



# SERVICE BULLETIN

## SB-AG-93

Rev IR: 06/03/2026

### VERTICAL STABILIZER FWD ATTACH FITTING INSPECTION & FASTENER REPLACEMENT

| Affected Aircraft Models | Serial Number Range |
|--------------------------|---------------------|
| S2R-T660                 | -197 & PRIOR        |

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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  | Initial Release         | T. Surratt<br>06/03/2026 |

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## **1. PURPOSE/REASON FOR PUBLICATION**

This Service Bulletin is issued in response to one or more operator(s) reporting rivets shearing at the horizontal stabilizer attach fitting inside the vertical stabilizer.

## **2. SCOPE/COMPLIANCE**

This Service Bulletin outlines the procedures for inspection of structural security of the vertical stabilizer and replacing the existing rivets with improved fasteners in the forward attach fitting. The vertical stabilizer should be inspected prior to the next flight, and before each subsequent flight and this service bulletin should be complied with whenever any discrepancy is found or at the next 100-hour inspection, whichever occurs first.

## **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 Director of Engineering at Thrush Aircraft, LLC.

## **5. MAN HOURS**

Approximately 8 hours

## **6. SPECIAL TOOLS**

N/A

## 7. PARTS LIST

| QTY | PART NUMBER   | NOMENCLATURE                             |
|-----|---------------|--|
| 1   | 95267-3       | VERT. STAB. FWD ATTACH FTG (AS REQUIRED) |
| 1   | AMS-S-8802-B2 | SEALANT                                  |
| 15  | AN3-4A        | BOLT                                     |
| 30  | NAS1149F0363P | WASHER                                   |
| 30  | NAS1149F0332P | WASHER                                   |
| 15  | MS21042L3     | NUT                                      |

## 8. INSPECTION CRITERIA

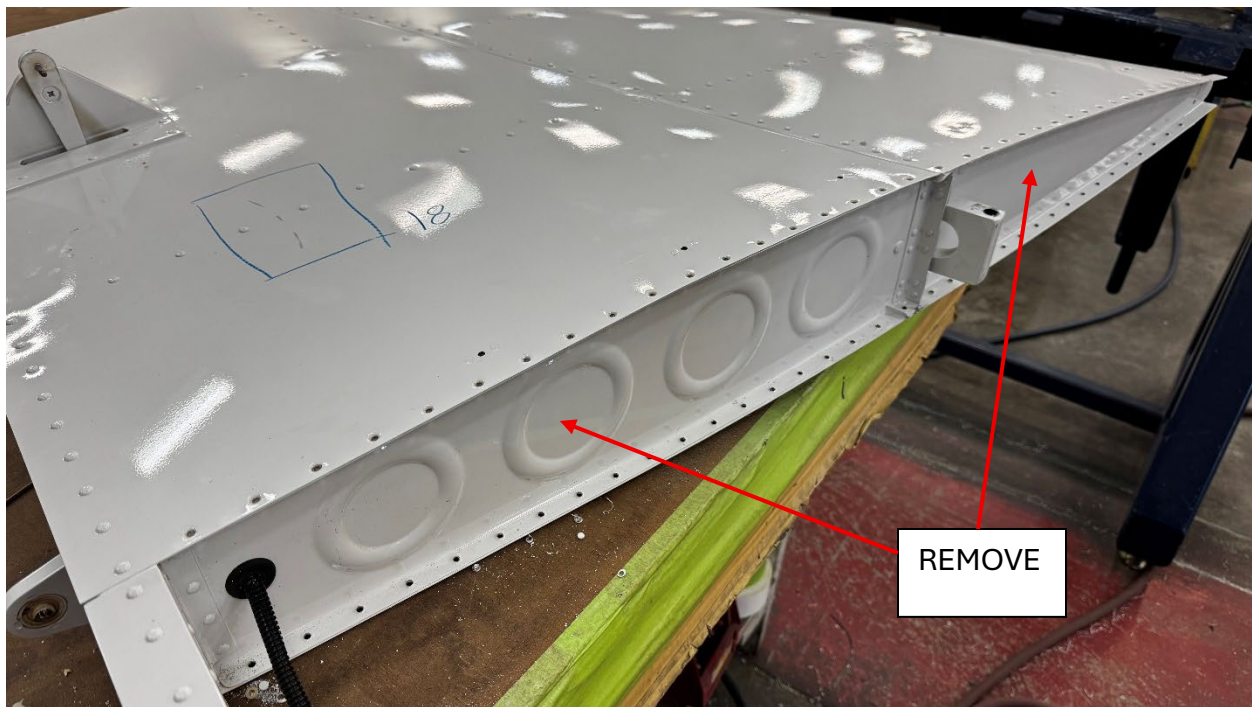
Prior to next flight, remove the lower vertical stabilizer closeout skins and inspect the vertical stabilizer for structural security by applying a force by hand to the vertical stabilizer forward and aft spar attachment locations. **\*\*\*If any discernable movement or unusual sounds such as clicking or popping are detected, do not fly the aircraft until this service bulletin is accomplished.\*\*\***

Prior to each subsequent flight inspect the vertical stabilizer for structural security by applying a force by hand to the vertical stabilizer forward and aft spar attachment locations. **\*\*\*If any discernable movement or unusual sounds such as clicking or popping are detected, do not fly the aircraft until this service bulletin is accomplished.\*\*\***

## 9. INSTRUCTIONS

1. Remove lower vertical stabilizer closeout skins.
2. Remove rudder.
3. Disconnect wire deflector cable.
4. Remove vertical stabilizer.
5. Visually inspect aft fuselage bulkhead to vertical stabilizer aft spar attachment bolts, replace any bolts with significant or unusual wear indications.

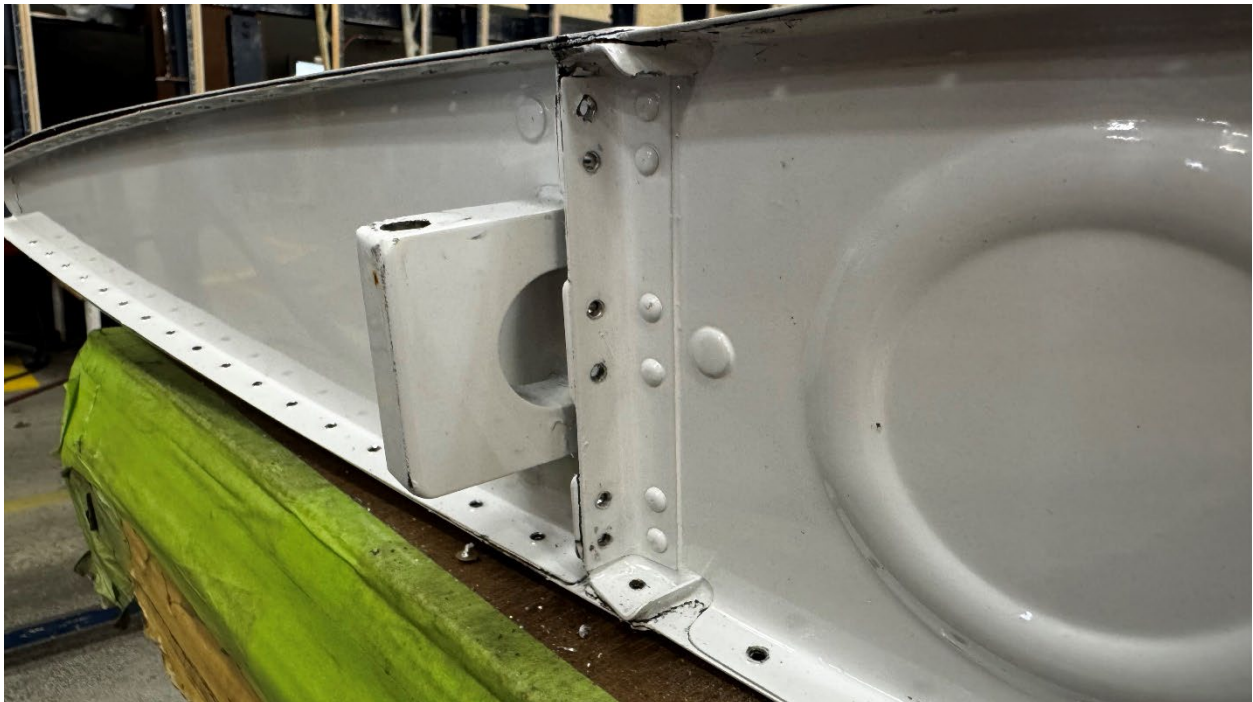
6. Visually inspect aft fuselage bulkhead bolt holes with 10X magnification for significant or unusual wear, cracks, or elongation. If damage is found, perform a dye penetrant inspection for cracks.
7. Visually inspect vertical stabilizer aft spar attachment bolt holes with 10X magnification for significant or unusual wear, cracks, or elongation. If damage is found perform a dye penetrant inspection for cracks.
8. Visually inspect vertical stabilizer aft spar assembly including J-channel doublers with 10X magnification for deformation, cracks, or other abnormal conditions. If damage is found, perform a dye penetrant inspection for cracks.
9. Visually inspect horizontal stabilizer attach fitting (95266-9) at L/H and R/H attach lug bolt holes with 10X magnification for deformation, cracks, unusual wear, or other abnormal conditions. If damage is found, perform a dye penetrant inspection for cracks.
10. Remove lower forward and aft vertical stabilizer ribs (P/Ns 95254-1, 40281-1) by removing rivets (MS20426AD4 & MS20470AD4) to gain access to lower vertical stabilizer attach fitting. (Reference Figures 1 thru 5)



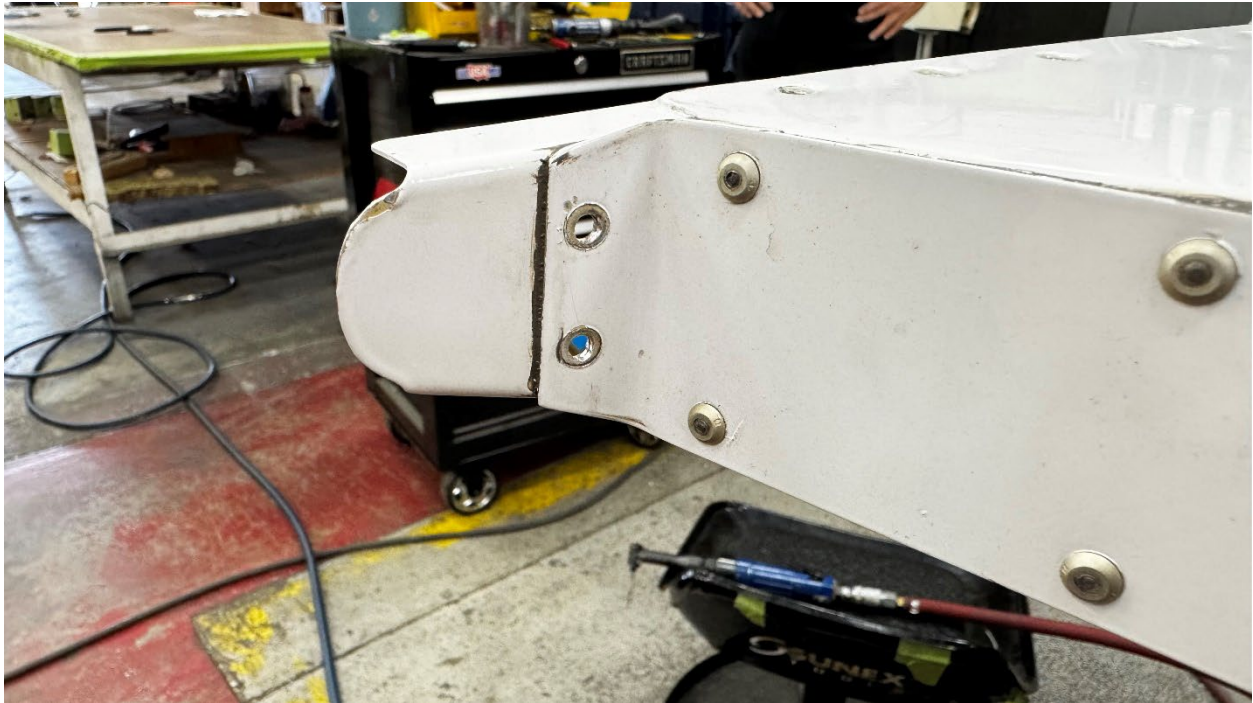
**Figure 1**



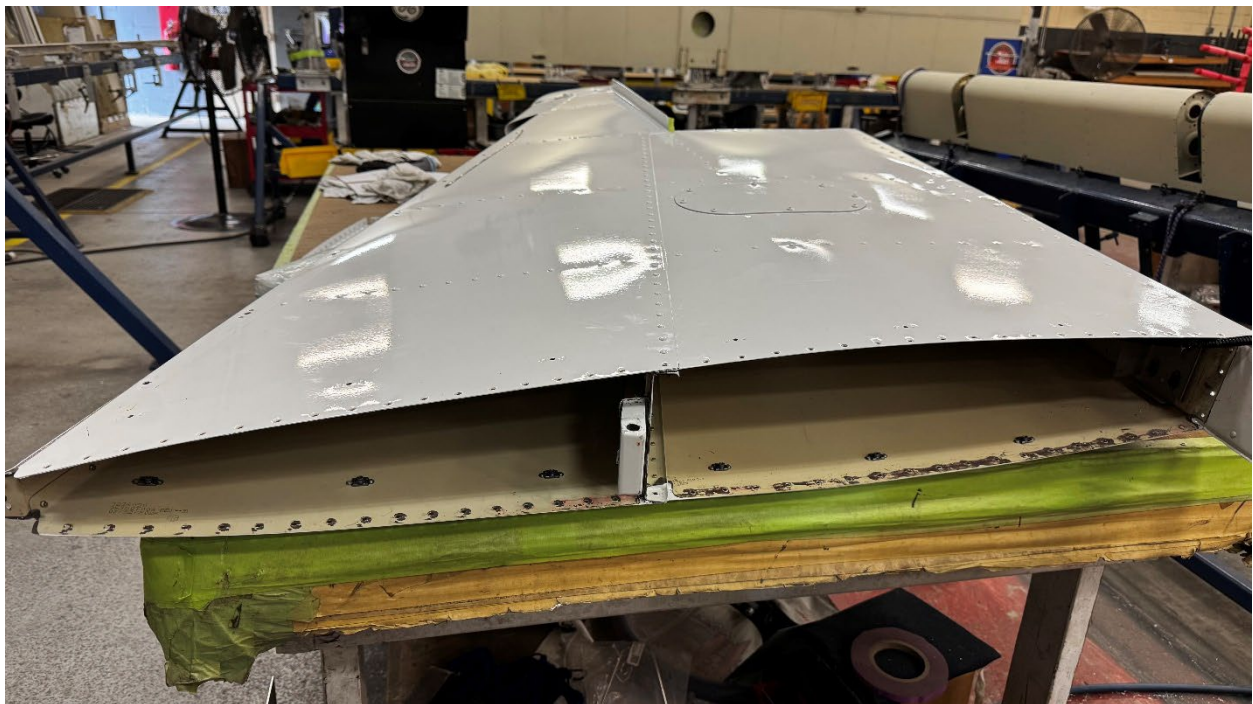
**Figure 2**



**Figure 3**



**Figure 4**



**Figure 5**

11. Carefully drill out 15ea MS20470AD4 rivets connecting lower vertical stabilizer attach fitting to vertical stabilizer forward spar. (Reference Figure 6)

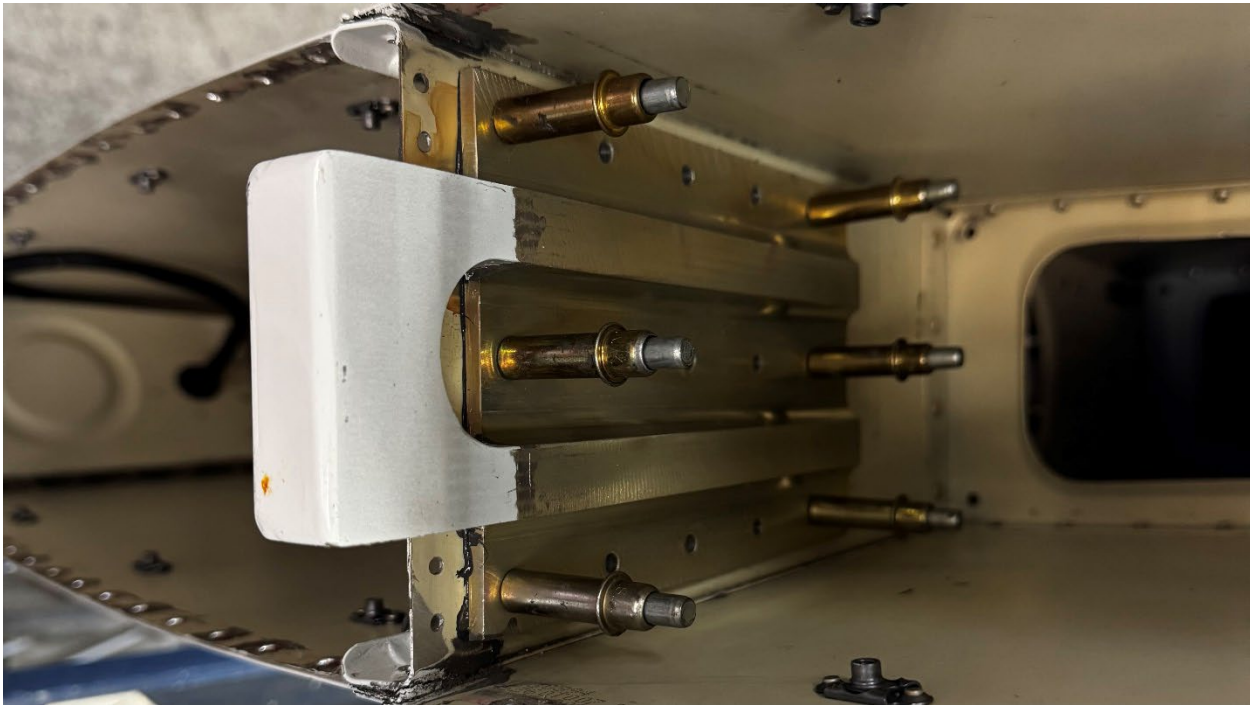


**Figure 6**

12. Remove attach fitting from vertical stabilizer aft spar, clean sealant from fitting and spar surfaces.
13. Inspect vertical stabilizer forward attach fitting (95267-3) bolt hole and rivet holes with 10X magnification and dye penetrant inspection methods for abnormal wear or cracks, replace fitting on condition.
14. Visually inspect rivet holes in vertical stabilizer forward spar web with 10X magnification and dye penetrant inspection methods.

**Contact Thrush Support at [support@thrushaircraft.com](mailto:support@thrushaircraft.com) if abnormal wear, cracks or other conditions are detected during any point in the above inspections.**

15. Match drill/ream 15ea rivet holes to  $\Phi.1850 \pm .001$  thru attach fitting and vertical stabilizer forward spar web. Maintain alignment of all holes during drill/ream operation. Deburr holes after reaming. (Reference Figure 7)



*Figure 7*

16. Install forward attach fitting wet with AMS-S-8802-B2 sealant and 15ea AN3-4A bolts, 30ea NAS1149F0363P washer or NAS1149F0332P washer (one under bolt head, one under nut, max 2 washers any combination under bolt head or nut, adjust quantity and thickness as required for 1-3 thread penetration in nut, adjust bolt length  $\pm 1$  length as required for 1-3 thread penetration in nut), 15ea MS21042L3 nuts. Install bolt head against aft spar face, nut against fitting face. Torque nuts to 20-25 in-lbs. plus running torque. (Reference Figures 8 & 9)



*Figure 8*



*Figure 9*

17. Install lower forward and aft ribs.
18. Install vertical stabilizer, rudder, and lower closeout skins in reverse order from removal.
19. Connect the wire deflector and set the correct tension per the AMM (SECTION 7-14).
20. Inspect installed condition of vertical stabilizer, verify vertical stabilizer security, perpendicularly to horizontal stabilizer and alignment with aircraft center line.
21. Rig rudder and trim tab per AMM (Section 7-8 & 7-9).
22. Note compliance with this service bulletin in aircraft logbook.



## 10. COMPLIANCE

### Service Bulletin SB-AG-93 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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Return Address:

**Thrush Aircraft, LLC  
Attn: Customer Support Team  
300 Old Pretoria Road  
Albany, GA 31721**