

SERVICE BULLETIN No. L13/007

Sheet 1 of 5

Subject: Reinforcement of the L13 rear fuselage skin panel on aircraft 1st through 17 series.

Reason: Rear fuselage skin panel cracking may occur between the joint for stabilizer hinge and frame No. 14 due to material fatigue after a longer service period.
This failure has been removed by incorporation of the Service bulletin No. L13/004.

Description: Reinforcement of the cracked rear fuselage skin panel in accordance with this Bulletin on the L13 sailplanes 1 through 17 series a/c, if such a crack occurs. The modification to be incorporated at all 1st to 17th series a/c during general overhaul.

Compliance: The modification as per this bulletin to ^{be} incorporated immediately.

Material-Cost and Availability: Material will be supplied by manufacturer and costs incurred covered by manufacturer as well.

Material information and Accomplishment instructions: see sheets No. 2 and 3.

Enclosures: 2 sheets of illustration

The Bulletin is effective by the date of delivery.

Manufacturer's
representative
Ing. Černocký

Omnipol, FTC
Pavlovský

Customer's
representative
Ing. Boron

State Aviation
Inspection, Min.
of transport
Sklenička

Material information

No.	Qty	Description	Dwg.No.	Material	Size
1.	2	Reinforcing sheet		42 4253.6	Sh. 0.63 60x100
2.	1	Cover strip		see Standard	strip 60 DIN L 554; 1#1300
3.		Adhesive lacquer		C 1107	.05 kg
4.		Aluminium lacquer		3067-01	.05 kg
5.	2	Rivet, flush head	3.5x8 CSN 02 2320.5	see S tandard	
6.	10	Rivet, flush head	3x7 CSN 02 2320.5	"	
7.	8	Rivet, flush head	2.6x6 CSN 02 2320.5	"	

Accomplishment instructions

1. Disassembly of rudder to Fig. 2

Remove the rudder to facilitate riveting of both reinforcing sheet panels. Further remove the cover strip item (2), section B-B from the fin (Section B-B shown with reinforcing sheet panel incorporated).

2. Drilling of rudder rivets to Fig.1

Centre-punch and drill out 5 rivets in the top rivet row on the fin and fuselage to detail view A, using a drill of 2.6mm dia./except the rivet connecting the fin spar with skin panel, which is to be drilled out using a rivet dia. 3mm/.

3. Modification of the reinforcing sheet panel for attachment to Figs.1,2

Slightly lift the fin skin item (3) within the area of removed rivets from the bottom rib and fin spar. Into a space thus formed insert the reinforcing sheet panel of 60x100mm size that will project about 20mm and from into the contour of fin and fuselage to dimensions shown in Fig.detail view 1. In this position mark the sheet panel according to fuselage skin contour and fin spar to obtain the upper cut out. Remove the reinforcing sheet panel and cut in accordance with the contour marked, then deburr. Drill 4 holes dia 2.1 into this panel to Fig.1, detail view A.

4. Riveting of the reinforcing sheet panel to Figs.1,2

Insert once again the reinforcing panel with cut out and holes for rivets under the fin skin panel and position in accordance with dimensions shown in detail view A. Drill 5 holes using a drill dia. 3.2mm in the upper row. Drill a hole joining the fin spar with skin sheet panel using a drill dia.3.7. Use a 120° countersink to make a counterbore for all 6 holes for the flush head rivets from outside of the skin sheet panels. After this operation install 5 rivets dia 3 mm and 1 rivet dia.3.5mm into the pre-drilled holes from outside the skin panel and attach by riveting.

After the upper rivet row has been attached complete forming of the bottom part of the reinforcing sheet panel. Drill through 4 holes for rivets using a drill dia. 2.7 mm /to enlarge holes of 2.1 dia.drilled before/. Countersink 120° all four holes for flush head rivets. Insert 4 rivets dia 2.6 into the drilled holes with head from outside the reinforcing sheet panel and attach. After the riveting has been completed cut out an opening in the reinforcing panel according to position of opening for the stabilizer hinge, refer to Fig.2, detail 1.

Proceed in the same way in modification of the other side of fin.

5. Bonding of the cover strip to Fig. 2

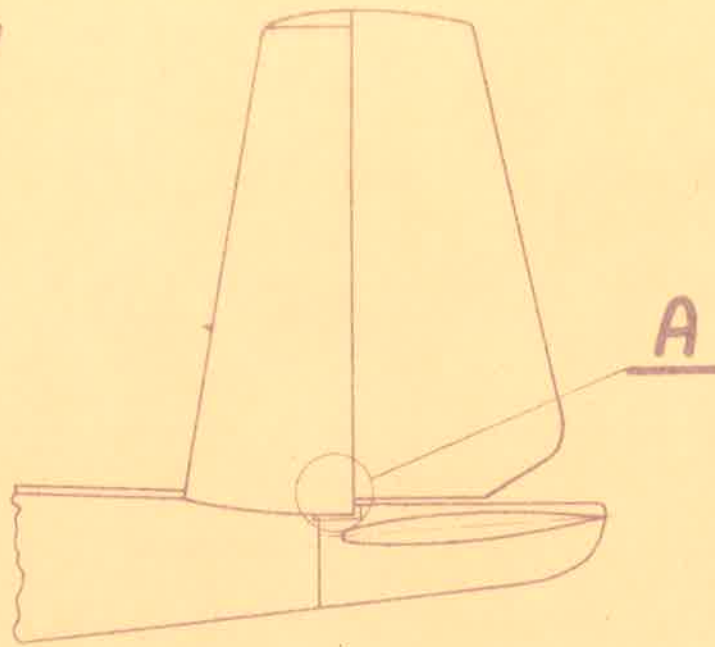
After the riveting on either side of fin has been completed apply an adhesive lacquer on circumference of the fin and attach the cover strip item (2) to dimensions shown in section B-B. Apply an aluminium lacquer on the cover strip after this has been attached.

6. Assembly of rudder

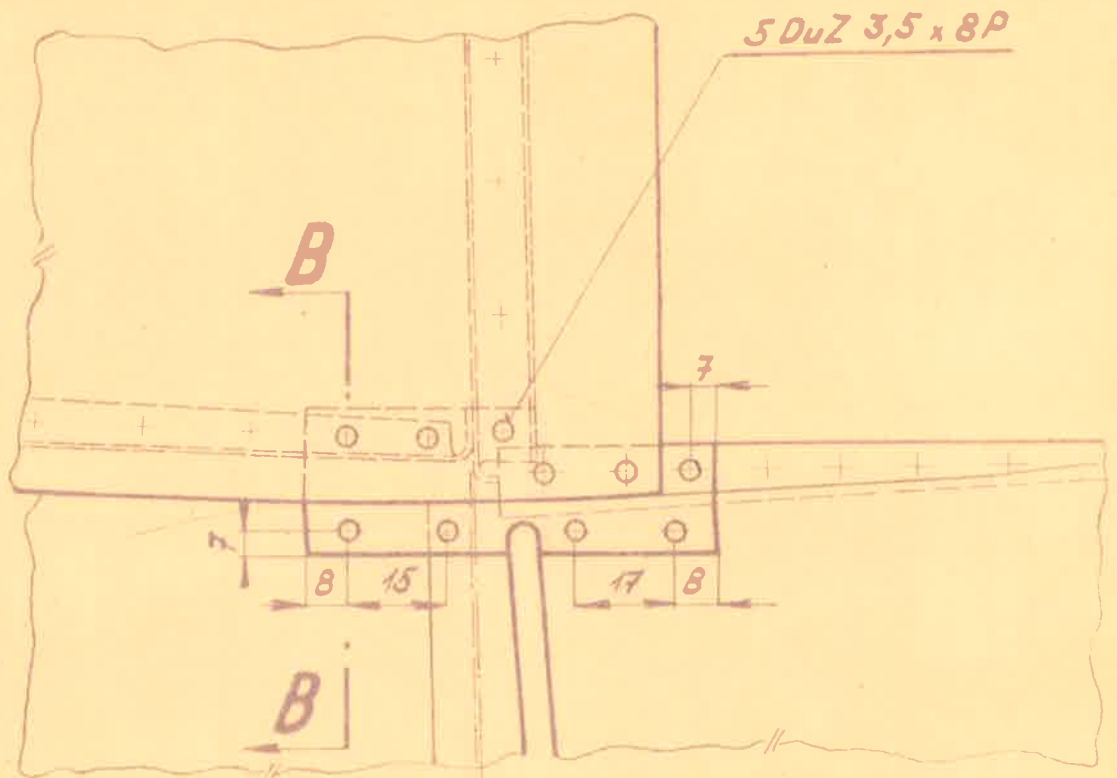
After this procedure is completed install rudder in its position.

2700/007

Обр. 1
фиг. 1



Detail A
Вынос A



Обр. 2
фиг. 2

Рез В-В
Сечение В-В

