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SLINGSBY SAILPLANES, KIRKBYMOORSIDE

YORK YO6 6EZ

TECHNICAL INSTRUCTION NO.65

SLINGSBY T59 KESTREL - MODIFICATION NO. 18

REPLACEMENT OF ELEVATOR ACTUATOR BRACKET

APPLICABILITY

This instruction is applicable to all marks of Slingsby T59 Kestrel Gliders.

COMPLIANCE

The modification has been made Mandatory by the Civil Aviation Authority and must be completed before the end of June 1974. Until that time the Daily Inspection called for in Technical Instruction No.63 must be continued.

MODIFICATION

Modification No.18 essentially replaces the welded steel elevator actuator bracket, Part No.59A-30-11 with a machined aluminium bracket, Part No. 59A-30-25.

PROCEDURE

1. Remove the tailplane from the aircraft and the rudder from the fin.
2. Remove the six bolts in the elevator actuator bracket and remove bracket from the tailplane.
3. Lie the fuselage on its side (to prevent nuts dropping to the base of the fin) and remove the rear tailplane attachment bracket from the fin by removing the four attachment bolts.
4. The new actuator bracket must now be assembled together using the bracket removed at 3. above. Loosely assemble the two halves of the bracket, Parts A,B,C., and fit on to the bracket removed at 3.
5. Holding the two halves firmly, drill the rivet hole, Letter D (.246") and ream to .25" +.002"
-.000"

6. Remove the fittings and deburr the holes drilled at 5.
7. Reassemble the two halves of the fitting applying a jointing compound (Celoseal) and rivet the two halves together, preferably with the fitting assembled to the tailplane rear attachment bracket as in 4.
8. Using a thin coat of Epoxy resin (Epikote 162, Epicure 113) replace the tailplane rear attachment bracket removed at 3. The resin will ensure a good fit of the bracket and its bolts, eliminating fretting at the bolt holes.
9. Fit the new bracket to the tailplane and fit the tailplane to the aircraft.
10. Check for full elevator movement and general freedom of controls. Elevator movement is; up $16.5^{\circ} \pm 1.5^{\circ}$; down $16.5^{\circ} \pm 1.5^{\circ}$.
11. Refit the rudder.
12. The aircraft should not be flown until the resin applied at 8. has cured, which should be after 12 hours at 65°F .

PARTS REQUIRED

1. Elevator Actuator Bracket (Replacement Kit, Part No.59A-03-8A/B/C)
2. Drawing of above - Drawing No.59A-03-7
3. Celoseal - 10 gms.
4. Epoxy Resin; Epikote 162 - 50 gms.
Epicure 113 - 19 gms.

These parts may be obtained from Slingsby Sailplanes, Irkbymoorside, York YO6 6EZ, England.