

SERVICE BULLETIN



FUJI HEAVY INDUSTRIES LTD.

HEAD OFFICE ; SUBARU BLDG.
SHINJUKU, TOKYO, JAPAN

JCAB APPROVED

NO. 200-003 DATE November 7, 1981 (SUPERSEDES NO. 200-003)
REV. B DATE September 18, 1991 (SUPERSEDES NO. 200-003A)
REASON To change priority, modification requirement, etc.

1. SUBJECT	: Inspection and Modification of F.STA 7105 Bulkhead and Replacement of Bracket.
2. AIRCRAFT AFFECTED	: All FA-200 aircraft
3. PRIORITY	: Mandatory
4. REASON	: (1) There have been instances reported whereby cracks have been found in the upper corners of F.STA 7105 bulkhead web and doubler. As a result of investigation, it has been determined that inspection and modification are required. (2) Since there have been instances reported whereby cracks have been found in the both left and right corners of the bracket added per SB No. 200-003, replacement of the bracket is required.
5. DESCRIPTION	: (1) Aircraft, prior to S/N 297, which have not had bulkhead modification per SB No. 200-003 accomplished. (a) Inspect bulkhead web and doubler for cracks per para 6-(1) of this bulletin. Irrespective of crack occurrence, modify bulkhead per para 6-(1) or this bulletin. (b) If inspection reveals a crack exceeding 15 mm (0.59 inch) in length, contact Fuji Heavy Industries, Ltd. (2) For aircraft, prior to S/N 297, which have had SB No. 200-003 accomplished, and aircraft S/N 297 and sub, replace bracket per para 6-(2) or (3) of this bulletin.

"B"

"B"

"B"



AIRCRAFT DIVISION

1-11 YOUNAN 1 CHOME. UTSUNOMIYA TOCHIGI JAPAN 〒320
TEL 0286 (59) 4833 TELEX 3522 176

SERVICE BULLETIN 200-003B

PAGE 1 OF 8

6. ACCOMPLISHMENT : (1) Aircraft, prior to S/N 297, which have not had bulkhead modification per SB No. 200-003 accomplished.

(a) At the next 100 hours inspection, after receipt of this bulletin, accomplish inspection per para 12 (1) and modification per para 12 (2).

"B"

(2) At the next 100 hours inspection, after receipt of this bulletin, accomplish modification per para 12-(2) on aircraft classified in the following (a) or (b):

(a) Aircraft, prior to S/N 297, which have had bulkhead modification per SB No. 200-003 accomplished and which have had more than total 2,100 flight hours after modification.

(b) Aircraft S/N 297 and sub which have had more than total 2,100 flight hours.

(3) At the first 100 hours inspection after having reached 2,100 hours, accomplish modification per para 12-(2) on aircraft classified in the following (a) or (b):

"B"

(a) Aircraft, prior to S/N 297, which have had bulkhead modification per SB No. 200-003 accomplished, and which have less than total 2,100 flight hours.

(b) Aircraft S/N 297 and sub which have had less than 2,100 flight hours.

7. APPROVAL : JCAB Approval (No-Tokyo-3-002) September 6, 1991

"B"

8. PARTS REQUIRED : The following parts will be required to comply with this bulletin.

"B"

No.	P/N	NAME	QTY		REMARKS
			*A	**B	
1	MS20995-C32 or MS21256-2	SAFETY WIRE or CLIP	4	-	If bulkhead web cracked
2	MS24665-134	PIN	11	11	
3	NAS679A06W	NUT	3	3	
4	MS20995-C32 or MS21256-1	SAFETY WIRE or CLIP	4	4	
5	NAS679A4W	NUT	15	15	
6	NAS679A5W	NUT	2	2	
7	203-440050-137	BRACKET	1	1	
8	MS20470AD4 or NAS1738B4-2	RIVET	12	12	
9	NAS1738B5-4	RIVET	2	-	Prior to S/N 202
10	MIL-P-8585 or EQUIVALENT	ZINC CHROMATE PRIMER	AR	AR	YELLOW

NOTES :

- *A is applicable to aircraft, prior to S/N 297, which have not had bulkhead modification per SB No. 200-003 accomplished.
- **B is applicable to aircraft, prior to S/N 297, which have had bulkhead modification per SB No. 200-003 accomplished. Also applicable to aircraft S/N 297 and sub.

- 9. SPECIAL TOOL : None required.
- 10. WEIGHT AND BALANCE: Negligible.
- 11. REFERENCE : Not applicable.
- 12. DETAILED INSTRUCTION

(1) Inspection of F.STA 7105 (Reference figure 2):

- (a) Remove vertical fin fairing.
- (b) Remove access cover from left hand side of aft fuselage.

- (c) Inspect F.STA 7105 bulkhead web for cracks. (see figure 2 for crack suspected areas.) It is recommended that a small inspection mirror be used through the rudder cable thru hole (as shown in figure 1) for this inspection.
- (d) Inspect aft side (doubler) of the above bulkhead for cracks. Use a suitable mirror through access hole in the upper tail cone web.

(2) Modification of F.STA 7105 Bulkhead (Reference figures 2 and 3):

NOTE

The following steps (a) through (c) are applicable only when crack(s) are found in bulkhead web for aircraft, prior to S/N 297, which have not had bulkhead modification per SB No. 200-003 accomplished.

- (a) Remove baggage room floor panel.
- (b) Remove aft fuselage partition panel.
- (c) Disconnect elevator control cable at baggage room turnbuckle.
- (d) Remove rudder per para 8-4-1 of the FA-200 service manual.
- (e) Remove elevator per para 8-5-1 of service manual.
- (f) Remove vertical stabilizer per para 7-13-1 of service manual.
- (g) Remove horizontal stabilizer per para 7-14-1 of service manual.
- (h) For aircraft prior to S/N 202, remove elevator horn fitting stop and modify as shown in figure 4.
(Applicable only to aircraft, prior to S/N 202, which have not had bulkhead modification per SB No. 200-003 accomplished.)
- (hA) See figure 3. Cut out fuselage skin, and add chamfer on fittings for horizontal stabilizer rear spar as shown in detail C.
(Finish chamfered surface smoothly.)
- (i) Install bracket, P/N 203-440050-137, on tail cone upper web between horizontal stabilizer rear spar fittings as shown in figure 3. Trim upper ends of fuselage skin as required.

NOTES

- (1) For aircraft with bracket installed, remove the existing bracket and install new bracket P/N 203-440050-137.
- (2) Locally fabricate bracket P/N 203-440050-137 in accordance with figure 5.

- (iA) If bracket, P/N 203-440050-137, interferes with vertical stabilizer fairing, trim fairing to match cutout in fuselage skin.
- (iB) Apply zinc chromate primer to bare metal surfaces on reworked parts.
- (j) If crack(s) have been found in F.STA 7105 bulkhead web and doubler, drill #40 stop hole at end of each crack.
- (k) Install horizontal stabilizer per para 7-14-1 of service manual.
- (l) Install vertical stabilizer per para 7-13-1 of service manual.
- (m) Install elevator per para 8-5-2 of service manual.
Connect elevator control cable (if disconnected) at baggage room, and rig elevator system per para 8-5-3 of service manual.
- (n) Install rudder per para 8-4-2 of service manual, and rig rudder system per para 8-4-3.
- (o) Install aft fuselage partition panel (if removed).
- (p) Install baggage room floor panel (if removed).

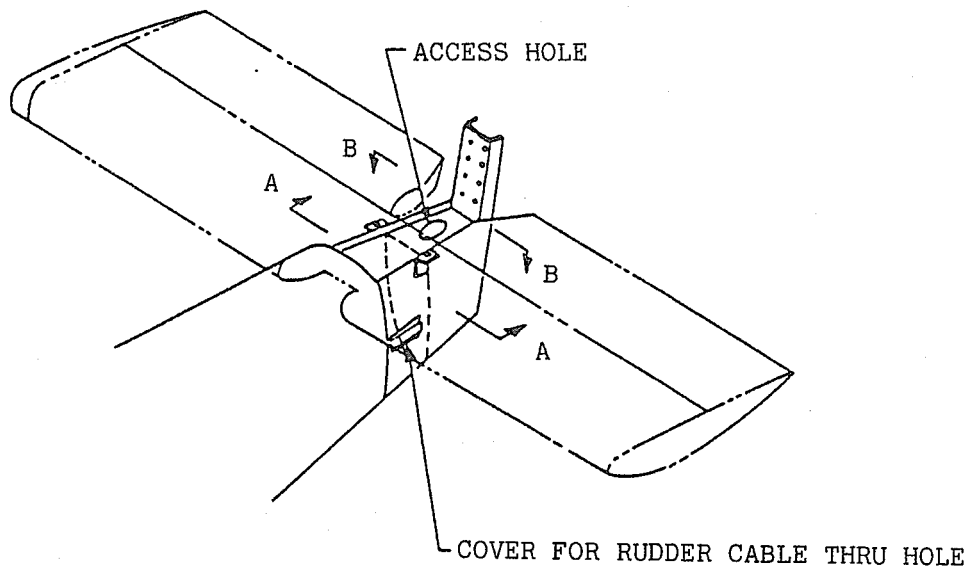


FIGURE 1. LOCATION OF F.STA 7105

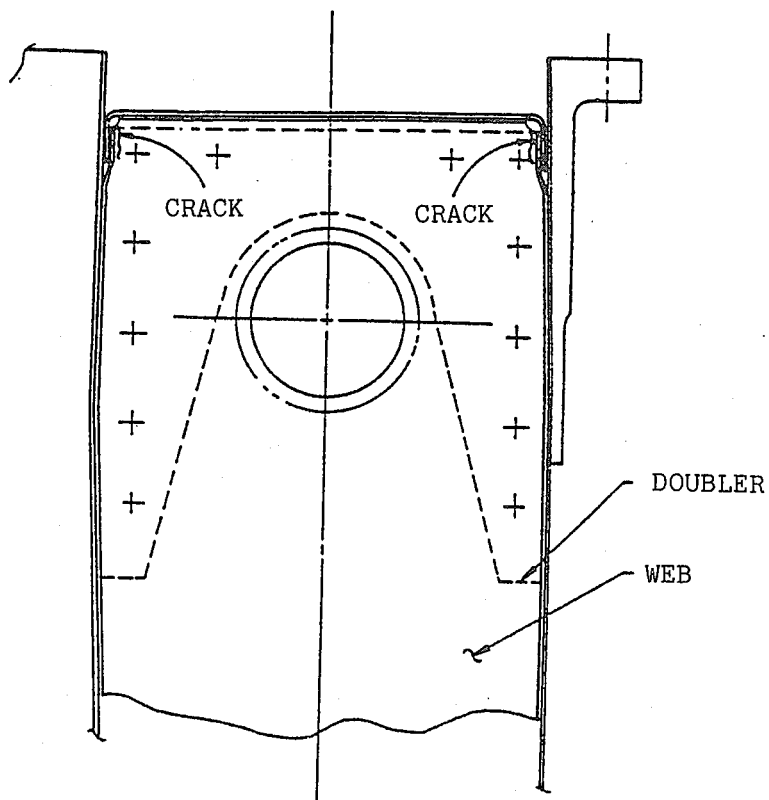


FIGURE 2. (VIEW A-A) F.STA 7105 BULKHEAD

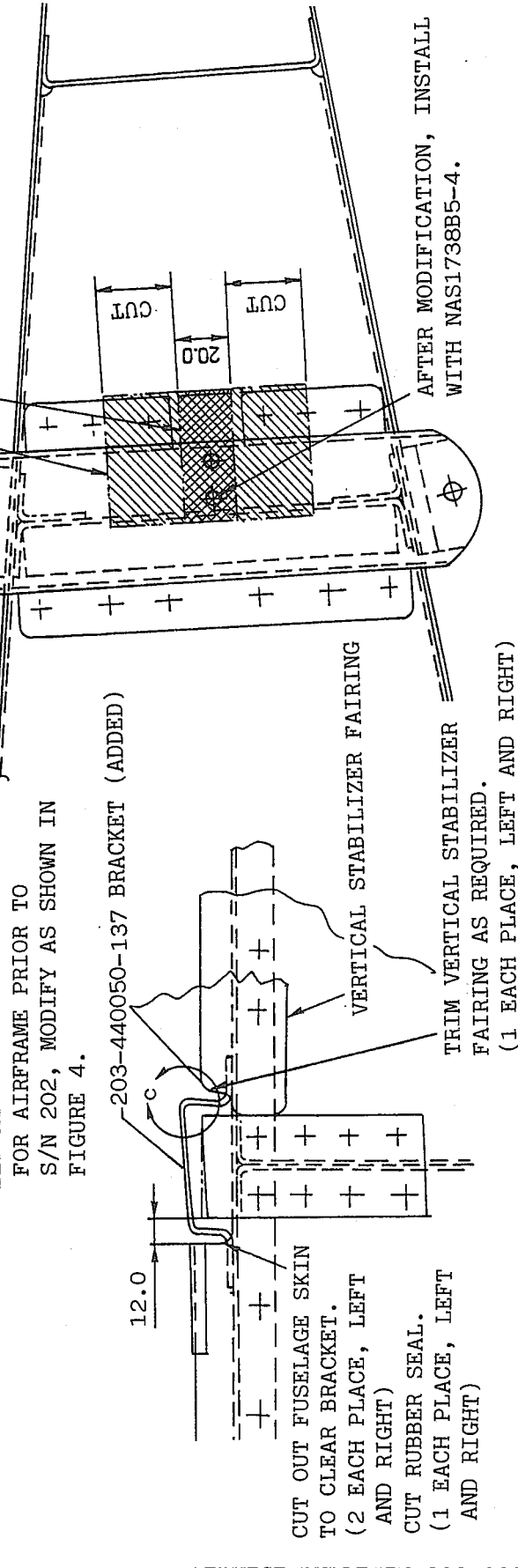
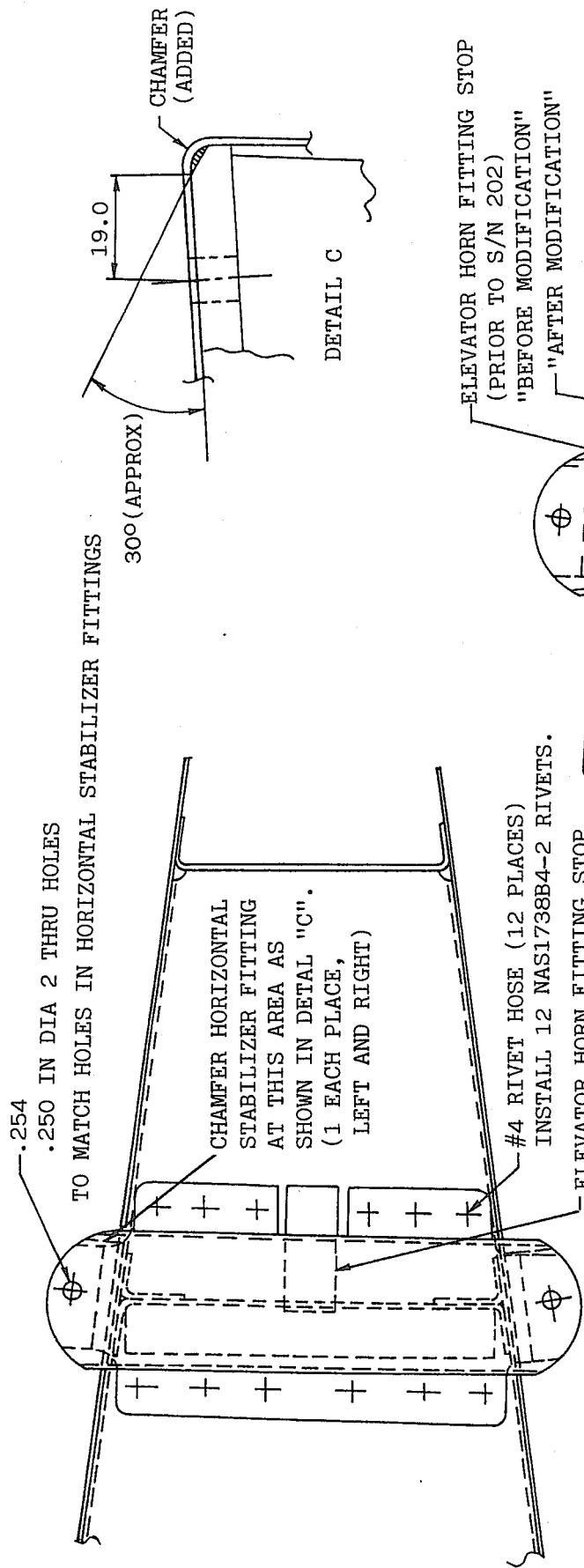


FIGURE 3. (VIEW B-B) DETAILS FOR MODIFICATION
FIGURE 4. DETAILS FOR STOP MODIFICATION

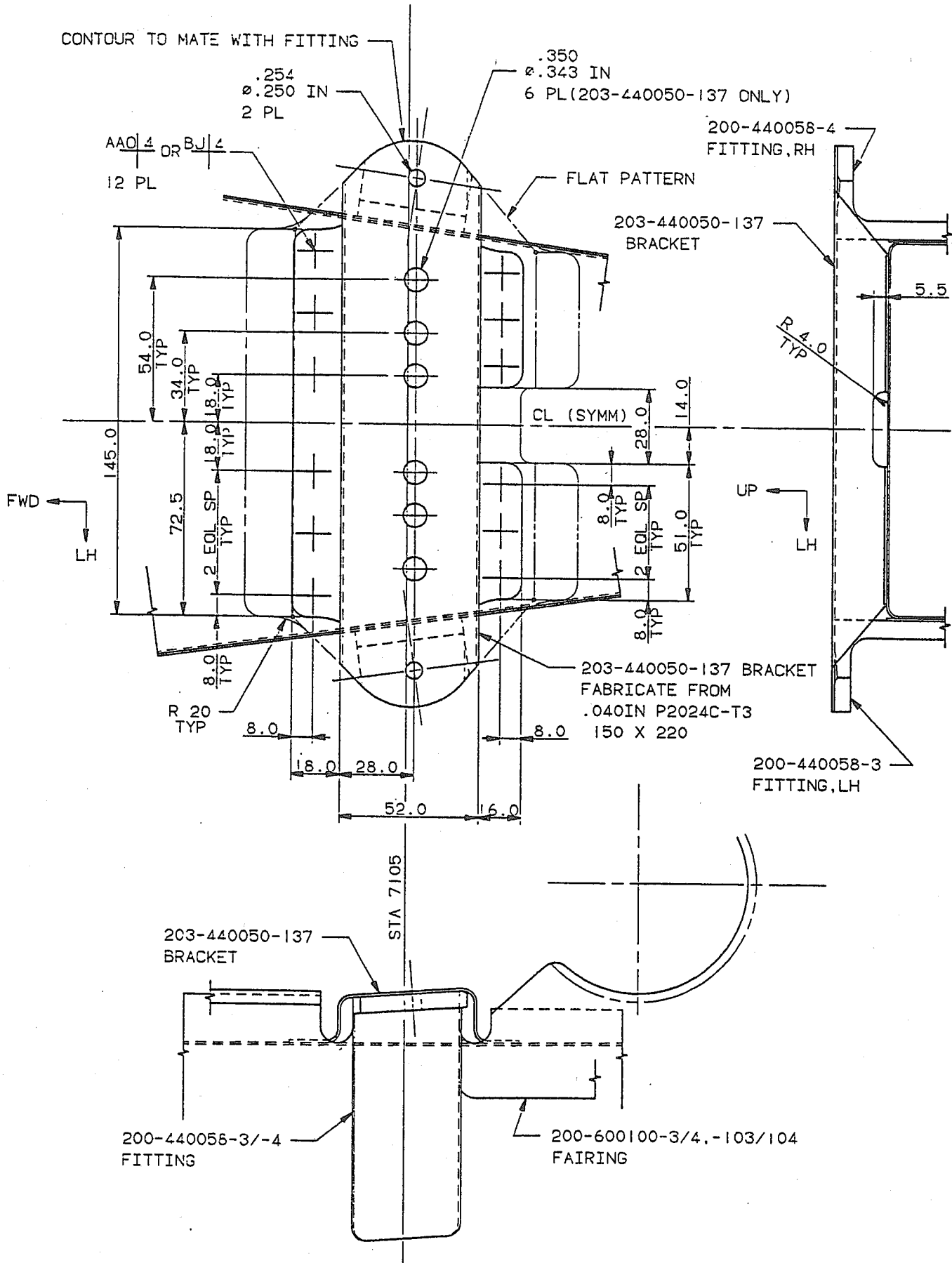


FIGURE 5 DETAIL FOR
203-440050-137 BRACKET