

INSTALLATION INSTRUCTIONS

1. Refer to the appropriate service manual and remove the left and right stabilator from the aircraft. Also remove the access panel from the right side of the aft fuselage.

NOTE

Before proceeding with installation of kit, inspect each stabilator torque tube bearing fitting for relative movement as described in Service Bulletin No. 411. If relative movement is not present at any of the four fittings, do not attempt to remove the hi-shear rivets; remove the hi-shear rivets only from a fitting where relative movement is present.

2. Using the following steps, make a skin cutout on the left and/or right side of the aft fuselage bottom skin to gain access to the hi-shear rivets.

a. Locate and mark the skin cutout(s) using the dimensions on Sketch "A".

b. Refer to Sketch "A" and drill out all existing rivets indicated with an "X".

c. Make cutout(s) in skin. Additional adjacent rivets maybe removed as required in order to cut out the skin.

3. Refer to Sketch "B". Position cover plate (P/N 28216-02) over cutout with top of plate underneath top skin .875 inches and rear of plate aligned with existing skin at station 258.75.

4. Drill .144 holes thru top of plate using existing rivet holes in the skin as a guide. Drill each hole to a depth of .30. Temporarily fasten plate in position.

5. Locate and drill balance of .144 holes thru bottom and rear of plate using existing rivet holes as a guide. Drill each hole to a depth of .30.

6. Locate and drill four new .144 holes at forward end of plate as shown on Sketch "B". Remove cover plate(s).

7. Using the following steps, remove the existing hi-shear rivets, as shown on Sketch "A", that attach the stabilator torque tube bearing fittings to the side stringers. See Caution note below.

a. Carefully drill or chisel off the collar of the hi-shear rivet (center punch collar before drilling).

b. Tap out rivet from fitting using hammer and punch.

c. Enlarge hole in fitting and stringer to $.136 + .002$. If holes exceed .138 diameter, new part must be installed.
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d. Install AN21-15A clevis bolt, two AN960-6 washers and AN363-640 nut as shown on Sketch "B". Torque nut dry to a desired torque of 8-10 inch lbs. See "TORQUE NOTE" on Page 2 to determine final torque.

CAUTION

Remove only one rivet at a time, enlarge hole and install clevis bolt, washers and nut.