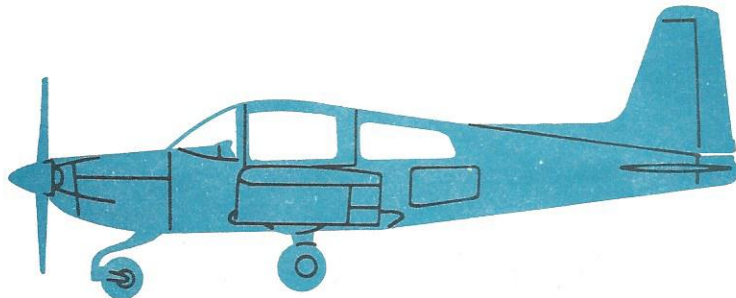
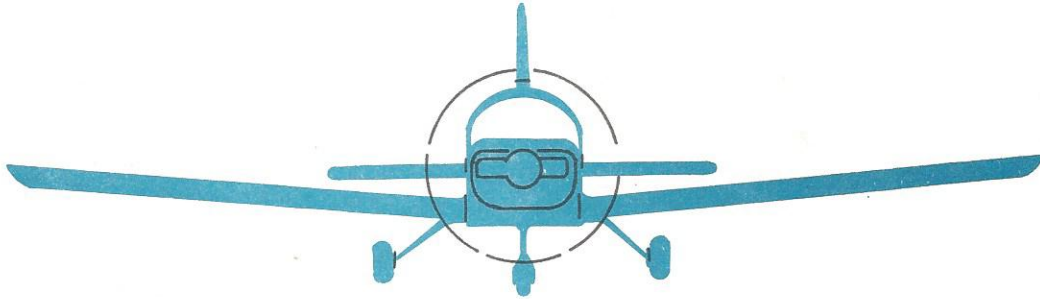


# SINGLE ENGINE AIRCRAFT SERVICE KIT NO. 144

**SUBJECT:** FLIGHT CONTROL (ATA NO. 27) AILERON TORQUE TUBE, MODIFICATION OF



NOTED BY	
NAME	DATE
_____	_____
_____	_____
_____	_____
_____	_____
_____	_____
_____	_____
_____	_____
_____	_____
_____	_____

JUNE 4, 1979

GULFSTREAM AMERICAN SINGLE ENGINE AIRCRAFT SERVICE KIT NO. 144.

SUBJECT: Flight Control (ATA No. 27) Aileron Torque Tube, Modification of.

PURPOSE/DISCUSSION: This Service Kit is the modification of the Aileron Torque Tube as called out in Service Bulletin 163. The modification is to be done after the inspection as called out in Service Bulletin 163.

DESCRIPTION: This Service Kit consists of disassembling the aileron torque tube, cleaning and reassembling with rivets and Loctite Epoxy.

SPECIALTOOLS/  
EQUIPMENT REQUIRED: None.

EFFECTIVITY:	<u>MODEL</u>	<u>SERIAL NUMBER</u>
	AA5A	0176 through 0805
	AA5B	0302 through 01078

Also effective all spare stock of part number 5202035-505 shipped from Gulfstream American between May 1976 and January 1979.

WEIGHT AND BALANCE: Negligible.

PRICE: Prices are subject to change without notice:

Price: Refer to Service Bulletin 163

MODIFICATION INSTRUCTIONS:

A. Prepare the aircraft for safe maintenance as follows:

- A-1 Insure that the Master Switch is OFF and all aircraft System Switches are OFF.
- A-2 Insure aircraft is grounded.
- A-3 Comply with all safe maintenance practices as recommended in the Maintenance Manual and FAA Regulations.

B. Rework Instructions:

- B-1 Remove ailerons from the aircraft. Refer to Service Bulletin 163.
- B-2 Disassemble the aileron torque tube joint by drilling out the rivets with a #30 or #29 drill.

NOTE

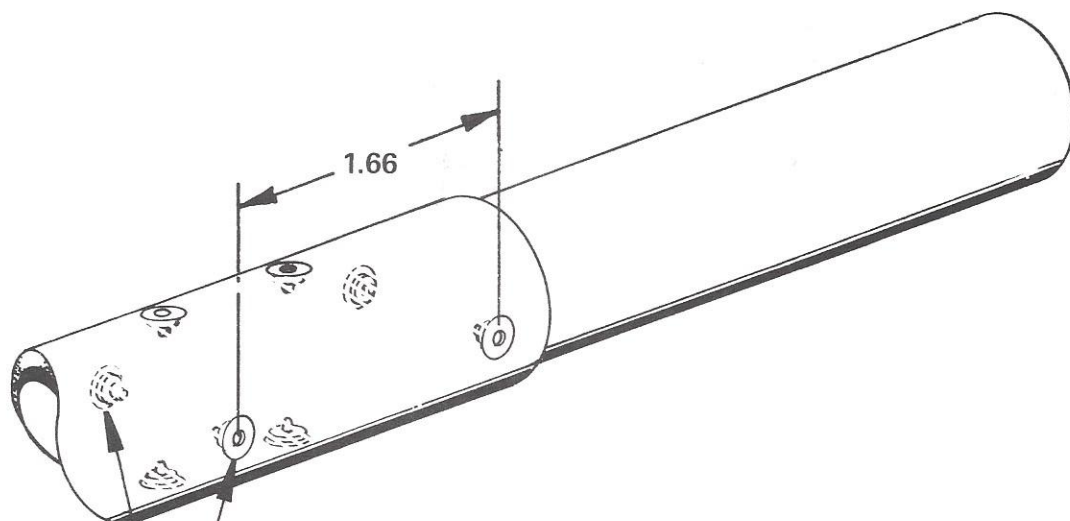
Mark both tubes to insure alignment on final assembly.

- B-3 Separate torque tube.

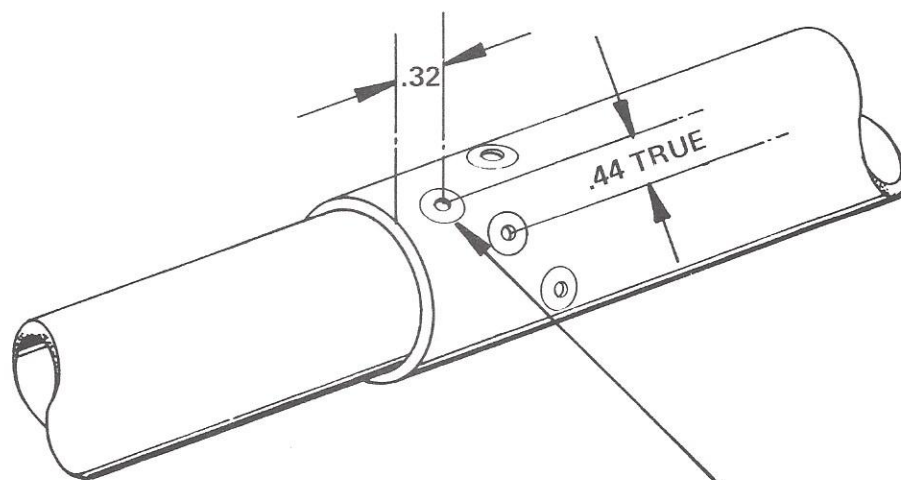
NOTE

If the torque tube cannot be separated because of bonding, open existing holes to .176 - .180, countersink 100° x .290 DIA and install CR3242-5-4 rivets.

- B-4 Clean torque tube mating surface by lightly sanding with 360-400 grit Carborundum (non-silicone) paper.
- B-5 Reassemble joint and drill existing holes to .176 - .180 and countersink 100° x .290 DIA. Also drill two new holes at each end of the torque tube (.176 - .180) as shown in Figure 1, countersink holes 100° x .290 DIA.
- B-6 Separate tubes and remove all chips and lightly debur all holes.
- B-7 Using MEK or Acetone and a clean rag clean the mating surfaces.
- B-8 Mix epoxy per package instructions (Loctite 'Clear' Epoxy Kit # 446).



ADD HOLES  
 (TYPICAL 2 PLACES)  
 DRILL .176 - .180  
 COUNTERSINK 100° X  
 .290 DIA., 8 HOLES  
 OUTBOARD JOINT



ADD HOLES  
 (TYPICAL 2 PLACES)  
 DRILL .176 - .180  
 COUNTERSINK  
 100° X .290 DIA.,  
 INBOARD JOINT

FIGURE I