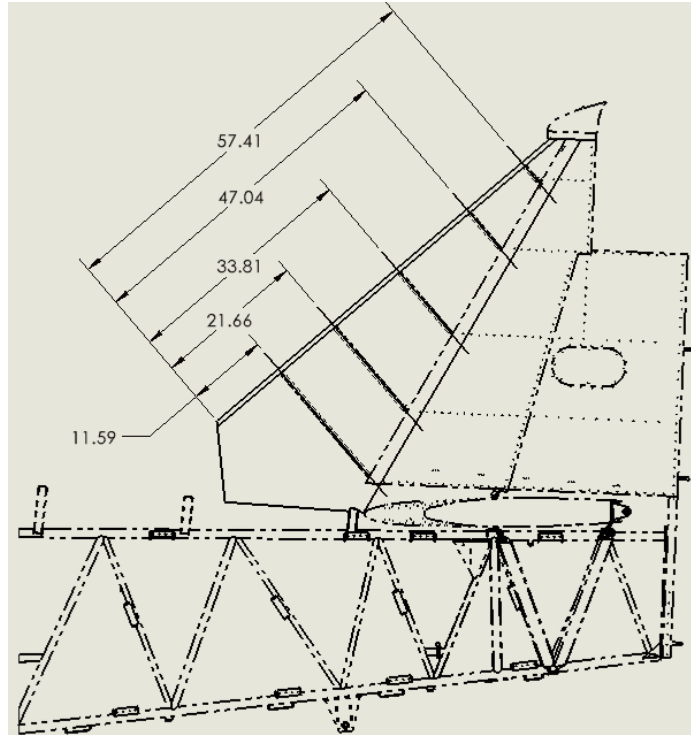


Figure 1 – Single Cockpit

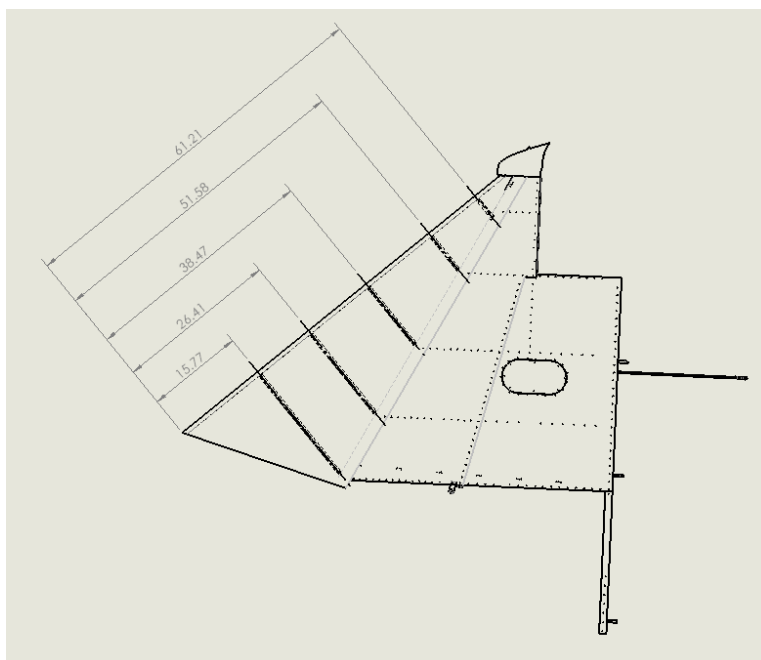


Figure 2 – Dual Cockpit

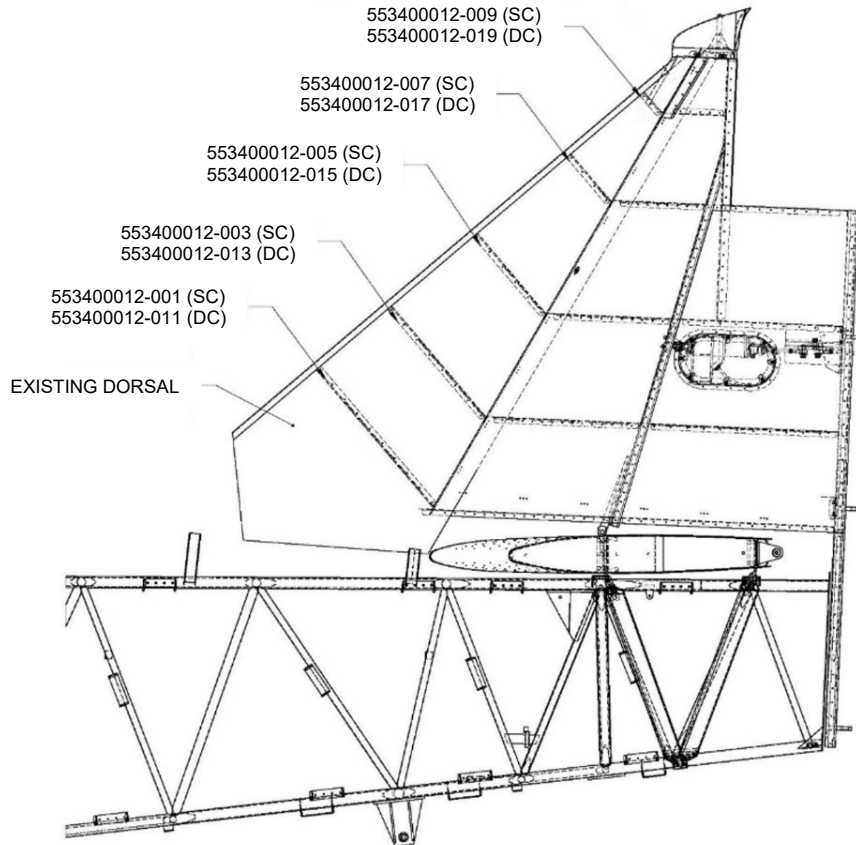


Figure 3

3. Remove ribs then deburr holes in dorsal fin.
4. Install ribs using MS20470AD4 rivets.

5. Reinstall dorsal fin to vertical, turtleback, and forward dorsal fin (SC only) in opposite order of removal (reference Figure 4).

NOTE: Trim closeout skin as required to allow clearance of top rib (reference Figure 5).



Figure 4



Figure 5

6. Apply sealant around perimeter of dorsal fin (reference Figure 6).



Figure 6

7. Apply primer to non-painted surfaces and allow to completely dry.
8. After primer is dry sand by hand using 180-200 grit abrasive to blend into and roughen surrounding surface.
9. Prepared areas will be spray or brush coated with silicone alkyd copolymer enamel conforming to MIL-E-24635, Type II, Class 1.

NOTE: Allow paint to completely dry between each coat (at least two), ensuring to lightly sand between coats.

9. COMPLIANCE

Custom Kit CK-AG-73 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 INSPECTION AND MODIFICATION IS MADE

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