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CUSTOM KIT

CK-AG-56

Initial Release: 02/15/2022

Wing Upgrade

AIRPLANES AFFECTED:

MODEL

SERIAL NUMBERS

S2R-T34

001-272

S2R-T34HG

101-107

S2R-T65

001-018

S2R-T65HG

002-012

S2R-T45

001-015

S2R-G5

101-105

S2R-G6

101-155

S2R-G10

101-168

A blue ink signature of 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.	B. Tobin 02/15/2022

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1. PURPOSE/REASON FOR PUBLICATION:

This Custom Kit provides instructions and parts for the replacement or installation of 94401-3 and 94401-4 wings.

This Custom Kit is applicable to aircraft with the following wing assembly part numbers:

- 20209 (multiple dash numbers)
- 25501-1 & 25501-2
- 25501-3 & 25501-4
- 94401-1 & 94401-2
- 94401-3 & 94401-4

2. SCOPE/COMPLIANCE:

This Custom Kit is recommended for the following Thrush models:

- S2R-T34
- S2R-T34HG
- S2R-T45
- S2R-T65
- S2R-G5
- S2R-G6
- S2R-G10
- S2R-H80

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:

12 hours will be required.

6. SPECIAL TOOLS:

- 5740T0001 Upper Tube Nut Wrench
- 5740T0002 Lower Tube Nut Wrench
- 5740T0003 Outboard Wrench
- ESK-689-101L and ESK-690-101R Wing Stands
- 5740T0004 Slide Hammer
- ESK-681-1 Drill Jig

7. CUSTOM KIT OVERVIEW:

In order to conduct the changes outlined in this document, aircraft must first meet the following requirements:

1. Compliant with CK20209-96.
2. Compliant with SB-AG-34.
3. Equipped with 53, 69, 96 or 115 gallon wings and the 4-gallon header tank.

8. PARTS LIST:

QTY	PART NUMBER	DESCRIPTION
1	22500-0913	Wing Mating Kit
1	20243-5	Angle – Wing Attach
1	20243-7	Angle – Wing Attach

9. ACCOMPLISHMENT INSTRUCTIONS:**9.1. Aircraft with the following wing assembly numbers can do a direct wing replacement:**

- 94401-1 and 94401-2
- 22501-3 and 22501-4
- 22501-1 and 22501-2

9.2. Aircraft with 94401-1 & 94401-2 wing assemblies

Aircraft with 94401-1 and 94401-2 wing assemblies include the following models:

- T34HG 103-107
- T65HG 011-012

9.3. Aircraft with 22501-3 & 22501-4 wing assemblies

Aircraft with 22501-3 & 22501-4 wing assemblies include the following models:

- T34 271-272
- G10 166-168

9.4. Aircraft with 22501-1 & 22501-2 wing assemblies

Aircraft with 22501-1 & 22501-2 wing assemblies include the following models:

- T34 236-270
- T34HG 101-102
- T45 015
- G6 148-155
- G10 139, 142-165

NOTE: The new wings 94401-3 and 94401-4 are very similar to previous wings but have improved lower splice blocks and spar caps. Please note that the service life for different wing models is not equal. Wing Service Life is identified on the type certificate data sheets for that particular wing model.

10. WING REMOVAL:

Remove wings per wing removal procedure in the aircraft's maintenance manual.

11. WING INSTALLATION:

Install wings per wing installation procedure in the aircraft's maintenance manual. Use the Bolt Size/Nut Torque values in TABLE 1 (below) instead of those listed in the maintenance manual.

TABLE 1: Wing Splice Fittings Torque Chart

BOLT SIZE	NUT TORQUE
3/16 – 32	25 – 30 in. – lbs.
1/4 – 28	50 – 70 in. – lbs.
5/16 – 24	100 – 140 in. – lbs.
3/8 – 24	160 – 180 in. – lbs.
7/16 – 20	450 – 500 in. – lbs.
1/2 – 20	480 – 690 in. – lbs.
5/8 – 18	1,100 – 1,300 in. – lbs.
3/4 – 16	2,300 – 2,500 in. – lbs.
1 – 12	2,300 – 2,500 in. – lbs.

12. RECORD OF COMPLIANCE:

Make appropriate entry in airplane maintenance records as follows:

“Thrush Custom Kit CK-AG-56 Rev. IR complied with at _____ total hours on aircraft.”

Modification accomplished by:

Name & Certificate #	Date
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13. 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-56 Rev. IR Compliance Report

Aircraft S/N:	Aircraft Owner:
Aircraft Registration #:	Address of Owner:
CK-AG-56:	
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) 317-8225, or emailed to ed.rusk@thrushaircraft.com.

Fold, Tape & Mail (Do Not Staple)

Return Address

**Thrush Aircraft LLC.
Attn: Ed Rusk
300 Old Pretoria Road
Albany, GA 31721**