

MANDATORY BULLETIN

MB No. L13/083a

Concerning: L13AC glider S/N 988601

Reason: Reinforcement of fuselage rear part and fin according to
The type documentation

To be accomplished not later than: Immediately after receiving of bulletin

To be accomplished by: Authorized service center

Cost covered by: LET, a.s. Kunovice, Czech Republic

Material availability: LET, a.s. Kunovice, Czech Republic

Validity: On the day of receiving

Manhours: 43

Sheets: 11

Pešák

Manufacturer

Engineering data contained in this Bulletin is CAI Approved.

Date: July 19, 1999

A. WORK PROCEDURE

1. Dismantling – see pic. 1

- 1.1. Carry out the dismantling of the rudder pos. 1.
- 1.2. Tilt down the rear cover.
- 1.3. Dismantle LH and RH elevator pos. 2.
- 1.4. Disconnect the elevator control pull-rod.
- 1.5. Carefully drill off the tubular rivets jointing the dorsal fin pos. 4 with fin pos. 3 and the fuselage
- 1.6. Remove the covering tape between the fin and the fuselage.
- 1.7. Drill off the stiffeners pos. 5, 6 jointing the fin with the fuselage skin and the stiffeners pos. 23 on the frame No. 13.
- 1.8. Drill off the rivets jointing the main spar of the fin with the fuselage on the frame No. 14.
- 1.9. Drill off from the fin the rivets jointing the LH and RH rib No. 1 (pos.7 – pic. 1) with the fin skin.
- 1.10. Dismantle the fin.
- 1.11. Drill off the rivets jointing the rib No. 1 of the fin with fuselage.
- 1.12. Drill off the rivets jointing the RH side of the skin with the frame No. 14 and 15 and the rivets jointing both halves of the skin on the upper part of the fuselage.
- 1.13. Drill off the rivets in the comb in lower part of the fuselage (joint of skins + tape) between the frame No. 14 and 15.
- 1.14. Dismantle RH side of the skin pos. 8
- 1.15. Dismantle the lid pos. 20 near the frame No. 14 on LH side of the fuselage.
- 1.16. Drill off the flange of the lid pos. 21.

2. Installation – see pic. 2, 3, 4, 5; Dwg. No. A590 015N

Fin modification

- 2.1. Set a new (shorter) rib No. 1 (LH + RH) of Dwg. No. A510 405L,R pos. 7 in the comb in the fuselage – see pic. 4, detail II, and rivet on the ribs in the original holes.
- 2.2. Set and rivet on the stiffening ribs pos. 17, 18 according to the dimensions in Detail II, pic. 4 in the fin.

Fuselage modification

- 2.3. Set the stiffener pos. 16 according to pic.5, section A-A and rivet on with 6 rivets of 5Duk2,6x5P to the frame No. 13.
- 2.4. Carry out the cut-offs according to pic. 5 in the fuselage skin and in the stiffener pos. 16.
- 2.5. Set the hinge pos. 15 and rivet on to the frame No. 13 (section A-A).

- 2.6. Set a new framing pos. 9 according to the original hole of lid on LH side of the fuselage between the frame No. 13 and 14 and rivet on according to Dwg.No. A590 015N.
- 2.7. Carry out the cut-off for the longeron in the frame No. 14 on RH fuselage side according to Dwg. No. A590 015N, view S.
- 2.8. Set the stiffener pos. 14 and the longeron pos. 11 on the RH fuselage side and rivet on the fuselage skin between the frame No. 13 and 14.

Modification of the rear part of the fuselage between the frame No. 14 – 15

- 2.9. Set the stiffeners pos. 12, 13 and the longeron pos. 10 according to Dwg. No. A590 on LH side of the fuselage between the frame No. 14 and 15 and rivet on the fuselage skin.
- 2.10. Set the stiffener pos. 13 on RH side of fuselage and rivet on the frame No. 15.

Reinstallation of the rear part of fuselage

- 2.11. Rivet on the RH half of the skin pos. 8 to the frames No. 14 and 15 and rivet together the skins in the upper part of the fuselage in the original holes.
- 2.12. Rivet together the comb in the lower part of the fuselage with the tape and hinge of the tail skid pos. 22.
- 2.13. Complete the longeron riveting pos. 11 on RH side of the fuselage in the skin and to the frame No. 15.
- 2.14. Rivet on the dorsal fin pos. 4 with the "CHERRY" tubular rivets in the original holes.
- 2.15. Complete the riveting of the hinge jointing the main spar of the fin with the frame No.14 according to the Dwg. No. A590 015N, view R.
- 2.16. Rivet on the hinge pos. 15 to the frame No. 13 according to pic. 3, view P.
- 2.17. Rivet on the stiffeners pos. 5 and 6 and the steel stiffener pos. 23 in the original holes according to the Dwg. No. A590 015N.
- 2.18. Reinstall the original lid pos. 20 on the glider.
- 2.19. Bond the shielding tape on the fin and coat with stretching lacquer.
- 2.20. Carry out the reinstallation of the new rudder (Dwg. No.A530 000N).
(The weight is placed in the leading part of the rudder).
- 2.21. Reinstall the elevators, the elevator control pull-rod and tiltable cover.

B. MATERIAL REQUIRED FOR MODIFICATION OF ONE GLIDER

Pos.	Unit	Qty	Name	Dwg. No. - standard	Note
1	pc	1	Rudder	A530 000N	
7	pc	1+1	Rib	A510 405L,R	
9	pc	1	Framing	A510 106N	
10	pc	1	Longeron LH	A510 107N	
11	pc	1	Longeron RH	A510 108N	
12	pc	1	Stiffener	A510 112N	
13	pc	2	Stiffener	A510 109N	
14	pc	1	Stiffener RH	A510 110N	
15	pc	1	Hinge	A510 104N	
16	pc	1	Stiffener	A510 014N	
17	pc	1	Rib	A510 404N	
18	pc	1	Rib	A510 406N	
701	pc	15	Rivet 2.6x5	ČSN 022302.5	3519 2605
702	pc	10	Rivet 2.6x6	ČSN 022302.5	3519 2606
703	pc	10	Rivet 2.6x7	ČSN 022302.5	3519 2607
704	pc	5	Rivet 3x6	ČSN 022302.5	3519 0306
705	pc	5	Rivet 3x7	ČSN 022302.5	3519 0307
706	pc	20	Rivet 3x9	ČSN 022302.5	3519 0309
707	pc	4	Rivet 4x9	ČSN 022302.5	3519 0409
708	pc	4	Rivet 4x10	ČSN 022302.5	3519 0410
709	pc	4	Rivet 4x12	ČSN 022302.5	3519 0412
710	pc	100	Rivet 2.6x5	ČSN 022320.5	3534 2605
711	pc	15	Rivet 2.6x6	ČSN 022320.5	3534 2606
712	pc	15	Rivet 2.6x7	ČSN 022320.5	3534 2607
713	pc	150	Rivet 3x5	ČSN 022320.5	3534 0305
714	pc	80	Rivet 3x6	ČSN 022320.5	3534 0306
715	pc	2	Rivet 4x10	ČSN 022320.5	3435 0410
716	pc	20	Rivet 3x6	ČSN 022304.5	3531 0306

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Pos.	Unit	Qty	Name	Dwg.No. - Standard	Note
717	pc	20	Rivet 3x7	ČSN 022304.5	3531 0307
718	pc	5	Rivet 3x8	ČSN 022304.5	3531 0308
719	pc	10	Rivet 3.5x6	ČSN 022304.5	3531 3506
720	pc	10	Rivet 3.5x7	ČSN 022304.5	3531 3507
721	pc	10	Rivet 3.5x8	ČSN 022304.5	3531 3508
722	pc	5	Rivet 3.5x12	ČSN 022304.5	3531 3512
723	pc	10	Rivet 3x8	LeN 3364	3540 5308
724	pc	50	Rivet	SHERRY	3554 9301
725	m	1.3	Tape cut	LeN 3496	8311 7125

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C. ILLUSTRATED PART

Pic. No. 1 to 5.

D. DOCUMENTATION REQUIRED

Dwg. No. A590 015N

E. TOOLS REQUIRED

The service center provides with own tools.

F. SPARE PARTS IN OPERATION

Not affected.

G. GLIDER MASS

The glider mass is increased by 0.4 kg.

H. RECORD IN LOGBOOK AFTER IMPLEMENTATION OF BULLETIN

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Reinforcement of fuselage rear part and fin carried out.

Date: ✎

Carried out by:

(legible signature of authorized engineer)

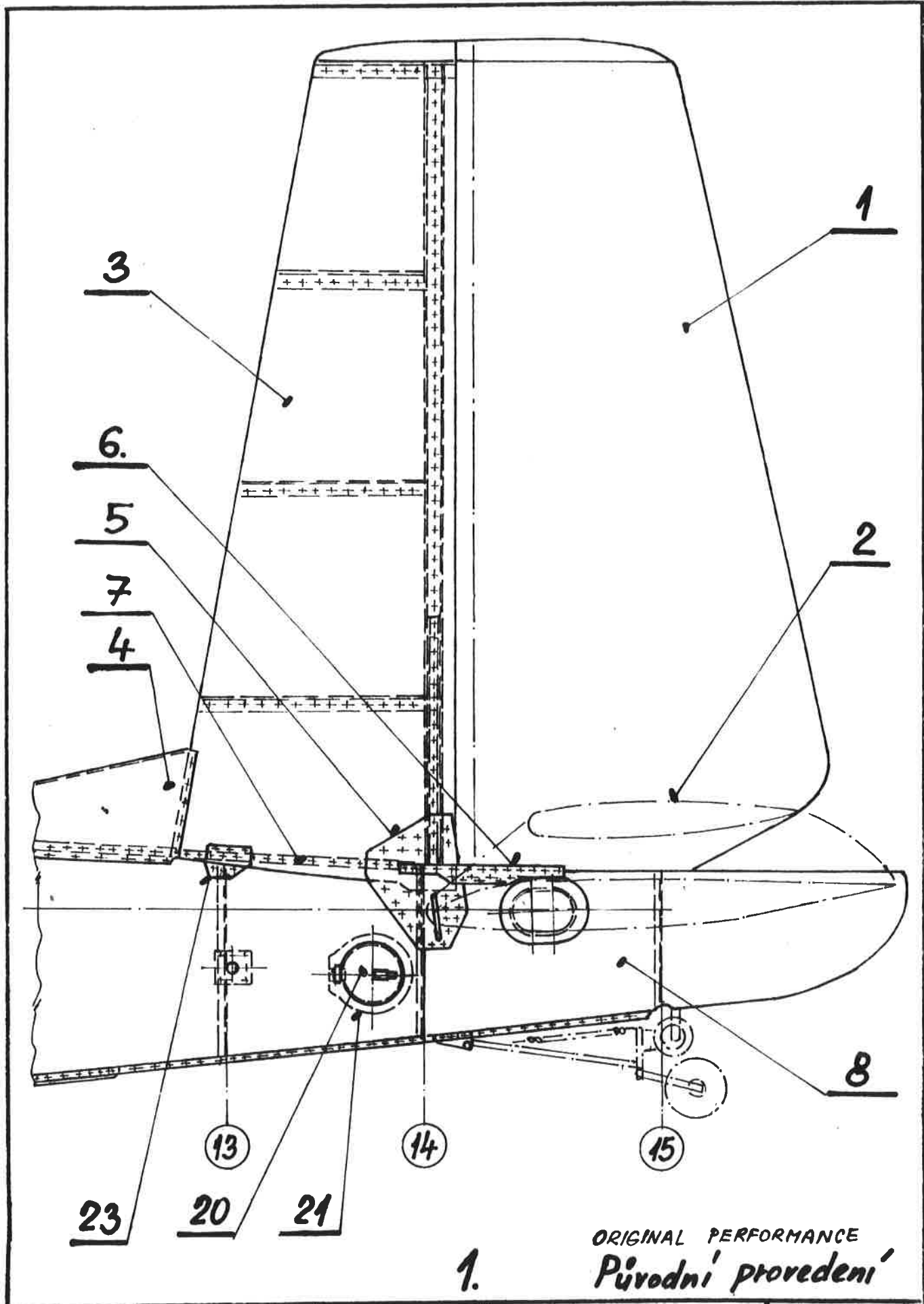
I. ACCOMPANYING DOCUMENTATION

Not affected.

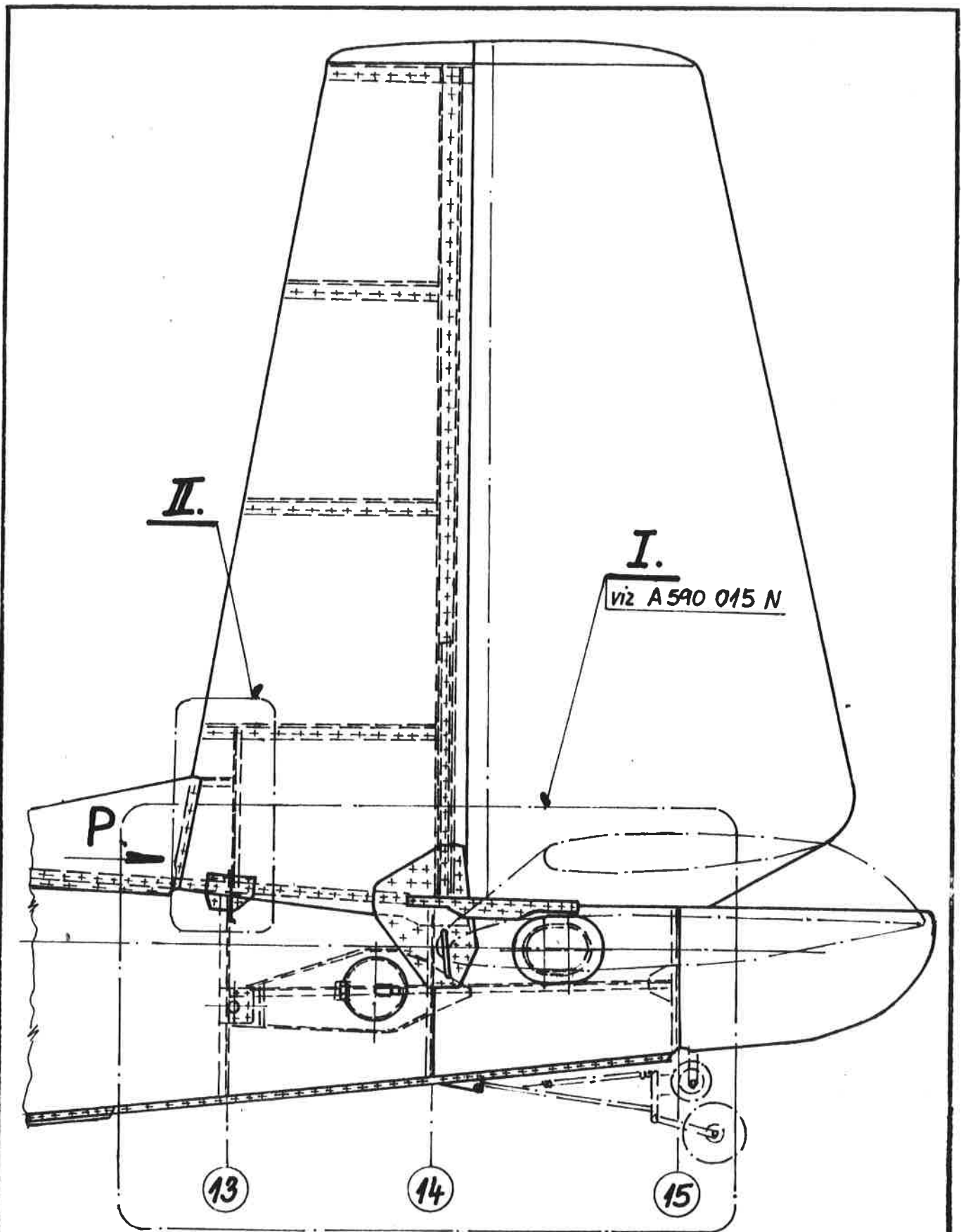
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L13/083a	Vypracoval <i>Štáka Štáka</i>	Kontroloval <i>Štáka</i>	Schválil <i>malet</i>	List: 7 Listů: 11
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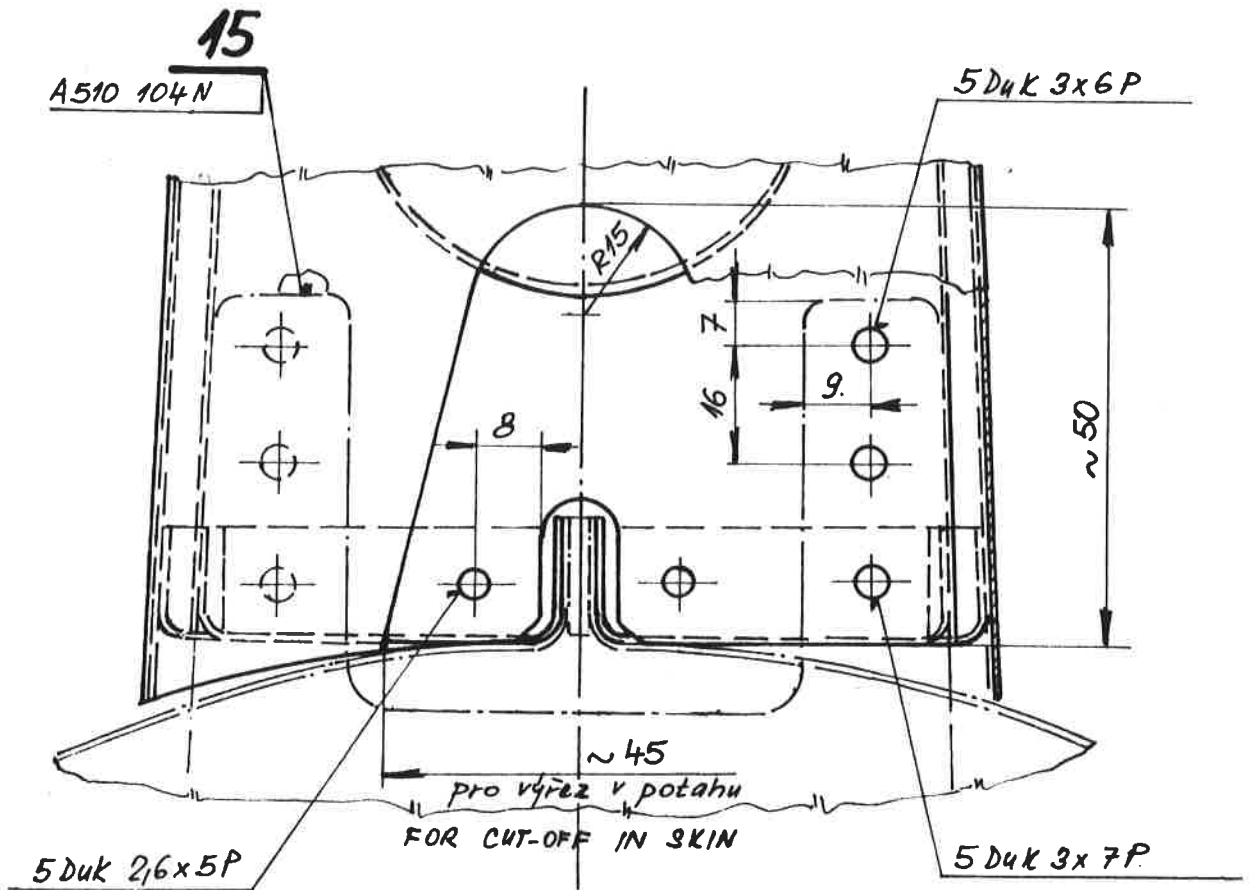


2.

NEW PERFORMANCE
Nové provedení

L13/083a	Vypracoval <i>Straka</i>	Kontroloval <i>Straka</i>	Schválil <i>Malin</i>	List: 8 Listů: 11
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P'
M:1



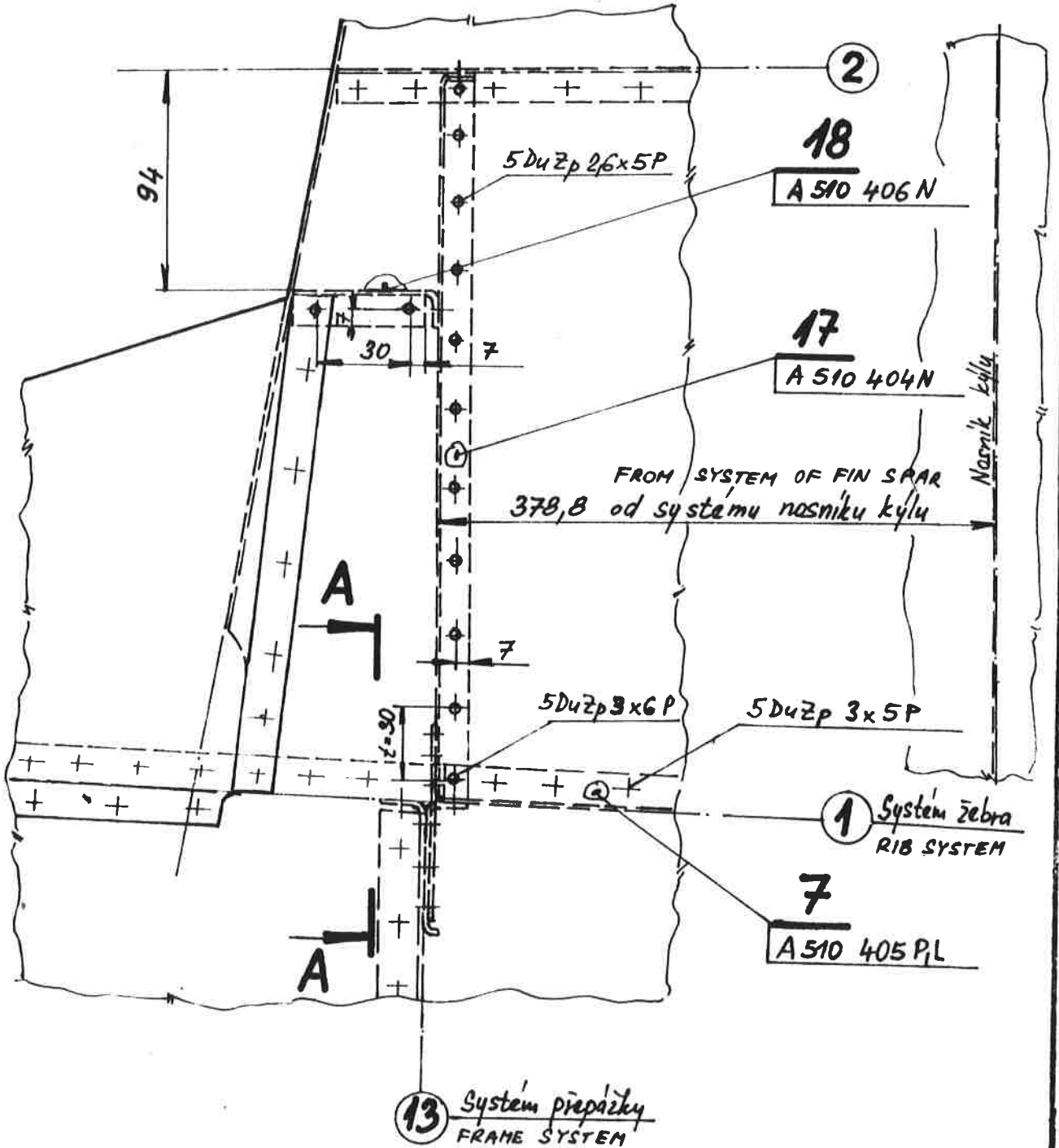
3.

L13/083a	Vypracoval <i>Straka</i>	Kontroloval <i>Fr.</i>	Schválil <i>Malin</i>	List: 9 Listo: 11
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Detail II.

DRAWN WITHOUT POS. 23
Kresleno bez poz. 23

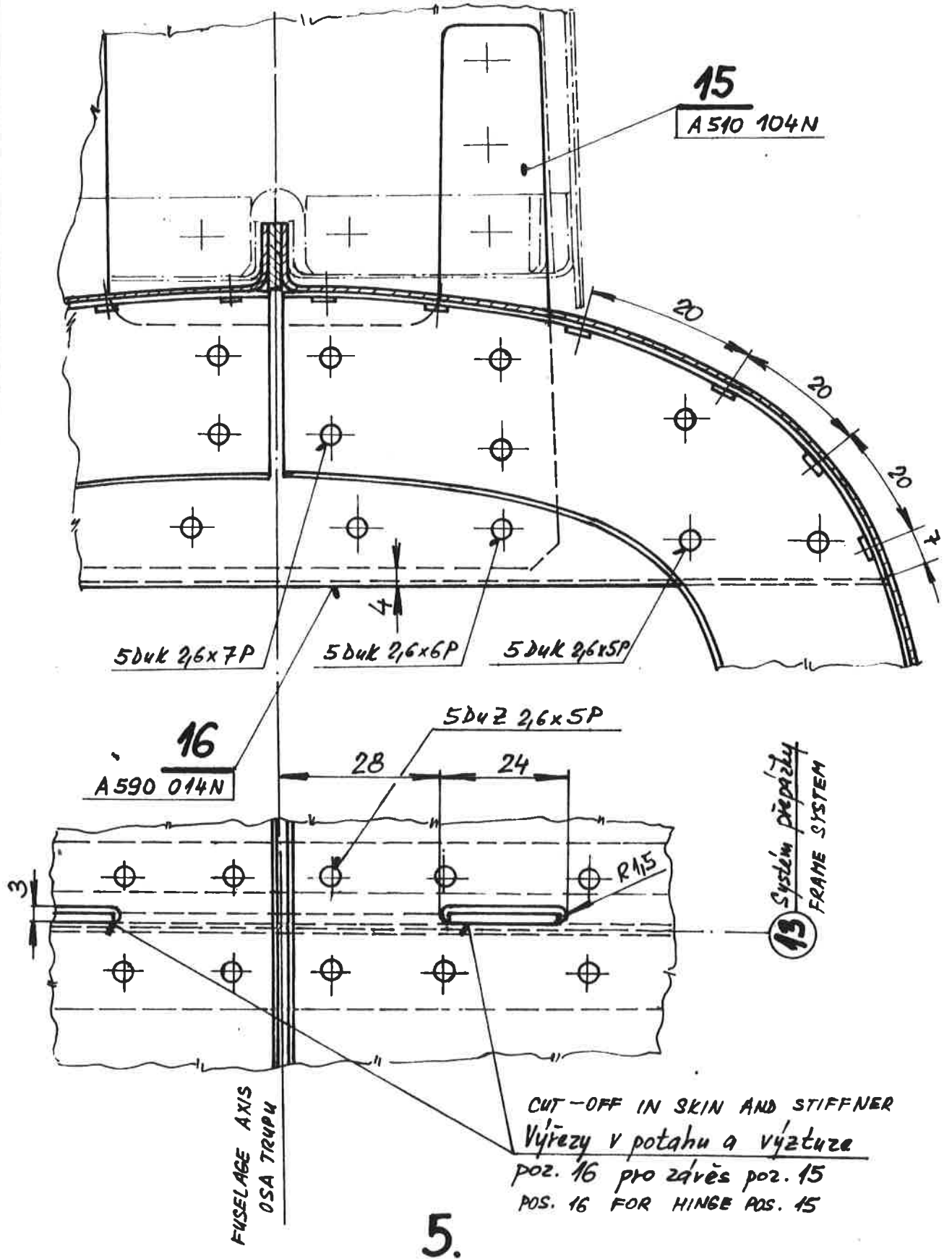
M2.5



4.

L13/083a	Vypracoval Straka	Kontroloval Straka	Schválil Maler	List: 10 Listů: 11
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SECTION A-A
Řez A-A
 M1:1



L13/083a	Vypracoval Straka Straka	Kontroloval [Signature]	Schválil [Signature]	List: 11 Listů: 11
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