



# SERVICE BULLETIN

SB-AG-86

Initial Release: 09/09/2024

## 510 Wing Rivets Inspection & Installation

Affected Aircraft Models	Serial Number Range
S2R-T34, S2R-H80, S2R-G10, R1340, & S2R-510	ALL

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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 09/09/2024

## 1. PURPOSE/REASON FOR PUBLICATION

Thrush Aircraft's Quality Control team discovered specific rivets were omitted in the outboard section of the 510 gallon series aircraft's wings during assembly after a drawing change. **This is not considered a safety of flight issue.**

## 2. SCOPE/COMPLIANCE

This Service Bulletin is released to all S2R aircraft with the 510 gallon series owners/operators as instructions for inspection and installation of the omitted rivets, as required.

## 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 Service Bulletin is approved by the FAA and the Director of Engineering at Thrush Aircraft, LLC.

## 5. MAN HOURS

2 hours may be required.

## 6. SPECIAL TOOLS

N/A

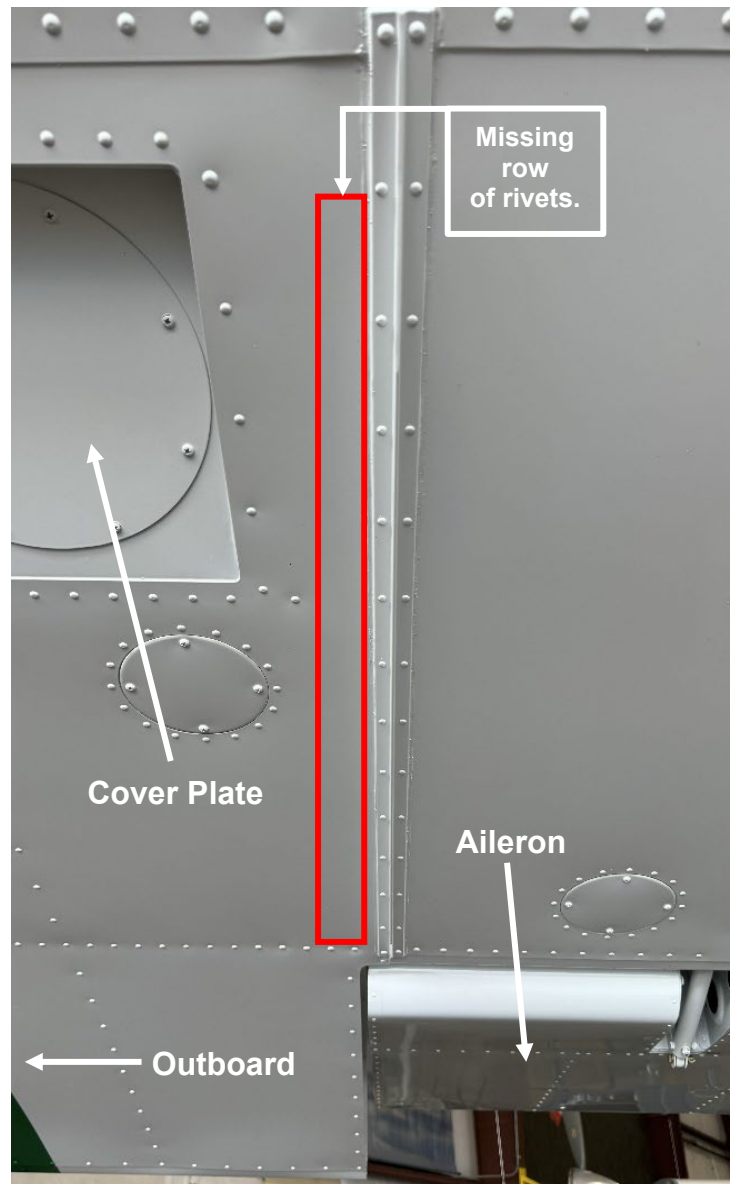
## 7. PARTS LIST

QTY	PART NUMBER	NOMENCLATURE	NOTE
23	MS20470AD4	RIVET	

**\*\*\* Parts listed above are included in the SB-AG-86 kit. \*\*\***

## 8. INSPECT

1. Inspect underneath the wing and locate the outboard boom hanger.
2. Look for three rows of rivets, one on each foot of the boom hanger and one outboard on the wing skin. (Reference Figure 8-1)
3. If the row of rivets on the outboard side of the boom hanger on the wing skin are not present, as shown in Figure 8-1, proceed to follow the rivet installation instructions.

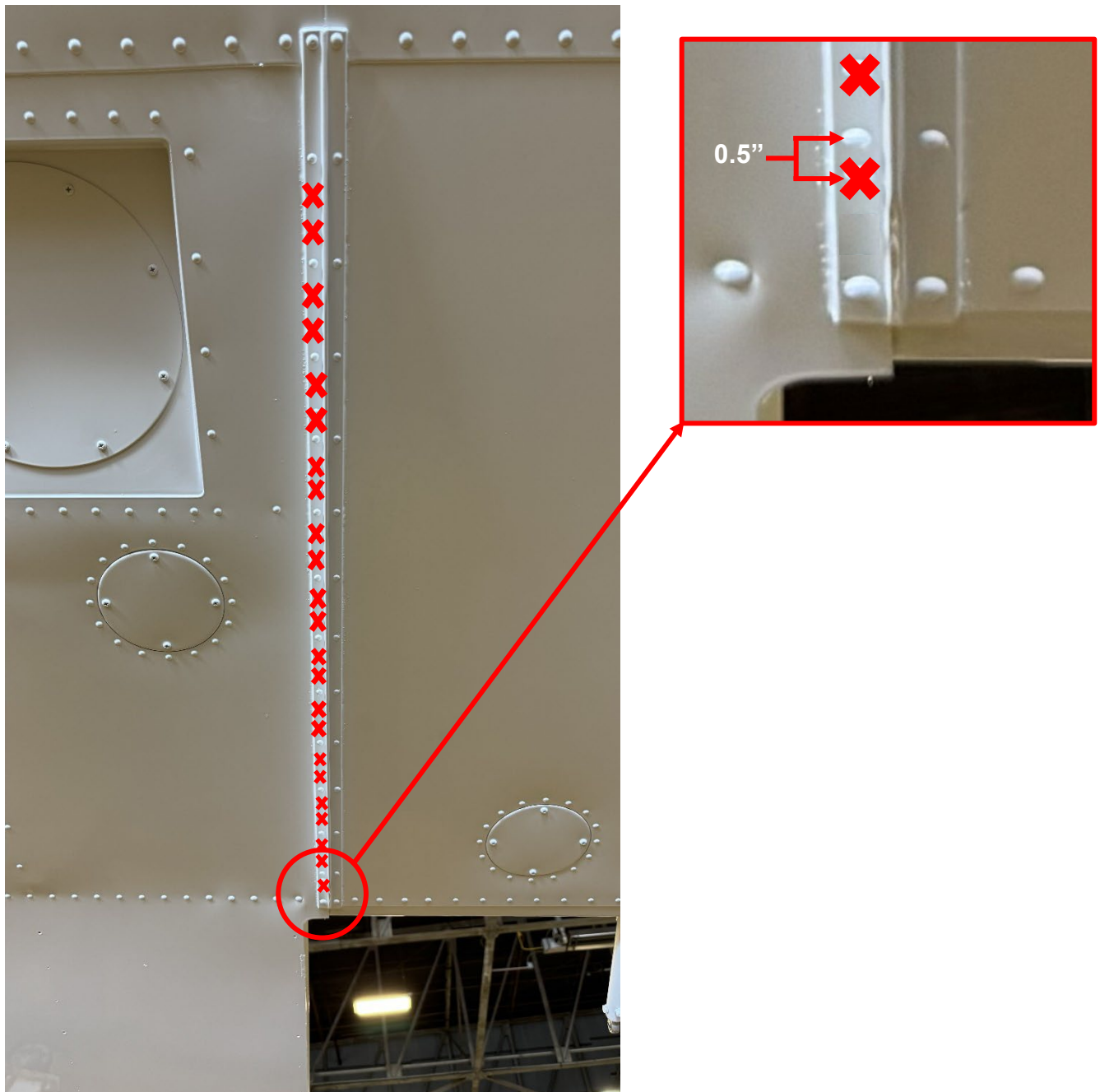


**Figure 8-1 Right Wing (Left Opposite)**

## 9. RIVET INSTALLATION

1. Measure and mark the locations for the rivets to ensure that they are interspersed and evenly spaced (2 between each and only 1 between aft rivets, 23 total) between the existing rivets on the outboard leg of the boom hanger as shown in Figure 9-1.

**NOTE:** Between the two outboard, aft existing rivets, measure 0.5 inch down from the forward existing rivet as shown in Figure 9-1.



**Figure 9-1 Right Wing (Left Opposite)**

2. Drill each marked location with a #30 drill bit then deburr.
3. Remove the light or the cover plate (where the light would be as shown in Figure 8-1) on the outboard side of the boom hanger. (Also reference Figure 9-2)



**Figure 9-2 Left Wing (Right Opposite)**

4. Remove all FOD and debris made from drilling and deburring the 23 holes.
5. Install rivets (P/N: MS20470AD4) in each hole.  
**NOTE:** Assistance with this step is suggested when installing solid rivets.  
**NOTE:** Cherrymax rivets may be used in place of solid rivets in limited access locations.
6. Inspect rivets to ensure proper installation.



## 10. PRIME & PAINT

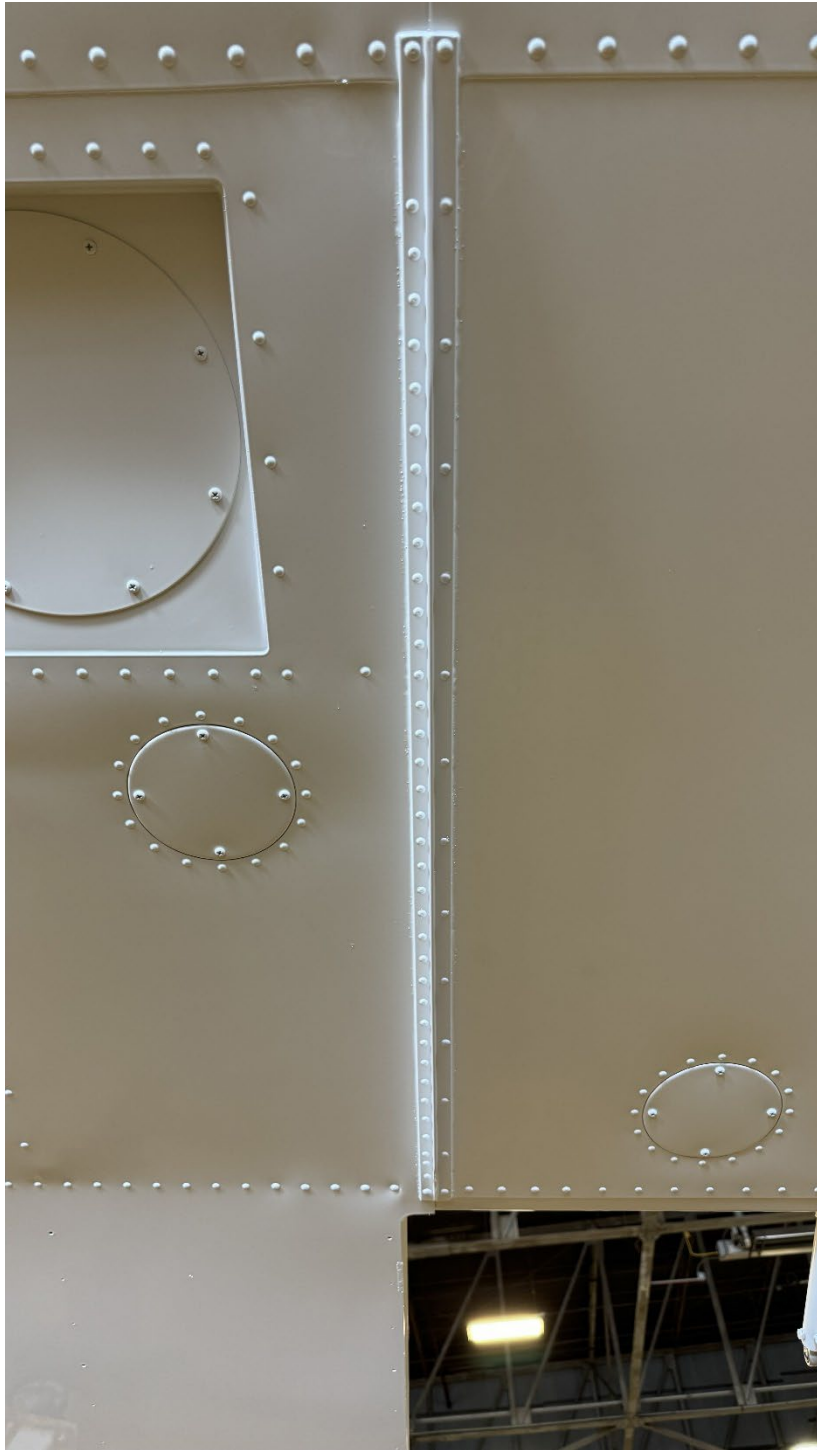
1. Scuff the rivet heads and a small area around them to ensure better adhesion of primer and paint.
2. Wipe down the non-painted surface to remove dust using acetone or equivalent cleaning solution.
3. Apply epoxy primer to non-painted surface and allow it to completely dry.
4. After the primer is dry, hand sand the surface with 180 to 200 grit abrasive to blend it into and roughen the surrounding painted area.
5. Spray or brush coat the prepared areas with silicone alkyd copolymer enamel conforming to MIL-E-24635, Type II, Class 1.

**NOTE:** The enamel paint will be the same color as the existing paint.

**NOTE:** Allow paint to completely dry between each coat as required.

## 11. REINSTALL LIGHT

1. After the enamel paint has completely dried, reinstall the light or cover plate.
2. Finished product should look similar to Figure 11-1.



*Figure 11-1 Right Wing (Left Opposite)*

## 12. COMPLIANCE

### Service Bulletin SB-AG-86 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**

This response card may be mailed, faxed to (229) 317-8225, or emailed to:  
[support@thrushaircraft.com](mailto:support@thrushaircraft.com)

Fold, Tape & Mail (Do Not Staple)

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