



# SERVICE

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SERVICE KIT NO. SK-111

DATE: July 19, 1971  
 TITLE: Rudder/Elevator Tip Rib Modification  
 SERIAL AFFECTED: AA1-0001 thru AA1-0458, AA1A-0001 thru AA1A-0239  
 WEIGHT AND BALANCE CHANGE: Negligible

Parts List

<u>Quantity</u>	<u>Part Number</u>	<u>Description</u>
1	901058-501	Doubler Assembly
3	1601-0410	Rivet (Avdel)

Description of Repair

This kit covers the repair of a loose or pulled rivnut in the outboard rib of the vertical and/or horizontal control surfaces.

Repair Instructions

1. Remove the 12 screws securing the control surface tip and remove the tip.
2. Remove the rib attach bolt, washer and nut, then remove the NAS221-8 screw and the tip rib assembly.
3. Drill out the loose or pulled rivnut with a .250"dia. drill. After rivnut is removed, redrill existing rivnut hole to .437"dia. thru outer face sheet only.
4. Place doubler assembly on control surface rib and use it as a template to mark the three (3) rivet hole locations. Drill three (3) .136/.139" dia. rivet holes through the outer face sheet skin of the rib, apply RTV 732 (Dow Corning) Sealant and attach doubler assembly using three (1601-0410) rivets per doubler using "pop" rivet tool (United Shoe Machinery Co. P/N PRG410 or equivalent).
5. Install tip rib assembly and tip (Torque rib attach bolt and nut assembly to 20-25 in. lbs).

N O T E

Apply Loctite Nut Lock (Loctite Corp. Cat. #74-31) to NAS221-8 screw at installation.

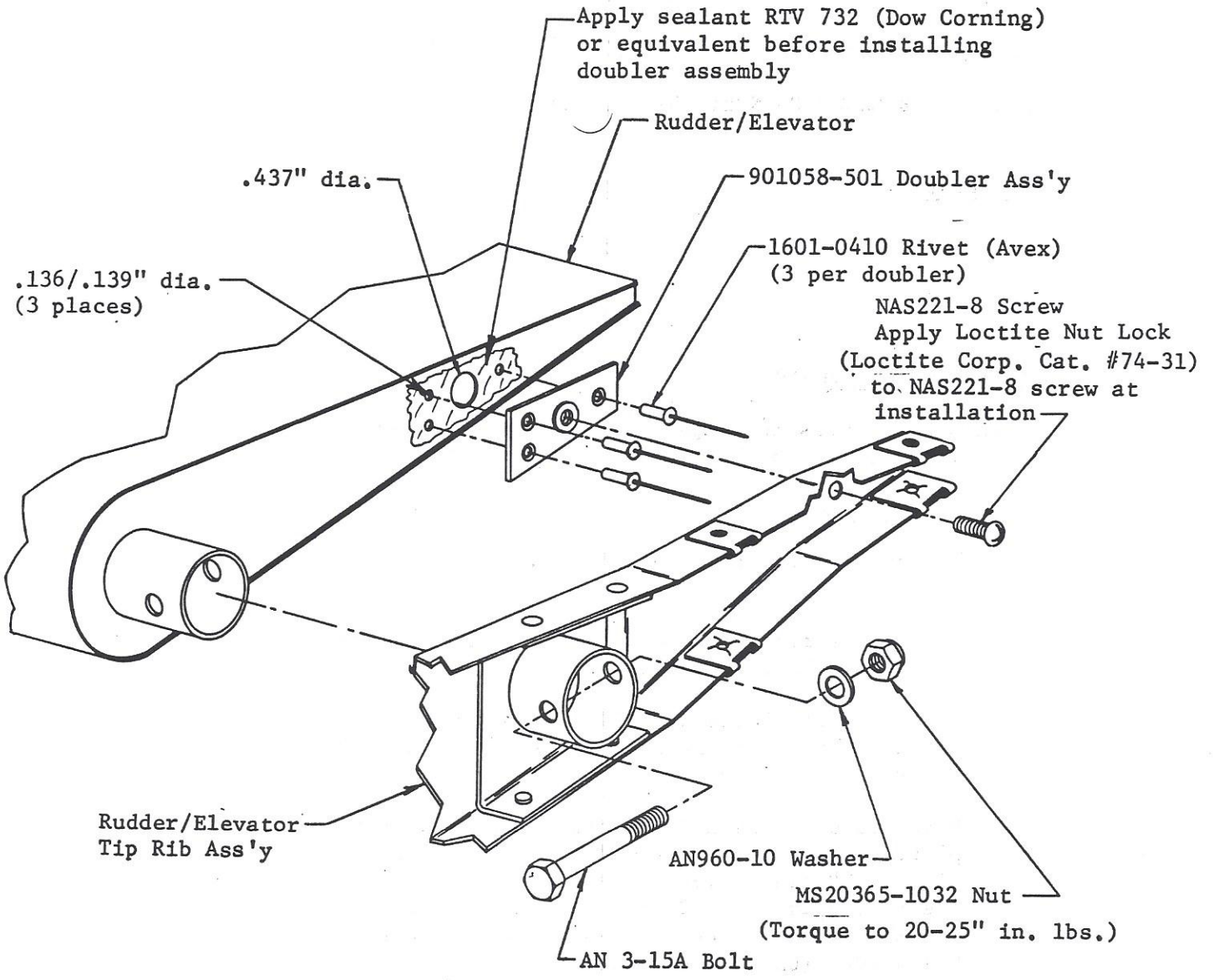


Figure 1. Rudder/Elevator Tip Rib Modification