Comp. Limited Kunovice

Aero Company Limited Prague Czechslovakia

MANDATORY BULLETIN No. L 23/018a

Effectivity: The L 23 sailplanes S/Nos. 897501÷897520; 907601÷907630; 907701÷907730; 917801÷917830; 917901÷917930; 928001÷928010; 938011÷938030; 938101÷938110; 948111÷948130.

Reason: The structure under the rudder footstep bearing is not sufficiently rigit which way influence cracking.

Description: To reinfarce the border of the footstep bearing base with angle iron, and to add stiffeners to the oblique supports of the base This modification will be inroduced in series production by an Engineering Modification No. ZKA 70177 starting from S/N 8201.

To be accomplished not later than: Upon receipt of the bulletin and the material.

To by accomplished by: Authorized repair shof or service center.

Cost covered by: Material cost - by the Manufacturer, labour cost - - by the Operator.

Material availability: LET a.s. Kunovice.

Validity: Upon receipt by the Operator.

Manhours: 4 man-hours

Melichárek
Manufacturer

Rybka
Customer's Representative

Příhoda
State Aviation Inspection

Sovák
OMNIPOL Company Limited

A. Procedure of Work

1. Remove the tailwheel cover - see Fig. 1, pos. 1.

2. Take out the spring (pos. 2) - see Fig. 2, Detail D - and drill out the rivets in the grip (pos. 3).
   - Locate the angle iron (pos. 4) - see view X, drill through holes in the footstep bearing base (using a drill of 2,7 dia), and rivet on by means of 7 button-head rivets (pos. 5).
   - Locate the LH and RH stiffener (pos. 6,7) on the oblique supports of the bearing base, drill through holes, and rivet on using button-head rivets (pos. 5) (5 rivets for each stiffener).
   - Drill through holes in the outer arms of the stiffeners and the angle iron of the frame using a 3.1 dia. drill, countersink to 120 , and rive on by means of contensunk - head rivets (pos. 8) - see Section A-A (2 rivets on each stiffener).
   - Adapt the bracket at rubber shock absorbers according to the dimensions shown in view Y.
   - Hang the spring (pos. 2) to a hole in pos.4.

3. Cut off partitition between holes (hatched surface) on the cover (pos. 1) - see Fig. 1, view - Z. Make a head from the rest of the partitition (dimension 3). Beat out the rear part of the hole (hatched surface), if necessary. Reinstall the cover.

B. Material necessary for modification of 1 sailplane

Pos.	Unit	Quantity	Name	Dwg.No -Standard	Note
2	pc	1	Spring		
4	pc	1	Angle iron assy	A 790 297 N	
6	pc	1	Stiffener	A 710 647 L	
7	pc	1	Stiffener	A 710 647 P	
5	pc	17	Rivet	2,6x5CSN022302.5	
8	pc	4	Rivet	3x6CSN022320.5	

C. Illustrations

Fig. 1 - General view of the sailplane
Fig. 2 - Auxiliary view of reinforcement of structure below footstep bearing

D. Supplementary Documents

Not required.

E. Tooling Required

Standard tooling of the Operator to be used.

F. Spare Parts in Service

Not affected.

G Sailplane Weight

+0,03 kg

H. Record in the Sailplane Logbook

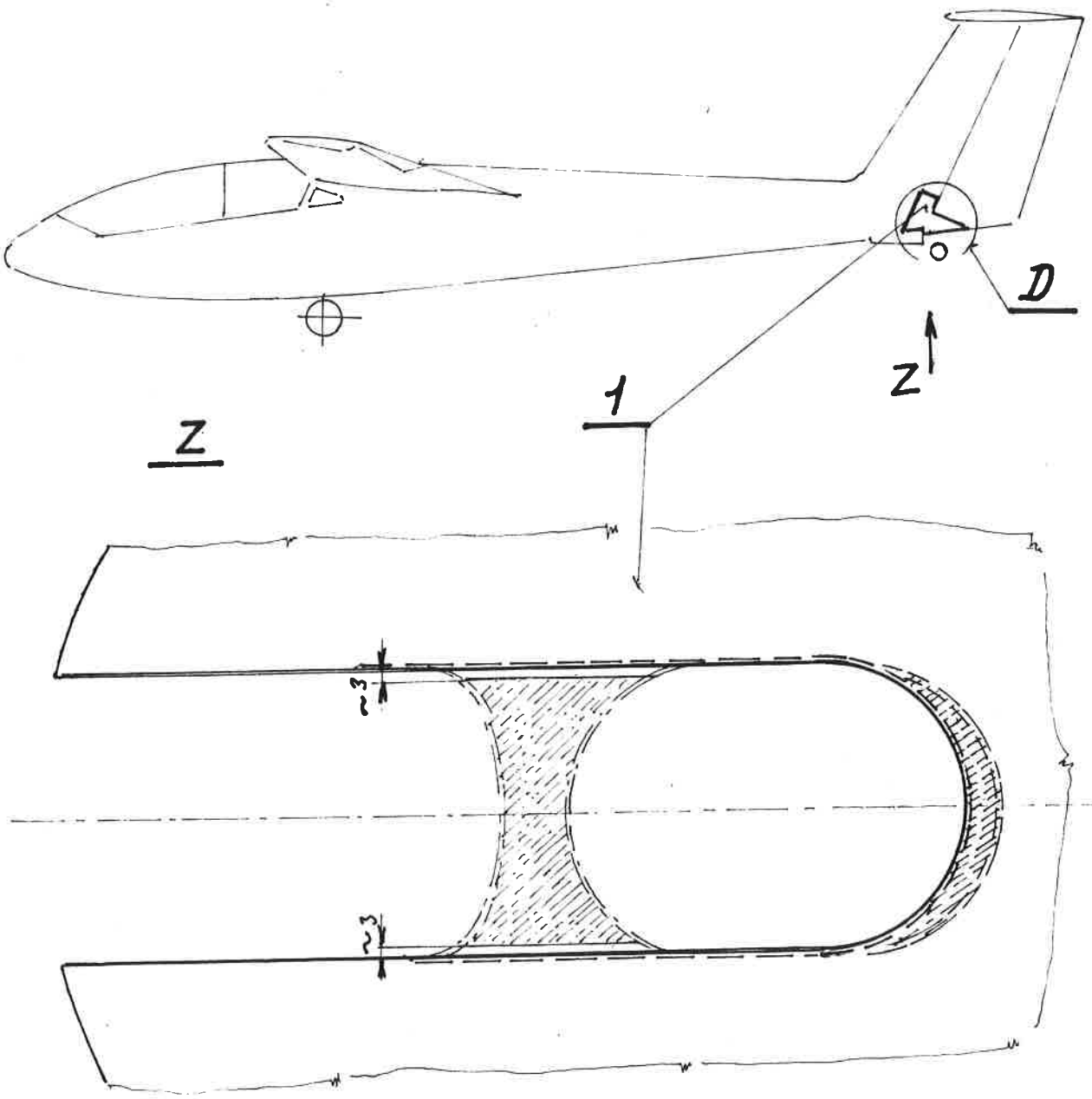
"Modification in the tail section accomplish per Mandatory Bulletin No. L23/018a."

Date: ..... Accomplished by: .....

(legible signature)

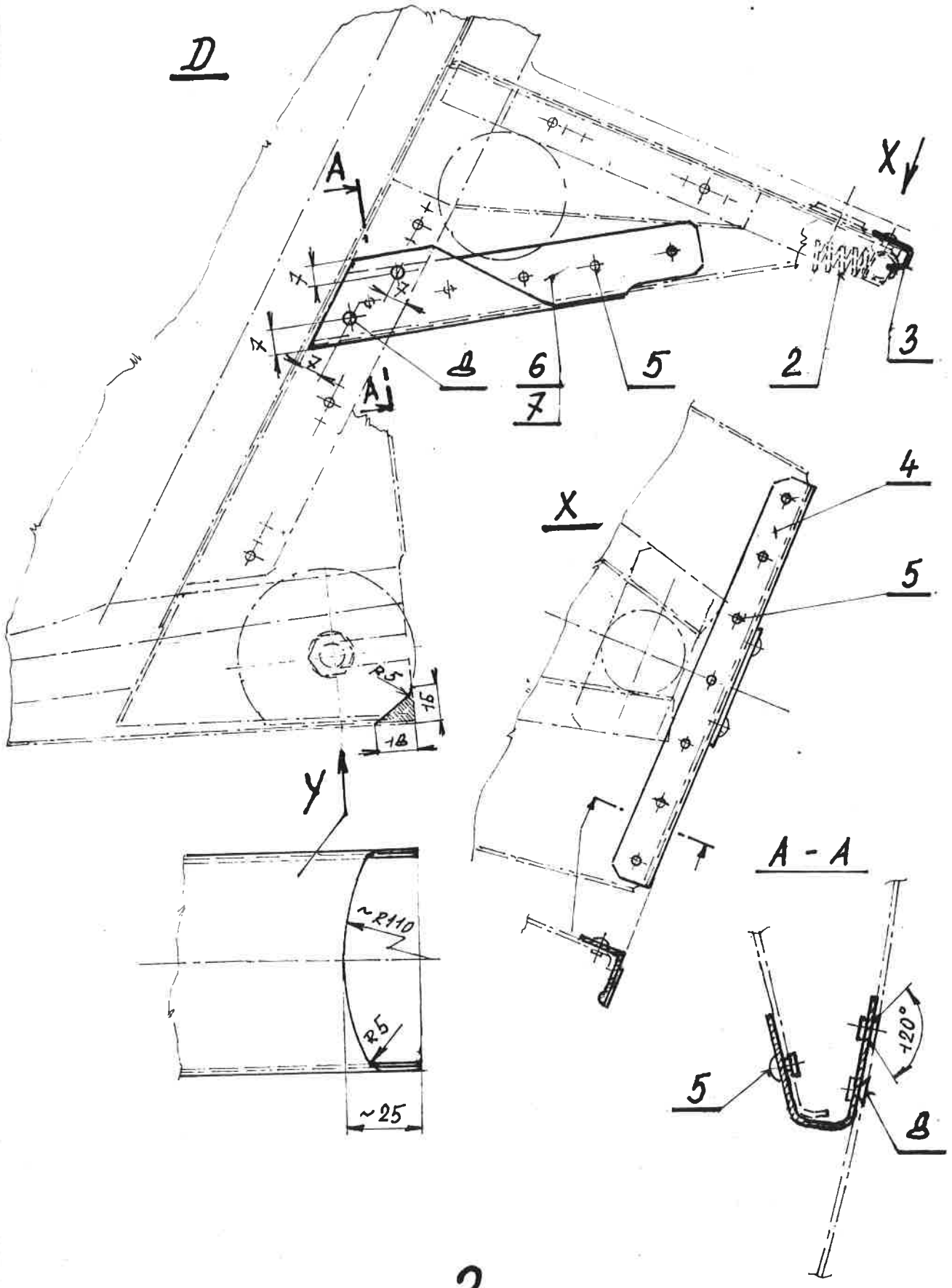
I. Accompanying Documentation

Not affected.



1

L23/018a	Vypracoval	Kontroloval	Schválil	List: 4 Listů: 5



2

L23/01B a	Vypracoval	Kontroloval	Schválil	List: 5 Listů: 5