Comp. Limited Kunovice

Aero Company Limited Prague Czechslovakia

MANDATORY BULLETIN No. L33/001a

Effectivity: L33 gliders S. No. 930101,930102,930103.

Reason: The crack in the border of fuselage - vertical stabilizer connection has occurred during the operation.

Description: Chief-designer´s measure:
Install new frame 7a into the rear part of the fuselage in the area of fuselage-vertical stabilizer connection.

To be accomplished not later than: Immediately after obtaining this bulletin and materials.

To by accomplished by: Authorized repair company or service station.

Cost covered by: LET Comp. Limited Kunovice.

Material availability: LET Comp. Limited Kunovice.

Validity: As soon as delivered to the operator.

Manhours:

Ing. Fridrich
Manufacturer

Pokorák
Customer's Representative

Ing. Příhoda
State Aviation Inspection

A. THE FUSELAGE - VERTICAL STABILIZER CONNECTION REPAIR TECHNIQUE

1. Dismantle wings, horizontal tail units, rudder, canopy, main landing gear cover.

2. Set the fuselage into the turned over position according to pict. 1.

3. Disconnect and pul out the elevator control pull - rod backward.

4. Make a hole for the cover according to pict. 2.

5. Make the hole in the monocoque of the fuselage according to view 6 on drawing No. G 010 100 N sheet 6 (note: It´s better to start the hole - making with the smaller diameter and step by step increase the hole to reach the right diameter. Clean off the edges).

6. Set in the frame 7a pos. 49 according to G 010 100 N sheet 5 pict. 3.

7. Set the angle - frames pos. 47, 48 together with the frame 7a and the vertical stabilizer skin (mutual adaptation = > checking set).

8. After setting of the frame 7a pos. 49 + angle - frames pos. 47, 48 into the checking set take out the angle - frames pos. 47, 48. Drill together the frame 7a with the skin of the fuselage, take out the frame 7a, press in the holes in the skin and in the frame 7a except the area under the vertical stabilizer.

9. Set again and fix the frame 7a pos. 49.

10. Rivet the frame 7a circumferently - pict. 4. Rivet the round head rivets in the area of the vertical stabilizer.

11. Drill out the rivet from the both sides from the vertical stabilizer - pict. 5.

12. Set the angle - frames pos. 47, 48 on the frame 7a pos. 49 so that it could be drilled together with the hole of drilled out rivet. Pict. 6.

13. Drill together the whole angle - frame with the frame 7a.

14. Take out the angle - frame.

15. Set in the tin pad 0,8 mm thick under the angle - frame L 1 (pict. 7) in the area of the bigger cut on the frame 7a and rivet it.

16. Rivet the angle - frames pos. 47, 48.

17. Set, drill together and rivet on the frame of the cover.

18. Suck the metal dust and waste.

19. Clean off and paint the edges of cutted and filed tin plates.

20. Screw in the cover.

21. Connect the control pull-rod, fit the rudder.

22. Screw in the main landing gear cover.

B. MATERIAL NECESSARY FOR ARRANGEMENT

1.	Stiffener	G 010 469 L P	1x
2.	Frame 7a	G 010 470 N	1x
3.	Frame	G 010 472 N	1x
4.	Cover	G 010 471 N	1x
5.	Rivet	5 DuZp 3 x 7 P	4x
6.	Rivet	5 DuZp 2,6 x 6 P	8x
7.	Rivet	5 DuZp 3 x 8 P	2x
8.	Rivet	5 DuK 3 x 6 P	22x
9.	Riveted nut	M4 ONL 3243	6x
10.	Rivet	5 DuZz 2,6 x 6 P	4x
11.	Rivet	5 DuZz 2,6 x 7 P	8x
12.	Rivet	5 DuZp 3 x 8 P	6x
13.	Screw	M4 x 14 ONL 3147	6x
14.	Angle - frame	L 1	1x
15.	Angle - frame	L 2	1x

C. PICTURE PART

pict. No. 1 - Setting of the fuselage into the turned over position.

2 - Making of the cover hole.

3 - Setting of the frame No. 7a.

4 - Riveting of the frame 7a (front view).

5 - Drilling out of the vertical stabilizer rivet.

6 - Setting of the angle - frame on the frame 7a.

7 - Putting of the pad between the border of the frame 7a and the skin.

D. APPENDIX DOCUMENTATION

Drawings G 010 100 N sheet 5
G 010 100 N sheet 6

E. NECESSARY TOOLS

F. SPARE PARTS DURING THE OPERATION

No influence.

G. WEIGHT OF THE AIRCRAFT

No influence.

H. THE ENTRY INTO THE AIRFRAME NOTE BOOK AFTER COMING INTO BEING OF THE BULLETIN INSTRUCTION.

"The setting of the frame 7a according to bulletin L 33/001a has been performed".

date:

.....

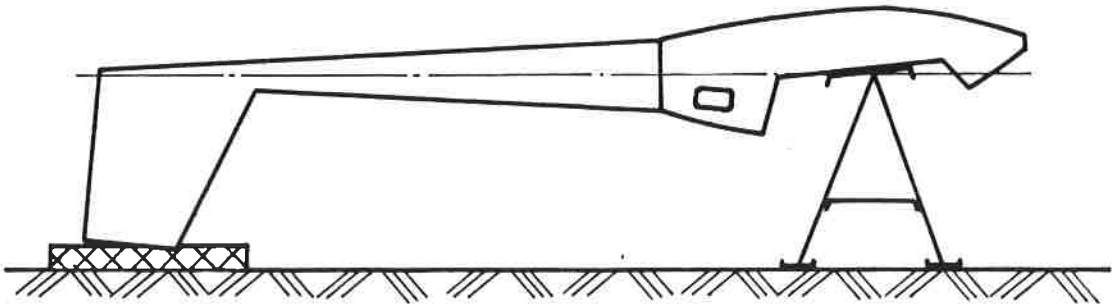
performed by:

.....
/legible signature/

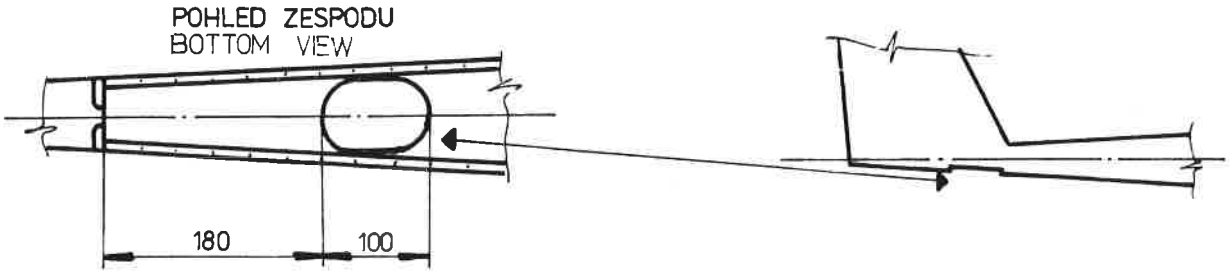
L33/001a	Vypracoval: Ing. Konečný	Kontroloval:	Schválil:	List: 4 Listů: 7

OBRAZOVÁ ČÁST
ILLUSTRATIONS

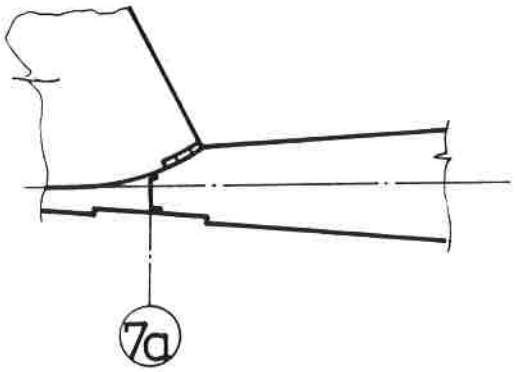
obr. 1
FIG. 1



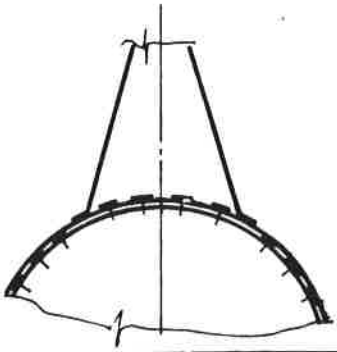
obr. 2



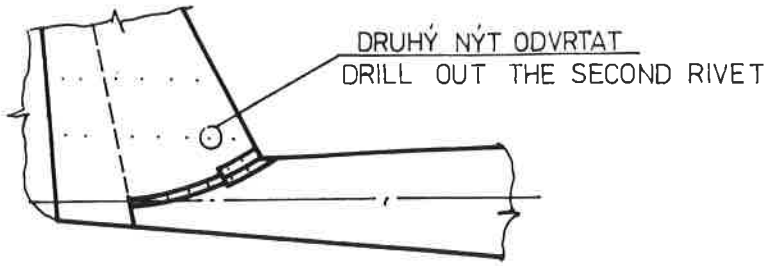
obr. 3



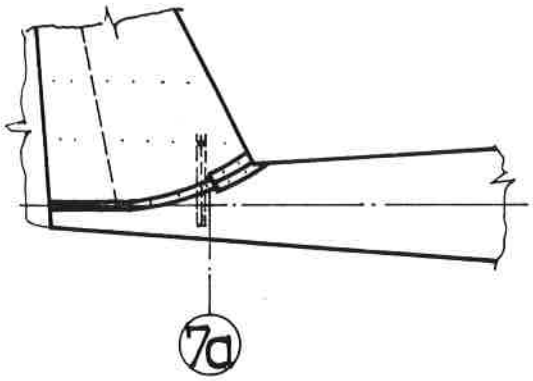
obr. 4



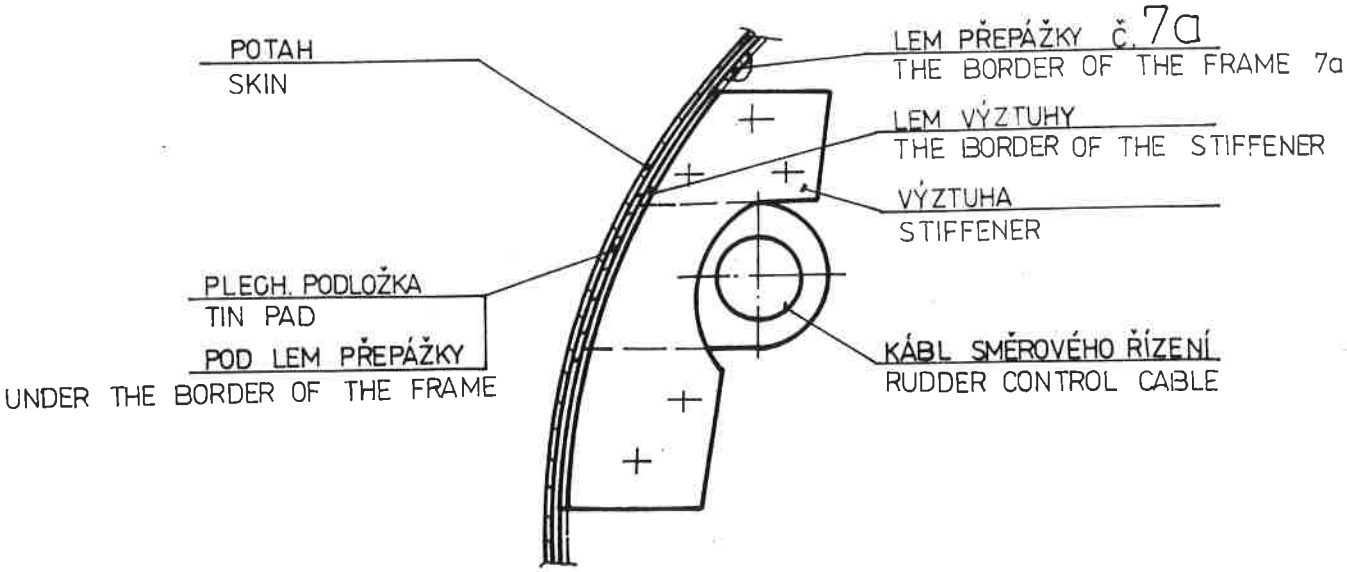
obr. 5



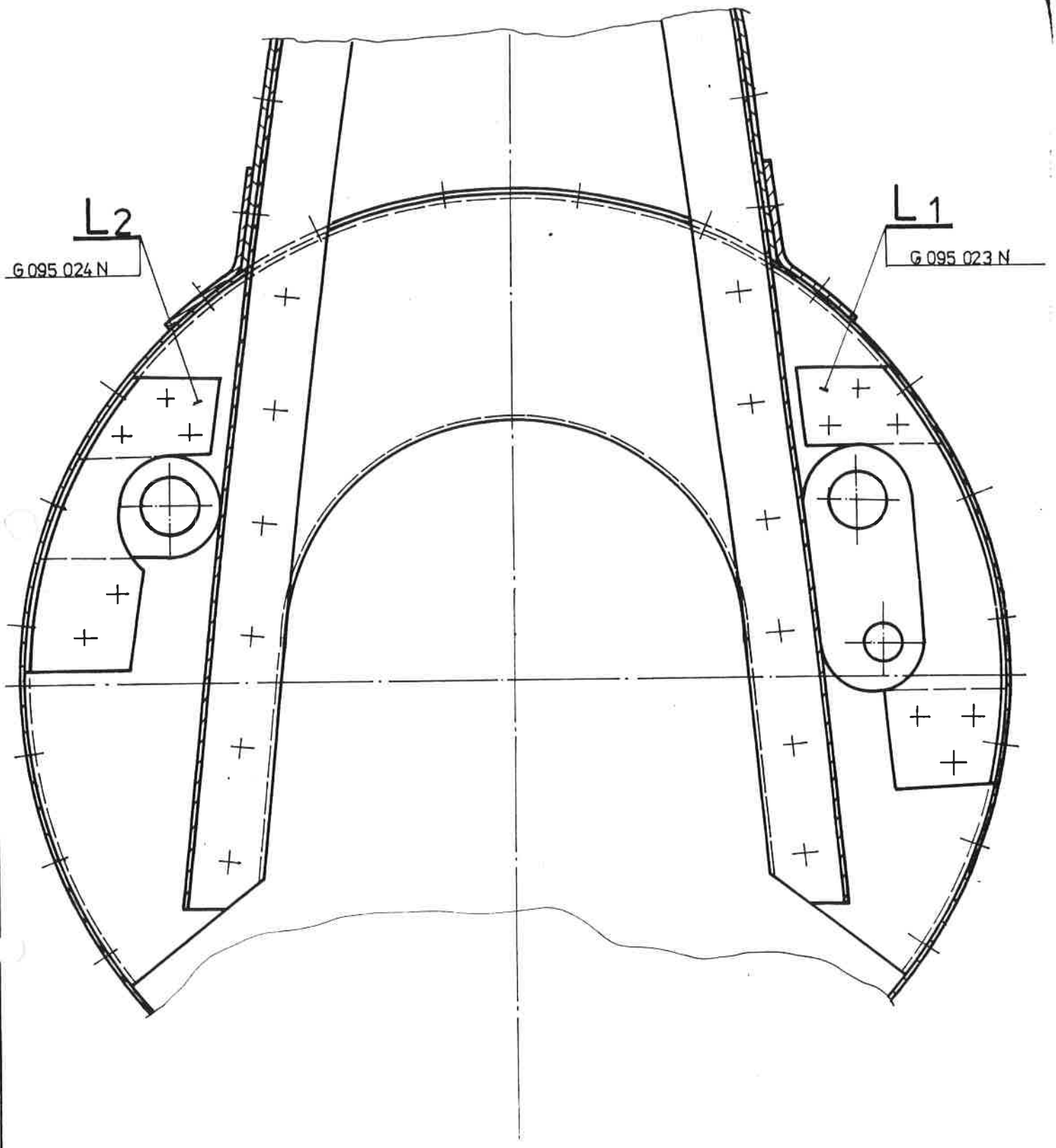
obr. 6



obr. 7



L33/001a	VYPRACOVAL Karáskova	KONTROLOVAL	SCHVÁLIL	LIST: 6 LISTŮ: 7



DOPLNĚK KE KONSTRUKČNÍMU VÝKRESU G010100 N.

THE APPENDIX TO THE DRAWING G 010100N

L 33/001a	VYPRACOVAL Karásková	KONTROLOVAL	SCHVÁLIL	LIST: 7 LISTŮ: 7