

SERVICE BULLETIN



FUJI HEAVY INDUSTRIES LTD.

JCAB APPROVED

HEAD OFFICE ; SUBARU BLDG.
SHINJUKU, TOKYO, JAPAN

NO. 200-010 DATE March 6, 1992 (SUPERSEDES NO.)
REV. DATE (SUPERSEDES NO.)
REASON

1. SUBJECT : HORIZONTAL STABILIZER FORWARD SPAR WEB, INSPECTION AND REPAIR OF
2. AIRCRAFT AFFECTED : All FA-200 series aircraft prior to S/N 12.
3. PRIORITY : Mandatory
4. REASON : Since there has been an instance reported whereby cracks occurred on the horizontal stabilizer forward spar web (center area), inspection and (if necessary) repair are required for the affected area.
5. DESCRIPTION : Visually inspect the horizontal stabilizer forward spar web for cracks. If inspection reveals crack(s), add both repair doubler and reinforcement doubler. If no cracks are found, install reinforcement doubler only.
6. ACCOMPLISHMENT : Immediately upon receipt of this bulletin.
7. APPROVAL : JCAB approval (No. Tokyo-3-010) February 17, 1992
8. PARTS REQUIRED : The following parts are required to comply with this bulletin:

No.	PART NUMBER	NOMENCLATURE	QTY	REMARKS
1	AN380-2-2	PIN, COTTER	14	
2	2024C-T3 .032inT	1 SHEET, 125x240		If crack found
3	2024C-T3 .032inT	2 SHEETS, 70x 45		If crack found
4	2024C-T3 .063inT	1 SHEET, 70x225		
5	MS20426AD4	RIVET	21	
6	MS20470AD4	RIVET	35	42 ea ... If crack found
7	MS20426AD3	RIVET	4	If crack found
8	MS20470AD5	RIVET	4	
9	MS20470AD3	RIVET	10	
10	NAS680A08K	NUT PLATE	2	If crack found

9. SPECIAL TOOL : None required.
10. WEIGHT AND BALLANCE: Negligible.

適用
04.3.20
第2課

AIRCRAFT DIVISION

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11. REFERENCE : None

12. DETAILED INSTRUCTIONS :

- (1) Remove horizontal stabilizer in accordance with Service Manual, para 7-6.
- (2) Visually inspect the center area of horizontal stabilizer forward spar web for cracks, paying particular attention to the circled A area as shown in the figure 1.
- (3) If no cracks are found, modify the forward spar as follows (see figure 2):
 - (a) Remove lower center skin located between forward and afterward spars.
 - (b) Remove two existing doublers from the aft surface of horizontal stabilizer forward spar (center area).
 - (c) Install new doubler in place of the doublers removed in the above step.
 - (d) Reinstall lower center skin.
- (4) If crack(s) are found, modify the forward spar as follows (see figure 3):
 - (a) Remove lower center skin located between forward and afterward spars.
 - (b) Stop drill each end of crack.
 - (c) Remove two existing doublers (forward) and two existing doublers (aft) from horizontal stabilizer forward spar (center area).
 - (d) In place of the removed doublers, install new doubler on aft surface of the spar. Also install new channel and doublers on forward surface of the spar.
 - (e) Reinstall lower center skin.
- (5) Install horizontal stabilizer in accordance with Service Manual, para 7-7.

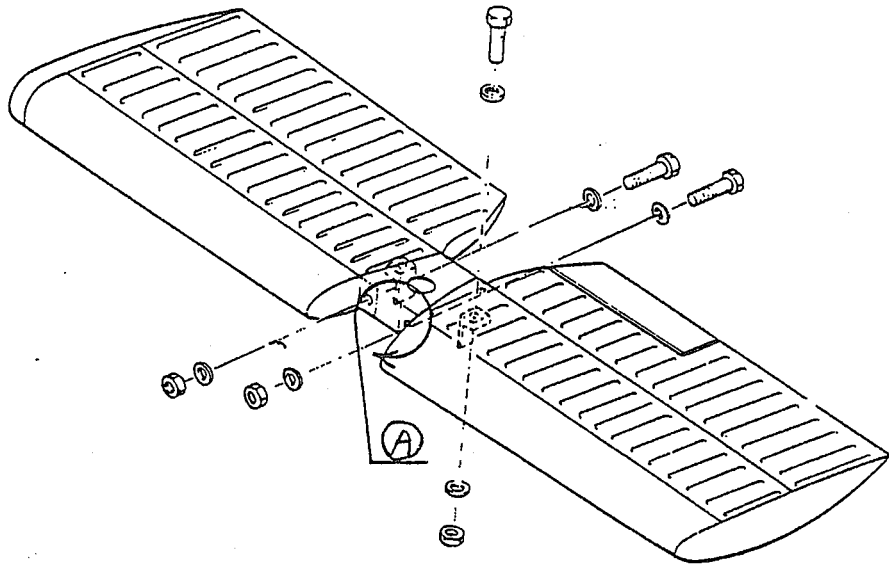
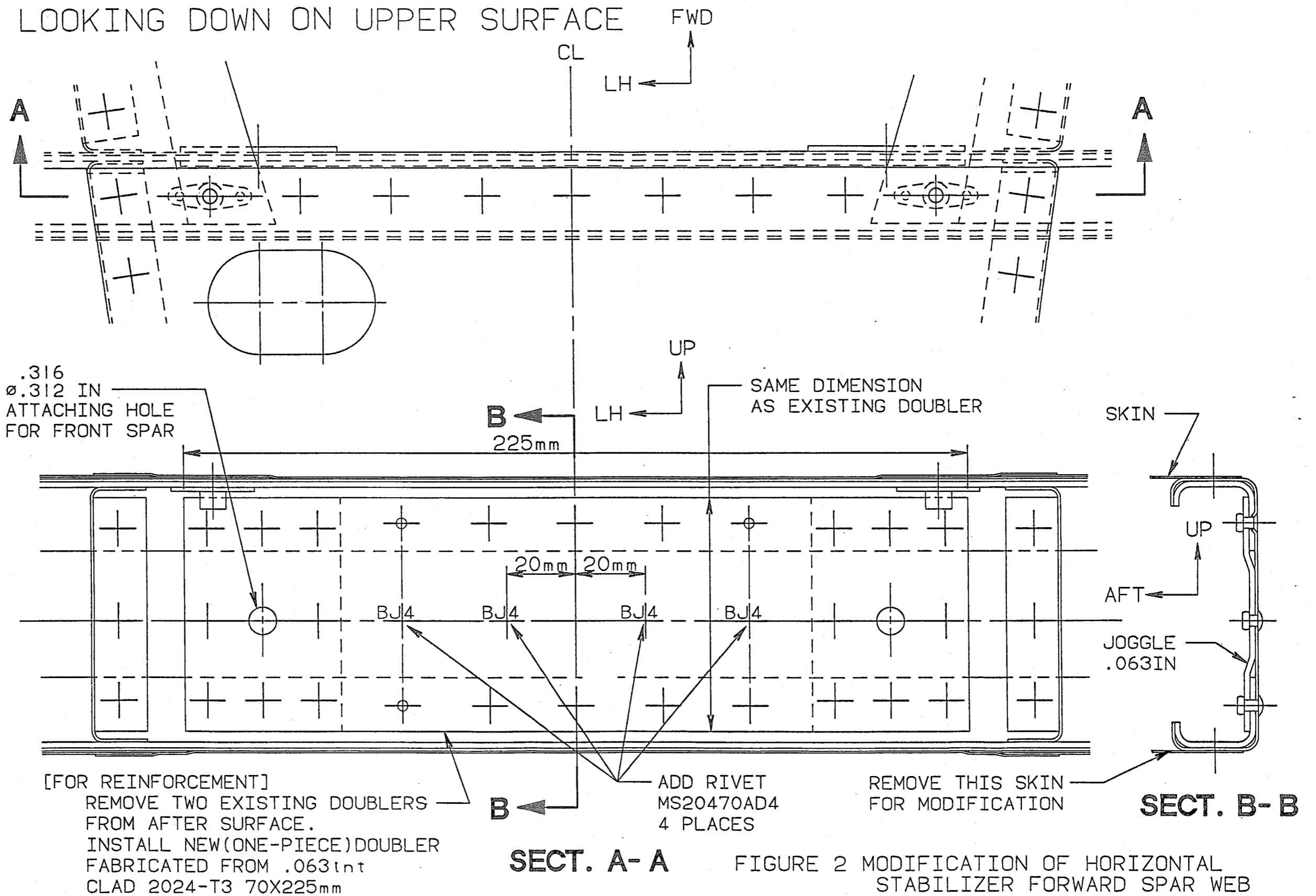


FIGURE 1

LOOKING DOWN ON UPPER SURFACE



SECTION A-A

FIGURE 2 MODIFICATION OF HORIZONTAL STABILIZER FORWARD SPAR WEB (IF NO CRACK FOUND)

LOOKING DOWN ON UPPER SURFACE

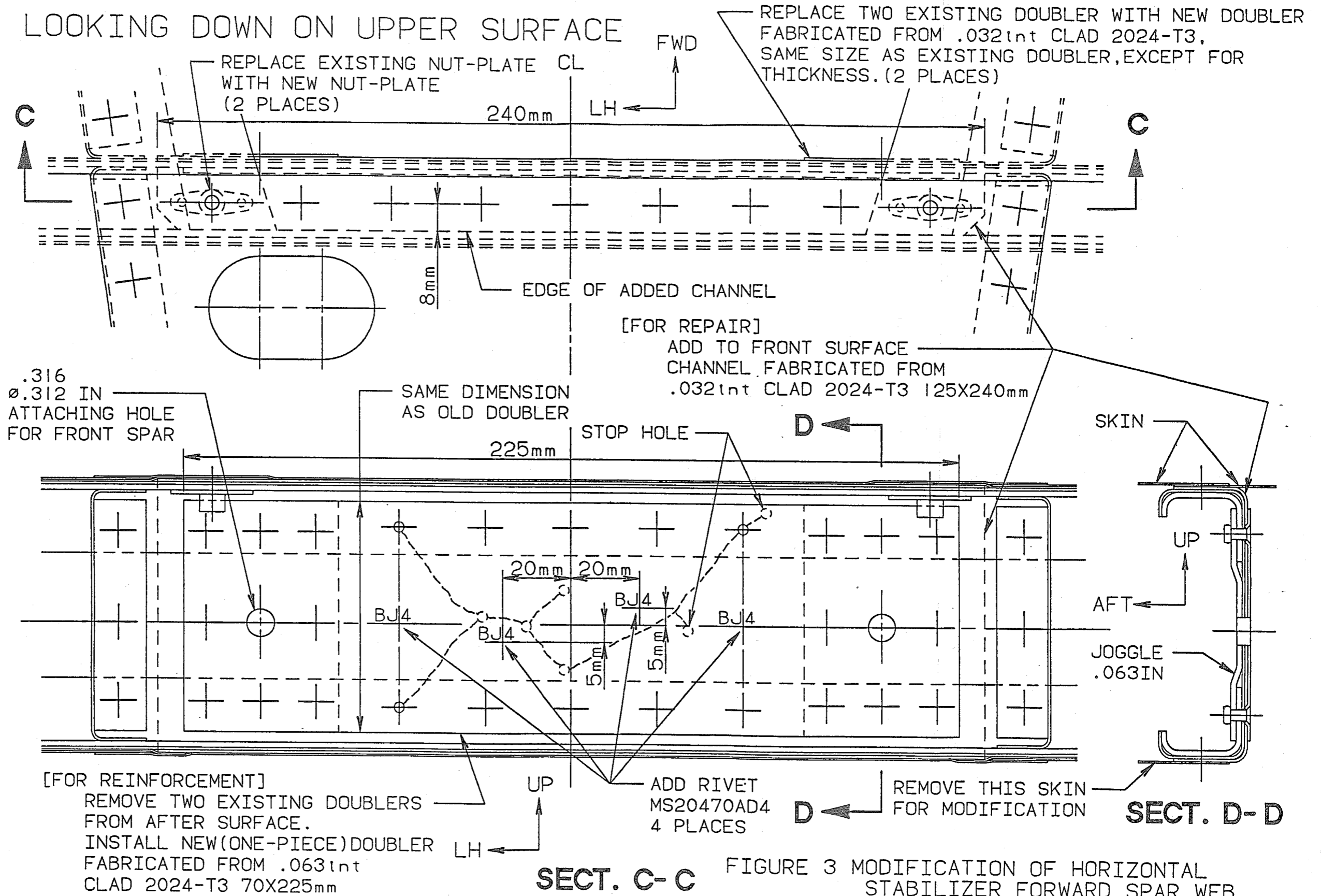


FIGURE 3 MODIFICATION OF HORIZONTAL STABILIZER FORWARD SPAR WEB (IF CRACK FOUND)