

INSPECTION / REPLACEMENT
AILERON PIVOT FORK ASSEMBLY

1. PLANNING INFORMATION

- | | | | |
|-----------|----------------------------------|--|----------------------------|
| A. | <u>EFFECTIVITY</u> | <u>MODEL</u> | <u>S/N</u> |
| | | 750XL (NZ) | Up to S/N 216, and S/N 220 |
| | | 750XL (CN) | 8001, 8002 |
| B. | <u>REASON</u> | Addition of retaining features to the aileron pivot fork bearing.
<u>Issue 3 adds the washer P/N AN960-516 as optional for the P/N AN960-516L.</u> | |
| C. | <u>DESCRIPTION</u> | Part A – Daily inspection.
Inspect the bearing assemblies at both fork ends for security.
Part B – Install retaining washers, and a new bolt secured with a castellated nut and split pin. | |
| D. | <u>COMPLIANCE</u> | Part A - Daily until Part B is completed.
Part B - Within the next 165 flight hours. | |
| E. | <u>APPROVAL</u> | By delegated authority. | |
| F. | <u>TOOLING</u> | N/A. | |
| G. | <u>WEIGHT AND BALANCE</u> | Negligible change. | |
| H. | <u>REFERENCE</u> | 750XL Maintenance Manual. | |
| I. | <u>HOURS REQUIRED</u> | Part A - 1 Hour.
Part B - 3 Hours. | |
| J. | <u>WARRANTY COVER</u> | Normal Warranty conditions apply. | |

2. **ACCOMPLISHMENT INSTRUCTIONS**

Part A – Daily Inspection

NOTE: The initial inspection (Steps A.1 to A.3) should be performed by a qualified and approved LAME.

- A.1) Remove the control stick boot, for both port side and starboard side control column.
- A.2) Inspect the bearing assemblies at both fork ends for security. Make sure the bearings are seated in the fork ends tightly and show no sign of slipping out.
- A.3) Re-install the control stick boot.

NOTE: Daily visual inspections may be performed by a qualified pilot.

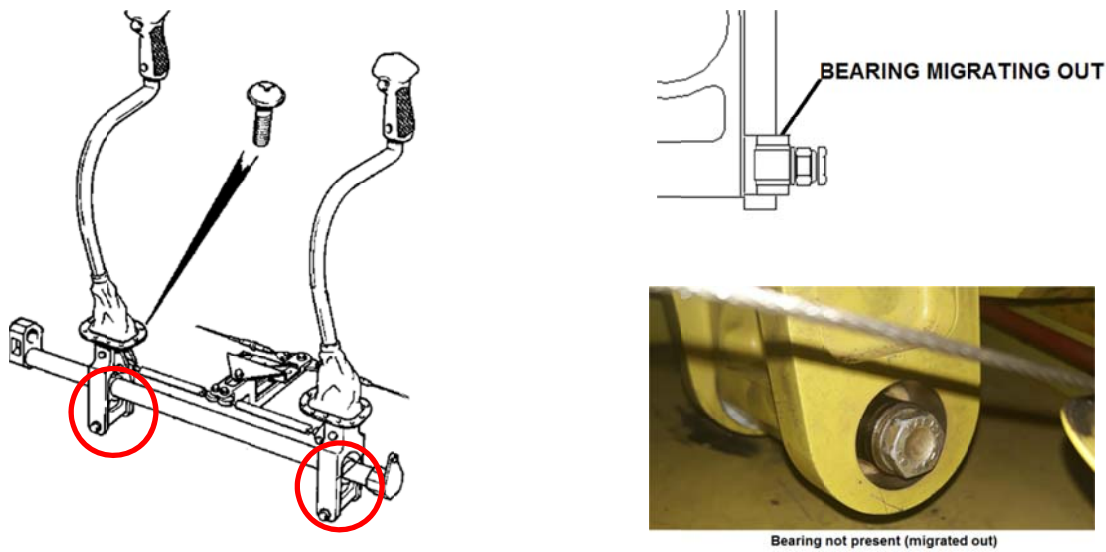


FIGURE 1 REMOVAL – FLOOR COVER AND STICK BOOT (TYPICAL)

Part B – Installation - hardware

- B.1) Remove the control stick boot and cockpit floor cover (Ref. 750XL MM, Section 27-10-00, Page 401).
- B.2) Uninstall the PAL NUT and the self-locking nut. Carefully remove the bolt. Refer Figure 2. Remove existing hardware.

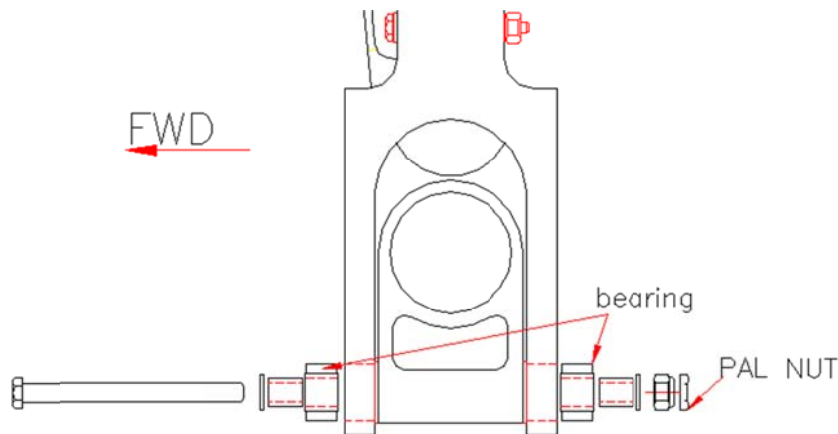


FIGURE 2 UNINSTALLATION

NOTE: While removing the bolt from the structure, insert a tooling pin following the trace of the bolt (tooling pin should have a diameter of 0.3", and length of 3.50"). This procedure will ensure hardware will not drop down, and the fork will align with the torque tube.

NOTE: The exploded views (Figures 2 and 3) are for clarification only. It is not required to remove the bearings and bushings from the fork.

CAUTION: Be careful handling the bearing, as the inner part of this bearing can slip out easily.

B.3) Re-install the hardware as follows:

- a) Open the inner diameter of the P/N AN970-4 washer with a 5/16" drill. (Refer WAS7-3 washer in Figure 3, refer to the attached drawing). The WAS18-1 washers may also be fabricated IAW the attached drawing.

NOTE: The Bolts P/N NAS6605D60 may be fabricated from P/N NAS6605-60 iaw PAL DWG BOL6605 (refer to the attached drawing).

- b) Apply AeroShell 22 grease (or any grease product that meet MIL-PRF-81322) to the drilled surface and the inner face of the AN970 washers (See Figure 3).

NOTE 1: Ensure that the bolt thread is not contaminated by grease.

NOTE 2: Check that the teflon washers are in between the pivot and the fork before assembly.

- c) Re-install all parts, according to the sequence shown in Figure 3. Torque nut to 100 - 140 lb.in, before installing the split pin.

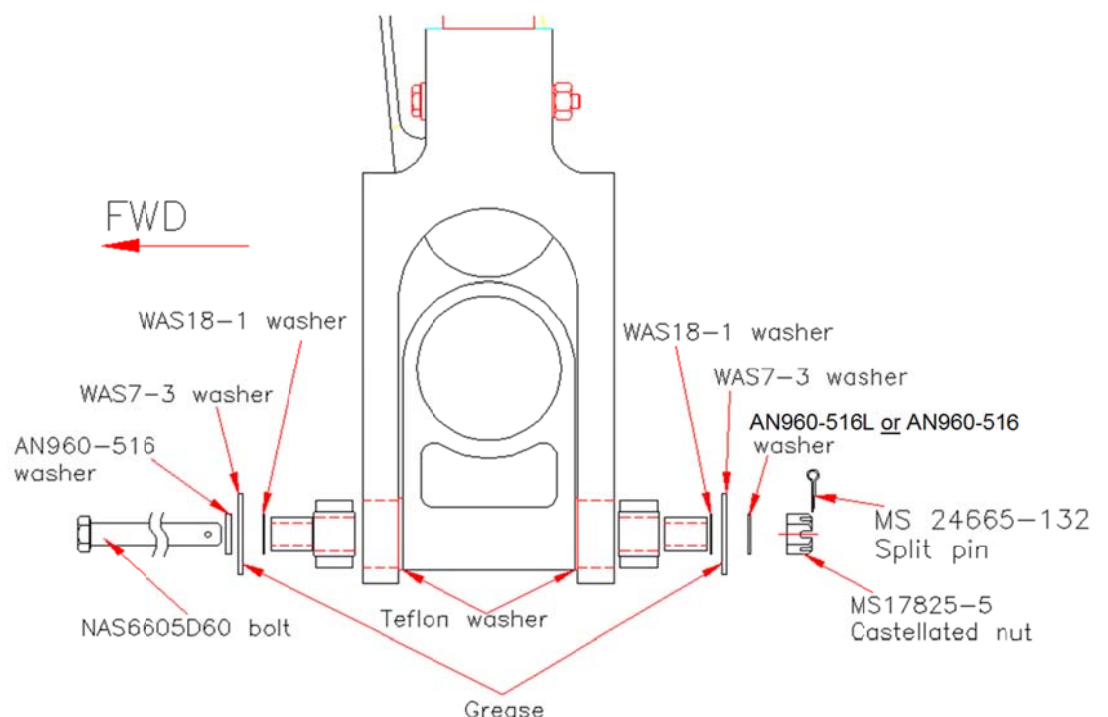


FIGURE 3 RE INSTALLATION – HARDWARE

- B.4) A duplicate inspection is required to the work carried out above.
- B.5) Reinstall the cockpit floor cover and control stick boot (Ref. 750XL MM, Section 27-10-00, Page 401).
- B.6) Carry out the functional test (after full installation), ensure full and free movement.

3. CERTIFICATION

Record compliance with this Service Bulletin in the Aircraft Logbook.
The accomplishment of Part B of this Service Bulletin is a terminating action.

4. MATERIAL REQUIRED

<u>Description</u>	<u>Part Number</u>	<u>Qty Required</u>
Washer	WAS7-3 (Refer attached drawing)	4
Washer	WAS18-1 (Refer attached drawing)	4
Washer	AN960-516	2
Washer *	AN960-516L (or AN960-516)	2
Nut	MS17825-5	2
Split pin	MS24665-132	2
Bolt	NAS6605D60 OR NAS1305-60D OR PAL BOL6605D60 OR NAS6605-60 (hole drilled iaw PAL DWG BOL6605)	2
Grease	AeroShell Grease 22 (MIL- PRF-81322)	A/R
Tooling pin	-	

* use as necessary to prevent thread bound