

# TECHNICAL BULLETIN



FUJI HEAVY INDUSTRIES LTD.

HEAD OFFICE : SUBARU BLDG.  
SHINJUKU, TOKYO, JAPAN

JCAB APPROVED

NO. 200-018                      DATE 62-2-26                      (SUPERSEDES NO.                      )  
REV.                                      DATE                                      (SUPERSEDES NO.                      )  
REASON

1. SUBJECT : Main Wing Front and Rear Auxiliary Spar and Fuselage Joint Fitting Bolt Holes, Repair Scheme for
2. AIRCRAFT AFFECTED : FA-200 S/N 12 and subsequent
3. PRIORITY : Desirable
4. REASON : To provide standard repair scheme for worn holes in the subject fittings.
5. DESCRIPTION : Increase bolt hole size from 3/8 in to 7/16 in, and replace existing bolt with next larger oversize bolt. If worn area is not completely removed by enlarging holes to next oversize, contact FHI Commercial Service Section for additional instructions.
6. ACCOMPLISHMENT : Any time inspection indicates wear in the bolt holes.
7. APPROVAL : JCAB approval (No-Tokyo-61-021) December 26, 1986
8. PARTS REQUIRED : The following parts are required to accomplish this bulletin:

No.	P/N	Nomenclature	* Quantity
1	NAS1307-15D	Bolt	1
2	AN310-7	Nut	1
3	AN960D716L	Washer	1
4	AN960D716	Washer	1
5	MS24665-285	Pin	1

\* Note: Indicates quantity required per one place.

9. SPECIAL TOOL : Drilling Tool 200-018T
10. WEIGHT & BALANCE : Negligible
11. REFERENCE : Not applicable
12. ACCOMPLISHMENT INSTRUCTIONS:
  - (1) Raise aircraft by jacks in accordance with FA-200 Service Manual, Paragraph 2-2, or place aircraft on a suitable support stand.
  - (2) Remove wing root cover.
  - (3) Remove bolt from main wing auxiliary spar fitting whose hole is worn.

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Notes: 1. If both front and rear fitting holes are worn, remove standard bolt and replace with new oversize bolt in one attachment joint at a time.

2. If holes are not in alignment, adjust wing by suitable stand to bring them in alignment.

- (4) Install 27/64 in drilling bushing (item 4, Figure 1) into drilling tool (1). Install drilling tool (1) on wing fuselage joint fitting (fuselage side) by tightening set screws (3). Insert step pin (2) into drilling tool (1) to check for alignment.
- (5) Assure drilling tool (1) is properly positioned and installed.

#### CAUTION

Extreme caution should be exercised to ensure relative relation between wing and fuselage is not disturbed in the following steps.

- (6) Remove step pin (2) from drilling tool (1). Drill 27/64 in holes through fittings.
  - (7) Replace 27/64 in drilling bushing with .4370 in reaming bushing (5).
  - (8) Ream inside dia. of fittings to .4370-.4380 inch dia.
  - (9) Remove drilling tool (1) from the fitting.
  - (10) Inspect inside dia. of holes to ensure that worn area is completely removed.
  - (11) Apply zinc chromate primer to inside dia. of holes. Install next larger oversize bolt.
  - (12) If the opposite side fitting hole is worn, repeat the above steps (3) through (11).
  - (13) Reinstall wing root cover.
  - (14) Lower airplane by removing jacks or stand.
13. COMPLIANCE RECORD : After repair has been completed, make entries in aircraft log book.

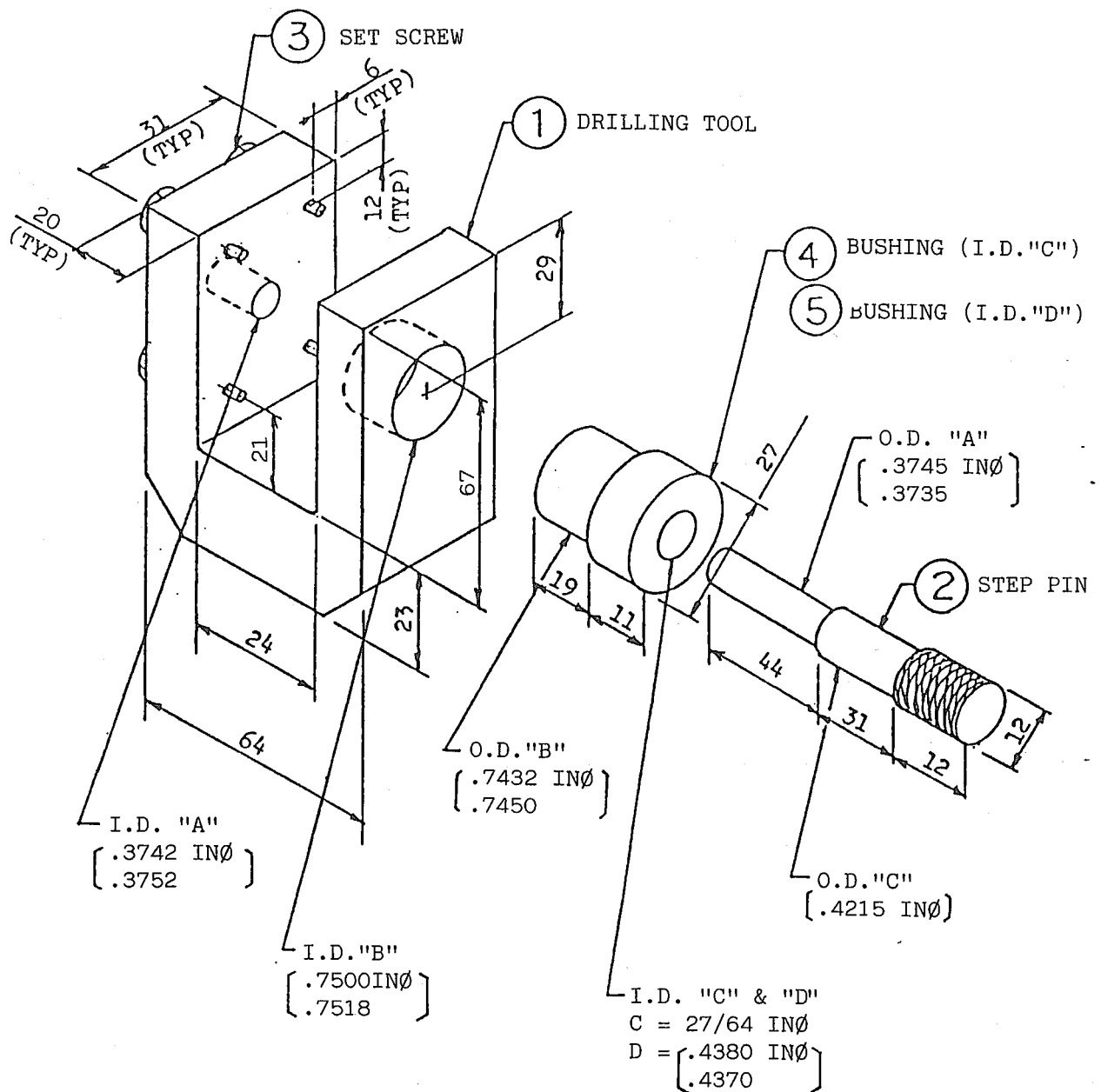


FIGURE 1. DRILLING TOOL (200-018T)