

Airworthiness Directive

DCA/750XL/8 Fuselage Roof, Station 180.85 – Inspection and Repair

Applicability: Model 750XL aircraft, S/Ns 102, 104 to 120, 122 and 125.

Requirement: To detect the possible installation of undersize rivets in the fuselage roof at STN 180.85, BL 19.67, WL 86.2 accomplish the following:

Inspect the rivets in the fuselage roof at STN 180.85, BL19.67, WL 86.2, per the accomplishment instructions in Pacific Aerospace Corporation (PAC) Service Bulletin No. PACSB/XL/019, dated 21 April 2006.

Replace undersize rivets, per the replacement instructions in PAC SB No. PACSB/XL/019.

(PACSB/XL/019 refers)

Compliance: Within the next 150 hours TIS.

Effective Date: 31 August 2006



MANDATORY SERVICE

PACIFIC AEROSPACE CORPORATION

Pacific Aerospace Corporation Limited
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PACSB / XL / 019

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INSPECTION – Fuselage roof, Station 180.85

1. PLANNING INFORMATION

- | | | |
|----|--------------------|--|
| A. | EFFECTIVITY | PAC 750XL aircraft Serial No's; 102, 104 - 120 inclusive, 122,125. |
| B. | REASON | Possible installation of undersize rivets in the fuselage roof at STN 180.85, BL 19.67, WL 86.2. |
| C. | DESCRIPTION | This inspection is to determine that the rivets installed are actually 5/32" rather than 1/8". |
| D. | COMPLIANCE | At next 150 hours inspection. |
| E. | APPROVAL | By the delegated authority. |
| F. | TOOLING | No special tools are required. |
| G. | WEIGHT AND BALANCE | Not affected. |
| G. | REFERENCE | PAC 750XL Maintenance Manual |

N/A | NSOD | NIA | LARGE
 DCAI... 750XL / 8
 02 AUG 2006

1.0 Background:

During routine inspection of an aircraft during release to service at Pacific Aerospace Corporation, it was identified that a row of 1/8" solid rivets had been incorrectly fitted where 5/32" solid rivets had been specified in the fuselage top (43 locations). STN 180.85, BL 19.67, WL 86.2 (Fig 1)

Investigations have indicated that this may well have been an isolated case as all other fuselages inspected at Pacific Aerospace Corporation revealed that the correct rivets had been fitted as specified.

However in order to avoid the possibility that the same error may have occurred in earlier aircraft the following recommendations are made.

A visual inspection of these specific co-ordinates must be performed in order to identify that 5/32" rivets have been fitted and not 1/8".



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2.0 Accomplishment instructions (Inspection)

- 2.1 At the co-ordinates specified visually inspect to determine that the correct rivet 5/32" has been installed. Using aids as necessary, (e.g. verniers) examine the rivet heads in the positions indicated. Refer to the illustration (Fig 1) which shows the fuselage roof.
- 2.2 The rivet heads at the points arrowed should be those of 5/32" rivets, clearly larger than those (1/8"). As a guide the head of the 5/32" rivet should measure \varnothing 0.327" the incorrect 1/8" rivet head size should measure \varnothing 0.289".
- 2.3 If rivets are 5/32", no further work is required complete section 4.0 of this SB.
- 2.4 If the rivets appear to be 1/8", proceed as in part 3.0.

3.0 Replacement

- 3.1 Incorrect rivets to be removed and replaced using the following rivet type MS20470AD5 (43). Components are available from Pacific Aerospace Customer Service.
 - Referring to the Maintenance Manual, Chapters 25 & 53 remove the Roof cabin linings.
 - Drill the heads and remove the 1/8" rivets one at a time, following normal rivet removal procedure.
 - As each rivet is removed, drill the hole out to 5/32", then ream using a number 21 (0.159") ream.
 - Install and drive an MS20470AD5 rivet.
 - Proceed until all 43 affected rivets have been replaced.
 - Paint in accordance with standard aircraft practices refer to Maintenance Manual Chapter 20.
- 3.2 Reinstall the cabin lining referring to the Maintenance Manual, Chapter 25.

4.0. CERTIFICATION

Record compliance with this Bulletin in the Airframe Log Book,



MANDATORY SERVICE

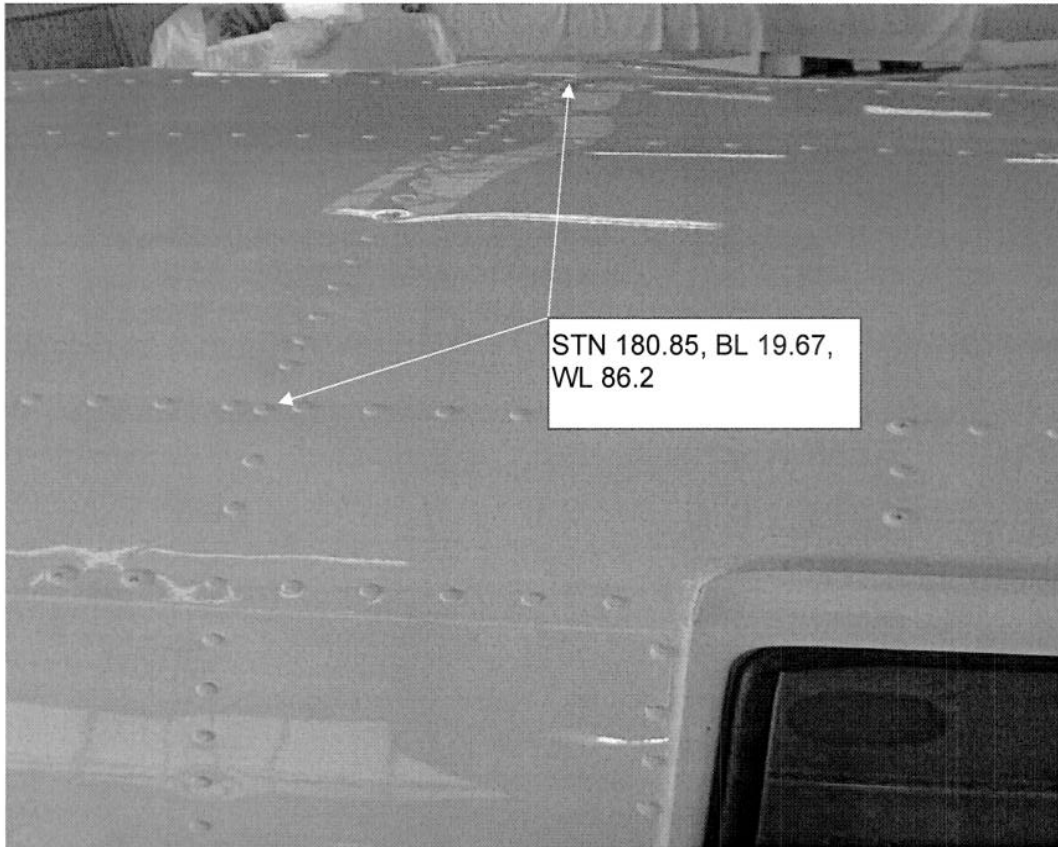
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Figure 1



3.



Aircraft Certification Service
Federal Aviation Administration

FAA MCAI INFORMATION FORM

To: Airworthiness Authority of

In support of the FAA's actions to address your country's Mandatory Continued Airworthiness Information (MCAI) in the United States, please provide the items highlighted below by _____, if not contained in the referenced Airworthiness Directive (AD) or service information.

Aircraft Manufacturer/Model	ECAA AD/Revision No./Date	Service Bulletin/Revision No./Date
Pacific Aerospace 750XL	DCA/750XL/8 31 AUG 06	PACSB/XL/019

1. Describe the unsafe condition, AND its root cause. Include description of how the problem could affect the safe operation of the airplane. *Undersize rivets installed in fuselage frame to skin joint. Production error, may affect fuselages ability to sustain limit loads.*
2. Provide the number and description of occurrences that prompted the AD.
 Number of Occurrences: *1 occurrence*
 Description: *Detected by manufacturer during regular post production QA check*
3. How was the compliance time (s) established?
Inspection to be accomplished at next scheduled maintenance check.
4. Cost of parts and/or installation work hours for the owner/operator (data from the manufacturer and their supplier, if applicable):
 Costs: *Inspection : 0.5 manhours*
 Work hours: *Repair : TBA*
5. If parts are required, are they available for all aircraft?
 Yes No Not applicable Availability/Lead Time: *Standard A/C Rivets*
6. What category best describes the cause of the unsafe condition?
 Design Problem Quality Control Problem Operational
 Maintenance Unapproved Parts Other (Specify)
7. Should a ferry flight be permitted?
 Yes No
8. Number of aircraft affected, by serial number (S/N) (U.S. Registered and Worldwide):
 ALL, or S/N: *102, 104 - 120, 122, 125.*
 U.S. Registered _____
 Worldwide (including) U.S. Registered *20*
9. If this is interim action, is terminating action available? If so, please provide description and recommended compliance time.
10. Other: *Manufacturer has issued SB, no other reports of discrepant rivets received. AD issued to ensure compliance with SB.*

Date: *30 AUG 06*