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AIRCRAFT MAINTENANCE MANUAL

CHAPTER 55
STABILIZERS

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RUDDER AND HORIZONTAL STABILIZERS - INSPECTION/CHECK

1. General

A. This procedure has one task. The task gives instructions to do a visual inspection of the internal area of the rudder and the horizontal stabilizers.

TASK 55-00-01-200-801

2. Examine the Composite Flight Controls

A. General

(1) Use the equipment listed below to examine the composite flight controls:

- (a) Flexible Video Borescope with (4) four way articulation, .5 inch (12mm) diameter X 10 feet (3m) long insertion tube with forward and side viewing optical tip adapters.
- (b) Flexible Fiberoptic Borescope with (4) four way articulation, .35 inch (8mm) diameter X 3 feet (1m) long insertion tube with forward and side viewing optical tip adapters.
- (c) Flexible or rigid guide tube - Dekoron is a trade mark for a formable type metal cored tubing.

B. Location Zones

Zone	Area
320	Subzone - Vertical Fin and Rudder
330	Subzone - Left Horizontal Stabilizer and Elevator
340	Subzone - Right Horizontal Stabilizer and Elevator

C. Procedure

SUBTASK 55-00-01-010-001

(1) Remove the access panels that are necessary.

SUBTASK 55-00-01-290-001

(2) Put the borescope tube into an access hole that is 2 inches in diameter.

SUBTASK 55-00-01-290-002

(3) Move the borescope tube until you can see an area where an inspection is necessary.

NOTE: If you can not move the optical tip into the correct areas, use a guide tube.

SUBTASK 55-00-01-290-003

(4) Examine the area for these unsatisfactory conditions:

NOTE: Do not move the borescope tube while you examine an area.

- (a) Signs of deterioration.
- (b) Bulges and cracks on the skins and the ribs.
- (c) Corrosion on the fasteners.
- (d) Other signs of the stress.

SUBTASK 55-00-01-970-001

(5) Make a record of all the unsatisfactory conditions before you move the borescope to a different area.

SUBTASK 55-00-01-410-001

(6) Install the access panels.

————— END OF TASK —————

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STABILIZER - STRUCTURAL INSPECTIONS - MAINTENANCE PRACTICES

TASK 55-05-03-210-801

1. INTERNAL - GENERAL VISUAL: INTERNAL - HORIZONTAL STABILIZER CENTER SECTION

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-210-001

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-210-802

2. INTERNAL - GENERAL VISUAL: INTERNAL - STABILIZER TORSION BOX COMPARTMENT

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-210-002

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-210-803

3. INTERNAL - GENERAL VISUAL: INTERNAL - VERTICAL FIN LEADING EDGE

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-210-003

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-210-804

4. INTERNAL - GENERAL VISUAL: INTERNAL - VERTICAL FIN

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-210-004

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-210-805

5. INTERNAL - GENERAL VISUAL: INTERNAL - VERTICAL FIN TRAILING EDGE

A. General

(1) This procedure is a scheduled maintenance task.

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B. Inspection

SUBTASK 55-05-03-210-005

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-210-806

6. INTERNAL - GENERAL VISUAL: INTERNAL - LEFT HORIZONTAL STABILIZER LEADING EDGE

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-210-006

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-210-807

7. INTERNAL - GENERAL VISUAL: INTERNAL - RIGHT HORIZONTAL STABILIZER LEADING EDGE

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-210-007

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-210-808

8. INTERNAL - GENERAL VISUAL: INTERNAL - LEFT HORIZONTAL STABILIZER LEADING EDGE

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-210-008

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-210-809

9. INTERNAL - GENERAL VISUAL: INTERNAL - RIGHT HORIZONTAL STABILIZER LEADING EDGE

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-210-009

(1) Do the inspection.

————— END OF TASK —————

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TASK 55-05-03-210-810

10. INTERNAL - GENERAL VISUAL: INTERNAL - LEFT HORIZONTAL STABILIZER

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-210-010

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-210-811

11. INTERNAL - GENERAL VISUAL: INTERNAL - RIGHT HORIZONTAL STABILIZER

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-210-011

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-210-812

12. INTERNAL - GENERAL VISUAL: INTERNAL - LEFT HORIZONTAL STABILIZER TRAILING EDGE

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-210-012

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-210-813

13. INTERNAL - GENERAL VISUAL: INTERNAL - RIGHT HORIZONTAL STABILIZER TRAILING EDGE

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-210-013

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-211-801

14. INTERNAL - DETAILED: LEFT ELEVATOR TAB SUPT FTGS ON FRONT SPAR AND TAB SPAR AT LEADING EDGE CUTOUTS

A. General

(1) This procedure is a scheduled maintenance task.

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B. Inspection

SUBTASK 55-05-03-211-001

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-211-802

15. INTERNAL - DETAILED: RIGHT ELEVATOR TAB SUPT FTGS ON FRONT SPAR AND TAB SPAR AT LEADING EDGE CUTOUTS

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-211-002

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-210-814

16. INTERNAL - GENERAL VISUAL: INTERNAL - LEFT HORIZONTAL STABILIZER TRAILING EDGE

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-210-014

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-210-815

17. INTERNAL - GENERAL VISUAL: INTERNAL - RIGHT HORIZONTAL STABILIZER TRAILING EDGE

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-210-015

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-211-803

18. INTERNAL - DETAILED: INTERNAL - LEFT ELEVATOR TAB HINGE FITTING

(Figure 201)

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-211-003

(1) Do the inspection.

————— END OF TASK —————

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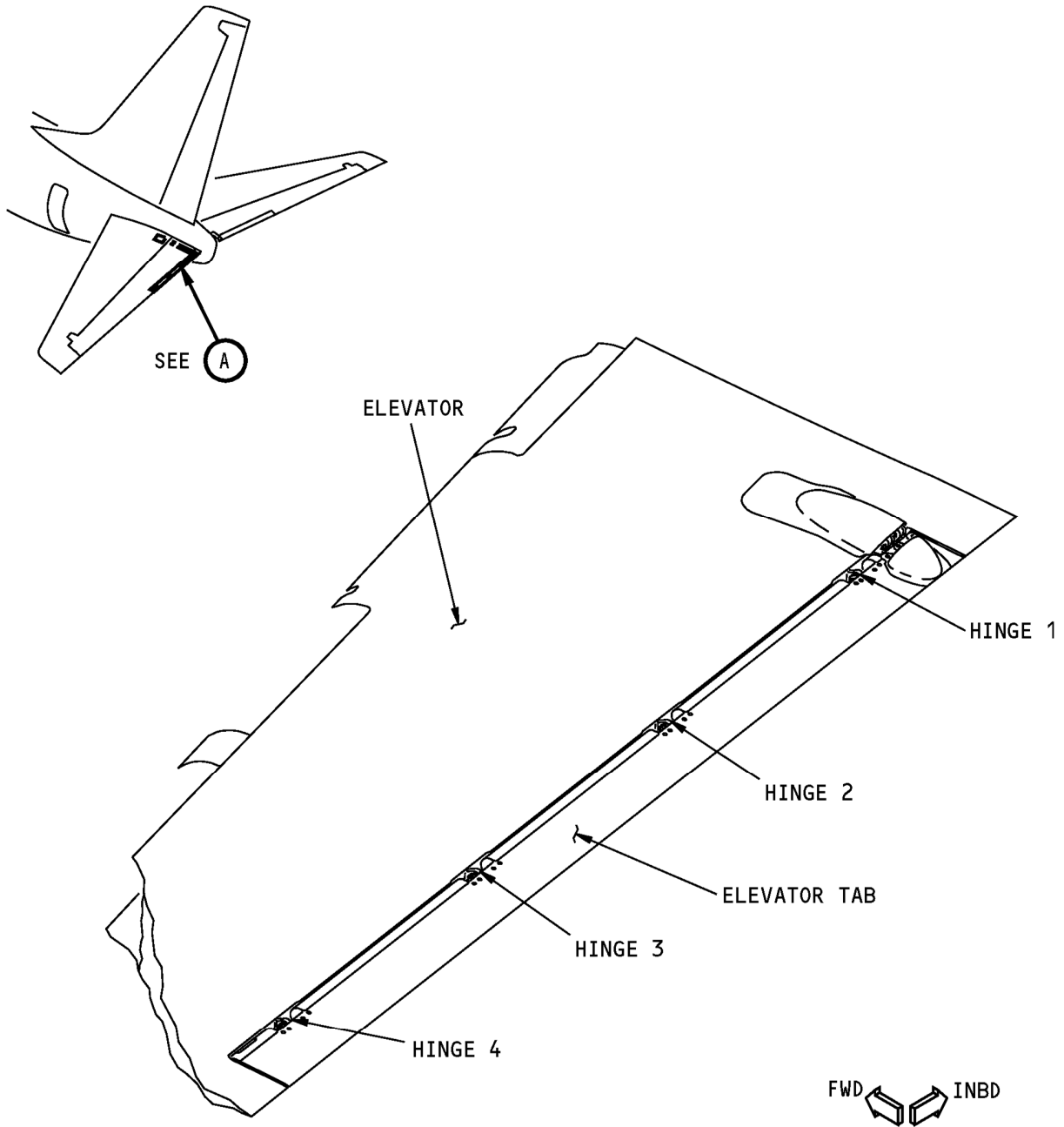
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LEFT ELEVATOR TAB



Left Elevator Tab
Figure 201/55-05-03-990-801

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TASK 55-05-03-211-806

19. INTERNAL - DETAILED: INTERNAL - RIGHT ELEVATOR TAB HINGE FITTING

(Figure 202)

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-211-006

(1) Do the inspection.

————— END OF TASK —————

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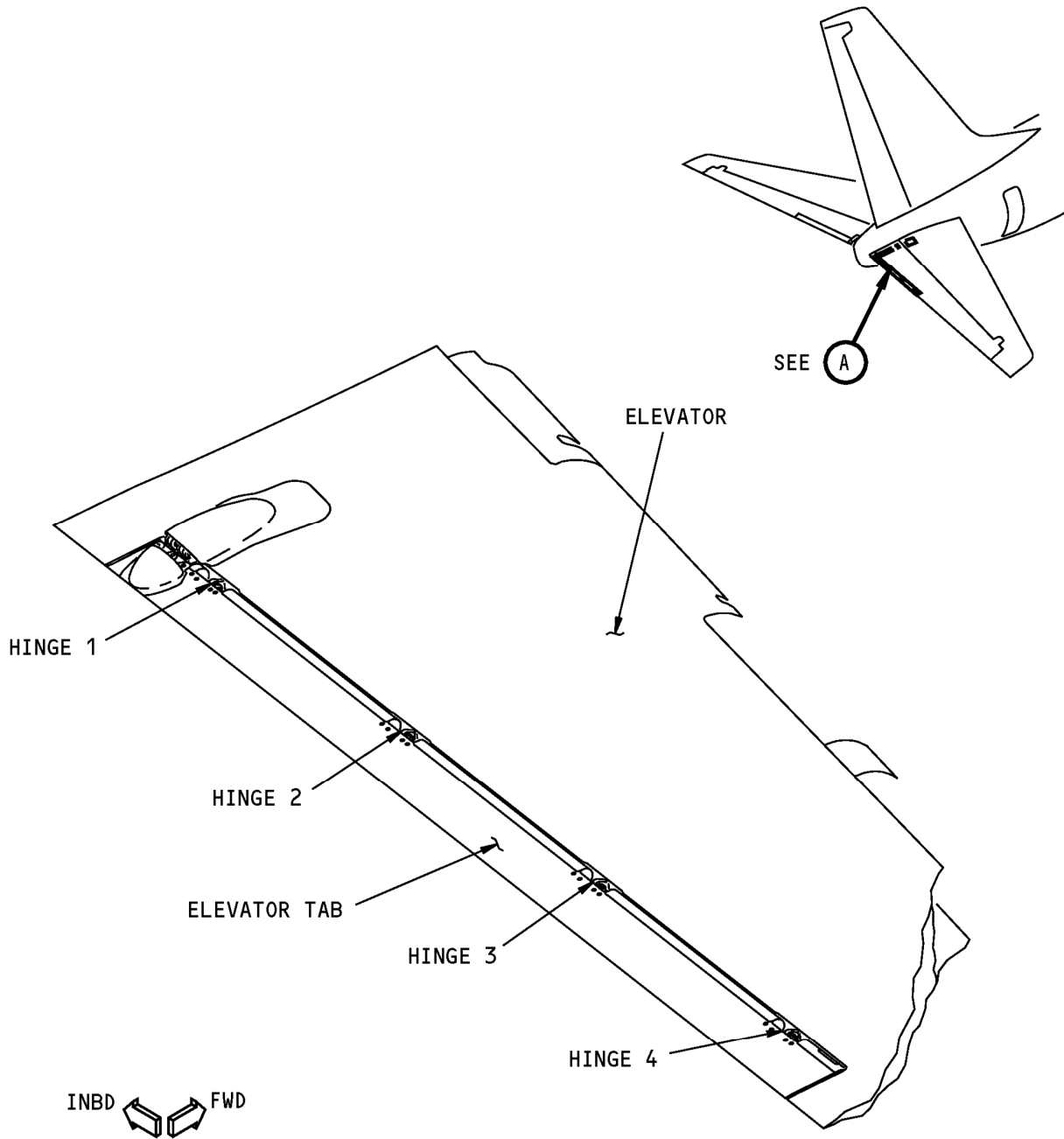
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RIGHT ELEVATOR TAB



Right Elevator Tab
Figure 202/55-05-03-990-804

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TASK 55-05-03-210-816

20. INTERNAL - GENERAL VISUAL: INTERNAL - RUDDER, ELEVATOR AND ELEVATOR TAB ATTACH FITTINGS

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-210-016

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-211-807

21. INTERNAL - DETAILED: LEFT ELEVATOR HINGE, ACTUATOR, AND TAB MAST ARM FTGS AND BALANCE WT SUPPT STRUC

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-211-007

(1) Do the inspection.

————— END OF TASK —————

TASK 55-05-03-211-808

22. INTERNAL - DETAILED: RIGHT ELEVATOR HINGE, ACTUATOR, AND TAB MAST ARM FTGS AND BALANCE WT SUPPT STRUC

A. General

(1) This procedure is a scheduled maintenance task.

B. Inspection

SUBTASK 55-05-03-211-008

(1) Do the inspection.

————— END OF TASK —————

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THRUST BRACE LINKS - REMOVAL/INSTALLATION

1. General

- A. This procedure has two tasks:
 - (1) A removal of the thrust brace links.
 - (2) An installation of the thrust brace links.
- B. The thrust brace links are located at the rear spar of the horizontal stabilizer center section.
- C. There are four thrust brace links (two on each side).

TASK 55-10-10-000-801

2. Thrust Brace Links Removal

(Figure 401, Figure 402, Figure 403)

A. References

Reference	Title
24-22-00-860-812	Remove Electrical Power (P/B 201)
27-41-31-000-801	Horizontal Stabilizer Center Section Hinge Fitting Removal (P/B 401)
29-11-00-860-805	Hydraulic System A or B Power Removal (P/B 201)

B. Tools/Equipment

Reference	Description
SPL-1672	Assembly - Lock, Stabilizer Trim (Part #: F71336-501, Supplier: 81205)

C. Location Zones

Zone	Area
300	Empennage

D. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door

E. Prepare for the Removal

SUBTASK 55-10-10-860-001

- (1) Do this task: Hydraulic System A or B Power Removal, TASK 29-11-00-860-805.

SUBTASK 55-10-10-860-002

- (2) Set the stabilizer trim cutout switches to the CUTOFF position.

NOTE: The stabilizer trim cutout switches are installed on the control stand.

SUBTASK 55-10-10-860-003

- (3) Do this task: Remove Electrical Power, TASK 24-22-00-860-812.

SUBTASK 55-10-10-860-004

- (4) Use the stabilizer trim wheel on the control stand to set the horizontal stabilizer at zero degree (3 units of trim).

SUBTASK 55-10-10-480-002

- (5) Install the lock, SPL-1672 on the stabilizer trim wheel at the control stand (TASK 27-41-31-000-801):

- (a) Turn the trim wheel to put the handle at the top of the wheel.

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- (b) Adjust the height of the trim lock to put the trim wheel handle correctly on the yoke.
- (c) Install the pin through the yoke.
- (d) Install the safety pin.

SUBTASK 55-10-10-010-001

(6) Open this access panel:

(Figure 401)

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

SUBTASK 55-10-10-480-001

(7) Install suitable wood beams to support the center section at approximately any horizontal position, (Figure 402).

F. Remove the Thrust Brace Links

SUBTASK 55-10-10-020-001

(1) Disconnect the upper inboard end, (Figure 401).

- (a) Remove the cotter pin [6] and nut [5].
- (b) Remove the two washers [7], the washer [4], and the bolt [3].
- (c) Discard the two washers [7].
- (d) Disconnect the thrust brace link [1] from the center section fitting.

SUBTASK 55-10-10-020-002

(2) Disconnect the lower inboard end, (Figure 401).

- (a) Remove the cotter pin [6] and nut [5].
- (b) Remove the two washers [7], the washer [4], and the bolt [8].
- (c) Discard the two washers [7].
- (d) Disconnect the thrust brace link [2] from the center section fitting.

SUBTASK 55-10-10-020-003

(3) Disconnect the upper outboard end.

- (a) Remove the cotter pin [6] and nut [5].
- (b) Remove the two washers [7], the washer [4], and the bolt [3].
- (c) Discard the two washers [7].
- (d) Remove thrust brace link [1] from the fitting.

SUBTASK 55-10-10-020-004

(4) Disconnect the lower outboard end.

- (a) Remove the cotter pin [6] and the nut [5].
- (b) Remove the two washers [7], the washers [4], and the bolt [3].
- (c) Discard the two washers [7].
- (d) Remove thrust brace link [2] from the fitting.

————— END OF TASK —————

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TASK 55-10-10-400-801

3. Thrust Brace Link Installation

(Figure 401, Figure 402, Figure 403)

A. References

Reference	Title
24-22-00-860-811	Supply Electrical Power (P/B 201)
27-41-31-400-801	Horizontal Stabilizer Center Section Hinge Fitting Installation (P/B 401)
29-11-00-860-801	Hydraulic System A or B Pressurization (P/B 201)

B. Tools/Equipment

Reference	Description
SPL-1672	Assembly - Lock, Stabilizer Trim (Part #: F71336-501, Supplier: 81205)

C. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

D. Location Zones

Zone	Area
300	Empennage

E. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door

F. Install the Thrust Brace Links

SUBTASK 55-10-10-420-001

(1) Connect the upper inboard end, (Figure 401).

(a) Install the thrust brace link [1] to the center section fitting.

1) Apply grease, D00633 to the shank and thread of bolt [3].

2) Install the two washers [7], the bolt [3] and the washer [4].

NOTE: The two washers [7] should be new washers.

3) Install the nut [5] and the cotter pin [6].

a) Tighten nut [5] to 440-540 pound-inches (49.7-61.0 Nm).

NOTE: If the cotter pin slot in the nut does not align with the cotter pin hole in the bolt within the specified torque range, tighten the nut to obtain cotter pin hole alignment, but do not exceed 650 pound-inches (73.4 Nm).

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(2) Connect the lower inboard end.

(a) Install the thrust brace link [2] to the center section fitting.

1) Apply grease, D00633 to the shank and thread of bolt [8].

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