

AVIONS PIERRE ROBIN

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FRANCE

**BULLETIN DE SERVICE**  
**SERVICE BULLETIN**

**N° 109**

**I M P E R A T I V E**

Objet Object :

Rudder bars

Aircraft concerned :

HR 200/100 - HR 200/120 - HR 200/120 B  
HR 200/160 - HR 200/100 S - R 2160 - R 2100  
R 2100 A - R 2160 D - R 2112 - All Serial numbers

Date :

28/04/86

Date of application

Upon receipt of this S.B.

Approuvé par la DGAC Approved by DGAC

22.09.1986

A fatigue crack has been detected on rudder bars, where the vertical and horizontal tubes are joined.

Prior to any flight, after the date of applicability of this S.B., visually check for the presence of cracks in the area concerned (cf. Spare Parts Catalogue, plate 7, page 18, items 1 and 2).

If no crack is found, the aircraft may be flown and this inspection renewed every 100 flying hours.

If a crack is found, ground the aircraft and apply the rudder strengthening measures specified by the constructor (ref. 97.23.25).

The reinforcement of the rudder bars cancels the above specific instructions but the rudder bars must evidently continue to be checked in the course of normal maintenance.

Regardless of the results of the above checks, rudder bar strengthening must be performed during the next maintenance inspection and, at the latest, on the 30.06.87.

Only on outside tube  
Ext Ø 22 x 25

3 Holes Ø 6 at 120°  
Observe positions

3 Circular welds

If a crack is detected, enlarge  
the gap with a hacksaw blade and  
reweld on reinforcing sleeve

ARGON Welding

Identification Ring  
(bleue paint)

- Work must be performed only in A.P.R. Approved workshop
- Number of parts required per aircraft : 4 sleeves as per drawing (cf. Service Bulletin n° 109)
- Protective treatment : remove paint before welding.  
Apply primer + chromat + matt black finish.  
Apply grease in the bore.

Page 1	PLAN	Page 2, Page 3	Désignation	Nature	Observations
<p>Modif. 10 Date MODIFICATION</p> <p>Le plan se présente les VIGNES PIERRE ROBIN et le tout est soumis à l'approbation des autorités compétentes.</p> <p>DESSINÉ PAR <i>Chauvin</i> 14.12.56</p> <p>ÉCHELLE: Ensemble 10.</p> <p>DÉSIGNATION: Rudderbar 27.23.05</p> <p>REINFORCING SLEEVE</p>					
				<p><b>ROBIN</b> VIGNES PIERRE ROBIN</p> <p>N° 972325</p>	