



Nomad SERVICE BULLETIN

Reference No 270

TRANSMITTAL LETTER
FOR
SERVICE BULLETIN NMD-52-12

DOORS — ENTRANCE — UTILITY STEPS (CO G100)
— REINFORCEMENT (Mod N732)

1. **Reason**

To prevent cracking of the side member assemblies of the utility steps in the vicinity of the support strut attachment.

2. **Instructions**

Insert Service Bulletin NMD-52-12 and Transmittal letter dated 7 Feb 1995 into the Service Bulletin publication and annotate the index accordingly.

Revision Status

Original 7 Feb 1994

D J PILKINGTON
TECHNICAL SERVICES MANAGER

7 Feb 1995

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DOORS — ENTRANCE — UTILITY STEPS (CO G100) — REINFORCEMENT (Mod N732)

1. PLANNING INFORMATION

A. Effectivity

(1) Aircraft Affected

All N22 series and N24 series aircraft fitted with Customer Option G100 (Passenger Entry Utility Steps).

(2) Spares Affected

All spares of Utility Steps PN 1/N-84-101 and PN 2/N-84-101.

B. Reason

To prevent cracking of the side member assemblies of the utility steps in the vicinity of the support strut attachment.

C. Description

The existing side plates on the side member assemblies are replaced by two reinforcing plates and two angles.

D. Compliance

(1) Compliance with this Service Bulletin is recommended.

(2) Aircraft — At the next 300 hourly service or within 12 months following receipt of this Service Bulletin whichever occurs first.

(3) Spares in stock — Prior to sale or being placed into service.

E. Approval

The requirement detailed herein has been approved by a person authorised under Civil Aviation Regulation 35 and conforms with the type certificate requirements.

F. Manpower

Approximately 4 man-hours.

G. Materials Price and Availability

Contact ASTA Defence Customer Spares for price and availability of modification parts kit NMD-52-12-1.

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H. Tooling Price and Availability

None.

I. Weight and Balance

Negligible.

J. References

None.

K. Publications Affected

Customer Option G100 Maintenance Manual Supplement
Customer Option G100 Illustrated Parts Catalogue Supplement

2. ACCOMPLISHMENT INSTRUCTIONS

A. Disassembly

- (1) Derivet centre step PN 1/N-84-102 (Ref Fig 1). Support tube PN 1/N-84-111 and punch out two pins PN 1/N-84-113. Discard pins.
- (2) Grind off the peened end of the two bolts securing tube PN 1/N-84-111. Remove nuts, washers and bolts and scrap. Withdraw tube completely.
- (3) Scrap spacers PN 1/N-84-114 (2-off) and PN 1/N-84-127 (2 off). Derivet and remove four side plates PN 1B/N-84-103 from the LH and RH side members (Ref Fig 1). Punch out rivet tails from the side members. Scrap side plates.

B. Rework

- (1) Position bottom plate PN 1F/N-84-103 and top plate 1E/N-84-103 on the forward face of the RH side member tube (Ref Fig 2).
- (2) Insert the 1/4 in bolt to align the plates and side member tube. Clamp in position.
- (3) Temporarily clamp inner angle PN 1H/N-84-103 and outer angle PN 1G/N-84-103 and ensure there is sufficient clearance between the angles and the plates (Ref Fig 2 Section X X). Remove the inner and outer angles.

NOTE

When backdrilling take care not to enlarge or elongate existing holes in the side member tube.

- (4) Using existing holes on the side member, backdrill eight rivet holes with a No 30 drill. Drill the remaining 10 rivet holes, using a No 30 drill (Ref Fig 2).
- (5) Remove plates and deburr holes.
- (6) Position inner angle PN 1H/N-84-103 on the side member tube making sure correct alignment (Ref Fig 2) and clamp in place.

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- (7) Drill the six rivet holes on the side with a No 30 drill.
- (8) Remove angle, deburr holes then pin in position with 1/8 skin pins. Using a drill bush (OD 0.6266/0.6250 in, ID 0.2500 in) backdrill a pilot hole in the inner angle.
- (9) Open up the 0.2500 in pilot hole. Ream hole "B" to the same size as existing hole in side member tube.
- (10) Position outer angle PN 1G/N-84-103 on the side member tube (Ref Fig 2) and clamp. Ensure correct alignment. Repeat steps (7) to (10) for outer angle.
- (11) Using existing holes on the side member, backdrill eight rivet holes with a No 30 drill.
- (12) Drill the remaining 10 rivet holes in the bases of the angles with a No 30 drill, as shown in Figure 2.
- (13) Using a drill bush (OD 0.2500) drill then ream hole "A" in base of the angles to the same size as existing hole in side member tube.
- (14) Remove angles and deburr holes.
- (15) Wet assemble with Zinc Chromate Primer, inner and outer angles and top and bottom plates.
- (16) Rivet up using 18-off Cherrymax rivets PN CR3523P4-2 and 30-off Cherrymax rivets PN CR3523P4-3 (Ref Fig 2).
- (17) Repeat steps (1) to (16) for AFT side member. Surface finish reworked areas and new spacers before reassembly.

C. Reassembly

- (1) On tube PN 1/N-84-111 use a reamer to remove any loctite from pin holes.
- (2) Refit tube PN 1/N-84-111 and install new spacers PN 2/N-84-114 between strut assemblies and side members and spacers PN 2/N-84-127 between side members and step support assembly.
- (3) Fit new bolts PN NAS1104-19, washers PN AN960 416L and nuts PN AN316-4R. Peen bolt end.
- (4) Fit new pins PN 1/N-84-113 secure in place using Retaining Compound 75 (Loctite).
- (5) Pin step PN 1/N-84-102 in position and attach using pop rivets PN AGS2050-424BS (14 off).
- (6) Reidentify utility steps assembly PN 1/N-84-101 or PN 2/N-84-101 by adding /NMD-52-12 after the part number.

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3. MATERIALS INFORMATION

The following parts are required per aircraft.

New Part No	Qty	Description	Old Part No	Instruction/Disposition
Contents of Service Bulletin kit NMD-52-12-1				
1/N-84-113	2	PIN		
1E/N-84-103	2	PLATE, Top		
1F/N-84-103	2	PLATE, Bottom		
1G/N-84-103	2	ANGLE, Outer		
1H/N-84-103	2	ANGLE, Inner		
2/N-84-114	2	SPACER	1/N-84-114	Scrap old part
2/N-84-127	2	SPACER	1/N-84-127	Scrap old part
AGS2050-424BS	14	RIVET, Pop		
AN316-4R	2	NUT, 1/4 in		
AN960-416L	2	WASHER, 1/4 in		
CR3523P4-2	36	RIVET, Cherrymax, 1/8 in		
CR3523P4-3	60	RIVET, Cherrymax, 1/8 in		
NAS1104-19	2	BOLT, 1/4 in	NAS1104-17	Scrap old part
Parts removed				
	4	Plate, Side	1B/N-84-103	Scrap

4. SPECIAL TOOLS AND EQUIPMENT

Following drill bushes are required to carry out the rework detailed in this Service Bulletin and may be locally manufactured.

	Outer Dia.	Inner Dia.
Drill bush 1	0.6266/0.6250 in	0.2500 in
Drill bush 2	0.2500 in	0.200 in

5. RECORDING

- A. Record compliance with Service Bulletin NMD-52-12 in the Aircraft Log Book.
- B. Strike out Mod Plate SD320, located on the forward face of frame 67.95, as follows:
 - (1) N22 Series aircraft Strike out No 182 on mod plate stamped 1/N-00-111 or 11/N-00-111 respectively.
 - (2) N24A aircraft Strike out No 115 on mod plate stamped 201/N-00-1010.

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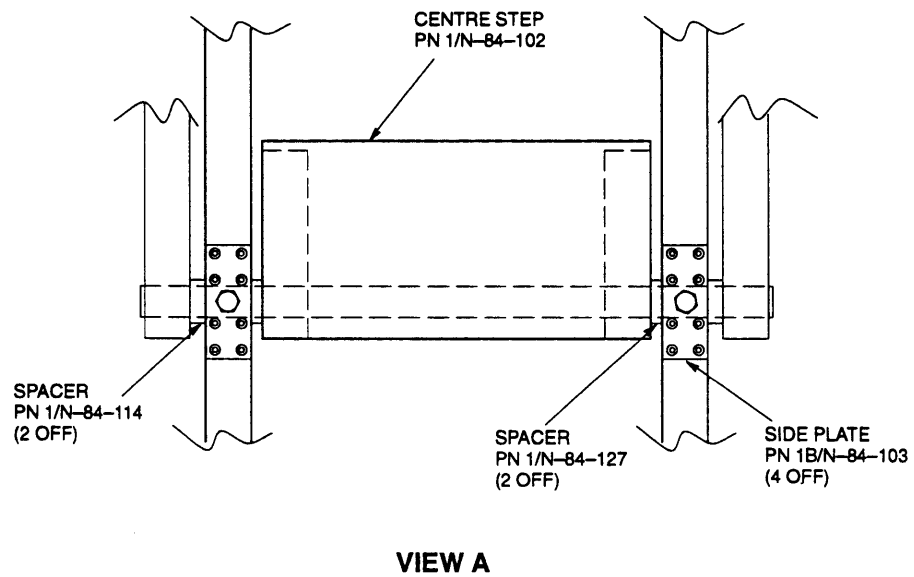
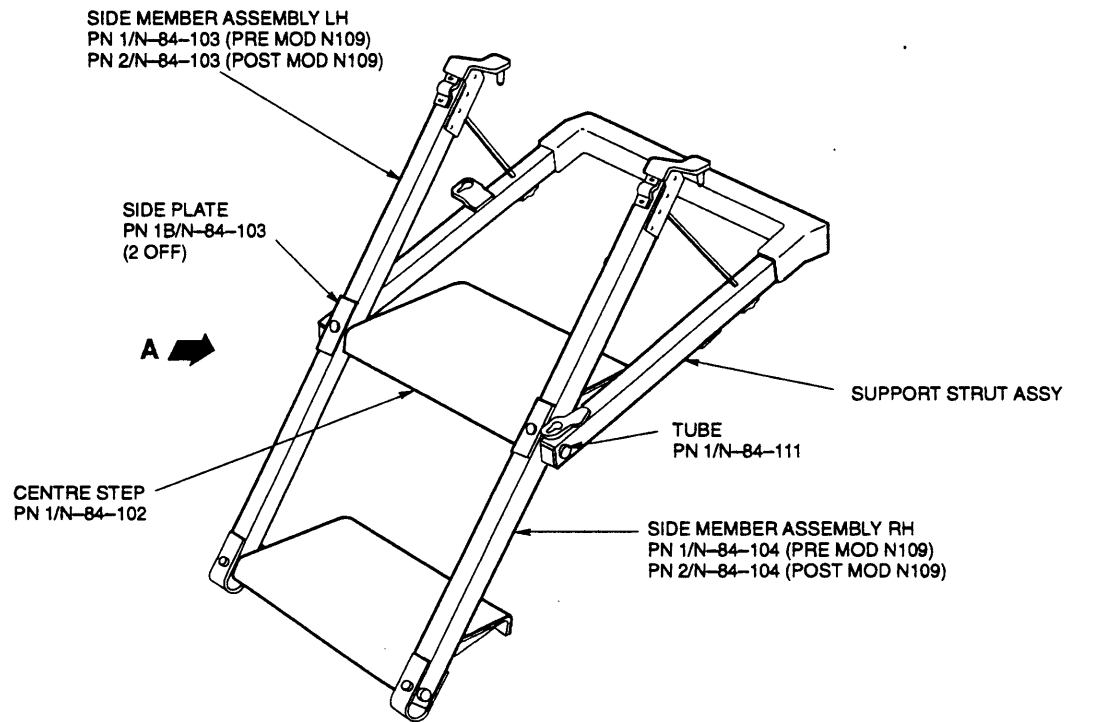


Figure 1 Utility Steps (CO G100) Pre Mod N732

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