

Aero service letter **No. SL-AG-59**

Commander

P.O. BOX 3090 ALBANY, GEORGIA 31706-3090 PHONE 229/883-1440 FAX 229/439-9790

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June 24, 1969

HOPPER BAFFLE ATTACH T-ANGLE (REAR WALL)

APPLICABILITY: ALL S-2R Aircraft, Serial Number 1416R through 1487R.

Since the issuance of Service Letter 58, which called for reinforcing the lower forward baffle attachment T-angle, there have been reports of separation of the T-angle from the rear hopper wall.

It is requested that an immediate inspection be made of the rear lower baffle attach T-angle. If separation from the hopper wall has occurred, the aircraft should be grounded until repairs are made.

If the T-angle is still attached to the rear hopper wall, inspections must be made daily until the following reinforcement is made. In no case should more than 25 hours flying time elapse before carrying out the reinforcement described in this Service Letter.

A reinforcement kit is being sent to all S-2R owners at no charge.

REPAIR/REINFORCEMENT PROCEDURE:

1. Clean the inside of the hopper thoroughly using appropriate solvents and/or detergent soap applied with a scrub brush on a long handle. Rinse with fresh water and leave both hopper lid and gate open a sufficient length of time to eliminate chemical fumes.
2. Wear a suitably rated respirator and protective clothing before entering hopper. An electric fan should be mounted above the hopper with the gate open so that fresh air is continually circulated through the hopper.
3. Remove R/H lower fuselage skin in battery area. Remove the hopper baffles to allow working space.
4. If the rear lower T-angle has separated from the hopper wall, place it in the original position. Then drill seven 3/16" holes, equally spaced, in each leg of the T-angle and through the hopper wall. Two of these holes will be above the floorboard and the other five will be below. When drilling through the ends of the T-angle, be sure the holes will

clear the wood stiffeners sufficient distance to allow the plate to be installed on the outside.

5. After the 14 holes have been drilled through the T-angle and hopper wall, place the 54041 plate on the outside of the hopper and position to pick up the 14 holes. Mark the hole location on the plate and drill the plate to match in a drill press.
6. Now scribe a center line mark on each of the 54041 strips. Place the strips opposite the holes in the 54041 plate and drill the strips to match in a drill press.
7. Apply a coating of EPC-711 to the T-angle and the outside hopper wall and bolt the plate and strips to the rear hopper wall; sandwiching the T-angle between the strips and hopper wall. The plate has to be wedged between the floorboard angle and the outside hopper wall in order to be positioned correctly. This can be accomplished by placing a screwdriver between the hopper wall and the felt strips along the floorboard. The bolt heads should be on the inside of the hopper.
8. Be sure the EPC-711 is applied around all bolts and plates so as to prevent leakage and allow to dry.
9. In order to strengthen the lower part of the hopper, a welded bracket is furnished. This bracket should be bolted to the lower forward hopper brace tube plates. Remove the two closest ¼" bolts together from the square-shaped brace tube plates and install the slightly longer bolts supplied in this kit to pick up the welded bracket assembly. Be sure a coating of EPC-711 is applied under the welded bracket and around the bolts to prevent leakage.
10. Drill a 3/16" hole through the forward lower corner of the fore and aft baffle to match the hole in the welded bracket. Bolt these two parts together with the AN3C-4A bolt furnished with this kit.
11. Inspect all surrounding areas of the hopper for cracks and make repairs as necessary using standard fiberglass repair procedures.
12. Water-check the hopper for leaks and then re-install baffles.

SERVICE KIT #59 PARTS LIST

2 ea.	AN4C-11A	Bolt
1 ea.	SK343-1	Bracket
6 ea.	AN960C-416	Washer
2 ea.	AN365C-428	Nut
1 ea.	AN3C-4A	Bolt
29 ea.	AN960C-1032	Washer
15 ea.	AN365C-1032	Nut
1 ea.	54041-10508	Plate
2 ea.	54041-10509	Strip
14 ea.	AN3C-6A	Bolt