



# service bulletin

Service Bulletin Number : **SB-AG-34**

5 August 1993

REVISED 6 DECEMBER 93

## FUSELAGE-WING ATTACH TUBE BEEF-UP

<b>MODELS AFFECTED:</b>	All S2R series aircraft, piston and turbine ; All serial numbers with more than 1000 hours total airframe time.
<b>REASON FOR PUBLICATION:</b>	Field reports and Ayres Repair Station experience with cracks in the 10854-1 tube assembly, below the wing attach angles, near the weld cluster.
<b>COMPLIANCE:</b>	Immediate inspection upon receipt of this bulletin of any airplane with more than 1000 hours total airframe time. Immediate compliance is required before the next flight if any crack (s) exist. If no cracks exist, it is required that the area described be inspected every 100 hours months, whichever first occurs, until such time that the wings are removed. If the wings are removed for any reason, the rework described in this Service Bulletin shall be accomplished prior to the next flight.
<b>BY WHOM WORK WILL BE ACCOMPLISHED:</b>	A & P mechanic or equivalent FAA approved Welding equipment
<b>APPROVAL:</b>	FAA approved
<b>SPECIAL TOOLS:</b>	Welding equipment
<b>PARTS:</b>	Are available from your nearest Ayres Corporation dealer. See drawing SB-AG-34-1 included here.

### ACCOMPLISHMENT INSTRUCTIONS

1. Remove fuselage side skins to gain access to the wing main spar attach angles, remove landing gear area skins underneath the airplane.
2. With flashlight and mirror, inspect the areas shown in the drawing SB-AG-34-1 in this bulletin. The area is very-difficult to see, so great care must be taken to thoroughly inspect all around the weld cluster. If there is any doubt about the appearance, or suspicion of a crack partially hidden by the wing attach angles, remove them for better access, perform dye penetrant check.
3. If the inspection reveals a crack, compliance is required before the next flight, see drawing SB-AG-34-1.

4. If no crack is found, the aircraft may be returned to service for the next 100 hour period. This fly/inspect cycle shall be repeated until such time as a crack is found or the wings are removed.
5. Compliance with the repair specified in this bulletin eliminates the requirement for repeat inspections for this problem.

**RECORD  
COMPLIANCE:**

Ayres Service Bulletin SB-AG-34 complied with on \_\_\_\_\_ by inspection and no crack(s) found. Aircraft approved for return to service. Total airframe time at compliance \_\_\_\_ hours.

\_\_\_\_\_  
Signature      Title      Date

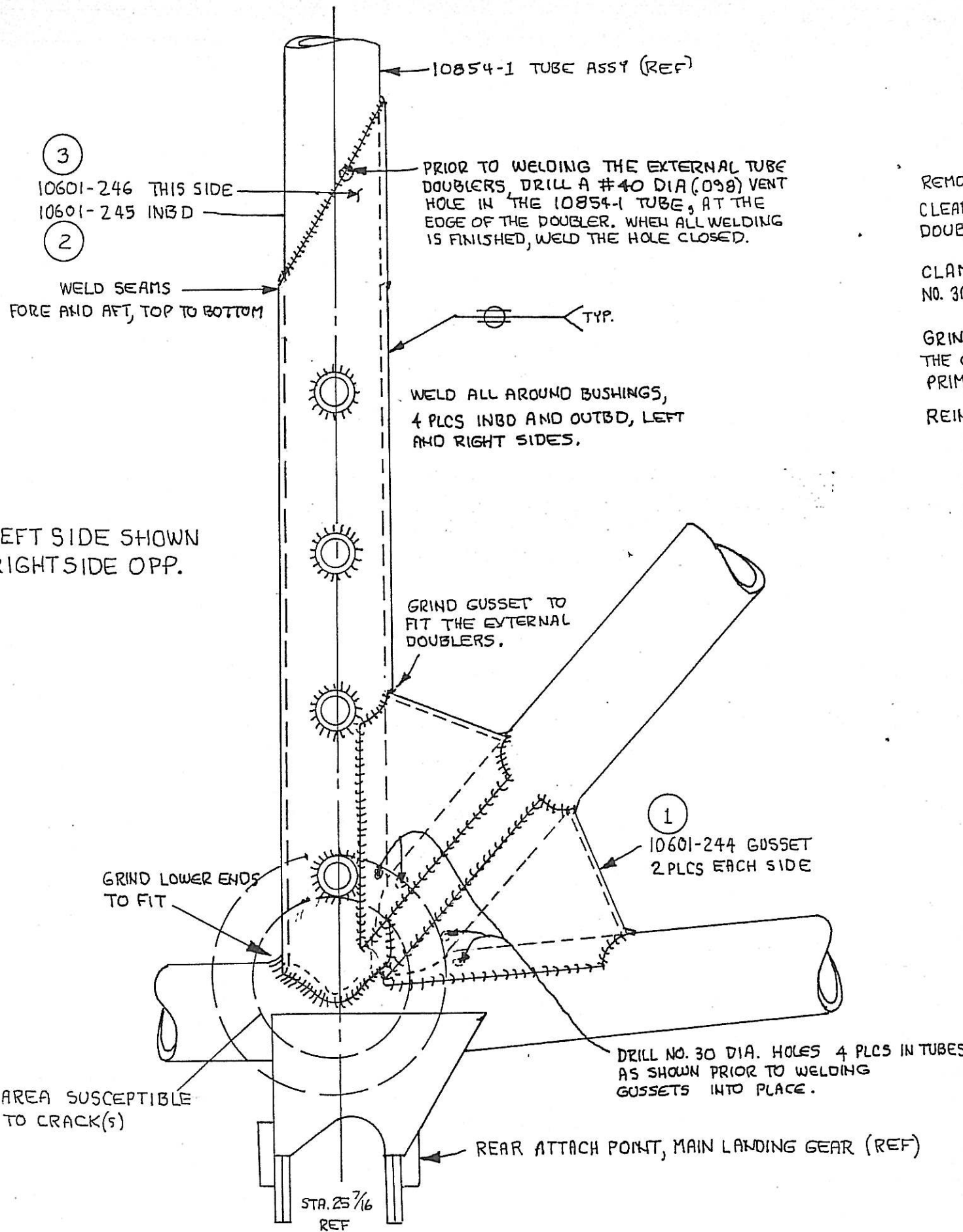
Ayres Service Bulletin SB-AG-34 complied with on \_\_\_\_\_ by structural modification per drawing SB-AG-34-1. Total airframe time at compliance \_\_\_\_ hours.

\_\_\_\_\_  
Signature      Title      Date

[Drawing of Wing Attach Fitting Beef-Up](#)

ing of Wing Attach Fitting Beef-Up

REVISION			
LTR	CHANGE	DATE	APP



REMOVE WINGS AND WING ATTACH ANGLES.  
 CLEAN AREA THOROUGHLY, AND REMOVE PAINT FROM AREAS TO BE WELDED. FIT THE EXTERNAL TUBE DOUBLERS AT THE BOTTOM BY GRINDING AS REQD TO MATCH THE CLUSTER TUBES.

CLAMP THE -245 AND -246 IN PLACE AND DRILL #40 DIA VENT HOLE AS SHOWN. DRILL THE 4 EACH NO. 30 DIA. VENT HOLES IN THE CLUSTER TUBES AS SHOWN. WELD THE DOUBLERS COMPLETELY, EXCEPT UPPER VENT.

GRIND AND FIT THE -244 GUSSET AT THE FRONT TO MATCH THE EXTERNAL DOUBLER RADIUS. WELD THE GUSSETS INTO PLACE. WELD THE VENT HOLE AT TOP CLOSED. WIREBRUSH, SAND AND CLEAN THE REPAIR. PRIME AND PAINT.

REINSTALL WINGS, RECORD COMPLIANCE IN AIRCRAFT LOG BOOKS.

3	2	TUBE DOUBLER	10601-246	
2	2	TUBE DOUBLER	10601-245	
1	4	GUSSET	10601-244	
	-	SERVICE BULLETIN - FUSELAGE-WING ATTACH TUBE BEEF UP	SB-AG-34	
NO.	QTY.	DESCRIPTION	PART NO.	R
LIST OF MATERIALS - ODD DASH NUMBERS SHOWN - EVEN DASH NUMBERS OPPOSITE				RELEASE
EXCEPT AS SPECIFIED LIMITS ARE: ANG. ± 2° 3 DEC. ± .010. 2 DEC. ± .03. BREAK ALL SHARP EDGES. MFG. PER SPEC. 525		DATE AUGUST 5, 1993 DFTM. <i>George F. Williams</i>	INFORMATION CONTAINED HEREIN IS PROPRIETARY AND MAY NOT BE REPRODUCED WITHOUT WRITTEN CONSENT OF:	
SCALE NOT TO SCALE		CHK.	AYRES CORPORATION ALBANY GEORGIA	
EFF. AC NOTED		PROJ.		
MODEL S2R		APPD.	NEXT ASSY.	
FUSELAGE-WING ATTACH TUBE BEEF UP			SB-AG-34-1	
			SHEET 1 OF 1	