

Service Bulletin No: 57-018

Ref No: 184

Modification No: EC-19-0354

ATA Chapter: 57

WINGS - WING STRUCTURE**REPLACEMENT OF THE ANGLE BRACKETS INSTALLED ON THE LH AND RH WING MIDDLE RIB 23****1. Planning Information****A. Effectivity**

MSN 101 thru MSN 618.

B. Concurrent Requirements

None.

C. Reason**(1) Problem**

A mandatory inspection for corrosion of the angle brackets installed on the LH and RH wing middle rib 23 can lead to the requirement to replace the brackets.

(2) Solution

The angle brackets installed on the LH and RH wing middle rib 23 are replaced.

NOTE: When you replace the brackets in accordance with this Service Bulletin, the requirement for the repetitive mandatory inspections is cancelled.

D. Description

This Service Bulletin gives the data and instructions necessary to replace the angle brackets installed on the LH and RH wing middle rib 23.

E. Compliance

Highly recommended.

F. Approval

The technical content of this Service Bulletin is approved under the authority of Letter of DOA Acceptance ref. FOCA.21J.002.

Pilatus advises Operators/Owners to check with their designated Airworthiness Authorities for any changes, local regulations or sanctions that may affect the embodiment of this Service Bulletin.

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H. Manpower

	Man-Hours
Preparation	3.00
Replacement of the brackets	48.00
Repair to Paint Finish	3.00
Close-Up	5.00
TOTAL MAN-HOURS	59.00

I. Weight and Balance**(1) Weight Change**

None.

(2) Moment Change

None.

J. Electrical Load Data

Not changed.

K. Software

Not changed.

L. References

Aircraft Maintenance Manual (AMM): 20-31-00, 20-40-01, 27-10-01.

Structural Repair Manual (SRM): 51-00-04, 51-20-02, 51-20-03.

Tool and Equipment Manual (TEM): 12-00-12.

M. Publications Affected

Not applicable.

N. Interchangeability of Parts

Not applicable.

2. Material Information
A. Material - Price and Availability

Modification Kit P/N 500.50.07.092 and P/N 500.50.07.093 is required for this Service Bulletin.

Operators who require further information on Price and Availability should contact their Customer Liaison Manager at:

Pilatus Aircraft Ltd,
6371 Stans,
Switzerland.

Operators are requested to advise Pilatus Aircraft Ltd. of the Manufacturer's Serial Number (MSN), the flying hours and landings of aircraft which are allocated for this Service Bulletin using the Service Bulletin Evaluation Form.

NOTE: When you order the modification kit from Pilatus Aircraft Ltd, you will also get a parts list. Use the numbers in column 1 (Pos.) to identify the parts in the kit (Ref. Para. 2.B.(1), Column 1).

B. Material Necessary for Each Aircraft
(1) Material to be Procured

Modification Kit No. 500.50.07.092 (LH wing).

The table below lists the parts in the Modification Kit (Ref. Para. 2.A.) and the disposition of the replaced parts:

POS. NO.	DESCRIPTION	OLD PART NO.	QTY	DISP. CODE	FIG	ITEM
1	FITTING, RIB 23	-	1	N	1	12
		111.36.07.262	1	D	1	12
2	FITTING, RIB 23	-	1	N	1	15
		111.36.07.263	1	D	1	15
3	FITTING, LH, RIB 23	-	1	N	1	2
		111.36.07.265	1	D	1	2
5	FITTING, LH, RIB 23	-	1	N	1	16
		111.36.07.267	1	D	1	16
7	SHIM, RIB 23	-	2	N	1	13
		111.36.07.264	2	D	1	13
8	NUT PLATE	-	2	N	1	14
		938.42.68.013	2	D	1	14
9	NUT PLATE	-	2	N	1	1
		938.41.33.235	2	D	1	1
10	RIVET, SOLID, CSK	-	2	N	-	-

POS. NO.	DESCRIPTION	OLD PART NO.	QTY	DISP. CODE	FIG	ITEM
11	RIVET, SOLID, CSK	-	2	N	-	-
12	RIVET, SOLID, CSK	-	2	N	-	-
13	RIVET, SOLID, CSK	-	4	N	-	-
14	RIVET, SOLID, CSK	-	2	N	-	-
15	RIVET, SOLID, HLF-RD	-	20	N	1	D
16	RIVET, SOLID, HLF-RD	-	10	N	1	D
17	RIVET, SOLID, HLF-RD	-	1	N	1	D
18	RIVET, SOLID, HLF-RD	-	1	N	1	D
19	RIVET, SOLID, HLF-RD	-	11	N	-	-
20	RIVET, SOLID, HLF-RD	-	12	N	-	-
21	RIVET, BLIND, HLF-RD	-	51	N	1	A
22	RIVET, BLIND, HLF-RD	-	14	N	1	A
23	RIVET, BLIND, CSK	-	6	N	-	B
24	RIVET, BLIND, CSK	-	30	N	1	C

Disposition Codes: D - Discard N - New

Modification Kit No. 500.50.07.093 (RH wing).

The table below lists the parts in the Modification Kit (Ref. Para. 2.A.) and the disposition of the replaced parts:

POS. NO.	DESCRIPTION	OLD PART NO.	QTY	DISP. CODE	FIG	ITEM
1	FITTING, RIB 23 (262)	-	1	N	1	12
		111.36.07.262	1	D	1	12
2	FITTING, RIB 23 (263)	-	1	N	1	15
		111.36.07.263	1	D	1	15
4	FITTING, RH, RIB 23 (266)	-	1	N	1	3
		111.36.07.266	1	D	1	3
6	FITTING, RH, RIB 23 (268)	-	1	N	1	17
		111.36.07.268	1	D	1	17
7	SHIM, RIB 23	-	2	N	1	13
		111.36.07.264	2	D	1	13

POS. NO.	DESCRIPTION	OLD PART NO.	QTY	DISP. CODE	FIG	ITEM
8	NUT PLATE	-	2	N	1	14
		938.42.68.013	2	D	1	14
9	NUT PLATE	-	2	N	1	1
		938.41.33.235	2	D	1	1
10	RIVET, SOLID, CSK		2	N	-	-
11	RIVET, SOLID, CSK		2	N	-	-
12	RIVET, SOLID, CSK		2	N	-	-
13	RIVET, SOLID, CSK		4	N	-	-
14	RIVET, SOLID, CSK		2	N	-	-
15	RIVET, SOLID, HLF-RD		20	N	1	D
16	RIVET, SOLID, HLF-RD		10	N	1	D
17	RIVET, SOLID, HLF-RD		1	N	1	D
18	RIVET, SOLID, HLF-RD		1	N	1	D
19	RIVET, SOLID, HLF-RD		11	N	-	-
20	RIVET, SOLID, HLF-RD		12	N	-	-
21	RIVET, BLIND, HLF-RD		51	N	1	A
22	RIVET, BLIND, HLF-RD		14	N	1	A
23	RIVET, BLIND, CSK		6	N	-	B
24	RIVET, BLIND, CSK		30	N	1	C
Disposition Codes: D - Discard - N New						

(2) Operator Supplied Materials (Ref. AMM, 20-31-00):

MATERIAL NO.	DESCRIPTION	QTY	REMARKS
P01-010	SOLVENT	A/R	Or equivalent
P02-031	ABSORBENT PAPER	A/R	Or equivalent
P04-012	CORROSION PREVENTATIVE	A/R	Or equivalent
P04-039	CORROSION PREVENTATIVE	A/R	Alternative to Material No. P04-012
P07-007	PRIMER	A/R	Or equivalent
P07-021	ALODINE 1132	A/R	Or equivalent

MATERIAL NO.	DESCRIPTION	QTY	REMARKS
P08-074	SEALANT	A/R	Or equivalent
P10-015	CPC ARDROX AV 30	A/R	Or equivalent

C. Material Necessary for Each Spare

None.

D. Re-identified Parts

None.

E. Tooling - Cost and Availability

None.

3. Accomplishment Instructions

WARNING: WEAR EYE PROTECTION WHEN YOU DRILL COMPONENTS. HOT AND SHARP SWarf AND PARTICLES OF MATERIAL CAN CAUSE INJURY TO PERSONNEL.

WARNING: BE CAREFUL WHEN YOU USE THE CONSUMABLE MATERIALS. OBEY THE MANUFACTURERS HEALTH AND SAFETY INSTRUCTIONS BEFORE.

NOTE: The metal work tool kit, P/N 990.00.02.011, is required for this modification (Ref. TEM 12-00-12).

A. Preparation

- (1) Put a warning sign "DO NOT OPERATE THE FLIGHT CONTROLS" in the front and rear cockpits.
- (2) Remove the left and/or right aileron (Ref. AMM, 27-10-01, Page Block 401).

B. Modification

NOTE: This procedure is applicable to the LH and RH wing middle rib 23.

(1) Removal (Ref. Fig. 1)

(a) Remove the aileron outboard-bearing support:

- 1 Remove the bolts (9), the washers (8) and, if necessary, the bonding strap (7).
- 2 Remove and the bolts (10) and the washers (11).
- 3 Remove the aileron outboard-bearing support (6) and the aileron trim shims (if installed).

NOTE: Make a note of the position of the aileron trim shims (if installed).

4 Clean the bolts (9) and (10) with the absorbent paper (Material No. P02-031) made moist with the solvent (Material No. P01-010).

5 Make sure the threads of the bolts (9) and (10) are in good condition and that there is no sign of corrosion.

(b) Get access to the rib 23 fittings.

1 Use the applicable diameter drill and remove the rivets (Ref. Fig. 1, Sheet 2) (Ref. SRM, 51-00-04) from the wing lower-outer skin (4) to get access to the outboard angle brackets installed on the middle rib 23.

2 Use the applicable diameter drill and remove the rivets (Ref. Fig. 1, Sheet 2) (Ref. SRM, 51-00-04) from the wing lower-inner skin (5) to get access to inboard angle brackets installed on the middle rib 23.

3 Carefully move the wing lower-inner skin (5) and the wing lower-outer skin (4) and hold in position to get access to the angle brackets.

- 4 Clean the work area with absorbent paper (Material No. P02-031) made moist with the solvent (Material No. P01-010).
- (c) Remove the rib 23 fittings.
- 1 Use the applicable diameter drill and remove the rivets (Ref. SRM, 51-00-04) from the rib 23 fittings (2) and (16) (LH) (or (3) and (17) (RH)).
 - 2 Remove and discard the rib 23 fittings (2) and (16) (LH) (or (3) and (17) (RH)) from the middle rib 23.
 - 3 Use the applicable diameter drill and remove the rivets (Ref. SRM, 51-00-04) from the rib 23 fittings (12) and (15).
 - 4 Remove and discard the rib 23 fittings (12) and (15) from the middle rib 23.
 - 5 Remove all the unwanted material, as a result of the rivet removal, from the work area.
 - 6 Clean the work area with absorbent paper (Material No. P02-031) made moist with the solvent (Material No. P01-010).

(2) Installation (Ref. Fig. 1)

- (a) Put the new rib 23 fittings (2) (Pos. No. 3) and (16) (Pos. No. 5) (LH) (or (3) (Pos. No. 4) and (17) (Pos. No. 6) (RH)) in position on the middle rib 23.
- (b) Use gripper pins (or equivalent) to hold the new rib 23 fittings (2) (Pos. No. 3) and (16) (Pos. No. 5) (LH) (or (3) (Pos. No. 4) and (17) (Pos. No. 6) (RH)) in position on the middle rib 23.
- (c) Make sure that the pre-drilled holes in the rib 23 fittings (2) (Pos. No. 3) and (16) (Pos. No. 5) (LH) (or (3) (Pos. No. 4) and (17) (Pos. No. 6) (RH)) align with the existing holes in the middle rib 23.
- (d) Use a 2,4 mm (0.10 in.) diameter drill and make the rivet holes, through the pre-drilled holes of the new the rib 23 fitting (2) (Pos. No. 3) (LH) (or (3) (Pos. No. 4) (RH)) into:
 - The new the rib 23 fitting (16) (Pos. No. 5) (LH) (or (17) (Pos. No. 6) (RH)).
- (e) Use a 3,3 mm (0.13 in.) diameter drill and increase the diameter of the rivet holes in the new rib 23 fittings (2) (Pos. No. 3) and (16) (Pos. No. 5) (LH) (or (3) (Pos. No. 4) and (17) (Pos. No. 6) (RH)).
- (f) Put the new rib 23 fittings (12) (Pos. No. 1) and (15) (Pos. No. 2) (LH and RH) in position on the middle rib 23.
- (g) Use gripper pins (or equivalent) to hold the new rib 23 fittings (12) (Pos. No. 1) and (15) (Pos. No. 2) (LH and RH) in position on the middle rib 23.
- (h) Make sure that the pre-drilled holes in the new rib 23 fittings (12) (Pos. No. 1) and (15) (Pos. No. 2) (LH and RH) align with the existing holes in the middle rib 23.

- (i) Use a 2,4 mm (0.10 in.) diameter drill and make the rivet holes, through the pre-drilled holes of the new rib 23 fitting (12) (Pos. No. 1) (LH and RH) into:
- The new the rib 23 fitting (15) (Pos. No. 2) (LH and RH).
- (j) Use a 3,3 mm (0.13 in.) diameter drill and increase the diameter of the rivet holes in the new rib 23 fittings (12) (Pos. No. 1) and (15) (Pos. No. 2) (LH and RH).
- (k) Release the wing lower-inner skin (5) and the wing lower-outer skin (4) and use gripper pins (or equivalent) to hold them in position.
- (l) Mark the centre of the holes for the bolts (9) for the aileron outboard-bearing support in:
- The new rib 23 fitting (2) (Pos. No. 3) (LH) or
 - The new rib 23 fitting (3) (Pos. No. 4) (RH)
 - The new rib 23 fitting (16) (Pos. No. 5) (LH) or
 - The new rib 23 fitting (17) (Pos. No. 6) (RH).
- (m) Mark the centre of the holes for the bolts (10) for the aileron outboard-bearing support in:
- The new rib 23 fitting (12) (Pos. No. 1) (LH and RH)
 - The new rib 23 fitting (15) (Pos. No. 2) (LH and RH).
- (n) Remove the gripper pins (or equivalent) and carefully move and hold in position the wing lower-inner skin (5) and the wing lower-outer skin (4) to get access to the angle brackets.
- (o) Remove the gripper pins (or equivalent) and remove the new rib 23 fittings (2) (Pos. No. 3) and (16) (Pos. No. 5) (LH) (or (3) (Pos. No. 4) and (17) (Pos. No. 6) (RH)) from the middle rib 23.
- (p) Remove the gripper pins (or equivalent) and remove the new rib 23 fittings (12) (Pos. No. 1) and (15) (Pos. No. 2) (LH and RH) from the middle rib 23.
- (q) Install the nut plates on the rib 23 fittings.
- 1 Use a 3,3 mm (0.13 in.) diameter drill to make the bolt holes in the positions you marked in Para. B.2.(l) in these rib 23 fittings:
- The new rib 23 fitting (2) (Pos. No. 3) (LH) or
 - The new rib 23 fitting (3) (Pos. No. 4) (RH)
 - The new rib 23 fitting (16) (Pos. No. 5) (LH) or
 - The new rib 23 fitting (17) (Pos. No. 6) (RH).

- 2 Use a 4,8 mm (0.19 in.) diameter drill and increase the diameter of the bolt holes.

 - The new rib 23 fitting (2) (Pos. No. 3) (LH) or
 - The new rib 23 fitting (3) (Pos. No. 4) (RH)
 - The new rib 23 fitting (16) (Pos. No. 5) (LH) or
 - The new rib 23 fitting (17) (Pos. No. 6) (RH).
- 3 Put the new nut plates (1) (Pos. No. 9) in position on these rib 23 fittings and align the bolt holes and use clamps (or equivalent) to hold in position:

 - The new rib 23 fitting (2) (Pos. No. 3) (LH) or
 - The new rib 23 fitting (3) (Pos. No. 4) (RH)
 - The new rib 23 fitting (16) (Pos. No. 5) (LH) or
 - The new rib 23 fitting (17) (Pos. No. 6) (RH).
- 4 Use a 2,4 mm (0.10 in.) diameter drill and make the rivet holes through the pre-drilled holes of the new nut plates (1) (Pos. No. 9) in these rib 23 fittings:

 - The new rib 23 fitting (2) (Pos. No. 3) (LH) or
 - The new rib 23 fitting (3) (Pos. No. 4) (RH)
 - The new rib 23 fitting (16) (Pos. No. 5) (LH) or
 - The new rib 23 fitting (17) (Pos. No. 6) (RH).
- 5 Remove the clamps (or equivalent) and remove the new nut plates (1) (Pos. No. 9) from the rib 23 fittings.
- 6 Use clamps (or equivalent) to hold the new rib 23 shims (13) (Pos. No. 7) in position on these rib 23 fittings:

 - The new rib 23 fitting (12) (Pos. No. 1) (LH and RH)
 - The new rib 23 fitting (15) (Pos. No. 2) (LH and RH).
- 7 Use a 3,3 mm (0.13 in.) diameter drill to make the bolt holes in the positions you marked in Para. B.2. (m) in these rib 23 fittings and in the rib 23 shims (13) (Pos. No. 7):

 - The new rib 23 fitting (12) (Pos. No. 1) (LH and RH)
 - The new rib 23 fitting (15) (Pos. No. 2) (LH and RH).
- 8 Use a 4,8 mm (0.19 in.) diameter drill and increase the diameter of the bolt holes.
- 9 Use a 2,4 mm (0.10 in.) diameter drill and make the rivet holes for the nut plates, through the pre-drilled holes of the new rib 23 shims (13) (Pos. No. 7) in these rib 23 fittings:

 - The new rib 23 fitting (12) (Pos. No. 1) (LH and RH)
 - The new rib 23 fitting (15) (Pos. No. 2) (LH and RH).

- 10 Remove the clamps (or equivalent) and remove the new rib 23 shims (13) (Pos. No. 7) from the rib 23 fittings.
- 11 Deburr all the rivet holes and the bolt holes in these components:
- The new rib 23 fitting (2) (Pos. No. 3) (LH) or
 - The new rib 23 fitting (3) (Pos. No. 4) (RH)
 - The new rib 23 fitting (16) (Pos. No. 5) (LH) or
 - The new rib 23 fitting (17) (Pos. No. 6) (RH)
 - The new rib 23 fitting (12) (Pos. No. 1) (LH and RH)
 - The new rib 23 fitting (15) (Pos. No. 2) (LH and RH)
 - The new rib 23 shims (13) (Pos. No. 7).
- 12 Apply a layer of alodine 1132 (Material No. P07-021) to the rivet holes and bolt holes in these components:
- The new rib 23 fitting (2) (Pos. No. 3) (LH) or
 - The new rib 23 fitting (3) (Pos. No. 4) (RH)
 - The new rib 23 fitting (16) (Pos. No. 5) (LH) or
 - The new rib 23 fitting (17) (Pos. No. 6) (RH)
 - The new rib 23 fitting (12) (Pos. No. 1) (LH and RH)
 - The new rib 23 fitting (15) (Pos. No. 2) (LH and RH)
 - The new rib 23 shims (13) (Pos. No. 7).
- 13 Apply a layer of sealant (Material No. P08-074 or approved alternative) on the mating surfaces between these components:
- The new rib 23 fitting (2) (Pos. No. 3) (LH) or
 - The new rib 23 fitting (3) (Pos. No. 4) (RH)
 - The new rib 23 fitting (16) (Pos. No. 5) (LH) or
 - The new rib 23 fitting (17) (Pos. No. 6) (RH)
 - The new rib 23 fitting (12) (Pos. No. 1) (LH and RH)
 - The new rib 23 fitting (15) (Pos. No. 2) (LH and RH)
 - The new rib 23 shims (13) (Pos. No. 7)
 - The new nut plates (1) (Pos. No. 9)
 - The new nut plates (14) (Pos. No. 8).
- 14 Put the new nut plates (1) (Pos. No. 9) in position on these rib 23 fittings and align the rivet and bolt holes and use clamps and/or gripper pins (or equivalent) to hold in position:
- The new rib 23 fitting (2) (Pos. No. 3) (LH) or
 - The new rib 23 fitting (3) (Pos. No. 4) (RH)
 - The new rib 23 fitting (16) (Pos. No. 5) (LH) or
 - The new rib 23 fitting (17) (Pos. No. 6) (RH).

- 15 Apply a layer of sealant (Material No. P08-074) on each rivet before you install it.
- 16 Install the rivets (Pos. No. 10, or Pos. No. 11, or Pos. No. 12) in the new nut plates (1) (Pos. No. 9) (Ref. SRM, 51-00-04).
- NOTE:** Use the correct rivet (Pos. No. 10, or Pos. No. 11, or Pos. No. 12), the rivet length is to be determined on installation.
- 17 Use absorbent paper (Material No. P02-031) and solvent (Material No. P01-010 or approved alternative) to remove unwanted sealant.
- 18 Put the new nut plates (14) (Pos. No. 8) and the new rib 23 shims (13) (Pos. No. 7) in position on these rib 23 fittings and align the rivet and bolt holes and use clamps and/or gripper pins (or equivalent) to hold in position:
- The new rib 23 fitting (12) (Pos. No. 1) (LH and RH)
 - The new rib 23 fitting (15) (Pos. No. 2) (LH and RH).
- 19 Apply a layer of sealant (Material No. P08-074) on each rivet before you install it.
- 20 Install the rivets (Pos. No. 12, or Pos. No. 13, or Pos. No. 14) in the new nut plates (14) (Pos. No. 8) (Ref. SRM, 51-00-04).
- NOTE:** Use the correct rivet (Pos. No. 12, or Pos. No. 13, or Pos. No. 14), the rivet length is to be determined on installation.
- 21 Use absorbent paper (Material No. P02-031) and solvent (Material No. P01-010 or approved alternative) to remove unwanted sealant.

(r) Install the rib 23 fittings.

- 1 Apply a layer of alodine 1132 (Material No. P07-021) to the rivet holes in the middle rib 23.
- 2 Apply a layer of sealant (Material No. P08-074 or approved alternative) on the mating surfaces between the structure of the middle rib 23 and these components:
- The new rib 23 fitting (2) (Pos. No. 3) (LH) or
 - The new rib 23 fitting (3) (Pos. No. 4) (RH)
 - The new rib 23 fitting (16) (Pos. No. 5) (LH) or
 - The new rib 23 fitting (17) (Pos. No. 6) (RH).
- 3 Use gripper pins (or equivalent) to hold these rib 23 fittings in position on the middle rib 23:
- The new rib 23 fitting (2) (Pos. No. 3) (LH) or
 - The new rib 23 fitting (3) (Pos. No. 4) (RH)
 - The new rib 23 fitting (16) (Pos. No. 5) (LH) or
 - The new rib 23 fitting (17) (Pos. No. 6) (RH).

- 4 Apply a layer of sealant (Material No. P08-074) on each rivet before you install it.
 - 5 Install the rivets (Pos. No. 19) in these rib 23 fittings (Ref. SRM, 51-00-04):
 - The new rib 23 fitting (2) (Pos. No. 3) (LH) or
 - The new rib 23 fitting (3) (Pos. No. 4) (RH)
 - The new rib 23 fitting (16) (Pos. No. 5) (LH) or
 - The new rib 23 fitting (17) (Pos. No. 6) (RH).
 - 6 Use absorbent paper (Material No. P02-031) and solvent (Material No. P01-010 or approved alternative) to remove unwanted sealant.
 - 7 Apply a layer of alodine 1132 (Material No. P07-021) to the rivet holes in the middle rib 23.
 - 8 Apply a layer of sealant (Material No. P08-074 or approved alternative) on the mating surfaces between the structure of the middle rib 23 and these components:
 - The new rib 23 fitting (12) (Pos. No. 1) (LH and RH)
 - The new rib 23 fitting (15) (Pos. No. 2) (LH and RH).
 - 9 Use gripper pins (or equivalent) to hold these rib 23 fittings in position on the middle rib 23:
 - The new rib 23 fitting (12) (Pos. No. 1) (LH and RH)
 - The new rib 23 fitting (15) (Pos. No. 2) (LH and RH).
 - 10 Apply a layer of sealant (Material No. P08-074) on each rivet before you install it.
 - 11 Install the rivets (Pos. No. 20) in these rib 23 fittings (Ref. SRM, 51-00-04):
 - The new rib 23 fitting (12) (Pos. No. 1) (LH and RH)
 - The new rib 23 fitting (15) (Pos. No. 2) (LH and RH).
 - 12 Use absorbent paper (Material No. P02-031) and solvent (Material No. P01-010 or approved alternative) to remove unwanted sealant.
- (s) Apply a layer of CPC Ardrex AV 30 (Material No. P10-015) to the nut plates (1) (Pos. No. 9) and the nut plates (14) (Pos. No. 8) (Ref. AMM, 20-40-01-201).
- (t) Close the access to the rib 23 fittings.
- 1 Remove all the unwanted material, all equipment and tools from the work area before you close the access.
 - 2 Apply a layer of sealant (Material No. P08-074 or approved alternative) on the mating surfaces between the wing structure, the wing lower-inner skin (4) and the wing lower-outer skin (5).
 - 3 Put the wing lower-inner skin (4) and the wing lower-outer skin (5) in position.

- 4 Use gripper pins (or equivalent) to hold the wing lower-inner skin (4) and the wing lower-outer skin (5) in position.
- 5 Apply a layer of sealant (Material No. P08-074) on each rivet before you install it.
- 6 Install the rivets (Refer to Table 1 and Figure 1, Sheet 2 for the rivet installation data and SRM, 51-00-04)).

IDENT	DESCRIPTION	Qty	REMARKS
A	Rivet - Cherrymax	51 14	Kit Pos. No. 21 Kit Pos. No. 22* *Alternate Rivet length to be determined on installation
B	Rivet – Cherrymax	6	Kit Pos. No. 23
C	Rivet – Cherrymax	30	Kit Pos. No. 24
D	Rivet – Solid Rivet – Solid Rivet – Solid Rivet – Solid	20 10 1 1	Kit Pos. No. 15 Kit Pos. No. 16* Kit Pos. No. 17* Kit Pos. No. 18* *Alternate Rivet length to be determined on installation

Table 1 - Rivet Installation Data

- 7 Use absorbent paper (Material No. P02-031) and solvent (Material No. P01-010 or approved alternative) to remove unwanted sealant.
- (u) Install the aileron outboard-bearing support:
- 1 Apply a layer of the corrosion preventative (Material No. P04-012) to the plain shank of the bolts (9) and (10).
 - 2 Put the aileron outboard-bearing support (6) and aileron trim shims (if installed) in position.

NOTE: Make sure you install the aileron trim shims in the positions noted in the removal procedure.
 - 3 Put the washers (8) and, if applicable, the bonding strap (7) on the bolts (9).
 - 4 Put the bolts (9) into the hole and turn the bolts (9) with your fingers until you can feel it has engaged the thread of the nut plates (1).
 - 5 Continue to turn the bolts (9) with a torque wrench and measure the torque necessary to turn the bolts (9) (run-down torque).
 - 6 Torque the bolts (9) to 2.3 and 2.9 Nm (20 and 25 lb in.) plus the run-down torque.
 - 7 Put the washers (11) on the bolts (10).
 - 8 Put the bolts (10) into the hole and turn the bolts (10) with your fingers until you can feel it has engaged the thread of the nut plates (14).

- 9 Continue to turn the bolts (10) with a torque wrench and measure the torque necessary to turn the bolts (10) (run-down torque).
- 10 Torque the bolts (10) to 2.3 and 2.9 Nm (20 and 25 lb in.) plus the run-down torque.
- (v) Clean the work area with absorbent paper (Material No. P02-031) made moist with the solvent (Material No. P01-010).
- (w) Apply a layer of the primer (Material No. P07-007) to all the rivet heads (Ref. SRM, 51-20-02).
- (x) Repair the aircraft paint finish (Ref. SRM, 51-20-03).

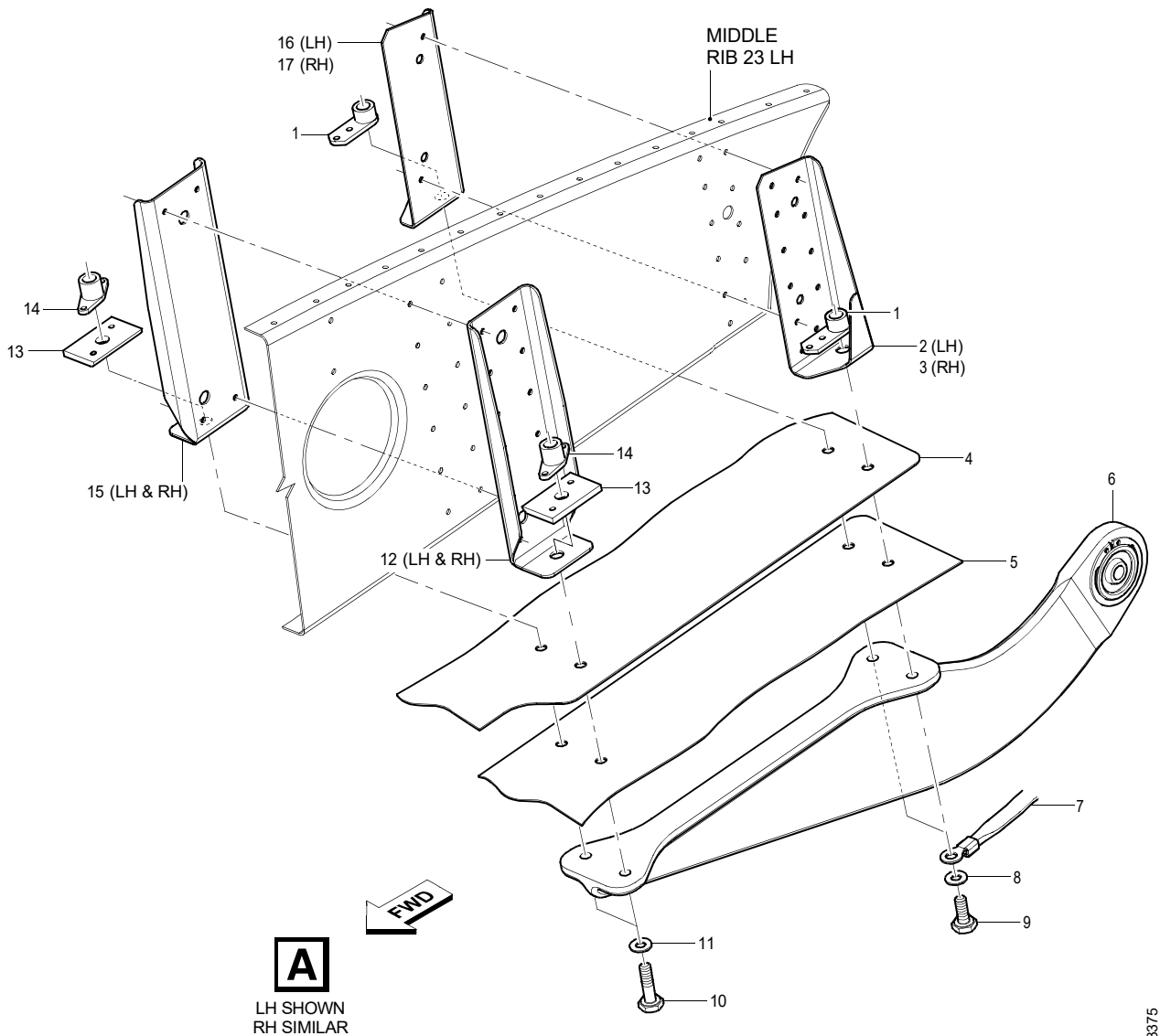
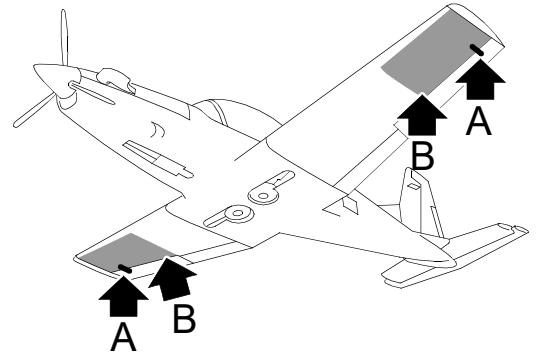
C. Job Close-Up

- (1) Remove all equipment, materials and tools from the work area. Make sure that the work area is clean.
- (2) Install the left and/or right aileron (Ref. AMM, 27-10-01, Page Block 401).
- (3) Remove the warning signs from the front and rear cockpits.

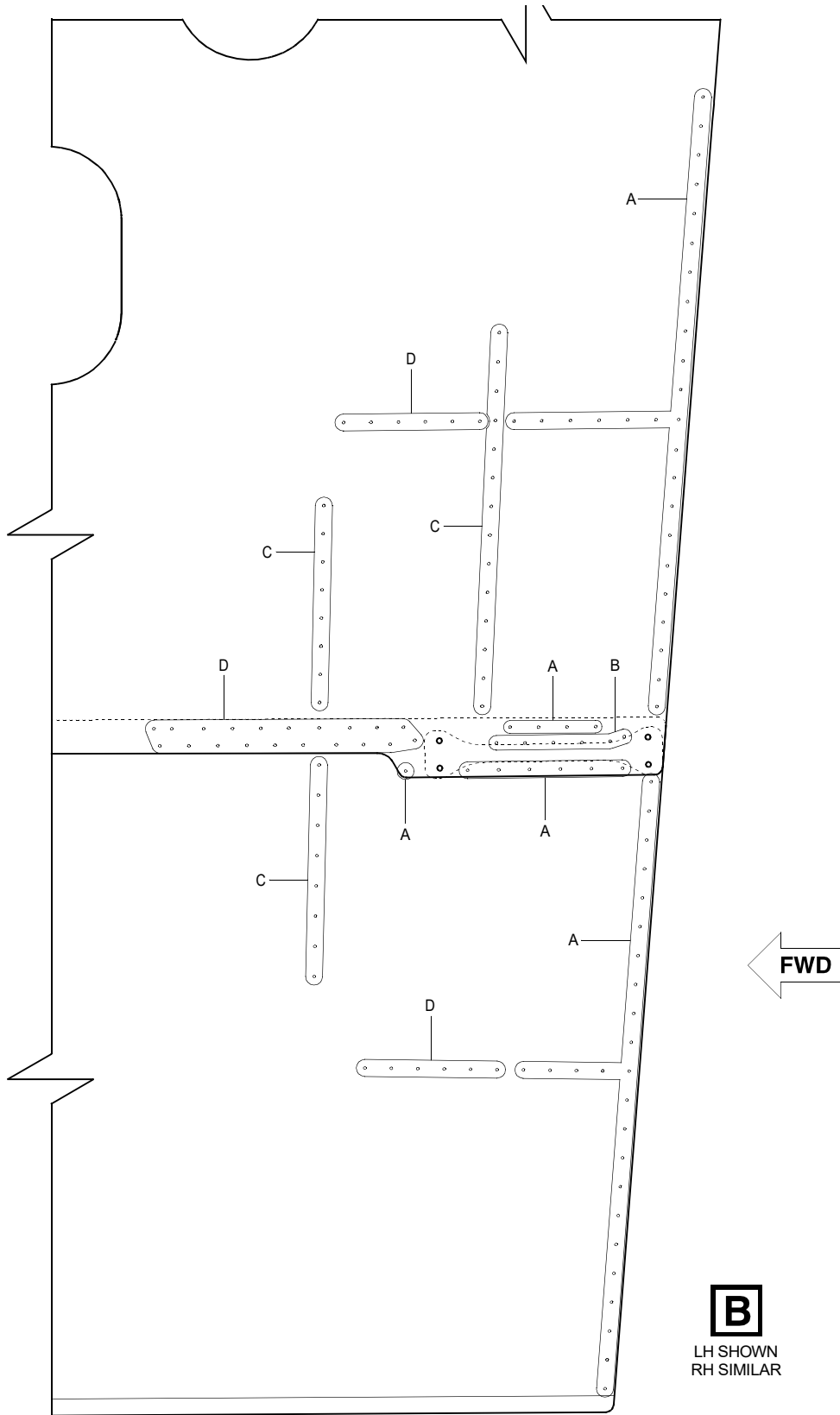
D. Documentation

- (1) Make an entry in the Aircraft Logbook that this Service Bulletin has been incorporated.
- (2) Use the Service Bulletin Evaluation Sheet and report your results and the serial number of the aircraft to Pilatus.

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Installation of the LH and RH Wing Middle Ribs 23
Figure 1 (Sheet 1 of 2)



Installation of the LH and RH Wing Middle Ribs 23
Figure 1 (Sheet 2 of 2)

SERVICE BULLETIN EVALUATION SHEET FOR SB No. 57-018			
Title	Wings - Wing Structure Replacement of the Angle Brackets Installed on the LH and RH Wing Middle Rib 23		
Customer			
Service Center			
EMBODIMENT REPORTING			
This SB has been embodied:		<input type="checkbox"/>	On the entire fleet
		<input type="checkbox"/>	Only partially
Provide embodiment details per aircraft (use additional copies of this table, if necessary)			
MSN	Flying Hours	MSN	Flying Hours
Additional embodiment comments/findings			
EDITORIAL COMMENTS (procedure, kit quality, suggested improvements, etc.)			
Name	Signature	Date	
Please complete and forward this form to: Pilatus Aircraft LTD, Customer Technical Support (MCC), P.O. BOX 992, 6371 Stans, Switzerland Fax: +41 (0)41 619 6773 Email: Techsupport@pilatus-aircraft.com			

SERVICE BULLETIN EVALUATION SHEET

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