

# ***Nomad*** SERVICE BULLETIN

ACN 008 622 008

Reference No 239

**TRANSMITTAL LETTER  
FOR  
SERVICE BULLETIN ANMD-55-30**

**STABILISERS — HORIZONTAL STABILISER — GUST DAMPER  
MOUNTING BOLT REPLACEMENT (POST MOD N663)**

---

**Reason**

1. Mounting bolt grip length incorrectly specified in 4 off locations.

**Instructions**

2. Insert the attached Service Bulletin ANMD-55-30, dated 18 Mar 92 into the Service Bulletin binder and annotate the Service Bulletin Index accordingly.

**Revision Status**

Original                      18 Mar 92

# **Nomad**

## SERVICE BULLETIN

### STABILISERS — HORIZONTAL STABILISER — GUST DAMPER MOUNTING BOLTS REPLACEMENT (POST MOD N663)

#### 1. PLANNING INFORMATION

##### A. Effectivity

(1) Aircraft Affected.

Aircraft LS 55, LS 69 and USCS aircraft LS 159 to LS 165.

(2) Spares Affected.

Horizontal Stabiliser S/N GAF-179.

##### B. Reason

Incorrect bolt grip length specified in 4 off locations.

##### C. Description

The gust damper assembly is removed, reworked and refitted to the mass balance arm with two original bolts and four new bolts.

##### D. Compliance

To be carried out in conjunction with Service Bulletin ANMD-55-26, Part 4 at Rev 5 or later OR not later than the next 100 hour inspection.

##### E. Approval

This Service Bulletin is approved pursuant to Civil Aviation Regulation 35 and complies with type certificate requirements.

##### F. Manpower

Estimated 10 manhours.

##### G. Materials — Price and Availability

Obtain parts from own stock or local sources.

##### H. Tooling — Price and Availability

A No 4 centre drill is required.

##### I. Weight and Balance

None.

##### J. References

Service Bulletin ANMD-55-26 (Mods N663 and N768).

Page No	1	2	3	4	5	6	7
Rev No	0	0	0	0	0	0	0

# **Nomad**

## **SERVICE BULLETIN**

### **K. Publications affected**

Maintenance Manual

Illustrated Parts Catalogue

Structural Repair Manual

## **2. ACCOMPLISHMENT INSTRUCTIONS**

### **NOTE**

- Wet assemble all bolts using sealant Duralac DTD396B. Use sparingly so that no sealant enters the assembled damper.
- Wet assemble all faying surfaces, except where specified, using sealant PR 1422-B2.
- Wet assemble all blind rivets using Epoxy Polyamide primer to MIL-P-23377D or Duralac DTD396B.

### **A. Gust Damper Assembly Removal**

- (1) Refer to Figure 1. Remove mass balance weights and studs. Retain all attaching hardware except the stiffnuts. Discard stiffnuts. Mark front and upper edges of weights to ensure correct reassembly.

### **NOTE**

Keep the mass balance weights in their removed order.

- (2) Remove the mass balance block from the mass balance arm. Mark front and upper surfaces to ensure correct reassembly.
- (3) Identify and derivet upper Channel PN 1/N-30-263 located on upper mass balance surface.
- (4) Carefully detach and remove channel from stabiliser.
- (5) Remove the six gust damper mounting bolts and countersunk washers. Retain all washers and two only bolts. Discard remaining four bolts.
- (6) Remove the gust damper from stabiliser.

### **B. Gust Damper Assembly Rework**

- (1) Refer to Figure 2. Remove gust damper end cap and extract the internal assembly. Do not dismantle.
- (2) Refer to Figure 3. Countersink the six housing mounting bolt holes 60° (included) to a depth of 0.070 to 0.080 in. Blow away any swarf and run a 10-32 UNF-2B tap through each hole.
- (3) Clean and dry the housing to remove all dirt, grease and swarf.
- (4) Apply Alodine 1200 to countersink at six locations
- (5) Lightly smear the interior with grease to MIL-G-23827.
- (6) Install gust damper end cap and torque tighten to 25-30 lb in.

# *Nomad* SERVICE BULLETIN

## C. Gust Damper Assembly Installation

- (1) Position gust damper assembly in mass balance arm. Ensure that the large end cap is uppermost.
- (2) Refer to Figure 4. Install two short bolts PN NSA6203-2H retained in Step 2.A.(5) and four new long bolts PN NAS6203-3H. Place one countersunk washer PN MS21299-C3 under each mounting bolt head.
- (3) Torque tighten all bolts to 20-25 lb in and lockwire each side set together (Ref Fig 4, Views A and B).
- (4) Thoroughly clean out holes and vacuum all areas to remove foreign objects.
- (5) Wet assemble channel PN 1/N-30-263. Locate correctly with skin pins and rivet in place.
- (6) Lockwire gust damper assembly to mass balance arm.
- (7) Refer to Figure 1. Wet assemble mass balance weights using Duralac DTD396B. Use new stiffnuts PN MS21044-N4. Torque tighten all nuts to 30-40 lb in.
- (8) Remove all excess sealant and touch up any damaged paintwork.
- (9) Carry out a horizontal stabiliser weight and balance check (Ref SRM Chap 55-10-00). Record total weight and mass balance weight.

## 3. MATERIALS INFORMATION

### A. Parts Required Per Aircraft

New Part No	Qty	Description	Old Part No	Instruction/Disposition
Parts to be obtained from own stock or local sources				
CR3523-4-2	20	Rivet, Cherrymax		
MS20470AD4-5	34	Rivet, Universal hd		
MS20470AD6-7	3	Rivet, Universal hd		
MS20470AD6-8	12	Rivet, Universal hd		
MS21044-N4	16	Stiffnut		
NAS6203-3H	4	Bolt, Close tolerance	NAS6203-2H	Discard old bolt

### B. Special Tools and Equipment

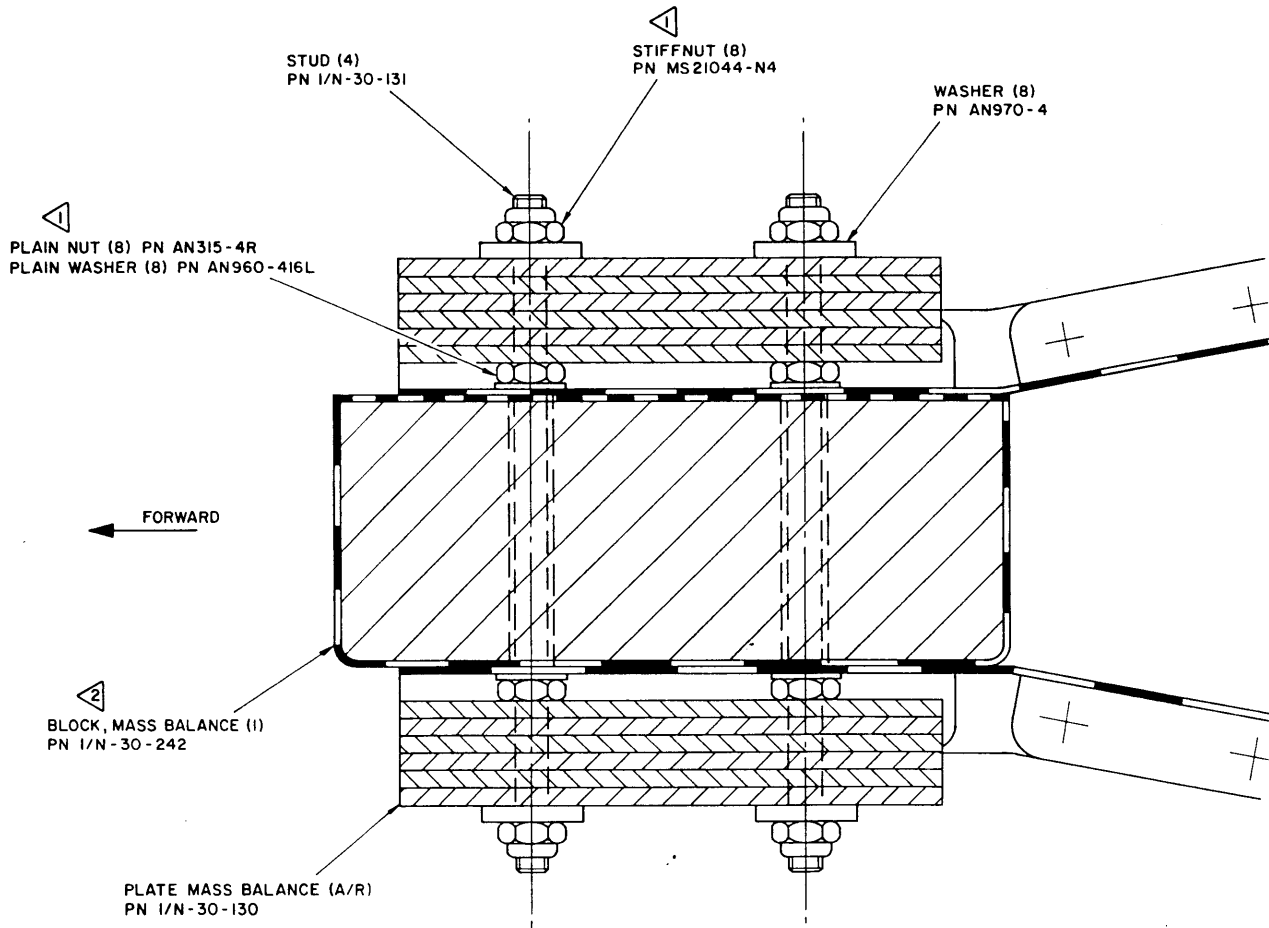
Centre Drill No 4.

## 4. RECORDING ACTION

Record compliance with Service Bulletin ANMD-55-30 in Airframe Log Book.

# Nomad SERVICE BULLETIN

12 60 216-1



NOTES:

- 1 TORQUE TIGHTEN TO 30-40 LB IN
- 2 WET ASSEMBLE USING DURALAC DTD 369B

Figure 1 Mass Balance Weights

# Nomad SERVICE BULLETIN

12 60 217-1

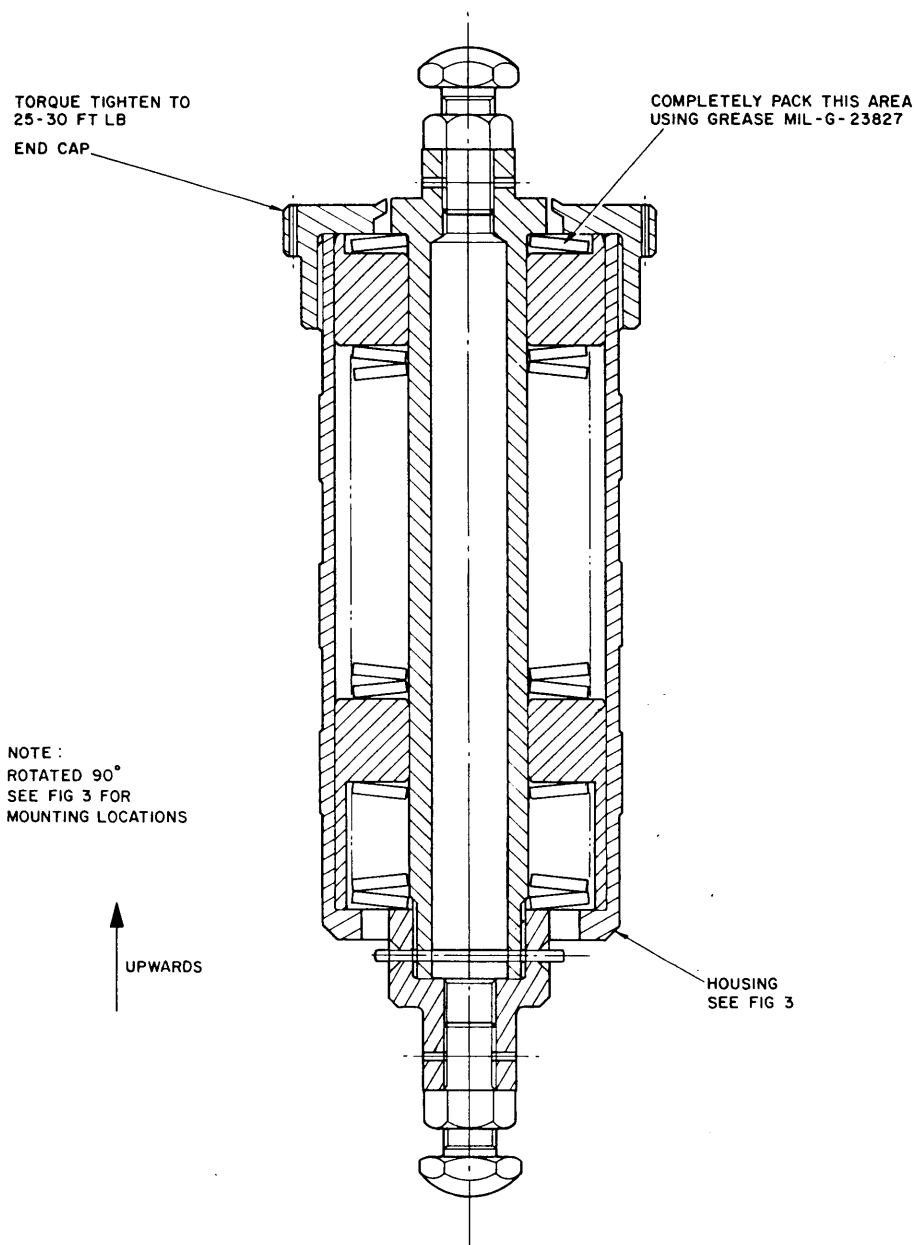
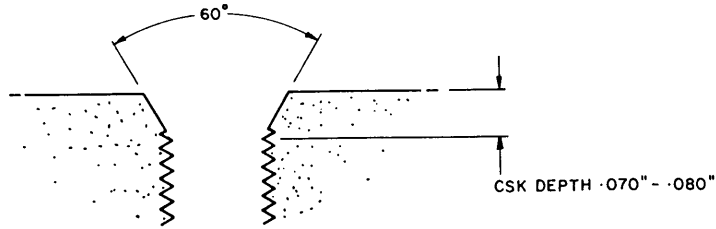


Figure 2 Assembled Gust Damper

# Nomad SERVICE BULLETIN

12 60-218-1



DETAIL A

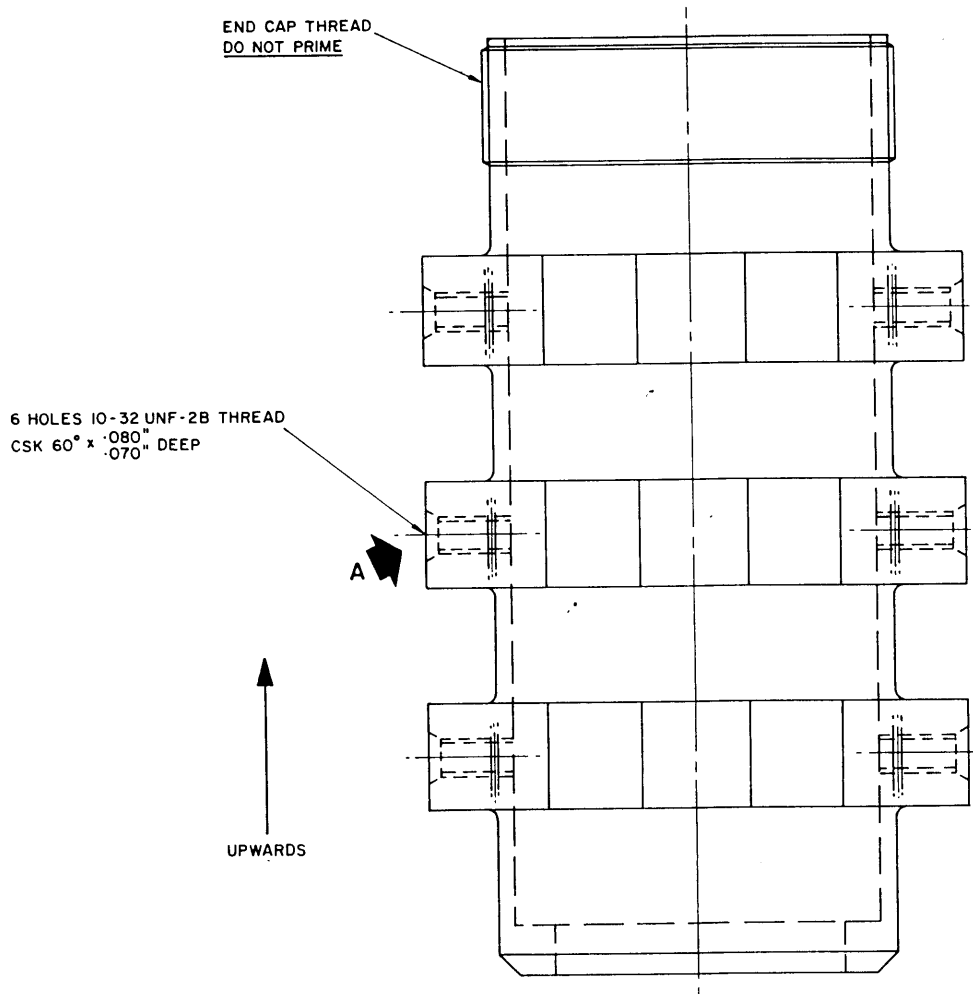
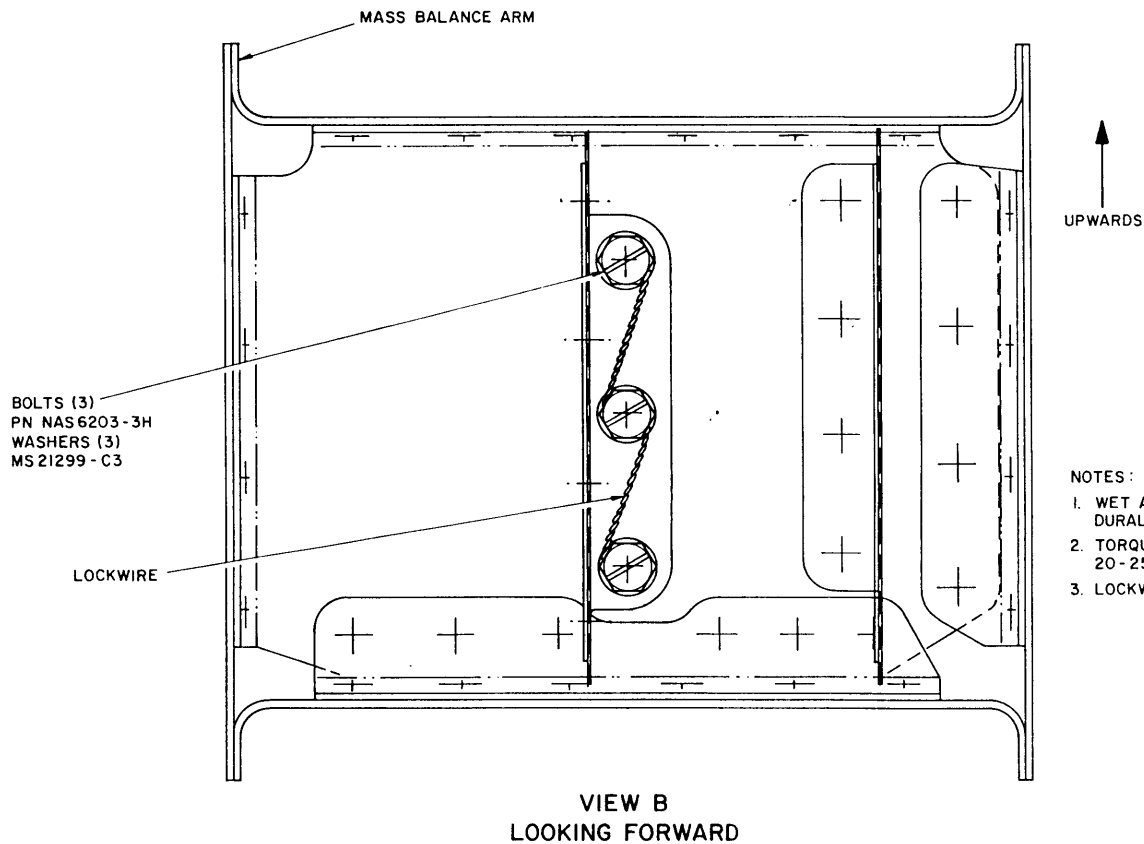
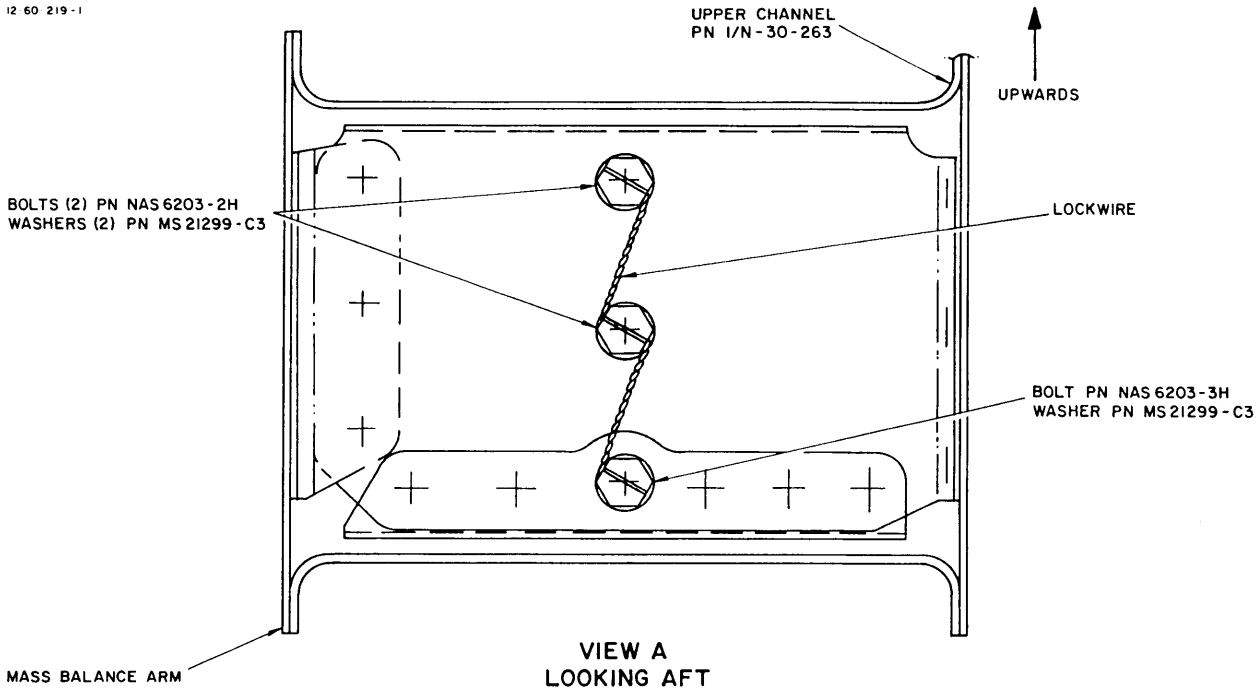


Figure 3 Gust Damper Housing PN 1/N-30-271

# Nomad SERVICE BULLETIN

12 60 219-1



- NOTES:
1. WET ASSEMBLE USING DURALAC DTD 369B.
  2. TORQUE TIGHTEN TO 20-25 LB IN.
  3. LOCKWIRE.

Figure 4 Gust Damper Mounting