

SERVICE BULLETIN

CESSNA / CITATION II

SB550-57-2

TITLE

AILERON FENCE REPLACEMENT

EFFECTIVITY

<u>MODEL</u>	<u>UNIT NUMBER</u>
550/551	-0002 THRU -0018, -0020 THRU -0045, -0047 AND -0048

The intent of this Service Bulletin has been incorporated on production airplanes 550/551, Unit -0049 and On.

REASON

To provide additional static lateral stability below approach speeds.

DESCRIPTION

This bulletin provides parts and instructions for replacing the existing aileron fences with new, taller fences.

COMPLIANCE

Mandatory

APPROVAL

FAA-DER Approved.

MANPOWER

<u>WORK PHASE</u>	<u>MAN-HOURS</u>
Modification	21.5

Authorized Citation Service Facilities may submit a Warranty Claim Form for accomplishment of this bulletin, provided the work is completed and the claim submitted by December 4, 1980.

MATERIAL-Cost and Availability

<u>PART NUMBER</u>	<u>AVAILABILITY</u>	<u>COST</u>
SB550-57-2	July 6, 1980	No Charge

TOOLING

None.

CHANGE IN WEIGHT AND BALANCE

Negligible.

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REFERENCE

None.

OTHER PUBLICATIONS AFFECTED

Cessna Citation II Illustrated Parts Catalog.

ACCOMPLISHMENT INSTRUCTIONS

1. Remove the right and left aileron from the wing and place on a clean, padded work table.
2. Remove rivets as required to remove the aileron fence. Carefully remove the fence from the aileron. Scrape away existing sealer from the aileron using a non-metallic scraper such as phenolic or plexiglas with one edge sharpened at a 45° angle.
3. (See Figure 1) Place and clamp the 5524000-77 Fence in position and back drill (.098) diameter holes thru the fence (2 places) using the existing holes in the aileron trailing edge. Use temporary sheet metal fasteners at these two locations.
4. Using a hole finder, locate the other four (4) holes and drill (.140) diameter thru the fence (4 places). Deburr all holes in the fence.
5. Repeat Steps 2 thru 4 for the left aileron trim tab and the 5524200-41 Fence.
6. Clean the ailerons in the area where the 5524000-77 Fence (RH aileron) and the 5524200-41 Fence (LH aileron trim tab) is to be installed using isopropyl alcohol. Also clean the lower surface of each fence with isopropyl alcohol.
7. Apply a thin coating of sealer from the MIL-S-8802 Semkit to the faying surfaces and install the 5524000-77 Fence (LH Aileron Trim Tab) and 5524200-41 Fence (RH Aileron) using MS20426B3-8 and NAS1739B4-2 Rivets as shown.
8. Apply a small fillet of sealer from the MIL-S-8802 Semkit around the edge of each fence.
9. Allow 24 hours before touch up and painting in accordance with the Maintenance Manual.
10. Allow the paint to dry then balance each aileron in accordance with Chapter 51 of the Cessna Citation Structural Repair Manual.
11. Reinstall each aileron in accordance with the Maintenance Manual.
12. Check for proper operation of the aileron controls.

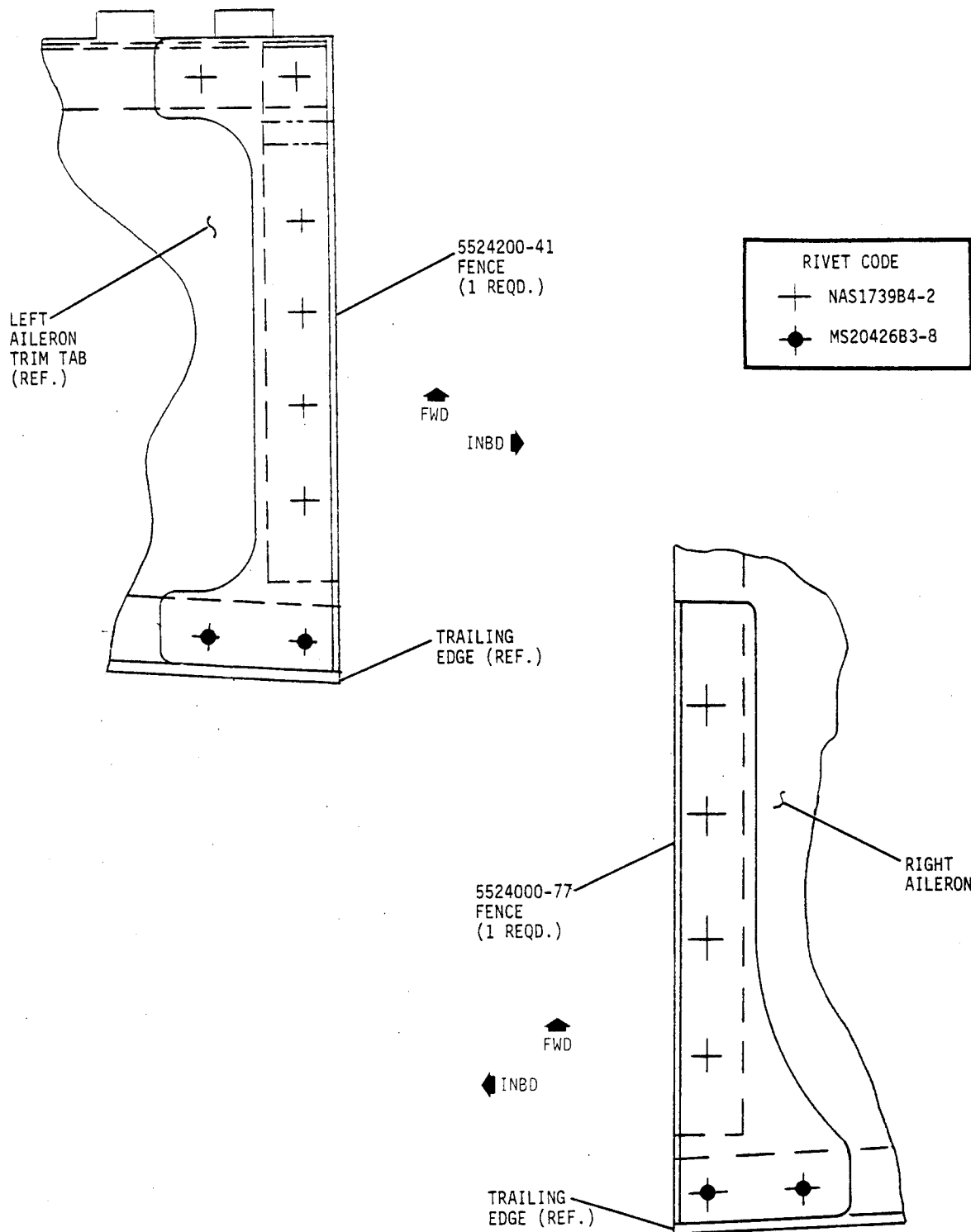
MATERIAL INFORMATION

The parts in this bulletin cover the installation for one airplane.

<u>NEW P/N</u>	<u>QUANTITY</u>	<u>KEY WORD</u>
SB550-57-2	1	Consisting of the following:
5524000-77	1	Fence
5524200-41	1	Fence
NAS1739B4-2	10	Rivet
MS20426B3-8	4	Rivet
MIL-S-8802	1	Semkit, 2 1/2 Oz. Sealer

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VIEW LOOKING DOWN
 Aileron Fence Replacement
 Figure 1