



SERVICE BULLETIN

No. 521

Piper Aircraft Corporation

Lock Haven, Pennsylvania, U.S.A.

"Modification DOA EA-1 Approved"

September 20, 1976 M

<u>Subject:</u>	Inspection of Stabilizer Stringer Attachment
<u>Models Affected:</u>	<u>Serial Numbers Affected:</u>
PA-31 and PA-31-325 Navajo	31-7612060 to 31-7612080 Inclusive, 31-7612082 to 31-7612089 Inclusive, 31-7612091, 31-7612096, and 31-7612099.
PA-31-350 Navajo Chieftain	31-7652105 to 31-7652115 Inclusive, 31-7652117, 31-7652118, 31-7652120 to 31-7652146 Inclusive, 31-7652148 to 31-7652162 Inclusive, 31-7652164, 31-7652165 and 31-7652168.
<u>Compliance Time:</u>	At the next scheduled Programmed Inspection Event, not to exceed the next fifty (50) hours of operation.

Purpose:

The stabilizer top and bottom skin panels are attached to spanwise stringers, located between the stabilizer front and rear spar. Flat head ("flush") rivets are used for attachment purposes, and are spaced along the corresponding stringers between the stabilizer inboard rib (Sta. 12.62) and tip rib (Sta. 91.12), both top and bottom surfaces.

It has been found that an inadequate number of rivets may have been used to attach the stringers to the top and bottom skin panels. An inadequate number of rivets may permit local buckling of the skin between rivets. See attached sketch/instruction data for an illustrated view of the subject area.

This service release provides instructions to inspect the stabilizer skin stringer attachment in the areas described above and depicted on the attached sketch/instruction sheet to insure that an adequate number of rivets are installed.

Instructions:

Refer to attached sketch/instruction data for inspection and (if required) proper rivet installation procedure.

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Material Required:

Piper part number 522 881 Rivet, NAS 1738B4-1, as required per inspection.

Availability of Parts:

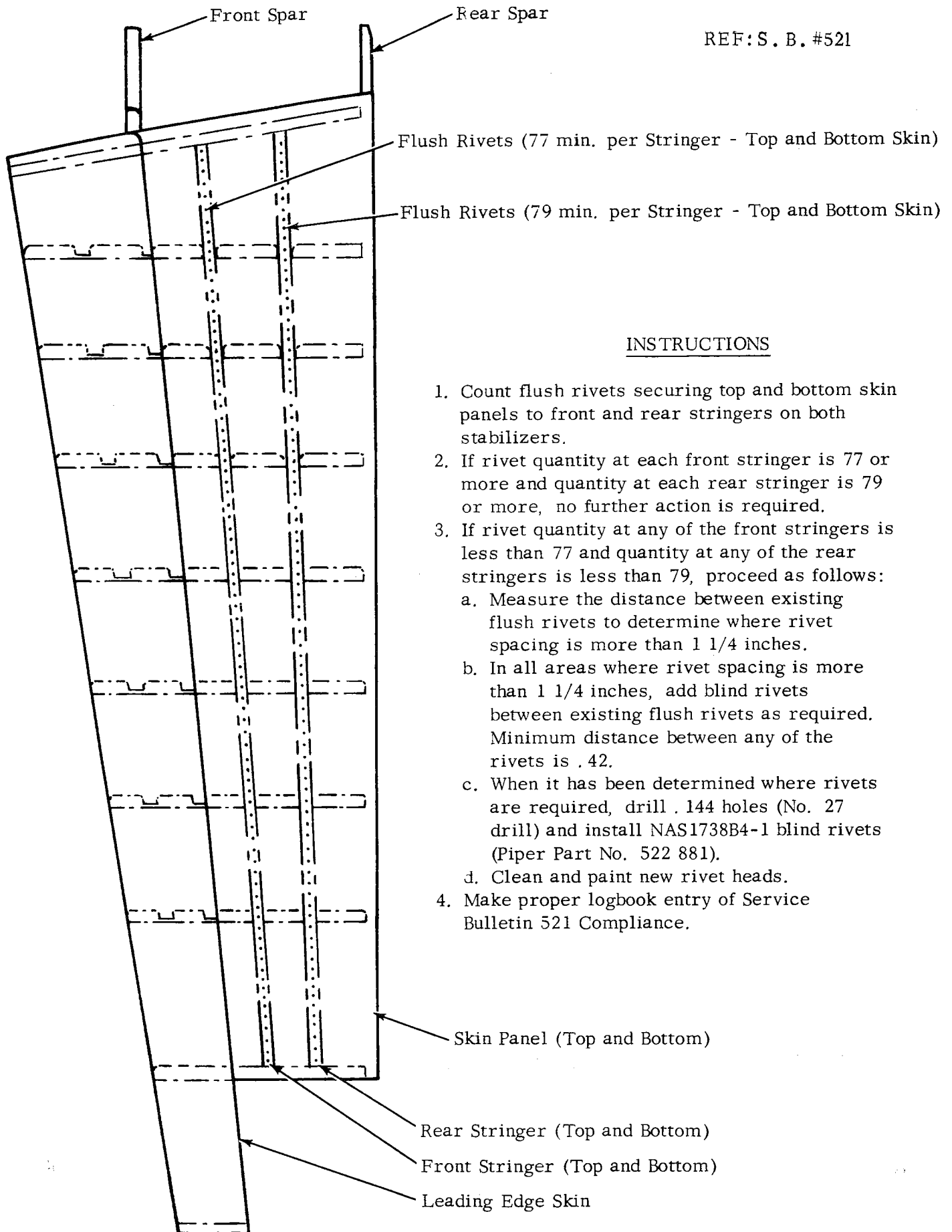
Your Piper Field Service Facility.

Effectivity:

This service release is effective upon receipt.

Summary:

Please contact your Piper Field Service Facility to make arrangements for compliance with the provisions of this service release in accordance with Compliance Time, above. Inspection time requirements is minimal (stabilizer removal not required for inspection or rivet installation if needed). Material and Labor allowance credit is offered through your Piper Field Service Facility, should rivet installation be required.



INSTRUCTIONS

1. Count flush rivets securing top and bottom skin panels to front and rear stringers on both stabilizers.
2. If rivet quantity at each front stringer is 77 or more and quantity at each rear stringer is 79 or more, no further action is required.
3. If rivet quantity at any of the front stringers is less than 77 and quantity at any of the rear stringers is less than 79, proceed as follows:
 - a. Measure the distance between existing flush rivets to determine where rivet spacing is more than 1 1/4 inches.
 - b. In all areas where rivet spacing is more than 1 1/4 inches, add blind rivets between existing flush rivets as required. Minimum distance between any of the rivets is .42.
 - c. When it has been determined where rivets are required, drill .144 holes (No. 27 drill) and install NAS1738B4-1 blind rivets (Piper Part No. 522 881).
 - d. Clean and paint new rivet heads.
4. Make proper logbook entry of Service Bulletin 521 Compliance.

TOP VIEW OF LEFT STABILIZER SHOWN - RIGHT OPPOSITE