

Rockwell service letter No. SL-AG-81

International

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Service Letter No. SL-AG-81
Revision No. 1
19 March, 1976

IMPROVED FLIGHT CHARACTERISTICS

APPROVAL: FAA DER Approved

Pge 1 of 10 - Parts Data:

Change:	Part No:	Was: 2 ea AN3C27	Bolt
		Now: 2 ea NAS1203-40D	Screw
	Quantity	Was: 2 ea AN174-22A	Bolt
		Now: 4 ea AN174-22A	Bolt
	To Read:	35 ea CR2249-5-2 or MS20600-5-2 Blind Rivet	
		50 ea CR2249-5-3 or MS20600-5-3 Blind Rivet	
		20 ea CR2249-5-4 or MS20600-5-4 Blind Rivet	
Add:	Part No:	2 ea 90206-1	Bushing
		2 ea 70273-R4-5	Plug

Page 4 of 10 ACCOMPLISHMENT INSTRUCTIONS:

Change: Step 15.c. to read:

- c. Drill four (4) 15/64 – inch diameter holes through elevator balance horn assembly and forward spar. Drill holes through top of spar from the top and then drill holes through bottom of spar from the bottom (see Figure 1, Detail D).

Step 15.d. to read:

- d. Ream holes through balance horn assembly and forward elevator spar to 0.2495/0.2505-inch.

Step 15.e. to read:

- e. Install 40376-501 elevator horn assembly on elevator with AN174-22A bolt(2 places), AN960-416 washer (4 places) and MS21044N4 nut (2 places) (see Figure 1, Detail D)

Delete: Step 15.f

Change: Step 20. to read:

20. Plug remaining holes in top of elevator aft spar with CR2249-5-2 or MS20600-5-2 blind rivets.

Change: Step 24. to read:

24. Locate, drill and install 70305-1 bellcrank support (2 places) on horizontal stabilizer. If clearance between bellcrank and elevator torque tube is not 0.03-inch, or better, trim bellcrank stiffener (see Figure 1, Detail F).

NOTE

Seal bolts with MIL-S-8802 sealer.

Change: Step 27. to read:

Rerig elevator trim travel as outlined in the Airplane Maintenance Manual, Section VII. The trim tab travel should be 8 (\pm 1) degrees up and 22 (\pm 1) degrees down. If necessary to obtain proper trim travel, relocate clevis attach point on elevator trim tab arm, install 90206-1 bushing and plug existing hole with 70273-R4-5 plug (see Figure 1, Detail F).

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Change: Figure 1 (sheet 3 of 4) as shown on page 3 of this revision.

Page 10 of 10.

Change: Figure 1 (sheet 4 of 4) as shown on page 4 of this revision.

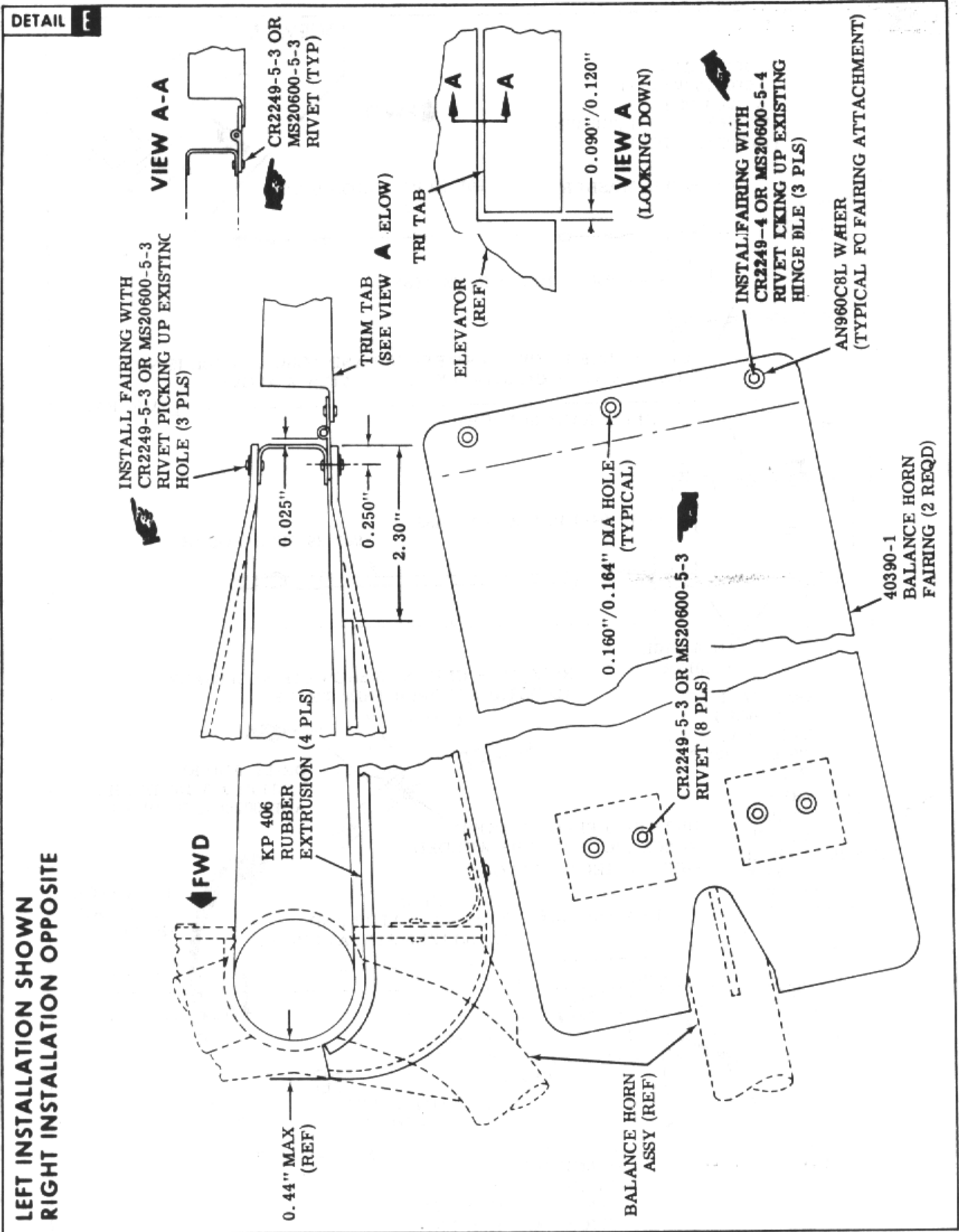


Figure 1. (Sheet 3 of 4)

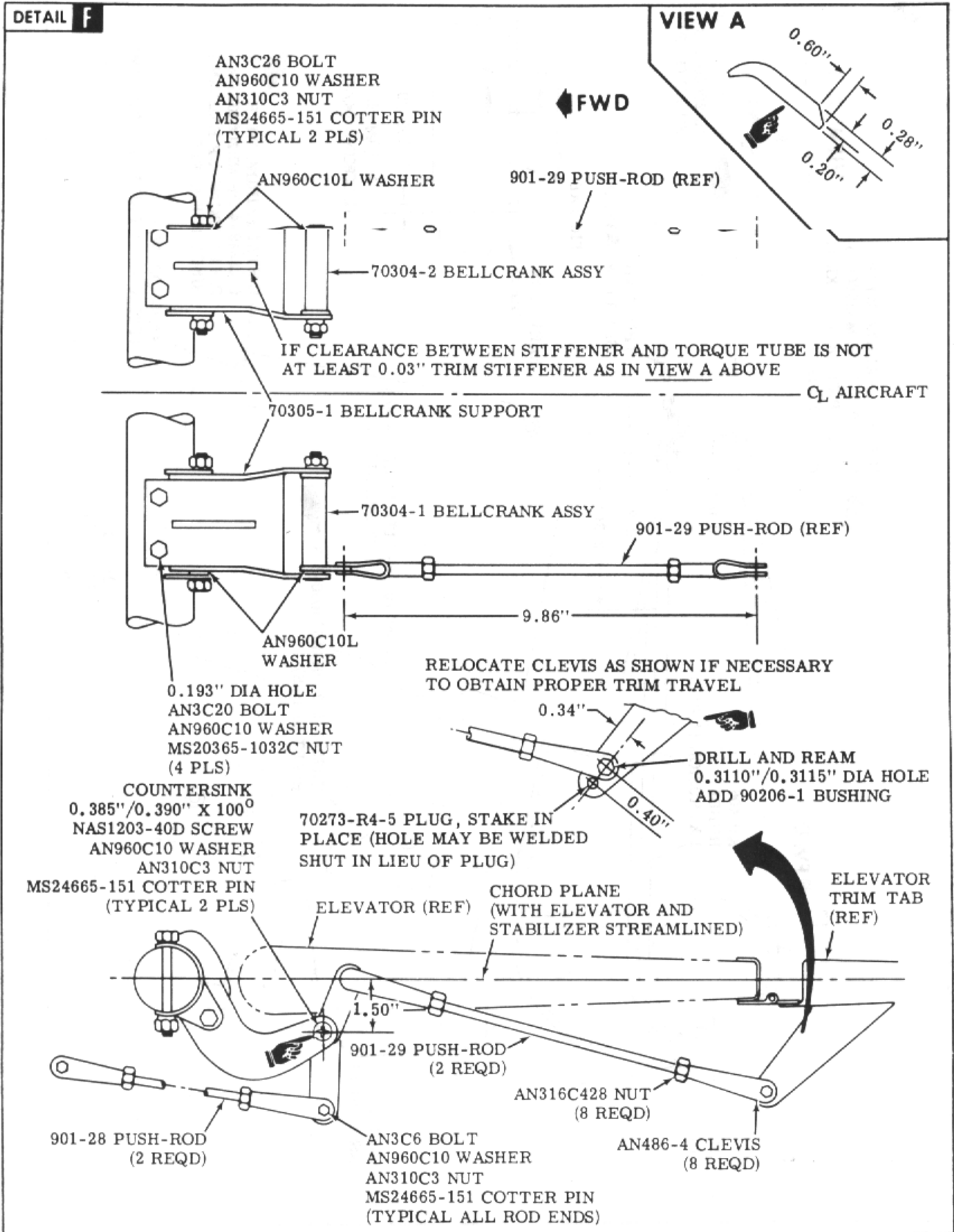


Figure 1. (Sheet 4 of 4)