

SERVICE BULLETIN

AA-SB-53-003

Fuselage Repair – Upper Longerons

1. PLANNING INFORMATION

1.1. APPLICABILITY

R2000 series aircraft. Specific serial numbers as authorised by Alpha Aviation Ltd.

1.2. CONCURRENT REQUIREMENTS

Nil

1.3. REASON

Corrosion has been found on the Fuselage Upper Longeron P/N 21.23.28.110 (LH) and/or P/N 21.23.28.120 (RH) of some aircraft.

1.4. DESCRIPTION

This Service Bulletin provides descriptive data for the replacement of sections aft of station 3100mm on affected Fuselages.

1.5. COMPLIANCE

Carry out repairs described in section 2 – Accomplishment Instructions.
Make a log book entry stating compliance with this Service Bulletin.

1.6. APPROVAL

By delegated authority (Alpha Aviation Concept Ltd, DO75992) COA AA/60/1162

1.7. WEIGHT AND BALANCE

Negligible effect on weight or balance


1.8. REFERENCES

R2000 Service Manual.
Drawing 60-53-992 'Upper Longeron Splice Repair'
Drawing 60-53-991 'Upper Longeron Splice'

1.9. OTHER PUBLICATIONS AFFECTED

Nil

Approved
msf 23/02/17



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2. ACCOMPLISHMENT INSTRUCTIONS

2.1. Preparation

1. Remove the Rudder, Fin and Stabilator from aircraft in accordance with the R2000 Service Manual.
2. Remove fasteners as required to gain access to trim the existing longeron sufficient to remove corroded section. NOTE: only one longeron section to be removed at a time.


2.2. Splice and Longeron section – Manufacture and Installation

1. Manufacture the Splice and replacement sections IAW Drawings 60-53-991 & 60-53-992.
2. Install IAW Drawing 60-53-992 instructions.
3. Replace fasteners removed in 2.1.2 above IAW drawing instructions.
4. Repair paint IAW drawing instructions.

2.3. Stabilator, Fin and Rudder Installation

1. Install the Stabilator, Fin and Rudder IAW R2000 Service Manual.
2. Control rigging to be checked and/or set IAW R2000 Service Manual.
3. Duplicate inspections to be carried out as applicable to regulating authority.

Approved
[Signature] 23/2/17





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3. FEED BACK

Maintenance organisations are requested to provide feedback on the accuracy of the data and repair process provided. Please also provide feedback on any problems encountered and any suggested improvements to this repair scheme. Please use Alpha form DES 22 (Design Feedback Form) for this purpose. A copy of the form and mailing details can be found in the Service Manual (latest revision) or request the form from Alpha Aviation. (Feedback by e-mail to tech.support@alphaaviation.co.nz will also be welcomed.)

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