



# SERVICE BULLETIN

No. 595

Piper Aircraft Corporation

Lock Haven, Pennsylvania, U.S.A.

"FAA/DOA SO-2 Approved"

June 5, 1978

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Subject: Elevator Outboard Hinge Bracket Rivets Replacement

Models Affected: Serial Numbers Affected:

PA-31 and PA-31-325 Navajos  
PA-31-350 Navajo Chieftain

31-7612040 to 31-7812055 Inclusive.  
31-7652071 to 31-7852057 Inclusive.

Compliance Time: Within the next fifty (50) hours of operation or at the next regularly scheduled inspection event, whichever occurs first.

Purpose: It has been determined that in the above referenced aircraft there exists a possibility of the rivets for the upper and lower attach point on the elevator outboard hinge bracket shearing and remaining undetected.

This service release provides instructions for the replacement of the existing rivets.

Instructions: Refer to the attached sketch/instruction data.

Material Required: Eight (8) each Huck Rivets (MS 90354-5-03), Piper part number 762 575.

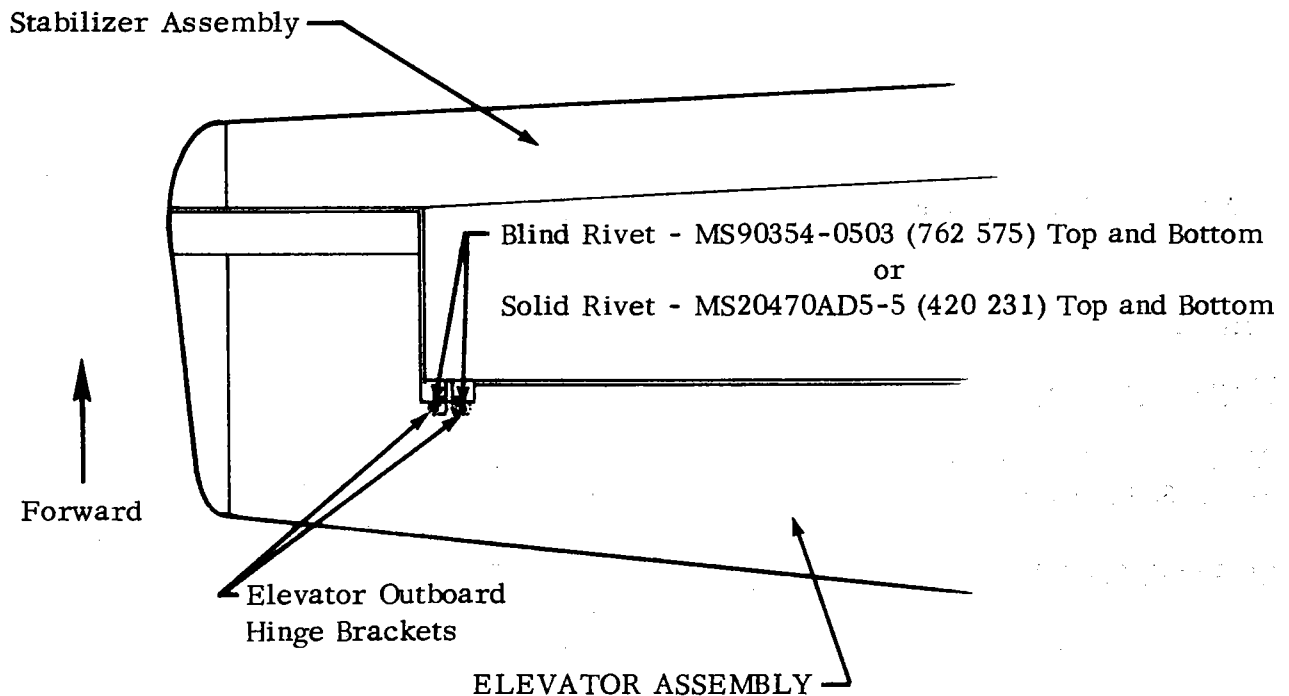
Availability of Parts: Your Piper Field Service Facility.

Effectivity Date: 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. For aircraft within their warranty period, reimbursement for one (1) hour per aircraft labor time is available through your Piper Field Service Facility in accordance with their respective labor allowance credit application procedure. Material cost - if any - is negligible.

This offer is in effect for a period of time not to exceed 180 days from the date of this Service release.

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TOP VIEW OF LEFT ELEVATOR SHOWN - RIGHT ELEVATOR OPPOSITE

### INSTRUCTIONS

1. Locate the two outboard elevator hinge brackets, on the left and right elevators, as shown on sketch above.
2. Replace existing MS20470AD4 solid rivets, attaching elevator hinge brackets to spar flange and skin, with MS90354-0503 blind rivets as follows. (If the MS90354-0503 blind rivets cannot be installed, due to lack of equipment etc., proceed to step 3 for alternate MS20470AD5-5 solid rivet installation. ) Accomplish on left and right elevator assemblies.
  - a. Remove one of the four (4) existing hinge bracket rivets as shown above. Removing one rivet at a time will prevent misalignment of the outboard elevator hinge brackets.
  - b. Enlarge the rivet hole to .166 dia. (#19 drill). Install MS90354-0503 rivet.
  - c. Repeat steps a. and b. above for each of the three (3) remaining rivets.
  - d. Make proper logbook entry of Service Bulletin 595 compliance.
3. If MS90354-0503 blind rivets cannot be installed, it will be acceptable to install MS20470AD5-5 solid rivets as follows. Accomplish on left and right elevator assemblies.
  - a. Refer to appropriate Navajo Service Manual and remove elevator assembly.
  - b. Remove one of the four (4) existing hinge bracket rivets as shown above. Removing one rivet at a time will prevent misalignment of the elevator hinge brackets.
  - c. Enlarge the rivet hole to .166 dia. (#19 drill). Install MS20470AD5-5 rivet.
  - d. Repeat steps b. and c. above for each of the three (3) remaining rivets.
  - e. Reinstall elevator assembly per appropriate Navajo Service Manual.
  - f. Make proper logbook entry of Service Bulletin 595 compliance.