

# SERVICE



# LETTER

Service Letter No. 363

November 30, 1961

TO: Distributors, Dealers, Certified Service Centers and Owners

SUBJECT: Inspection and Modification of Flaps

MODELS AFFECTED: PA-23-250 Aztec and Navy UO-1 Aircraft - Serial Nos. 27-1 to 27-451 inclusive and 27-453 to 27-504 inclusive

## NOTE

Several of the above indicated aircraft are equipped with flaps that have been modified as per this Service Letter. The serial numbers of these modified flaps are indicated below by flap serial numbers:

Flap Part #17104-40 (left):  
Flap Serial Numbers

2764	2789	2800	2809	2815	2823
2776	2790	2805	2811	2816	2827
2777	2792	2806	2812	2818	
2779	2794	2807	2813	2819	
2783	2795	2808	2814	2821	

Flap Part #17104-01 (right):  
Flap Serial Numbers

2804	2818	2842	2847	2851	2856
2811	2826	2844	2848	2852	2857
2815	2831	2845	2849	2853	2862
2817	2835	2846	2850	2854	

Aircraft having flaps with the above serial numbers will not be subject to the provisions of this Service Letter.

Service reports indicate that cracks have been noted in the outboard area of the subject flaps. These cracks may be observed in the spar, doubler or rib. It is requested that an inspection be made of these flaps to determine if cracks have developed in any one of the three components indicated. See the attached sketch.

(over)

PIPER AIRCRAFT CORPORATION, LOCK HAVEN, PA., U. S. A.

The procedure for inspection and modification of these flaps is as follows:

1. Extend flaps to full down position. Inspect area around outboard fittings for cracks (per enclosed sketch).
2. If no cracks are found, remove and discard the washers from under the nuts on the fitting bolts; install stiffener (part #19972-00) and replace nuts.
3. For cracks found in Area "A". If cracks are found in the rib flange, replace the rib (part #17104-42 L.H. or #17104-43 R.H.), stiffener part #19972-00, and doubler (part #30571-00 L.H. or #30571-01 R.H.).
4. For cracks found in Area "B". If cracks are found in the doubler, replace with new doubler (part #30571-00 L.H. or #30571-01 R.H.), install new rib and stiffener.
5. For cracks found in Area "C". If cracks are found in the spar from the bolt hole outboard; install new doubler, new rib and stiffener.
6. For cracks found in Area "D". If cracks are found in spar from bolt hole in-board, not over 1", stop drill with a .082" drill and install new doubler, new rib and stiffener.
7. For cracks found in Area "D" over 1" long. The entire flap should be replaced.

#### CAUTION

1. When drilling out rivets, be careful not to elongate holes.
2. When installing stiffener, part #19972-00, locate the stiffener so that the bend radius is toward the bend radius of the rib.

When flap replacement is necessary (per Item 7), new flaps will be furnished on a pro-rated basis in accordance with the following schedule:

<u>TIME ON AIRPLANE</u>		<u>FACTORY PARTICIPATION</u>
Less than	300 hours or 6 months	100%
Between	300 and 400 hours or 6 and 12 months	75%
Between	400 and 500 hours or 12 and 18 months	50%
Between	500 and 600 hours or 18 and 24 months	25%
Over	600 hours or 24 months	0

November 30, 1961

Distributors should order Kit No. 754 420 in sufficient quantities to comply with this Service Letter. This modification kit will include all material referred to in Paragraphs 2, 3, 4, 5 and 6 of the inspection and modification procedure. These kits will be provided on a no charge basis.

When the installation of Kit No. 754 420 is required in accordance with Paragraphs 3, 4, 5 and 6 of the inspection and modification procedure outlined in this Service Letter, seven (7) hours of warranty labor will be approved on the receipt of a Warranty and Credit Claim Form.

Very truly yours,

PIPER AIRCRAFT CORPORATION

  
Wes Holmes  
Service Manager

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(over)

Rev. December 1, 1961

INSTALLATION INSTRUCTIONS - KIT 754 420  
FLAP MODIFICATION

1. Extend flaps to full down position. Inspect area around outboard fittings for cracks as per included sketch.
2. If no cracks are found, remove and discard the washers from under the nuts on the fitting bolts; install stiffener (Part #19972-00) and replace nuts.
3. For cracks found in Area "A". If cracks are found in the rib flange, replace the rib (Part #17104-42 L.H. or 17104-43 R.H.) and install stiffener.
4. For cracks found in Area "B". If cracks are found in the doubler, replace with new doubler (Part #30571-00 L.H. or 30571-01 R.H.), install new rib and stiffener.
5. For cracks found in Area "C". If cracks are found in the spar from the bolt hole outboard; install new doubler, new rib and stiffener.
6. For cracks found in Area "D". If cracks are found in spar from bolt hole inboard, not over 1"; stop drill with a .082 drill and install new doubler, new rib and stiffener.
7. For cracks found in Area "D" over 1" long. If crack in spar inboard from bolt hole is over 1" replace entire flap.

CAUTION

When drilling out rivets, be careful  
not to elongate holes.

CAUTION

When installing stiffener Part #19972-00,  
locate the stiffener so that the bend radius  
is toward the bend radius of the rib.

1" MAX.

