PACIFICAEROSPACE

Pacific Aerospace Limited
Airport Road, Hamilton
Private Bag 3027, Hamilton 3240, New Zealand
TEL +64 7 843 6144 FAX +64 7 843 6134
EMAIL pacific@aerospace.co.nz
WEB www.aerospace.co.nz

MANDATORY SERVICE BULLETIN

PACSB / XL / 091
ISSUE 3

WING L/E TANK ABRASION REPAIR & PATCH

1. PLANNING INFORMATION

A.	EFFECTIVITY	All PAL 750XL aircraft up to and including S/N 135 (except S/N 113).
B.	REASON	To repair or prevent chafing to wing leading edge due to rubbing by the ventilation ducting.
C.	DESCRIPTION	Part A – Wing L/E tank repair where chafing has occurred on the leading edge. Part B – Wing L/E tank anti-abrasion patch installation.
D.	COMPLIANCE	Inspect for chafing – at next 150 hour check. If chafing is found: - Repair IAW Part A before further flight. If chafing is not found: - Apply Part B after receipt of parts and before 01 April 2018.
E.	APPROVAL	By delegated authority.
F.	TOOLING	N/A
G.	WEIGHT AND BALANCE	No change
H.	REFERENCE	PAL MOD PAC/XL/0319
I.	HOURS REQUIRED	Part A – 8 Hours Part B – 1 Hour
J.	WARRANTY COVER	Normal Warranty conditions apply

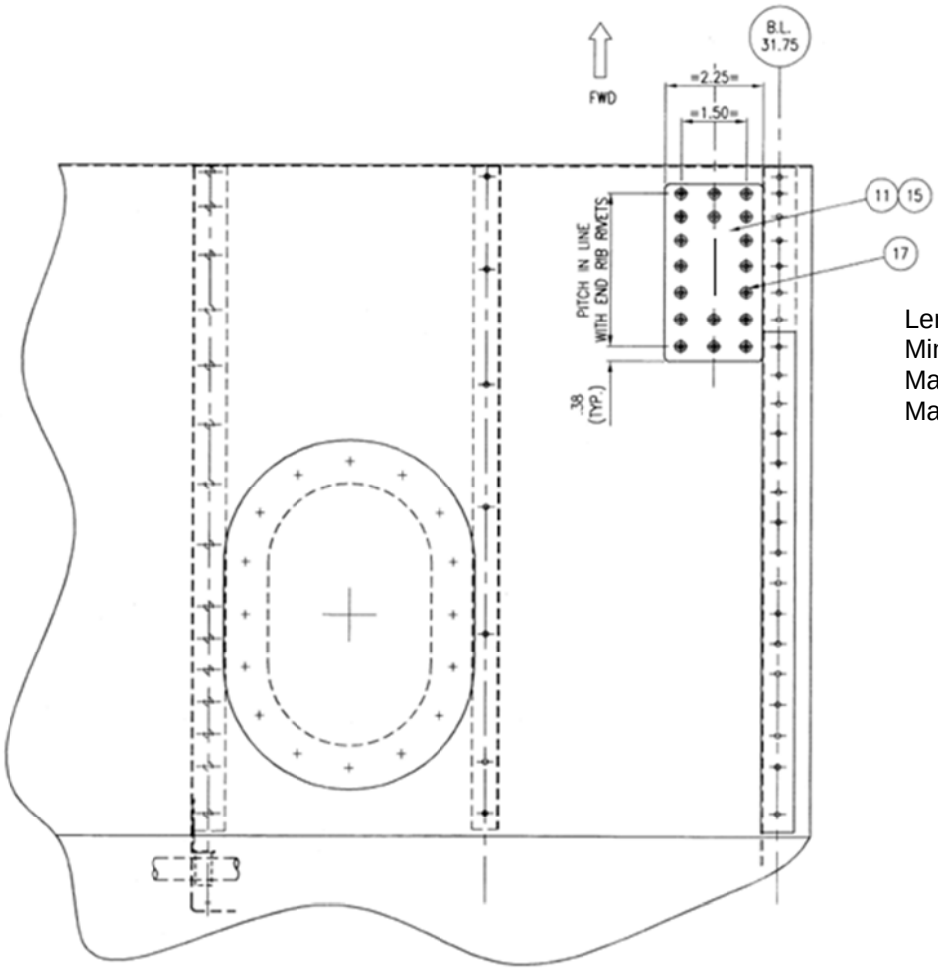
2. INSPECTION INSTRUCTIONS

Inspect the leading edge skin of both wings at the wing root and check whether there are chafing marks. After inspection, proceed as follows:

- If chafing marks are found, apply Part A and Part B of this Service Bulletin;
- If there are no chafing marks, apply Part B of this Service Bulletin.

3. PART A – ACCOMPLISHMENT INSTRUCTIONS

Repair Wing L/E Tank Abrasion



Length of patch = 2 x damaged area
Minimum length = 3" (Min. 4 rivets)
Maximum length = 6"
Maintain minimum 2D edge distance

Note: Item 11 is Doubler patch – Alc.Sheet, 0.025 thick 2024-T3
Item 15 is Adhesive sealant – AMS-S8802
Item 17 is Rivet AD 42 SB (POP)

Note 2: Repair this area IAW FAA AC43.13-1B Fig 4-16

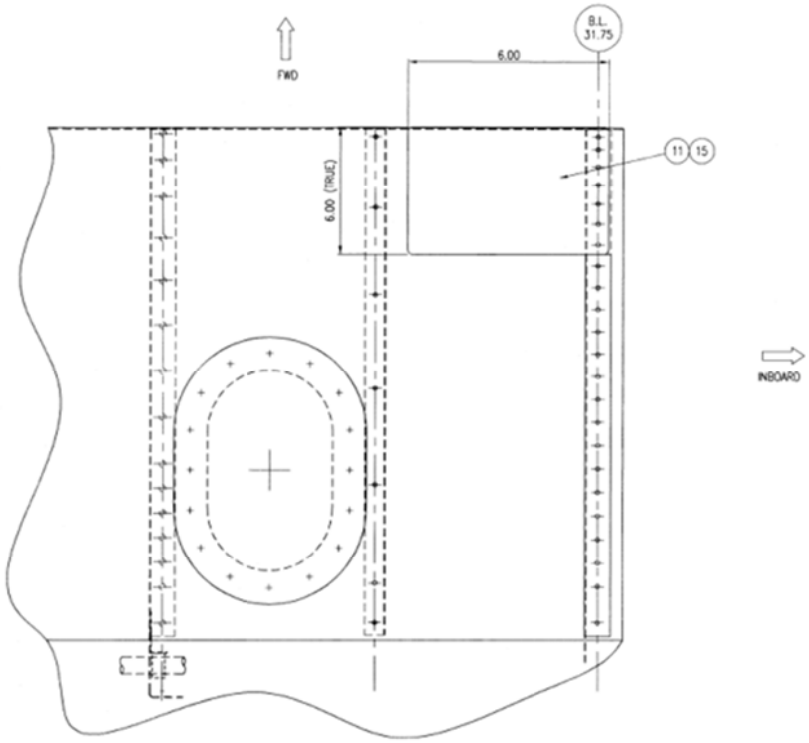
VIEW ON UNDERSIDE – R.H. WING
L.H. WING REPAIR SIMILAR (AS REQUIRED)

FIGURE 1 REPAIR WING L/E TANK ABRASION

1) Blend out gouges in skin to remove sharp corners (ratio 20:1).
2) Where gouges are located outside the repair patch perimeter as drawn, extend the patch, replicating the indicated fastener pitching as required. Make sure blended area is within rivet attachment area, if the patch exceeds 6" x 6", contact PAL for further information.
3) If patch rivets are required thru the wing inboard rib, ensure wing tank sealing is maintained/reinstated and replace rivets with the same P/N MS20470 AD4 solid rivets in existing locations (not the AD 42 SB rivet).
4) Remove any paint or primer between the mating surfaces and lightly scuff using scotchbrite. Clean with Prepsol/Acetone and allow to dry thoroughly. Apply AMS-S-8802 adhesive sealant liberally to mating surfaces ensuring no air gaps will result. Rivet the doubler patch in place while sealant is still wet.
5) Prime and paint in accordance with maintenance manual Chapter 20.
6) Install Teflon protection doublers as detailed in Part B of this Service Bulletin.

4. PART B – ACCOMPLISHMENT INSTRUCTIONS

Wing L/E Tank Anti-Abrasion Patch



Note: Item 11 is Anti-abrasion patch – Teflon Sht. 1mm THK. Etched
Item 15 is Adhesive sealant – Sikaflex 221

VIEW ON UNDERSIDE – R.H. WING
L.H. WING OPPOSITE HAND

FIGURE 2 WING L/E ANTI-ABRASION PATCH

1) Ensure mating surfaces of anti-abrasion patch and L/E skin are clean and free from dust or grease before bonding the anti-abrasion patch to the wing L/E skin.
2) Apply adhesive sealant on mating surfaces of anti-abrasion patch and wing L/E skin. Install the anti-abrasion patch as shown.

5. CERTIFICATION

Record compliance with Part A and/or Part B of this bulletin in the aircraft Log Book.

6. MATERIAL REQUIRED:

Part A

Description	Part Number	Qty Required
Rivet	AD 42 SB (POP)	A/R
Adhesive Sealant – PRC type	AMS-S8802	A/R
Repair Patch – ALC. SHT. - .025 THK. 2024-T3	11-03159-11	A/R

Part B

Description	Part Number	Qty Required
Adhesive Sealant	Sikaflex 221	A/R
Anti-abrasion patch – Teflon SHT. 1mm THK. ETCHED	11-03161-11	2