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Service Letter No. SL-AG-100
15 April, 1987
Revised 17 July 1990

WING RIB REPAIR

MODELS AFFECTED: S2R-T11, S/N T11-001 thru T11-005*
S2R-T15, S/N T15-001 thru T15-019*
S2R-T34, S/N T34-001 thru T34-081*
S2R-R1820, S/N R1820-001DC thru R1820-032DC
S2R-T65, S2RHG-T65 S/N T65-001 and up
*with or without DC suffix

REASON FOR PUBLICATION: This Service Letter provides a factory fix for wing nose rib cracks.

COMPLIANCE: In case fatigue cracks are discovered in wing nose ribs. (Reference: SL-AG-99 "Wing Rib Inspection")

BY WHOM WORK WILL BE ACCOMPLISHED: A & P mechanic or equivalent.

APPROVAL: FAA approved

ESTIMATED MAN HOURS: Two man hours per damaged rib

ACCOMPLISHMENT INSTRUCTIONS: Repair nose ribs in accordance with Ayres Drawing ESK-400 which is a part of this repair kit.

The repair utilizes either left or right hand rib doublers designed to pass through a standard 3 1/2 inch inspection hole. The longer dash 2 doubler, as a back to back reinforcement for each damaged rib, provides the best strength. Your kit will also include dash 1 (inside nesting) doublers for use where accessibility absolutely prevents installing the dash 2. You may reinforce each rib with either a dash 2 or a dash 1 doubler, but the dash 2 is preferred since it is longer and supports the skin closer to the spar.

A new row of rivets is placed in the flange of either doubler as shown in View A-A of Drawing ESK-400. Together with the dash 3 fasteners through the rib web, this repair provides strength in excess of the original design without reliance on the original rib flange.

However, prior to installing the doublers, all cracked material should be stop drilled or ground out smooth.

PARTS LIST:

QTY	P/N	DESCRIPTION
A/R	ESK-400-1	Doubler – inside
A/R	ESK-400-2	Doubler – outside
A/R	ESK-400-5	Shim
1	ESK-400	Drawing – Leading Edge Rib Repair
1		Compliance Card

RECORD COMPLIANCE:

Make an entry in aircraft records as follows:

Service Letter No. SL-AG-100 dated 15 April 1987, entitled "Wing Rib Repair" accomplished (date) .

Fill out the compliance card and return it to Ayres Corporation.